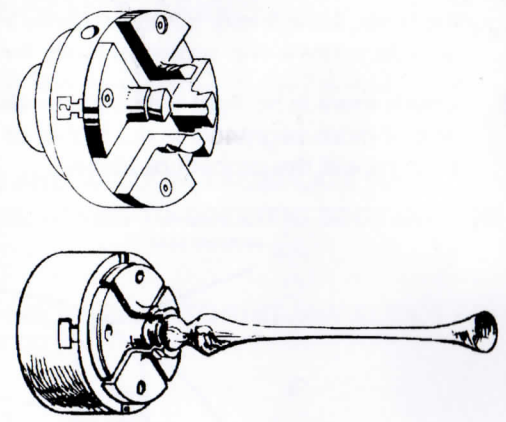


25mm JAW SET

Code: JS25N

SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.



MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on Page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments NOTE: There is only one screw position for each of the 25mm jaw segments. Only one screw is necessary for secure fastening of jaw segments because the jaw is designed for small turning work.

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using the 25mm jaws, bowls up to 150mm (6") in diameter by 50mm (2") depth can be turned.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 50mm AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK.
DO NOT EXCEED 684 RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE.

Recess: Maximum recess depth of 6.5mm can be used. Any recess diameter can be turned between 23.5mm (15/16") and 46mm (1 13/16"). The optimum recess diameter is 25mm (1"). At this diameter, full contact of jaws with recess is achieved. As the recess diameter is increased above 25mm, less jaw contact is made. This needs to be kept in mind when considering the recess depth and the size of the wood blank being mounted. Increase the recess depth to maximum if a recess diameter in excess of 25mm is used.

b. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approximately 12mm (31/64") to a maximum of 25mm (1").

DO NOT EXCEED 1440 RPM IN THIS MODE
MAXIMUM LENGTH Wood blanks up to 125mm (5" length by 25mm (1").

c. Spigot Mounting (Contracting Action)

Use wood blank size up to 125mm (5") length by 25mm (1") diameter.

DO NOT EXCEED 1440 RPM FOR THIS OPERATION
Spigot Size: Minimum spigot size is 8.5mm (23/64") up to a maximum spigot size of 25mm (1"). Spigot Depth Always use the maximum spigot depth which is 19mm (3/4").

d. Special Function

For lathes with hollow spindles, Teknatool Chucks with the 25mm jaws mounted, could accept long lengths of round dowel below the 25mm size, which could be fed through the lathe spindle and through the chuck. This means that multiple turnings could be achieved by simply advancing the dowel through the centre of the chuck and securing with the jaws, turning, parting off, and then advancing the next piece through. Do not allow dowel to protrude past spindle on the outboard end.

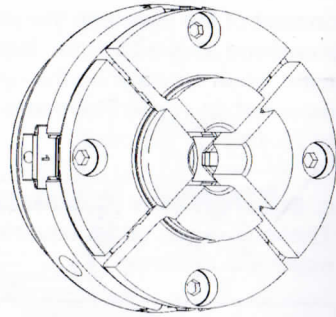
OPTIONAL ACCESSORIES

Not applicable for this jaw set.

The 25mm jaw set is not designed for mounting to the Cole/Mini Cole Jaws Sets. DO NOT USE WITH COLE OR MINI COLE JAW SETS.

35mm BOWL JAW

Code: 6019



SAFETY

Consult the safety section on Page 10 of the accessory jaw manual and also read the safety section of your Chuck manual and be thoroughly familiar with the safety operation before using these jaws. In addition, please carefully follow the specific safety information regarding the operational use of the Long nose Jaws outlined in the Operational section.

PARTS PROVIDED – Four bowl jaw segments.

NOTE

Use the M6x10 Countersunk screws provided with your Teknatool Chuck to mount the 35mm Bowl Jaws. Spares can be purchased from the Teknatool Website: www.teknatool.com

MOUNTING JAWS

See "Mounting the Accessory Jaws" on page 12 & 13 of the Accessory Jaw manual.

WARNING - BEFORE OPERATING YOUR BOWL JAW SET:

- DO NOT EXCEED 1000 RPM WITH THE JAWS IN ANY OPERATIONAL MODE.
- OUT OF BALANCE WOOD OR LARGE WOOD BLANKS MUST BE TURNED AT THE SLOWEST SPEED POSSIBLE ON OR BELOW 250 RPM.
- DO NOT ATTEMPT TO USE THESE JAWS IF YOUR LATHE DOES NOT HAVE A USABLE SPEED OF 250 RPM OR BELOW.
- MAKE SURE THAT JAW SLIDES DO NOT PROJECT BEYOND CHUCK BODY WHEN JAWS ARE EXPANDED.
- DO NOT STAND IN A POSITION THAT MIGHT PUT YOU IN THE PATH OF A DISLODGED ROTATING BOWL.

OPERATIONAL MODES

a. Expanding Dovetail Mode

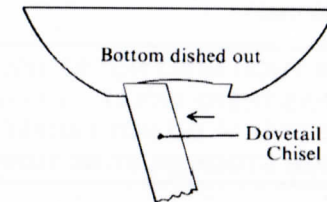
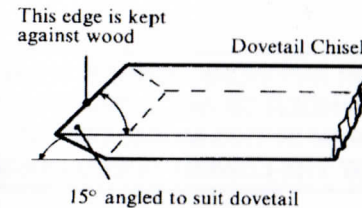
Using the bowl Jaws, bowls up to 300mm (8") in diameter by 150mm (4") depth can be turned. Recommend that there is 50mm (2") of wood outside of dovetail area.

Any recess diameter can be turned between 42mm and 62mm. The optimum aim size (true circle is 45mm).

Note the 42mm, 45mm and 62mm is the small diameter of the recess.

To make the recess is an easy process.

1. Draw a circle on the base of the bowl 45mm diameter.
2. Hollow out the recess area, being careful not to cut out further than the 45mm.
3. Use a left hand skew scraper with a 15 degree angle. These are a common standard chisel.
Position the chisel so that the scraper end is engaged with the wood along its front face.
The edge of the chisel that cuts the recess will now automatically be at 15 degrees.
4. Move the chisel outwards until the chisel is just cutting away the pencil circle. The 45mm is the optimum but you can make smaller (42mm) or up to (62mm) As the recess diameter is increased less jaw contact is made. This needs to be kept in mind when considering the recess depth and size of the wood blank being mounted.

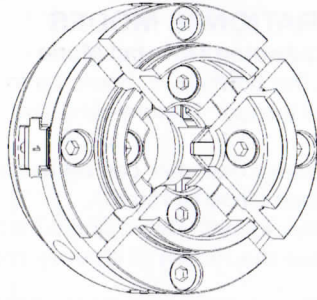


DO NOT EXCEED 600RPM IN THIS MODE

50mm JAW SET

Code: JS50N

These jaws are supplied standard with most Teknatool Chucks. Check your chuck specification.



SAFETY

Consult the safety section on page 10 of this manual and also read the safety section of your Teknatool Chuck manual and be thoroughly familiar with the safety operation before using these jaws.

MOUNTING THE JAWS

See "Mounting the Accessory Jaws" on page 12 & 13 of this manual.

PARTS PROVIDED – Four jaw segments

OPERATIONAL MODES

a. Expanding Dovetail Jaws

Using this method bowls of up to 310mm (12) in diameter by 100mm (4") in depth can be turned.

THIS METHOD MUST NOT BE USED FOR ANY WORK LONGER THAN 100MM AS THERE WOULD BE GREAT DANGER OF WOOD TEARING OUT OF THE CHUCK. DO NOT EXCEED 684RPM IN THIS MODE. OUT OF BALANCE STOCK MUST BE TURNED AT THE LOWEST SPEED POSSIBLE.

Recess: Maximum recess depth 6mm (1/4). Any recess can be turned between 50mm (2") and 75mm (3") diameter. The optimum recess diameter is 50mm (2"). Where ever possible keep your recess between 50mm – 60mm. Extra care must be taken while turning with recesses above 60mm. YOU MUST USE THE MAXIMUM RECESS DEPTH ON ALL RECESSES OVER 64mm (2.5") diameter OR ANY WORK WITH A DIAMETER OVER 150MM (6").

For smaller lids and thin platters, not exceeding 150mm diameter, only a shallow recess of around 3mm (1/8") is necessary.

b. Square Blanks (Contracting Action)

These jaws can grip a square spigot between approximately 40mm (1 9/16") to a maximum of 50mm (2").

DO NOT EXCEED 1020RPM IN THIS MODE

Maximum length: Wood blanks up to 150mm (6") length by 100mm (4").

c. Spigot Mounting (Contracting Action)

Use wood blank size up to 150mm (6") length by 100mm (4") diameter.

DO NOT EXCEED 1020RPM IN THIS OPERATION

Spigot Size: Minimum spigot size of 45mm (1 49/64") up to a maximum spigot size of 65mm (2 9/16").

Spigot Depth: The length of the spigot area must not be less than 16mm (5/8").