

FITTING A CHUCK TO LATHE

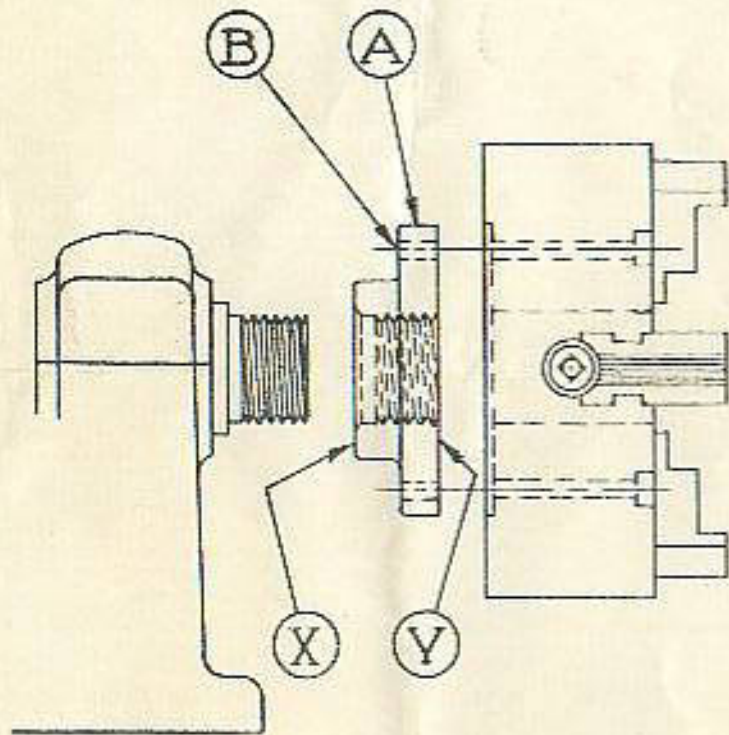
DO NOT MACHINE FACE "X" AS THIS IS FINISHED PERFECTLY SQUARE WITH THE THREAD.

CLEAN THREADS OF SPINDLE & CHUCK BACK AND OIL SPINDLE TO PREVENT CHUCK BACK STICKING. SCREW CHUCK BACK ON SPINDLE, TAKE A FINISHING CUT ON FACE "Y" AND TURN OUTSIDE DIAMETER "A" TO FIT VERY SNUGLY IN RECESS IN BACK OF CHUCK. DO NOT MAKE A DRIVE FIT, BUT CLOSE ENOUGH TO REQUIRE FORCING WITH THE HANDS.

TO LOCATE HOLES IN CHUCK BACK, CHALK BACK OF CHUCK AND TAP CHUCK BACK LIGHTLY IN PLACE.

DRILL BOLT HOLES "B" IN CHUCK BACK $\frac{1}{16}$ " LARGER THAN BOLTS. CHECK TO BE SURE BOLTS DO NOT BIND, AND BOLT CHUCK BACK TO CHUCK.

IN SOME CASES IT IS DESIRABLE TO TAP THE CHUCK BACK FOR HOLDING SCREWS INSTEAD OF USING BOLTS, WHEN THIS IS DONE ALL OPERATIONS ARE THE SAME AS ABOVE EXCEPT HOLES "B" ARE TO BE TAPPED INSTEAD OF DRILLED OVER SIZE.



					UNIT	CHUCK BACK		
					SHEET NO.	1	NO. SHEETS	1
					SCALE	NONE		
					SOUTH BEND LATHE			
					SOUTH BEND, IND., U.S.A.			
					DRAWN BY	C'KD. BY	TRACED BY	C'KD. BY
					G.Z.	J.H.	A.W.H.	G.Z.
					DATE	LET.	WAS	DR. NOTICE
					6-6-40	6-6-40	7-1-45	7-2-48