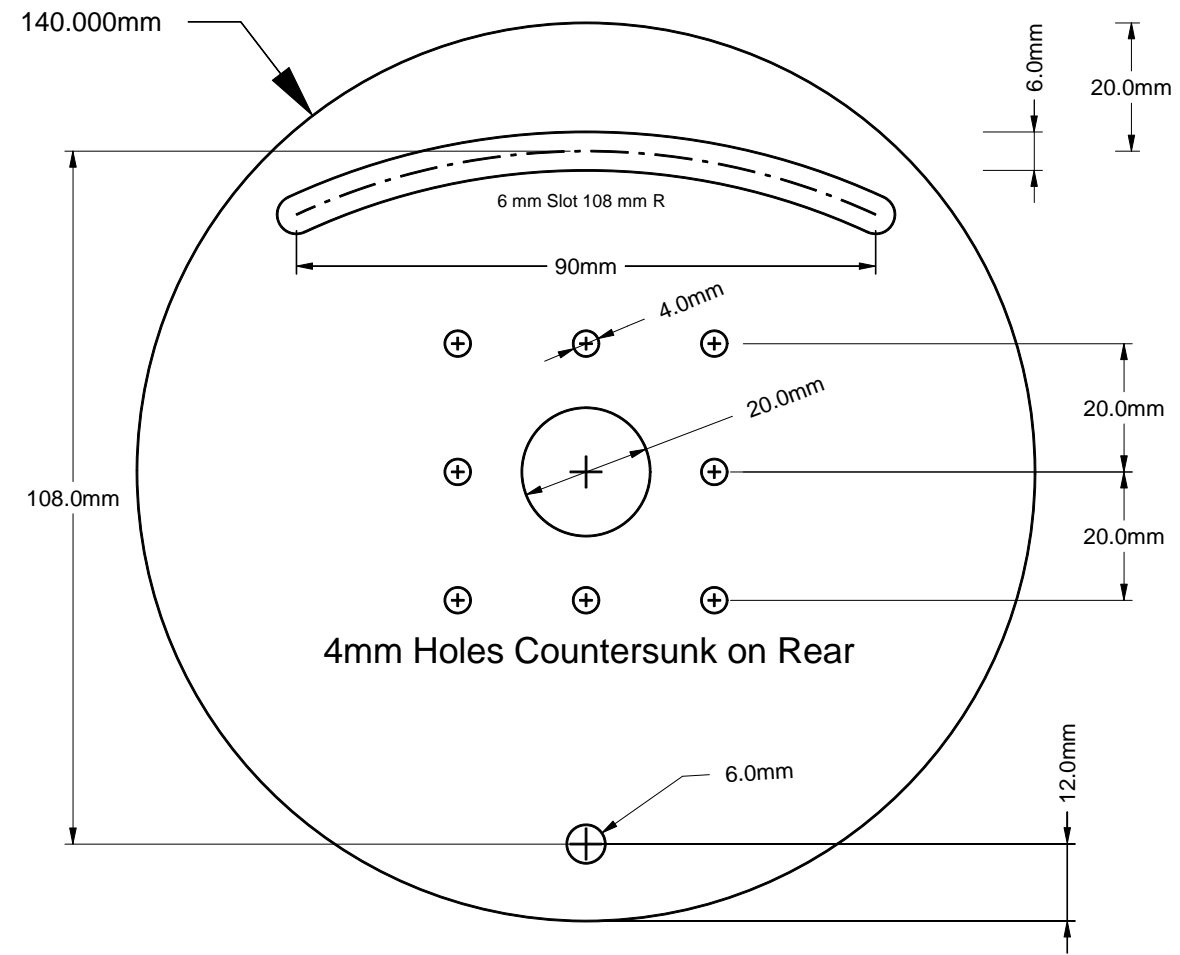
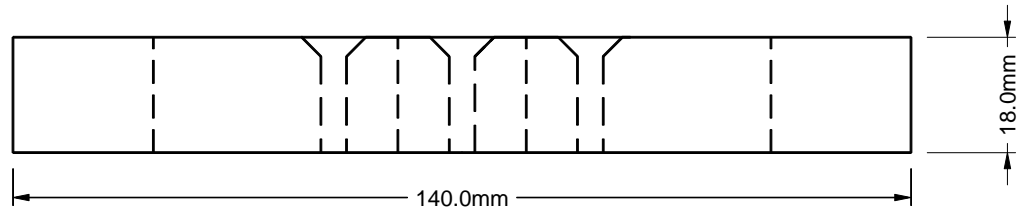
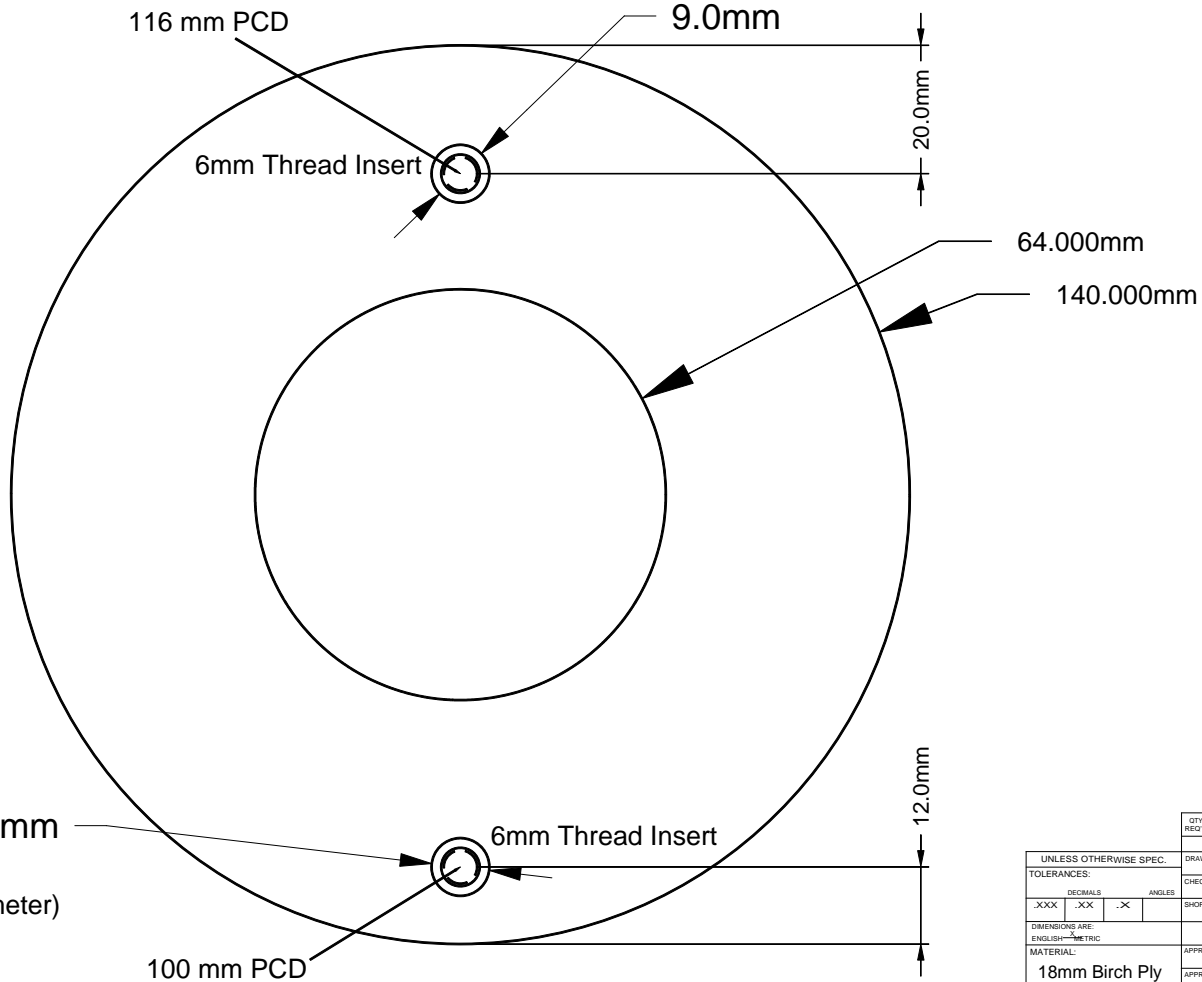
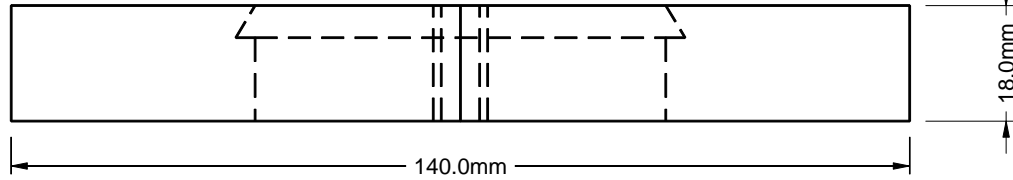


REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED



QTY. REQD.	PART OR DWG. NO.	DESCRIPTION	ITEM NO.
LIST OF MATERIALS			
UNLESS OTHERWISE SPEC.		DRAWN BY: PH	DATE:
TOLERANCES:		CHECKED BY:	
DECIMALS	ANGLES	SHOP CHECK BY:	
.XXX	.XX		
DIMENSIONS ARE:		APPROVED BY:	
ENGLISH—METRIC			
MATERIAL:		APPROVED BY:	
18mm Birch Ply			
FINISH:		APPROVED BY:	
		PLOT REFERENCE:	DRAWING NO.
		PLOT FACTOR SIZE: METRIC SCALE	
		PLOT SIZE	A
		B	
		C	
		D	1/8
		DO NOT SCALE DRAWINGS	CAD DRAWING:
TITLE:			REV.
Offset Chuck Sheet 1			©
Front Plate			

Dovetail to Suit Chuck Jaws

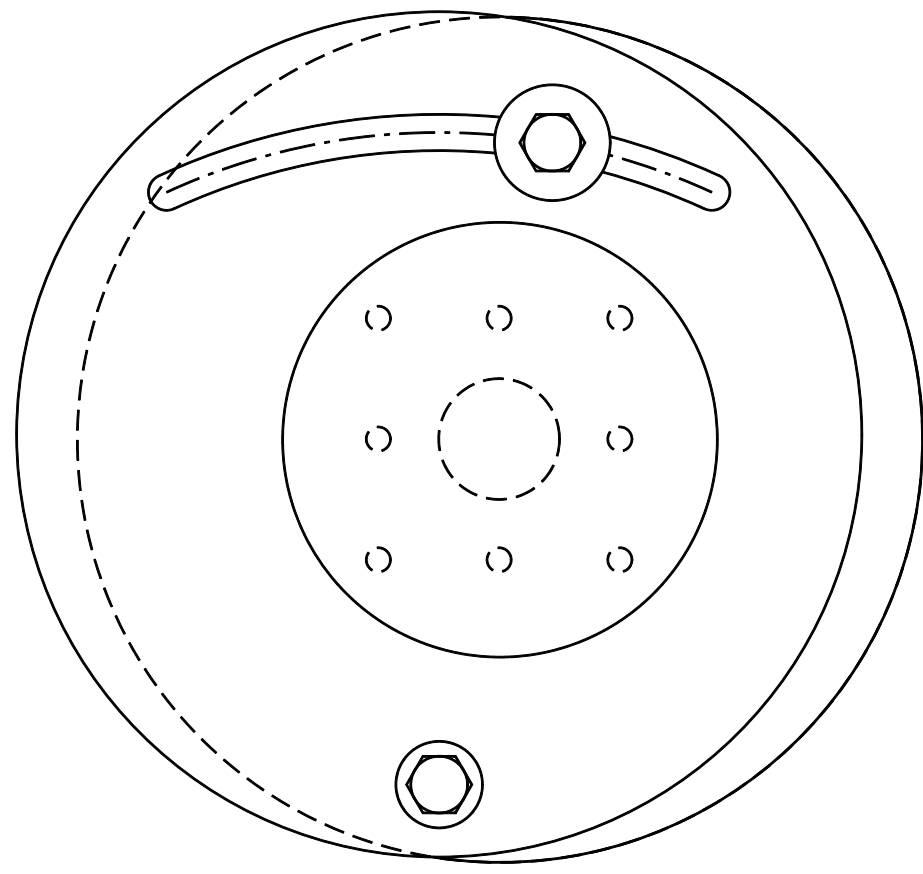


(PCD Pitch Circle Diameter)

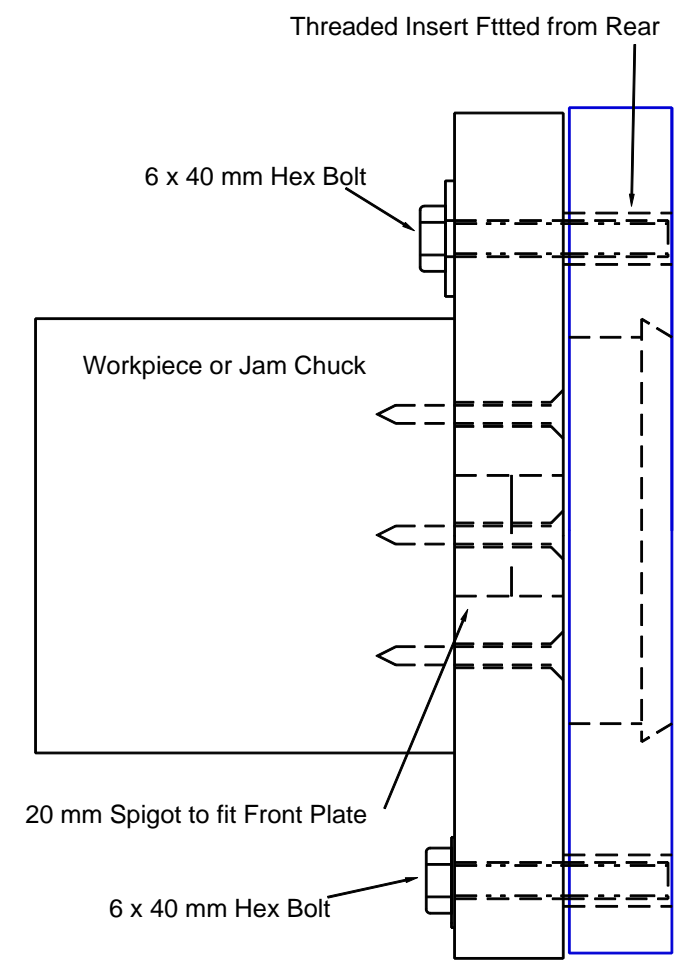
REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED

QTY. REQD.	PART OR DWG NO.	DESCRIPTION	ITEM NO.
LIST OF MATERIALS			
UNLESS OTHERWISE SPEC.	DRAWN BY: PH	DATE:	6 mm thread inserts x 2
TOLERANCES:	CHECKED BY:		6 mm Hex Sols 30mm Long x 2
DECIMALS	ANGLES	SHOP CHECK BY:	6 mm Washer
.XXX   .XX   .X			6 mm Penny Washer
DIMENSIONS ARE:	APPROVED BY:	TITLE:	
ENGLISH—METRIC		Offset Chuck Sheet 2	
MATERIAL:	APPROVED BY:	Rear Plate	
18mm Birch Ply		FLOT REFERENCE:	DRAWING NO.
FINISH:	APPROVED BY:	PLT PROFILE: APPROX. SCALE	©
		A	
		B	
		C	1/8
		D	CAD DRAWING:
		DO NOT SCALE DRAWING	

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED



10 Degree Offset to the Right



Threaded Insert Fitted from Rear

6 x 40 mm Hex Bolt

Workpiece or Jam Chuck

20 mm Spigot to fit Front Plate

6 x 40 mm Hex Bolt

QTY. REGD.	PART OR DWG NO.	DESCRIPTION	ITEM NO.
LIST OF MATERIALS			
UNLESS OTHERWISE SPEC:		DRAWN BY: PH	DATE:
TOLERANCES:		G A	
DECIMALS	ANGLES	CHECKED BY:	
.XXX	.XX	SHOP CHECK BY:	
DIMENSIONS ARE:		TITLE: Offset Chuck Sheet 3	
ENGLISH			
MATERIAL:		APPROVED BY:	
18mm Birch Ply		APPROVED BY:	
FINISH:		APPROVED BY:	
		PLOT REFERENCE:	
		DRAWING NO.	
		REV.	
		DO NOT SCALE DRAWINGS	

## Offset Chuck Instructions

1. Drill a hole in the centre of the Front Plate (6mm) this is marked out already
2. Use the front plate as a template to drill a centre hole in the back plate (6 mm)
3. Use a 6 mm bolt to align the front and back plate
4. The other two holes can now be drilled ensure that the hole in the slot is on the centre line
5. Separate the two parts and open out the holes in the back plate to suit the threaded inserts 9 mm
6. Fit the two 6 mm threaded inserts from the rear of the back plate, these may protrude through the front by a small amount and will need to be filed flush to the front face.
7. Drill the centre hole in the front plate to suit your screw chuck, then bolt the two parts together using the bolts provided. The penny washer is used on the bolt that is fitted to the slot and the normal washer on the pivot bolt.
8. Fit the parts to the screw chuck (front plate to the chuck) and turn the recess in the back plate to suit your chuck jaws. Bore the rear of the recess to a depth of 16 mm this can then be opened out when you fit the back plate to the chuck jaws.
9. Ensure both parts are aligned to each other and the bolts are tight. The outside diameter can now be turned (the corners could be cut off prior to turning) turn the OD to 140 mm and bore or drill 20 mm spigot location hole in the centre of the front plate. After turning lightly sand the edge.
10. Remove the front plate, mark out drill and countersink the 8 (4 mm) holes, finish the bore in the back plate.
11. The chuck is now ready to be used, a jam chuck can be used to turn many items, turn a 20 mm x 18 mm spigot or tenon on the end of the jam chuck and fit to the faceplate with suitable screws.