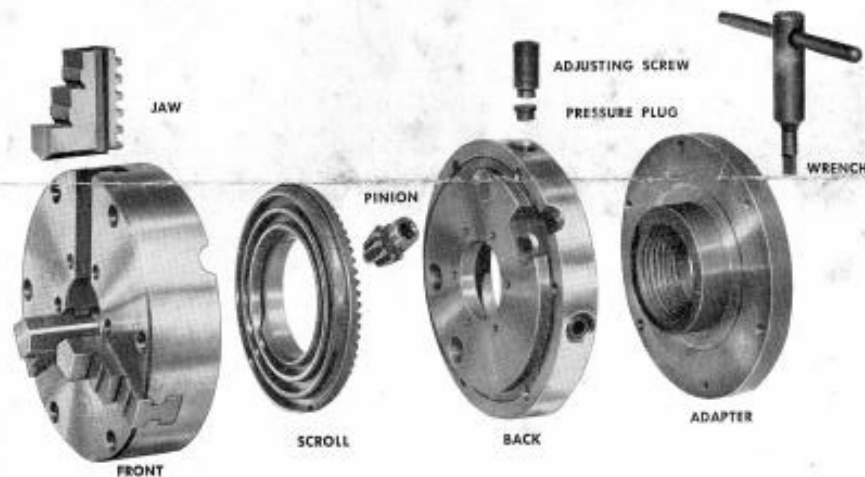


FOR 2-JAW AND ALL CHUCKS WITH SOFT JAWS

If your chuck has master jaws with soft blank tops or solid soft jaws be sure to *align O.D. of chuck true before machining soft jaws.*

If you have several jobs using soft jaws or soft top jaws which have been hardened, they can be realigned in your chuck without returning or regrinding by making use of the 4 adjusting screws. When making your own soft top jaws use the side of the master jaw as a keyway.

PARTS OF AN ADJUST-TRU CHUCK



ORDERING INFORMATION

When writing regarding your chuck be sure to mention the number stamped on chuck face. If scroll or jaws must be serviced or replaced we recommend they be returned with chuck for proper fitting of parts.

How to Mount and Operate

Buck

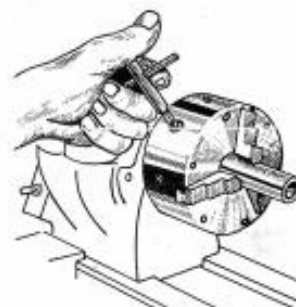
AJUST-
TRU

CHUCKS

Patent No. 2639157

THE function of the AJUST-TRU chuck is the same as any Universal chuck—to hold and center round and hexagon stock—but by using the built-in adjusting screws, work can be centered dead true.

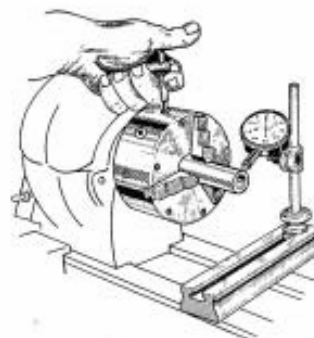
FOR MOST WORK, this chuck operates like any scroll chuck—stock is centered in the chuck quickly and with reasonable accuracy by turning the chuck pinion with the wrench furnished, until jaws grip work securely. Be sure to turn work when tightening jaws—it will assure a firm accurate grip.



FOR PRECISION ACCURACY, use the four opposed adjusting screws on the O.D. of the chuck body.

- 1—Mount the work as outlined above.
 - 2—Fasten an indicator to lathe compound rest or on a fixture.
 - 3—Turn the four adjusting screws until the indicator shows the work is running true.
 - 4—When chuck is true make sure none of the four adjusting screws are loose. If tight the chuck can not be jarred from its setting.
- Duplicate parts can now be chucked within .0005 without further adjustment.

CAUTION: Never loosen screws on face of chuck when adjusting chuck.



BUCK TOOL CO., KALAMAZOO, MICH.

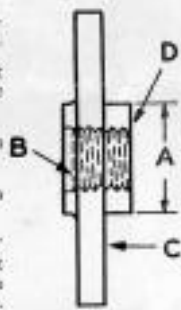
It is...

Your Responsibility TO MAINTAIN CHUCK ACCURACY

- ★ Keep Chuck Clean—the accuracy of the chuck can be destroyed by dirt, chips and grime collecting in the scroll, jaws, and chuck slots.
- ★ Nicks, burrs, chips, or dirt on the lathe spindle threads, pilot or shoulder—the chuck pilot, threads or shoulder, will throw the chuck out of alignment and result in inaccurate work.

HOW TO THREAD AND MOUNT SEMI-FINISHED ADAPTER WITH OUTSIDE MOUNTING HOLES IN CHUCK —

- 1—Grip adapter on diameter "A" with chuck.
- 2—Thread and form at "B" to fit your lathe spindle.
- 3—Mount adapter on lathe spindle.
- 4—Take a skim cut on face "C".
- 5—Check diameter "A" for run out, if it's out more than .010", take a light cut to make it true.



NOTE: If a truing cut is necessary do not turn below the low limit as shown in chart.

	4"	5"	6"	7 1/2"	8" & 9"
A MAX.	2.109	2.359	3.109	3.605	4.730
MIN.	2.089	2.339	3.089	3.585	4.710

IMPORTANT: If the chuck wobbles after being mounted on the lathe, it is an indication that the adapter face is not square with lathe spindle. To correct this, remove chuck from adapter and take a skim cut off face "C"—see drawing. When mounting adapter to chuck make sure face "D" does not contact chuck. If it does, machine face "D" enough to obtain clearance.

HOW TO THREAD AND MOUNT SEMI-FINISHED ADAPTER WITH INSIDE MOUNTING HOLES IN CHUCK —

- 1—Grip adapter on diameter "A" with chuck.
- 2—Thread and form at "B" to fit your lathe spindle.
- 3—Mount adapter on lathe spindle.
- 4—Take a skim cut on face "C".
- 5—Check diameter "A" for run out, if it's out more than .010", take a light cut to make it true.



NOTE: If a truing cut is necessary do not turn below the low limit as shown in chart.

	8"	10"	12"
A MAX.	4.730	6.344	7.875
MIN.	4.720	6.334	7.865

*Most 8" chucks are mounted as shown under 8" and 9" sizes.

SUGGESTIONS FOR OPERATION

- 1—Chuck work as far back into the chuck jaws as possible, turning the work as the jaws are tightened—it will assure a firm accurate grip.
- 2—Whenever possible, tighten the jaws around the solid part of the work.
- 3—DON'T OVERLOAD YOUR CHUCK—Do not chuck work larger than the diameter of the chuck.
- 4—USE THE WRENCH FURNISHED—it is designed to provide sufficient leverage to tighten the jaws. NEVER use a larger wrench or pipe over the end of the wrench to increase the leverage.
- 5—DON'T POUND OR HAMMER THE JAWS—Never use force if jaws seem to jam. Find cause of obstruction or take chuck apart. It may need cleaning and oiling. Be sure to remove chips and dirt which may have worked into jaw slots or scroll.
- 6—Never straighten work in the chuck.
- 7—Whenever possible never extend jaws beyond the outside diameter of the chuck.
- 8—When checking stock in chuck, make sure jaws are tightened securely.
- 9—Six jaw chucks must be cleaned more often than 3-jaw chucks as there are twice the number of jaw openings.

HOW TO CHANGE JAWS —

- 1—Remove jaws from chuck slots with chuck wrench. Wipe jaws with a clean cloth and cover with a light film of oil. Place jaws in box to prevent damage or loss.
- 2—Clean scroll, chuck slots and new jaws, then apply a light film of oil. Do not use too much oil—it collects dirt and chips which eventually clog the chuck jaws and scroll.
- 3—The jaws and chuck jaw slots are numbered 1, 2, and 3. Jaws must be inserted in the slot having the corresponding number. DO NOT INTERCHANGE JAWS FROM ONE CHUCK TO ANOTHER.

- 4—Turn scroll so that first thread on outside edge of scroll does not quite enter jaw slot No. 1 (See Figure 2, step 1).
- 5—Repeat process for jaws 2 and 3. (See Figure 2, steps 2 and 3). Continue if chuck has 6 jaws.

IMPORTANT: Jaw must slide into chuck easily—never use force. If jaw must be forced, it is because jaw is misaligned or dirt and chips are lodged in the jaw or scroll. Remove jaw and carefully clean the jaw and chuck scroll.

NOTE: THE PROCEDURE FOR 6 JAW CHUCKS IS THE SAME AS FOR 3 JAW CHUCKS.

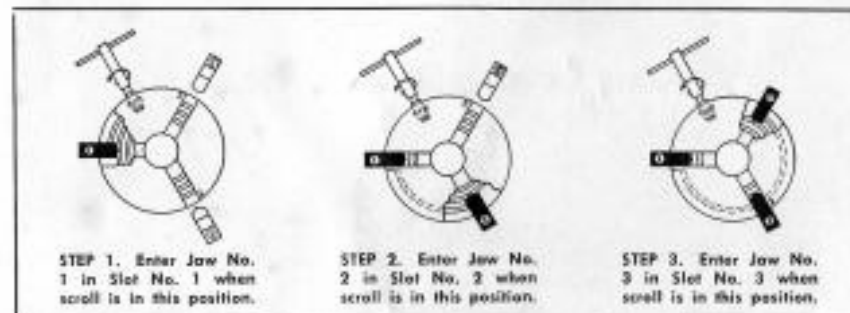


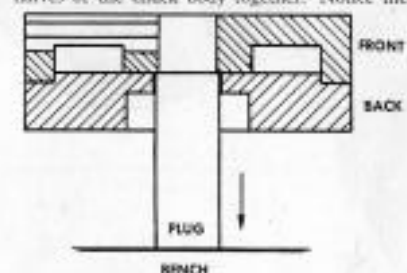
Fig. 2—Steps in mounting the jaws.

SUGGESTIONS FOR MAINTENANCE AND CARE

- OIL CHUCK FREQUENTLY—Most wear is due to dirt and lack of proper lubrication. Oil chuck jaws and scroll at regular intervals with a light film of clean SAE No. 10 machine oil. CAUTION: Do not apply too much oil—it collects dust and chips which eventually clog the chuck jaws and scroll.
- PROTECT CHUCK WHEN NOT IN USE—Don't leave your chuck on the floor or under the bench where dirt or chips can get into it.
- INSPECT YOUR CHUCK PERIODICALLY—If used properly this chuck will give good service for a long period. Through long wear or accidental strain, the jaws may get out of alignment. Check periodically to see that all parts are in good working order.
- To maintain chuck accuracy NEVER abuse your chuck.
- If parts are damaged or worn, return complete chuck and wrench for service.

HOW TO DISASSEMBLE ADJUST-TRU CHUCKS —

First remove chuck from adapter by removing 6 screws on the face of the chuck and loosening the 4 adjusting screws. Then loosen the 6 screws on face of chuck which hold the two halves of the chuck body together. Notice the



step on the hole through the center of the chuck—the back half is approximately 1/4" larger in diameter than the hole going through front half of chuck. If the back and the front do not easily separate, put a plug against this 1/4" shoulder and pound, with the chuck in upright position, on bench or floor as illustrated.