

VEVOR[®]

TOUGH TOOLS, HALF PRICE

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4-JAW SELF-CENTERING WOOD CHUCK

MODEL:KP2-3/4, KP96, KP965

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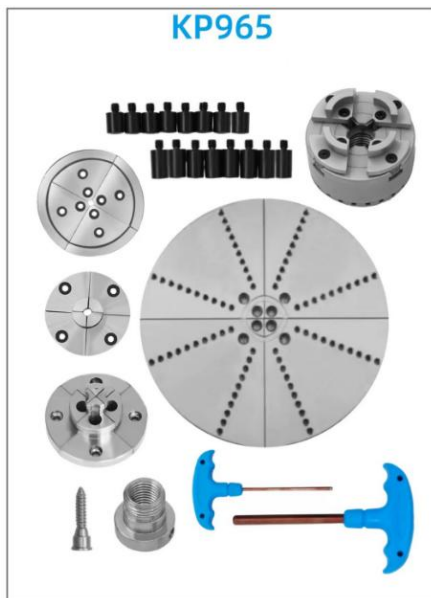
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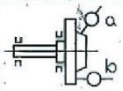
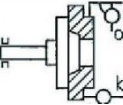
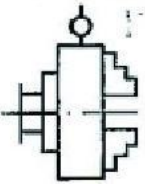
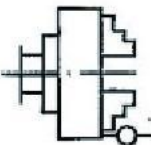
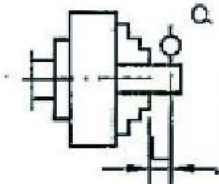
NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

✉ CustomerService@vevor.com

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

Geometry accuracy (mm)

Diagram of test	Test item	Chuck Diameter	
		70	96
	a.Radial run-out b.axial run-out	a:0.005 b:0.005	
			
	Radial run-out of chuck	≤ 0.15	≤ 0.15
	Axial run-out of chuck	≤ 0.15	≤ 0.15
	Radial run-out of test bar	$\alpha \leq 0.4$ L=50	$\alpha \leq 0.4$ L=50 (75)

DESCRIPTION

This Chuck is 4-Jaw Self-Centering chuck utilizing the precision, simplicity and reliability of the engineering chuck.

This Chuck is self-centering; grips internally and externally; will hold round and square work; has a hollow center so through boring can be done from either end; and can be run clockwise or anticlockwise.

Manufactured from, this gives the chucks a higher durability ensuring a longer life and high quality finish which is less.

PACKING LIST

(KP2-3/4, KP96)

1. 4-Jaw Self-Centering Chuck.....1pcs

2. Accessory

Wooden Screw 1pcs

T-bar Allen Key 1pcs

Key chuck.....1pcs

Adapter1pcs

3. Instruction



(KP965)

1.4-Jaw Self-Centering Chuck1pcs

2. Accessory

Wooden Screw.....1pcs

T-bar Allen Key 1pcs

Key chuck 1pcs

Adapter 1pcs

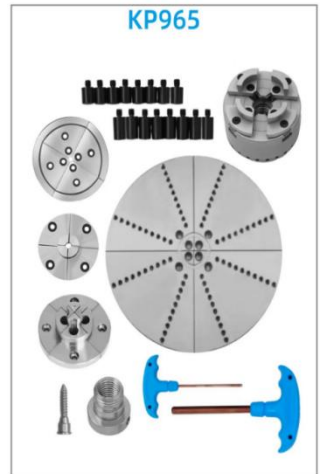
Big Round Jaw (4 pieces) 1sets

Pin Jaw (4 pieces) 1sets

Step Jaw (4 pieces).....1sets

Flat Jaw (4 pieces)1sets

Stud.....16pcs



3. Instruction

SAFETY PRECAUTIONS

1. Read and understand instructions manual before operation wood lathe.
2. Always wear eye protection.
3. Do not wear gloves, neckties, jewelry or loose clothing.
4. Do not operate without guards in place.
5. Rough out workpiece before installing face plate.
6. Do not mount a split workpiece or one containing a knot.
7. Tighten all locks before operating.
8. Rotate workpiece by hand before applying power.
9. Use slowest speed when starting a new workpiece and do not exceed

permitted speed.

10. Disconnect machine from power source before making repairs or adjustments.

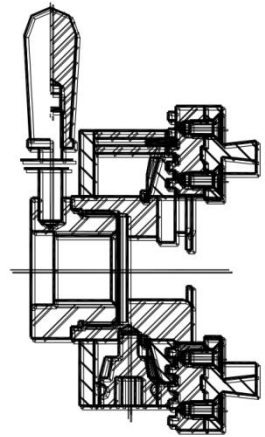
11. Do not operate while under influence of drugs, alcohol or medication.

12. Remove the tool rest before sanding or polishing.

It is beyond the scope of this manual to describe all of the turning techniques that are possible with the 4-Jaw Chuck. It is recommended that beginner turners attend a reputable course of instruction refer to one of the many available books on turning techniques.

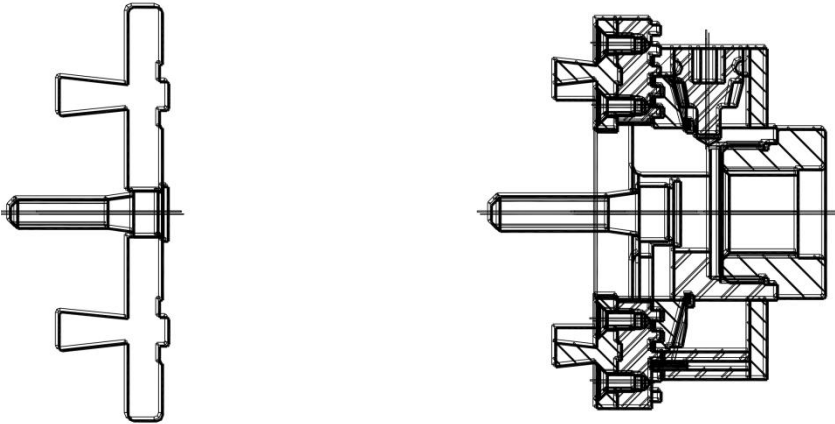
MOUNTING ON THE LATHE

The 4-Jaw Chuck fits a wide range of lathe spindle sizes. This is done by changing the threaded Adapter. Your dealer will advise on the Adapter required for your lathe. Check that the Adapter is firmly screwed into the Chuck body and then screw the assembled chuck onto the lathe spindle. Adapter must be firmly seated against the lathe spindle shoulder.



THE SCREW POINT

The Screw Chuck is used to mount small, cross-grained pieces.



4-Jaw Self-Centering Chuck

25MM JAWS

These jaws are used for expansion into small recesses and for firm holding of fine spindle work, such as earrings, chess pieces, etc.. To turn very small articles, the jaws can be unscrewed and the backing jaws only can be used.

DOVETAIL JAWS

Dovetail jaws are designed for mounting bowls by expanding into a recess or clamping onto a spigot. The size indicated is the outside measurement of the jaw face when fully closed. Dovetail jaws provide approximately 25mm of expansion beyond their specified size.

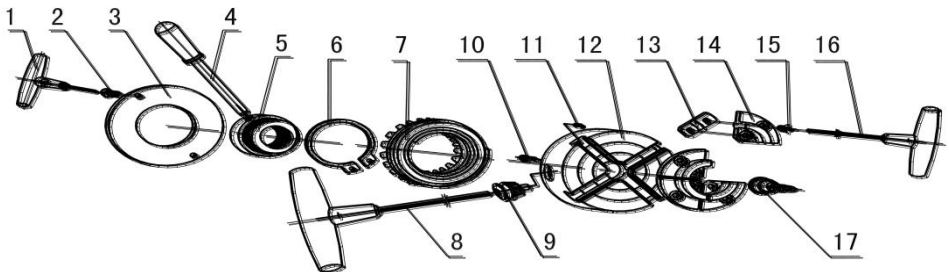
KEY CHUCK

The 4-Jaw Chucks provide one-hand tightening along with tremendous gripping power provided by the 6 to 1 ratio of the scroll. The totally enclosed back assures consistent, smooth action by preventing dust and debris from getting into scroll of the Chuck.

Key chuck cannot be beaten when it comes to holding power.

Its compact size makes it ideal for use on 300mm capacity lathes or smaller.

Basic Chuck includes: Chuck body, dovetail jaw set; T-Bar Allen Key; screw point; Key chuck; appropriate Adapter to fit your lathe and owner's manual.



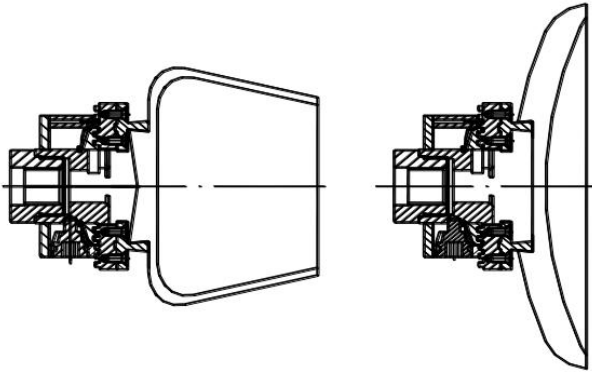
- | | | | |
|---------------------|------------|-----------------------|----------------|
| 1. T-bar Allen key | 2. Screw | 3. Lid | 4. Screwdriver |
| 5. Adapter | 6. Circlip | 7. Scroll ring | 8. Key chuck |
| 9. Pinion | 10. Pin | 11. Baking pin | 12. Chuck body |
| 13. Backing jaw | 14. jaws | 15. Countersunk screw | |
| 16. T-bar Allen key | | 17. Wood screw | |

CLAMP-MODE

With this application the workpiece is held by the jaws. To achieve a good hold, press the bowl end hard against the jaws. Fasten the workpiece to the screw or onto a face plate. When pre-turning bowls from green timber it is possible to do this between centers or with a pivot chuck. Turn a 5 to 10mm deep dovetail recess first.

EXPANSION MODE

For this application a recess is turned into the work piece. The depth of the recess depends on the actual size of the workpiece as well as the type of timber used. The minimum depth should be 5mm to 10mm.



MAINTENANCE

The chuck is engineered to close tolerances and may initially be stiff to operate. With use movement will be easier. To maintain easy jaw action, regularly spray oil into the scroll and work Key chuck through full range of movement. Inspect chuck regularly for build-up of dust in the scroll and jaws. Clean as required.

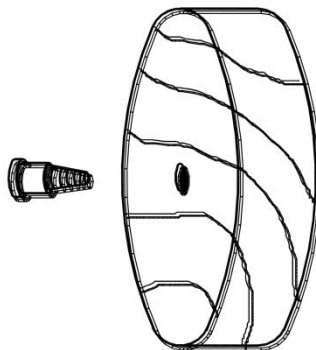
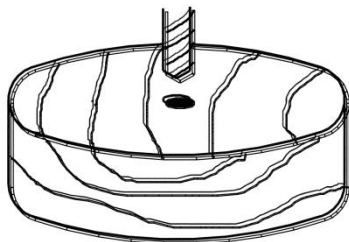
BEGINNER'S HINTS

Prepare the workpiece the following way:

200-250mm dia. 40-50mm thick; RPM 80- 100

1. Drill a 25mm deep and 7-8mm dia. hole in the center of workpiece (avoid drilling the end grain, less grip).
2. Make sure the work piece is as round as possible.

3. Choose appropriate speed before you start the lathe.
4. Screw the work piece hard against the jaws.
5. Heavy or unbalanced work pieces should not be fastened directly to the screw chuck. Use the faceplate rings instead.



Address: Baoshanqu Shuangchenglu 803long 11hao 1602A-1609shi
Shanghai

Imported to AUS: SIHAO PTY LTD, 1 ROKEVA STREET EASTWOOD
NSW 2122 Australia

Imported to USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim

Place, Rancho Cucamonga, CA 91730



Pooledas Group Ltd
Unit 5 Albert Edward House, The Pavilions
Preston, United Kingdom



SHUNSHUN GmbH
Römeräcker 9 Z2021, 76351
Linkenheim-Hochstetten, Germany

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