EASY CHUCKING SCREW *(Included with all Easy Chucks Feb.1, 2014)*

There are several different ways to begin your woodturning projects and one of the simplest is using a chucking screw.

Mount the chucking screw into your chuck and drill a specific size hole into your work piece. Screw the work piece onto the chucking screw. Cut your tenon and shape the outside of you project while you have it on the chucking screw. Flip your project over and do the inside of your bowl or hollow form while gripping the tenon with your Easy Chuck.

Installing and Using

1. Using the right jaws

The Easy Chucking Screw is only compatible with the EASY CHUCK.

And as of December 2013; only with the two Easy Jaw sets below:

- CJ125 - 1 3/8" Easy Dovetail Jaws *(came on your Easy Chuck)*
- CJ150 - 2 3/8" Easy Dovetail Jaws

2. Chose chucking screw size

You need to determine which screw size you need to use in order for you to keep working safely.

Using the ½" screw end, you can do projects up to 18" diameter OR up to 6" long.

1/2" Diameter Screw	
Diameter	Length
18"	2"
16"	2.5"
14"	3"
12"	3.5"
10"	4"
8"	4.5"
6"	5"
4"	5.5"
2"	6"

Using the 3/8" screw end, you can do projects up to 12" diameter OR up to 4" long.

3/8" Diameter Screw	
Diameter	Length
12"	2"
10"	2.5"
8"	3"
6"	3.25"
4"	3.5"
2"	4"

Note: As your project diameter is bigger, the length needs to get shorter or the forces will be unsafe.

3. Install screw into your chuck

1. With your Easy Chuck mounted on your lathe spindle, open the jaws until the inner most part of the jaws are beyond the center bore hole. Be sure all components are clean.
2. Insert the Easy Chucking Screw into the chuck bore hole.
3. Tighten the Easy Chuck firmly as you make sure the jaws come into square contact with the chucking flats of the Easy Chucking Screw.
4. Turn your lathe on a slow speed and confirm that

the end of the screw doesn't wobble. If the screw wobbles, loosen the chuck and repeat procedure #3.

4. Preparing your work piece

Determine which side of your blank you want to end up being the bottom of your bowl and drill your screw hole on the other side. Know that the hole you drill will be gone when you hollow out the inside of your bowl or hollow form.

Locate the center of your work piece and drill your hole as follows:

- For the 1/2" screw end - drill a 3/8" hole to at least 1 1/4" deep.
- For the 3/8" screw end - drill a 1/4" hole to at least 1" deep.

For easier mounting of dry or extremely hard (exotic) wood you may need to increase drill diameter up to 1/32" larger.

For your safety-

The face of your wood must contact at least 3 jaw faces when mounted on chucking screw. This means the surface of your wood must be reasonably flat and the hole you drill must be perpendicular to the face to within 5 degrees.

1. Position the hole in your work piece on the screw pilot and align the hole axis to the screw.
2. Turn the lathe spindle with left hand, while holding your work piece in place with your right hand.
3. After a few turns, the force required will be greater than you can exert on the spindle hand wheel.
4. Engage the lathes' spindle lock and turn the work piece, using both hands, until it is seated firmly against all 4 jaw faces.

Tips for ease and safety

- NEVER turn on the lathe to screw on your work piece.
- NEVER use a chucking screw with your lathe running in reverse!!!!
- The Easy Chucking Screw can only be used with the CJ125 or CJ150 jaws.
- The face of your wood must contact at least 3 jaw faces when mounted on chucking screw.
- Do not use the Easy Chucking Screw with wood that is cracked or rotten.
- When possible, use the additional support of your tailstock for added safety.

5. Removing your work piece

Insert the Chuck Key into chuck pinion to keep the chuck from unscrewing from the lathe spindle.