AXMINSTER TOOL CENTRE

Axminster's Super Precision Woodturning Chuck

User Manual

100247

www.axminster.co.uk

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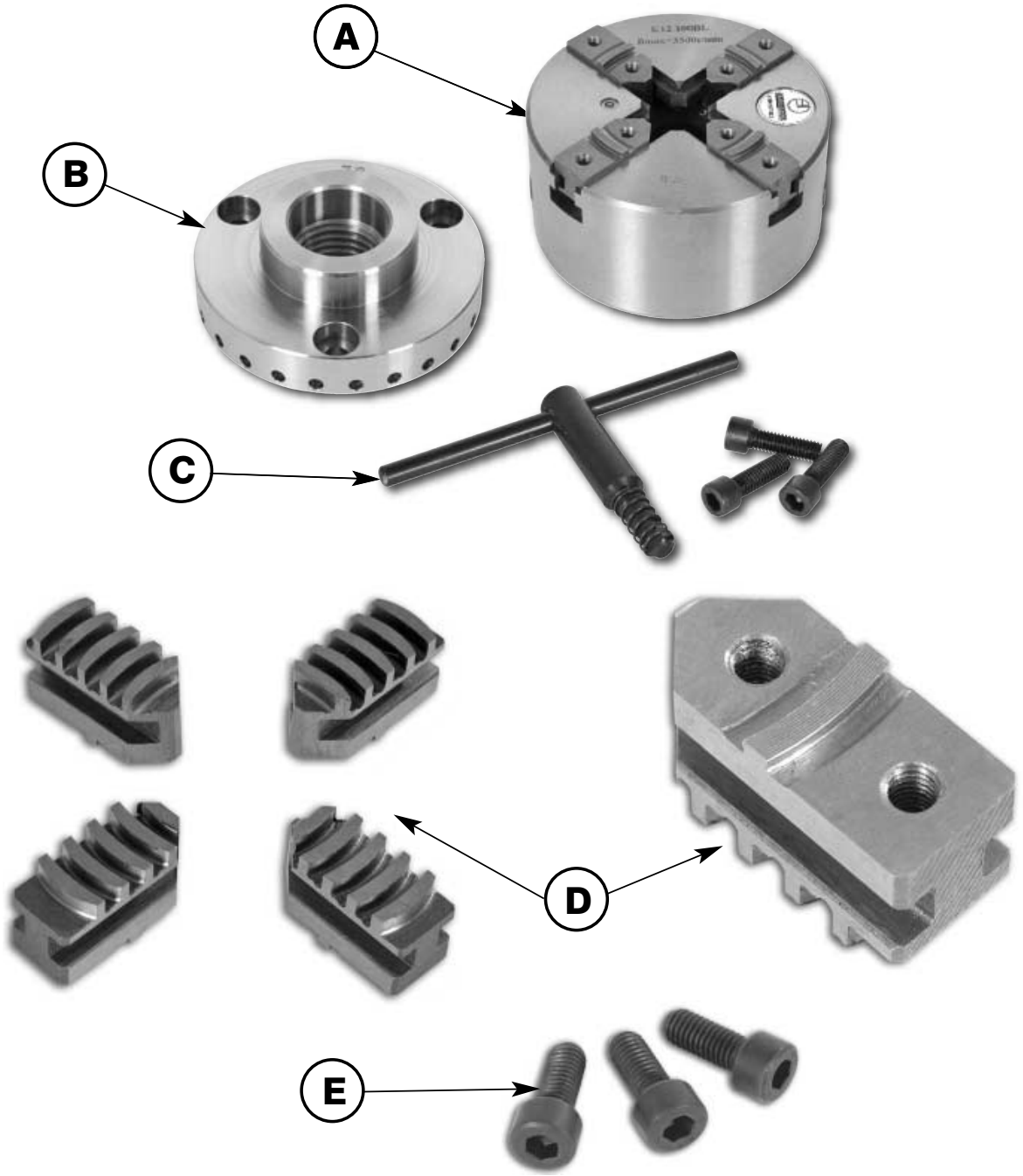
Page No.

SAFETY!!

The symbols shown on the cover of this manual advise you to observe the appropriate safety protocols when using this machine.

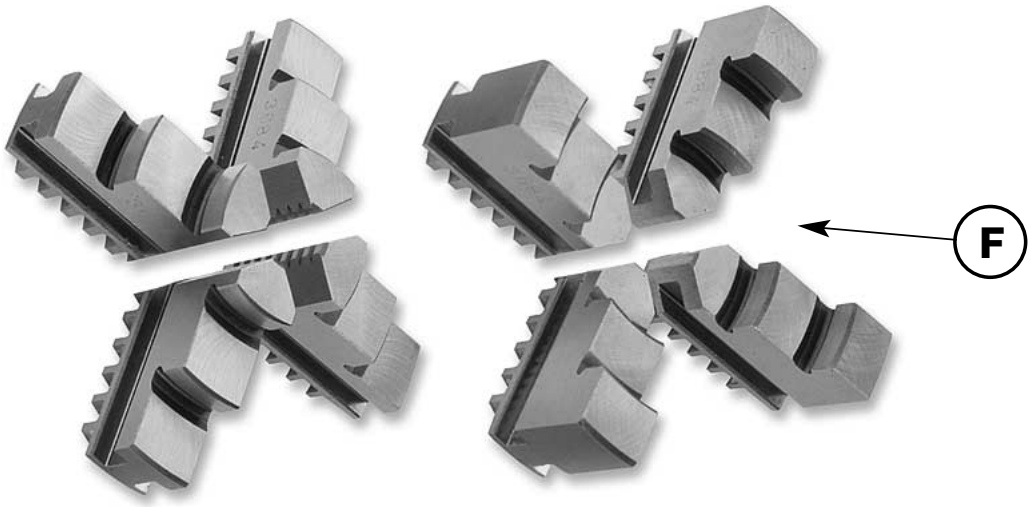
Safety Protection Symbols

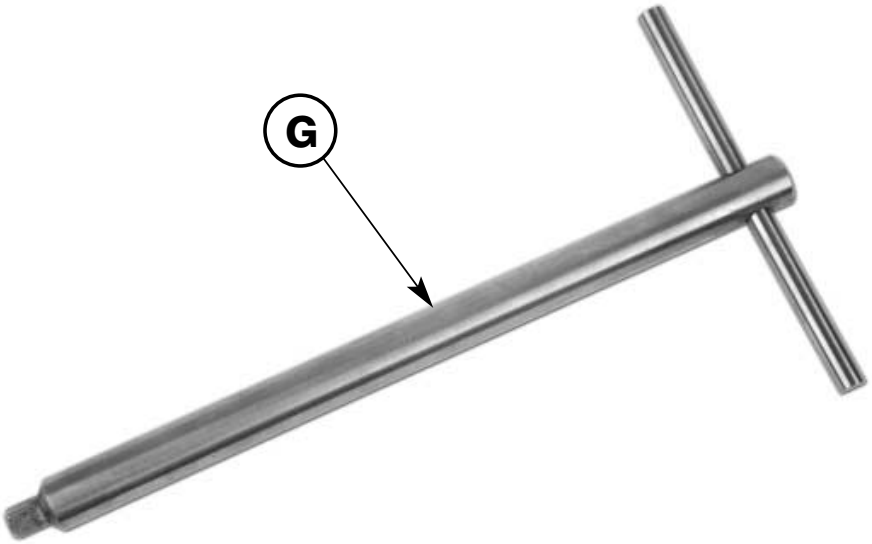
Model Number:	100247
1 No. Super Precision Chuck with Mounting Jaws	A
1 No. Threaded Indexed Backplate, included in package	B
1 No. Chuck Key	C
4 No. Mounting Accessory Jaws	D
3 No. Caphead Screws	E
1 No. Instruction Manual	



Optional Accessories...

4 No. Internal & External Step Jaws	F	Order No: 200038
1 No. Long Key (8mm²)	G	Order No: 600121





Good Working Practices/Safety

The following suggestions will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.

WARNING!! **KEEP TOOLS AND EQUIPMENT OUT OF THE REACH OF YOUNG CHILDREN**

BASIC SAFETY FOR MACHINE TOOLS

KNOW YOUR MACHINE TOOL

Read and understand the owner's manual and labels affixed to the tool. Learn its application and limitations as well as specific potential hazards peculiar to the tool.

EARTH ALL TOOLS

All machines should be equipped with an approved cable. The green and yellow conductor in the cable is the earth wire and should be connected appropriately.

NEVER connect the green and yellow wire to a live terminal.

KEEP GUARDS IN PLACE

Keep all guards in place. They are there for your protection and do not interfere with the correct operation of your machine.

REMOVE ADJUSTING KEYS AND WRENCHES

Form the habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.

KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents. Floors must not be slippery due to oil or sawdust. Make sure you clean up any waste materials on completion of work.

AVOID DANGEROUS ENVIRONMENTS

Do not use power tools in damp or wet locations or expose them to rain. Keep work area well lit. Provide adequate space surrounding the work area.

KEEP CHILDREN AWAY FROM WORK AREA UNLESS UNDER CLOSE SUPERVISION

All visitors should be kept a safe distance from work area. Children are naturally curious; therefore ensure they are closely supervised when they are near the work area.

MAKE WORKSHOP TAMPER PROOF

Many machines have lockable switches that can be secured with a small padlock or have a removable key. Please make use of them to prevent unauthorised operation of your machines.

DO NOT FORCE TOOL

It will do the job better and safer at the rate for which it was designed. Develop a patient approach to the work, you will get better results in the finished product.

WEAR PROPER CLOTHING

Do not wear loose clothing, gloves, neckties or jewellery that can catch in moving parts of machinery. Non-slip footwear with steel toecaps is recommended. Wear protective hair covering to contain long hair. Roll up long sleeves to above the elbow.

SECURE WORK

Where applicable use clamps or a vice to hold work. This leaves both hands free to operate the tool correctly and thus produces better results.

DIRECTION OF FEED

Feed work into a blade or cutter against the direction of rotation of the blade or cutter only. This will reduce the danger of kick back which is a serious hazard. Similarly, when using a lathe feed the cutting edge of the tool against the direction of rotation!

USE SAFETY GOGGLES AND FACE PROTECTION

Wear safety goggles (complying to relevant standards) at all times. Normal spectacles only have impact resistant lenses and are NOT sufficient. Also use face or dust masks if the cutting operation is dusty (connection of machine to a dust extractor is preferred). Always wear ear defenders for cutting, sawing, planing or routing operations. Your hearing can be permanently damaged if exposed to high noise levels for long periods of time.

Basic Safety for Machine Tools...

DO NOT OVERREACH
Keep proper footing and balance at all times.
MAINTAIN TOOLS WITH CARE
Keep tools sharp and clean at all times for the best and safest performance. Follow the manufacturer's instructions for lubricating and sharpening and also for changing accessories.
DISCONNECT POWER FROM THE TOOL
Before servicing or when changing accessories always disconnect the power supply to avoid accidental starting.
AVOID ACCIDENTAL START UP
Although most machines are now equiped with NVR switches develop the habit of making sure the switch is in the "OFF" position before connecting the machine to the power supply.
USE RECOMMENDED ACCESSORIES
Consult the owner's manual for details of any manufacturer's accessories or contact your supplier for details of recommended accessories. Follow the instructions that accompany the accessory. The improper use of accessories may cause hazards. The fitting of non-recommended accessories may also cause hazards.
CHECK DAMAGED PARTS
Before using the tool, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function. Check for alignment of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced. A parts list is to be found at the back of your operator's manual.
NEVER LEAVE A MACHINE RUNNING UNATTENDED
ALWAYS turn power off. Do not leave machine until it comes to a complete stop.
DRUGS, ALCOHOL AND MEDICATION
NEVER operate tools whilst under the influence of drugs, alcohol or after taking medication.
USE THE CORRECT TOOL
Do not force a tool or attachment to do a job for which it was not designed. This is dangerous workshop practice.

Specific Safety Instructions for the Chuck...

When using this chuck please follow the basic safety precautions and observe the following specific precautions:-

DO ensure the chuck is screwed fully onto the headstock shaft.

DO ensure that all accessory fittings are secure before starting your lathe.

DO start the machine in a slow speed if the work is unbalanced.

DO be aware that when gripping large diameter workpieces that the jaws may extend beyond the boundary of the chuck body.

DO keep your hands clear until the chuck has stopped rotating.

DO NOT attempt to exceed the normal capacity of any jaw fitted to the chuck as the jaws may not fully engage the scroll if they are extended too far.

DO NOT run your lathe in reverse.

KEEP PARTS NOT IN USE IN SAFE STORAGE, SMALL PARTS ARE EASILY LOST IN THE SHAVINGS

The Four Jaw Self Centring Chuck is a precisely made workholding device, which utilises the precision, simplicity and reliability of the engineering chuck. The purpose of this booklet is to show how it has been successfully adapted to enable you, the woodturner, to benefit from its great versatility in terms of gripping power, concentricity and capacity. maintenance is minimal, and the chuck, if it is used correctly, should give a lifetime of accurate and reliable service.

WARNING!! **MAXIMUM RUNNING SPEED 6000rpm**

Mounting the Chuck to the Backplate

The backplate is the bossed disc, internally threaded to suit the headstock of your lathe. It carries a register diameter which accurately locates in the rear face of the chuck body and ensures perfect concentricity. The chuck body is secured to the backplate with three M8 socket head cap screws. When fitting the backplate to the chuck, ensure that the register diameter is located fully and both chuck and backplate faces are together. A light tap with a soft faced hammer may be necessary to ensure full engagement. The securing screws should be tightened in stages with the 6mm hex key wrench provided.

The periphery of the blackplate carries 24 of 5mm diameter holes which may be used for indexing to provide accurate spacing for spokes? or decoration work, etc.
Our indexing arm (order no. 510217)

Mounting the Chuck to the Lathe

The chuck backplate is precisely machined to fit the headstock of your lathe and the chuck should screw firmly and fully into position. It may be necessary to restrain the headstock shaft whilst finally screwing the chuck home and a suitably sized paper washer placed on the headstock spindle will greatly assist chuck removal. Always ensure power to the lathe is off when fitting or removing the chuck and never fit or remove the chuck by running the lathe and holding the chuck, serious injury could result. To unscrew the chuck, the headstock shaft should be locked or restrained and the chuck key given a tug or a sharp tap with a soft hammer or a block of wood. Great care should be exercised when removing the chuck from the headstock as the sudden weight drop could cause damage or injury. If your lathe is reversible, care should be exercised - a lockable backplate is available if required.

Changing the Chuck Jaws...

When you receive your chuck it will be fitted with the accessory mounting jaws. (See fig A). To refit or change to other jaws proceed as follows. Using the chuck key provided, insert it into the pinion and wind in an anticlockwise direction until all four jaws are free and can be slid from the chuck body; when you remove these, note that the chuck jaw lugs have different lead distances from the nose to the first face of the lugs. (See fig B)

Fig A

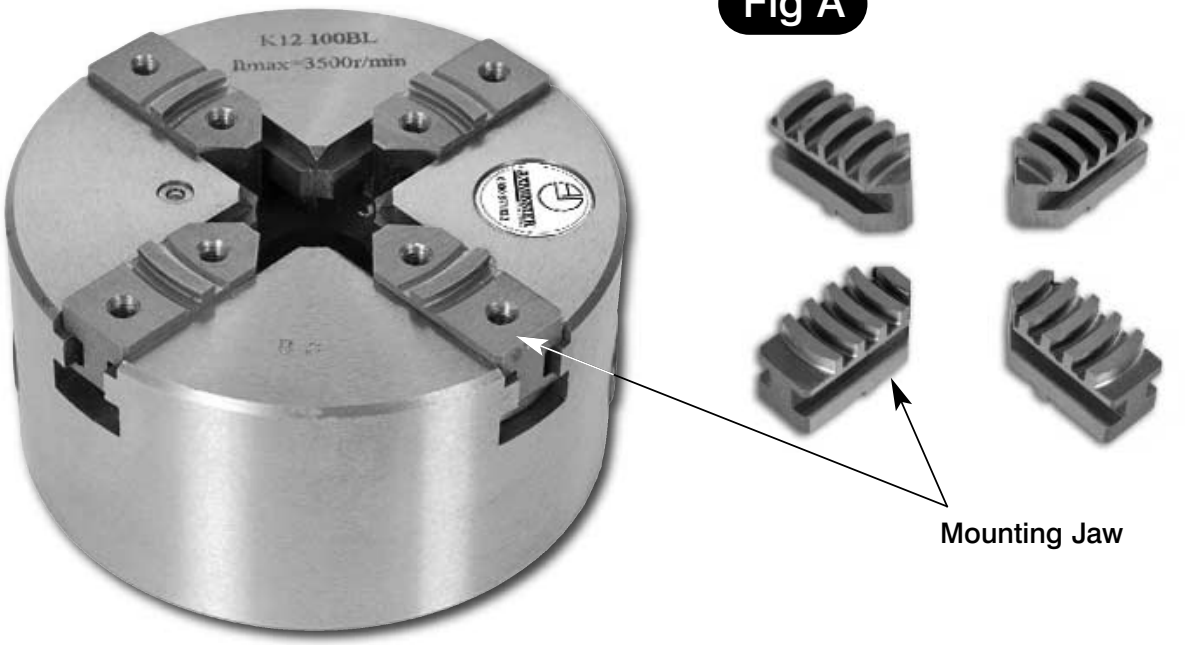
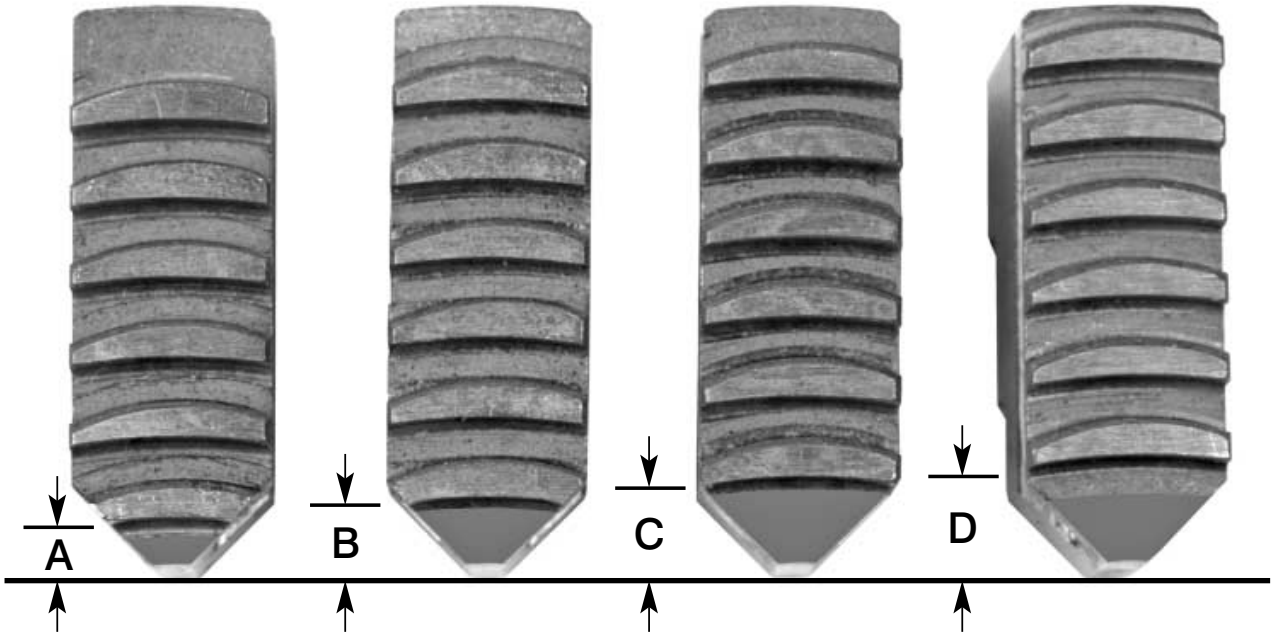


Fig B **Showing the Different Lead Distances of the Jaw Lugs**



Jaw A = Smallest Jaw D= Largest

A=1 B=2 C=3 D=4

NOTE: YOU CAN SELECT ANY OF THE FOUR RECESSES IN THE CHUCK TO INSERT THE FIRST JAW, MAKING SURE THAT YOU FIT THE REST IN SEQUENCE IN AN ANTICLOCKWISE DIRECTION.

Select the jaw (1) then rotate the chuck key clockwise until the outer end of the scroll is half way across the first recess (See figs 1,1a & 1b), then turn back until it's about to enter the recess. Insert jaw (1) and apply inward finger pressure to the jaw at the same time as turning the scroll forward again (See fig 2)(confirm the jaw has engaged in the scroll), continue to rotate the chuck key clockwise until the outer end of the scroll enters the second recess. Turn back the scroll as before and insert Jaw (2),apply finger pressure while turning the chuck key to move the scroll to the next recess (See figs 3 & 4) (confirm the jaw has engaged in the scroll), repeat until all the jaws are in place then close the jaws completely to confirm correct fitting. (See fig 7).

Fig 1

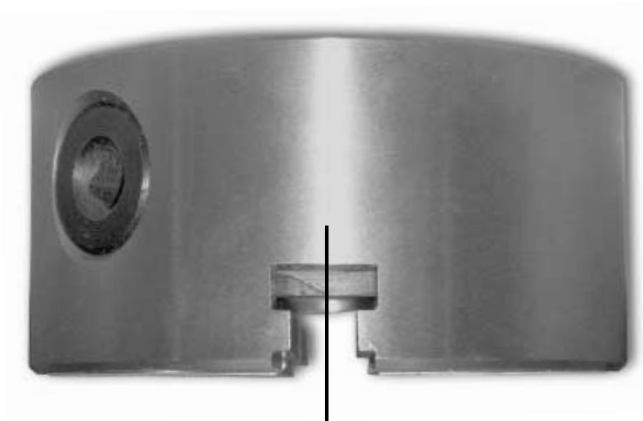
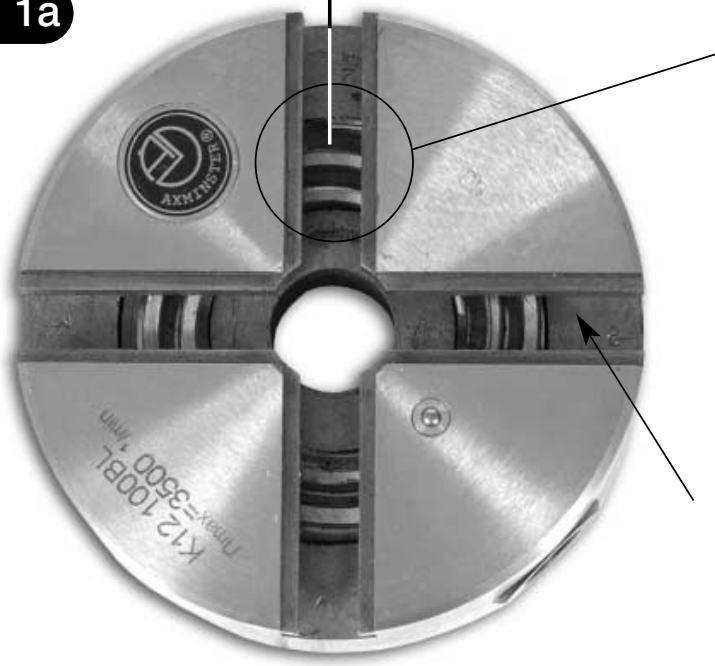


Fig 1b

Scroll

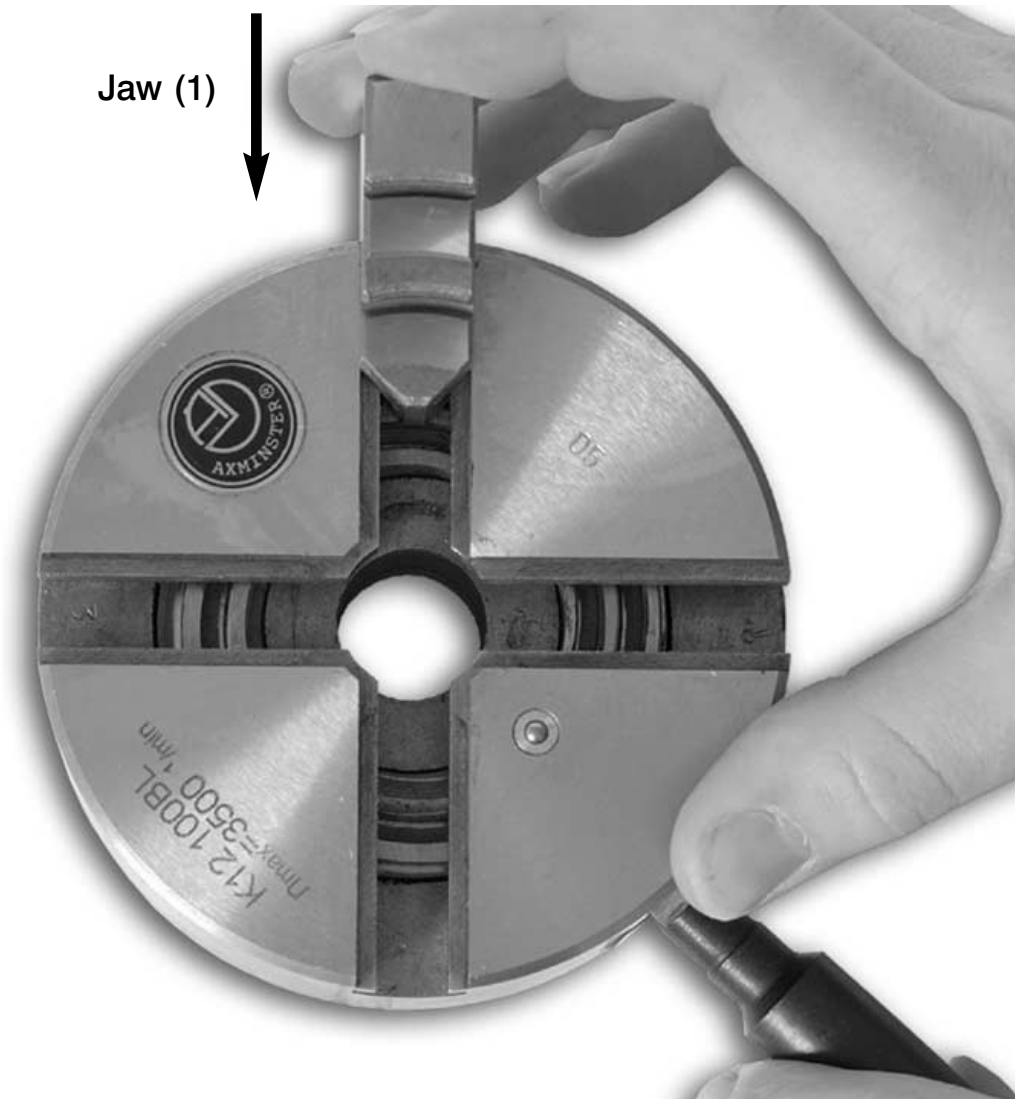
Fig 1a



Recess

Always install the jaws in an anticlockwise direction

Fig 2



Insert **jaw (1)** apply inward finger pressure to the jaw while turning the chuck key, check the jaw is engaged in the scroll.

Fig 3

Rotate the chuck key clockwise until the outer end of the scroll enters the second recess.

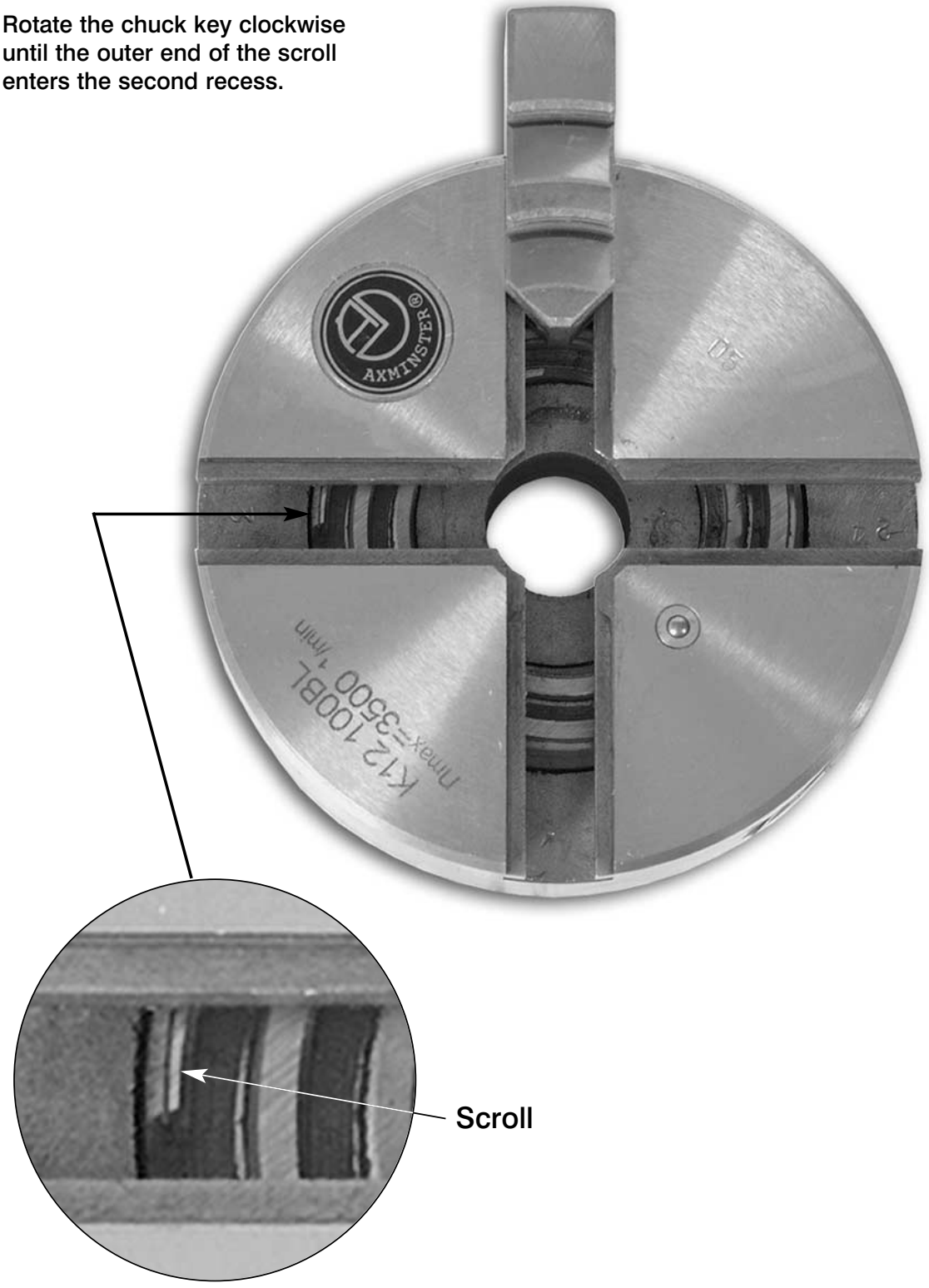
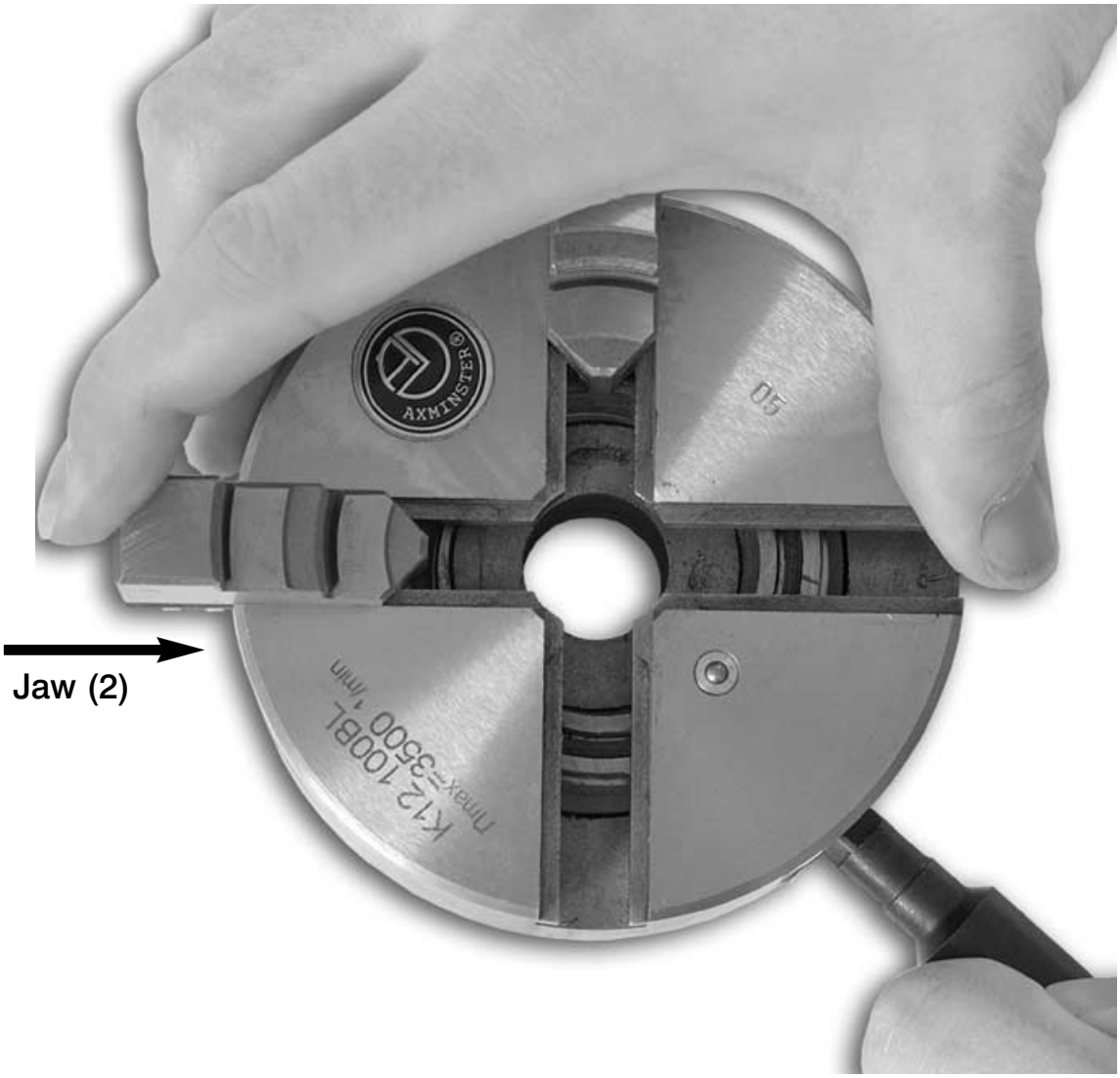


Fig 4



Turn back the scroll until its about to enter the second recess, then insert **jaw (2)** apply inward finger pressure, continue turning the chuck key until it reaches the third recess, check the jaw is engaged in the scroll.

Turn back the scroll as before then insert **jaw (3)** continue turning the chuck key to the fourth recess and install **jaw (4)**. When all jaws have been installed, turn the chuck key until the jaws are completely closed to confirm correct fitting. (See fig 7).

Fig 5

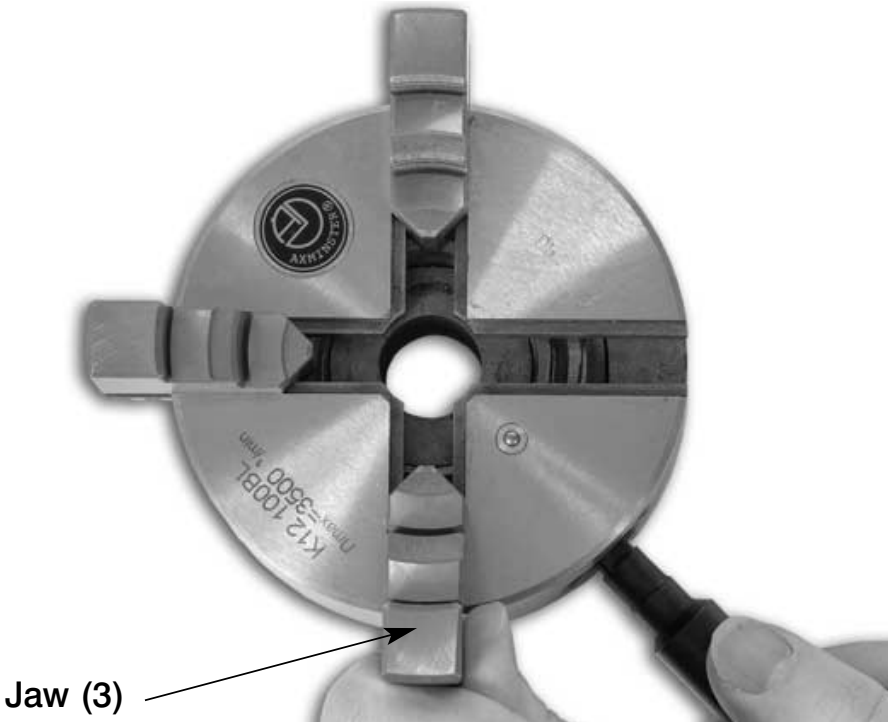
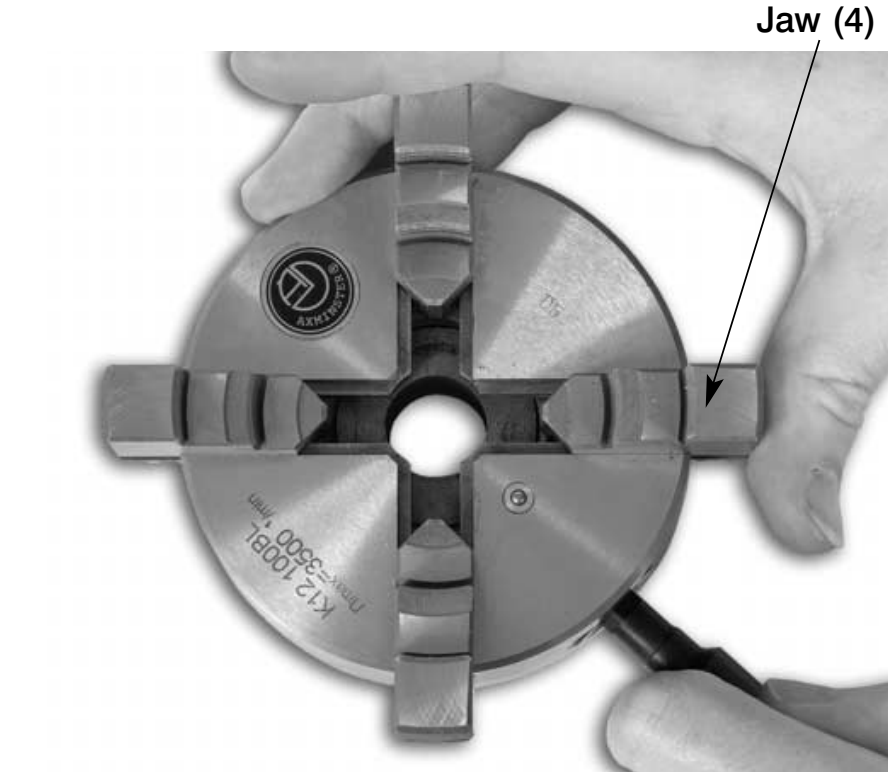


Fig 6



Close the jaws completely to confirm correct fitting.

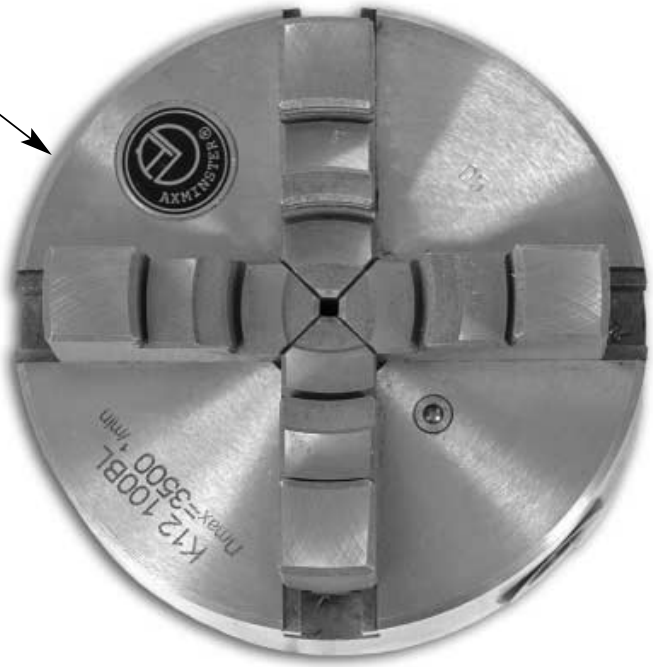
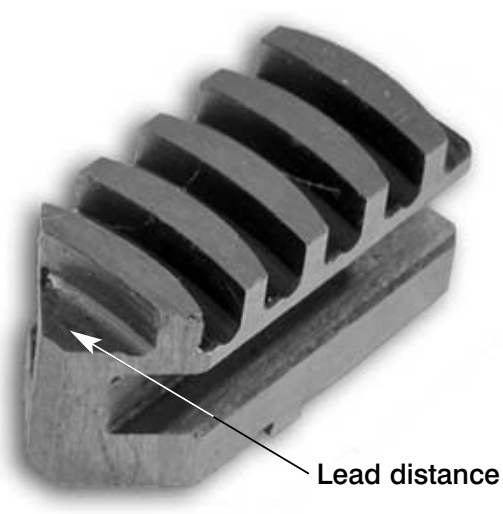


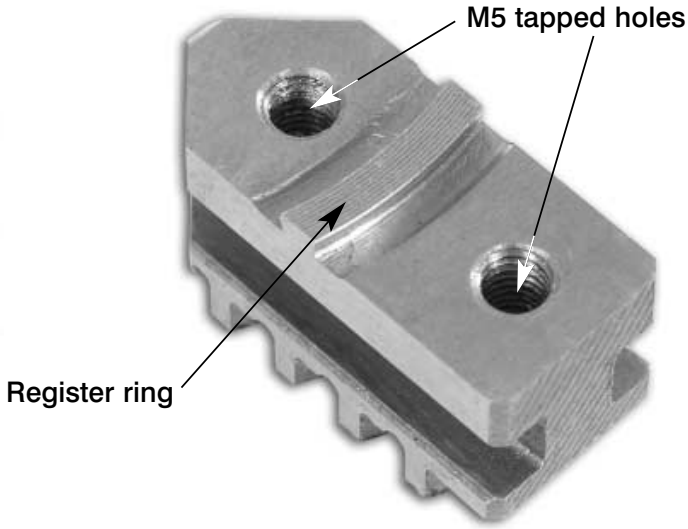
Fig 7

Accessory Mounting Jaws

These jaws have different lead distances exactly similar to the engineering jaws and are fitted in the same way as the internal & external jaws. The accessory mounting jaws carry a register ring and have two M5 tapped holes on the upper surface to locate & secure the accessory jaws.

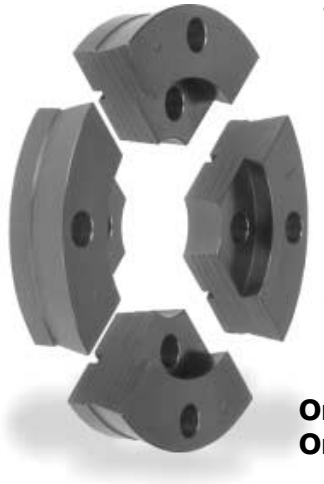
N.B When fitting any additional items to these accessory jaws leave the M5 securing screws approx; half a turn slack, firmly close the chuck, then finally tighten the screws, this will ensure correct alignment.



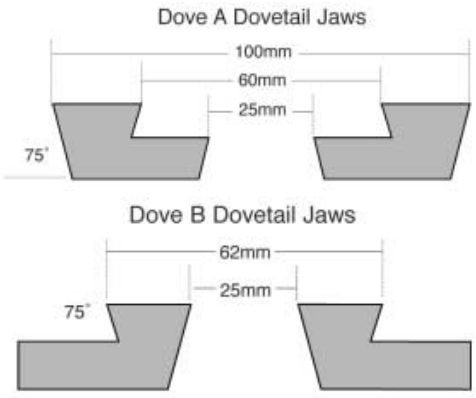


TYPE A&B **DOVETAIL JAWS**

MADE IN AXMINSTER



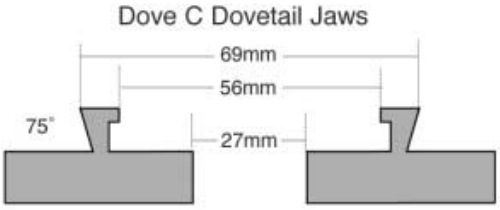
The A dovetail jaws are designed to expand into a 100mm recess and compress on to both 60mm and 25mm spigots. The B dovetail gives expansion into a 62mm recess and compression on a 25mm spigot.



Order no: 410158 Type A Jaws
Order no: 410159 Type B Jaws

MADE IN AXMINSTER

TYPE C **DOVETAIL JAWS**

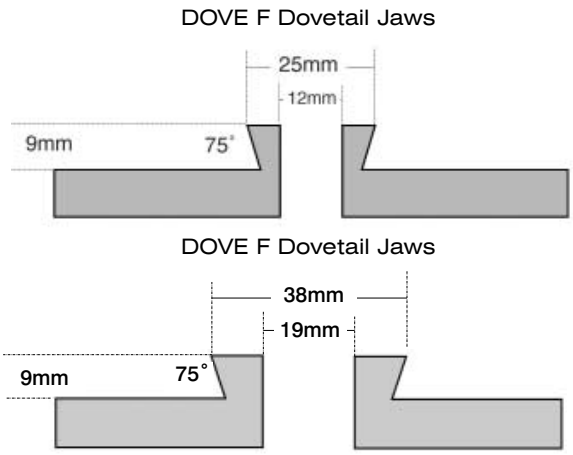


The C dovetail jaw expands into a 69mm recess and has a specially lipped internal grip onto a 56mm spigot especially designed for end grain work such as boxes and goblets.

Order no: 410161 Type C Jaws

DOVETAIL JAWS FOR SMALL WORK
(DOVE D & F)

These jaws for small work holding are dovetailed for gripping internally and have a plain bore for spigot holding. The two sizes of dovetail offered are 25mm and 38mm respectively at their optimum grip and 12mm and 19mm for their central bore.



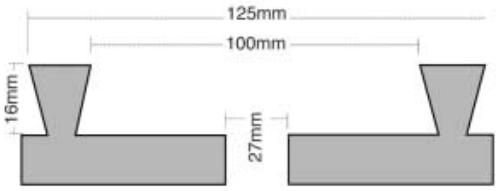
MADE IN AXMINSTER

Order no: 410164 Type D Jaw
Order no: 410167 Type F Jaw

TYPE M **MEGA JAWS**

MADE IN AXMINSTER

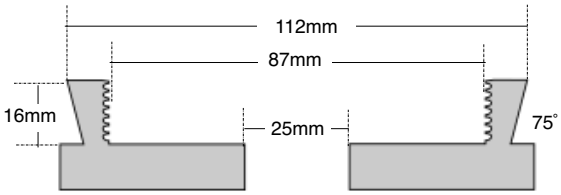
The external diameter is 125mm and the internal spigot will grip onto a 100mm diameter by 16mm spigot. These are the jaws to choose for large platters etc. and destined to be an all time favourite.



Order no: 410174 Mega Jaws

MADE IN AXMINSTER

AXMINSTER **LARGE GRIPPER JAWS**
(DOVE G)



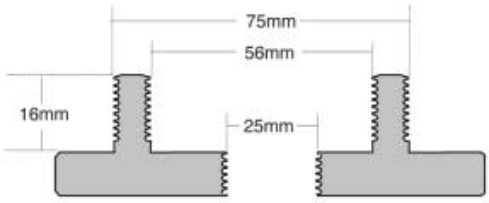
Specially designed to give a massive grip, particularly on large diameter parallel pieces. The type G gripper jaws have a large dovetail on the outside for turning large platters and bowls and a serrated grip on the inside specially designed to hold large hollow forms and end grain pieces.

Order no: 410168 Type G Jaw

TYPE H **MEDIUM GRIPPER JAWS**

MADE IN AXMINSTER

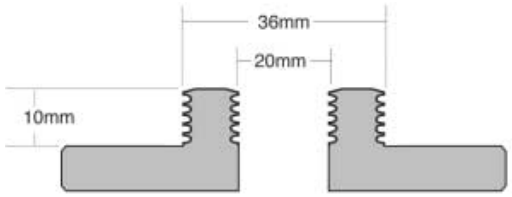
Similar to the Type G, these jaws provide excellent work holding especially for large diameter pieces. The main gripping surfaces are serrated on the internal and external walls and also on the central spigot grip.



Order no: 410170 Type H Jaw

MADE IN AXMINSTER

TYPE BF **SMALL GRIPPER JAWS**

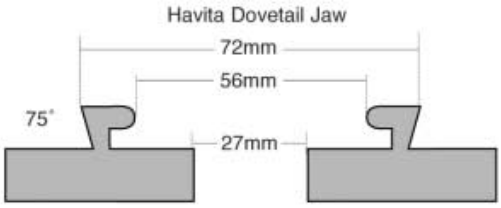


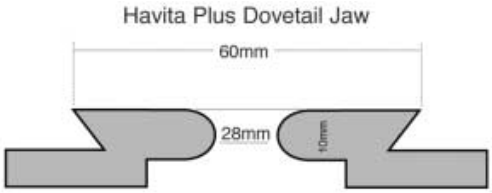
A development of the very successful type H three position gripper jaw, the BF offers the same power but for smaller diameters. Optimum sizes are 36mm externally and 20mm internally with the internal serrated grip extending for 30mm, giving unrivalled gripping power on spigots.

Order no: 410160 Type BF Small Gripper Set

HAVITA **DOVETAIL JAW**

The Havita jaws have a standard dovetail on the expansion side of the jaw with an optimum diameter of 72mm and a radiused grip on the inside. This enables the turner to produce a finished decorative spigot with a 6mm cove and hold this accurately and firmly without damage to the finished piece.



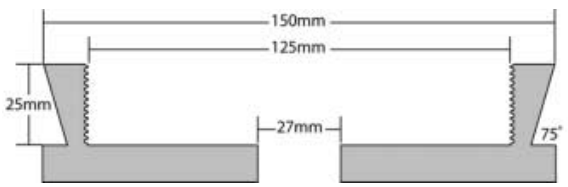


Order no: 410175 Havita Jaws
Order no: 410173 Havita Plus Jaws

MADE IN AXMINSTER

AXMINSTER **COLOSSUS 150mm GRIPPER JAWS**

For those of you who wish to turn very large hollow forms and big bowls and platters, we have introduced the Colossus Gripper Jaws. Based on the well established design of our very popular G type gripper jaws but offering a greatly increased work holding capacity for very large projects. The jaws will expand into a 150mm(6") dovetailed recess or grip onto a spigot of approximately 125mm(5") in diameter. Perfect for those large unseasoned logs you may want to turn into an *objet d'art.*



Order no: 210887 Colossus Gripper Jaws 6"

Woodturning Chuck Jaws...

100mm **WOOD JAW PLATES**

A set of pre-drilled steel quadrants onto which self-made wooden jaws can be mounted using woodscrews. The wooden jaws can be used for rechucking a bowl when removing a dovetailed recess or spigot, or for producing a variety of 'jam' chuck-type holding devices.

Order no: 910403 Wood Plate 100mm

MADE IN AXMINSTER

150mm **WOOD JAW PLATES**

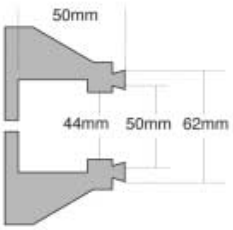
A larger version of the wood jaw plates giving scope for turning larger bowls. The greater diameter of the plates gives scope for larger wooden jaws which are less prone to distort under the tightening loads.

Order no: 910405 Wood Plate 150mm

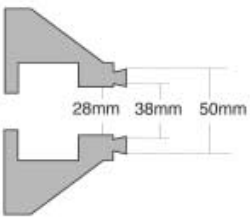
AXMINSTER **O'DONNELL SPIGOT JAWS**

Designed to give access around the jaws for close-in tool work. With a deep recess for holding long spigots and giving rock solid mounting when turning a long way from the headstock without tailstock support. The jaws are also dovetailed both inside and outside on the lip. Three sizes are produced - the size stated is the nominal bore of the spigot recess.

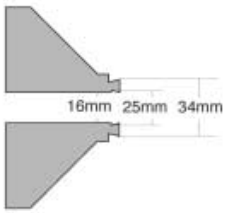
50mm O Donnell Jaws



38mm O Donnell Jaws



25mm O Donnell Jaws



Order no: 610356 25mm

Order no: 610357 38mm

Order no: 211354 50mm

MADE IN AXMINSTER

AXMINSTER **Spigot Jaws**

These second generation spigot jaws have been designed to give an improved grip when working with green wood. Similar in operation to a pin chuck, the spigot jaws are inserted into a 30mm diameter by 50mm deep hole in the blank and the jaws expanded into the hole. It is important to use the full depth of the jaws in order to give the best possible grip and to avoid over-stressing and damaging the jaws. Should the grip loosen during turning then another tweak on the key will soon restore it.

Order no: 810067 Spigot Jaws

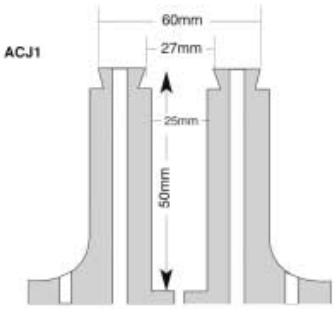
AXMINSTER **O'DONNELL JAW SET**
(Set of Three 25mm, 38mm,50mm)

MADE IN AXMINSTER

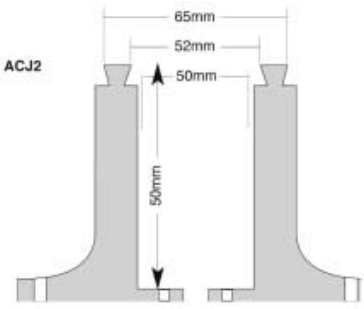
This is a great idea, a set of three O'Donnell jaws, spigotted together and secured with four screws, giving a range of three sizes, 25mm, 38mm or 50mm, by simply undoing the screws and sliding the inserts in or out. Our sincere thanks to the customer who suggested this idea. Supplied as a complete set of three jaw sizes with four allen cap head screws and a hex wrench. The jaws and inserts are now available separately so you might want to start with the 50mm jaws(211354) and add the inserts at a later date, but there is a price advantage if you buy them all together.

Order no: 718321 O'Donnell Jaw Set
Order no: 211328 25mm O'Donnell Jaw inserts
Order no: 211327 38mm O'Donnell Jaw inserts
Order no: 211354 50mm O'Donnell Jaws

310424



310425



CYLINDER **JAWS**

When turning long and thin projects it's a great advantage to be able to grip a blank along a substantial amount of its length to impart a good measure of stability to the workpiece. To overcome this problem we have designed a pair of cylindrical jaws, one with a 25mm diameter by 50mm long bore and the other with a 50mm diameter by 50mm long bore to accommodate a range of workpiece sizes. In addition, because we are always loath to provide you with jaws which perform only one function, we have added internal and external vetails on the ends.

MADE IN AXMINSTER

Order no: 310424 Cylinder Jaws 25mm
Order no: 310425 Cylinder Jaws 50mm

Woodturning Chuck Jaws...

AXMINSTER **BUTTON JAWS**

MADE IN AXMINSTER

These jaws use eight conical rubber buttons to securely pull back work onto the jaws. They are intended for use with bowls up to 9" in diameter. However, they may not be suitable for bowls with very thin edges as the pressure may deform the bowl edges.

The buttons are white rubber so as not to mark the workpiece and are "dovetailed" to hold the workpiece firmly against the plates.

Order no: 340956 Jaws 250mm
Order no: 340957 Jaws 400mm

Chuck Accessories...

AXMINSTER **MORSE TAPER CARRIERS**

Available in either 1 or 2 Morse taper, these carriers fit into the C chuck jaws and enable drive centres or arbors to be mounted without the need to remove the chuck from the lathe. You could, of course, purchase a carrier with a different taper from that of your lathe, thereby extending the range of usable centres.

Order no: 400019 1MT Carrier for C Jaws
Order no: 400020 2MT Carrier for C Jaws

MADE IN AXMINSTER

AXMINSTER **PIN CHUCK**

The pin chuck is a simple device which relies on the cam action of a pin rolling on a flat machined on the shaft to provide a secure grip for the workpiece. All that is required is a 25mm hole bored in the end of the timber; this is then slid onto the pin chuck with the pin in position on the flat and when the timber is rotated slightly the pin jams between the flat and the timber and locks it firmly in position on the chuck. The 5/8” diameter mounting shaft will fit in the nose of the accessory mounting jaws of the Super Precision, Woodturner’s or Clubman K10 chucks.

Order no: 800340 Pin Chuck 25mm

AXMINSTER **INDEXING ARM**

A universal, indexing arm for use with Axminster chucks, either the Super Precision with its indexing holes around the backplate or the Woodturner's chuck with the addition of the indexing ring (Order No. 510256). The base is secured to any convenient fixed object, preferably the lathe itself, so that the pin will drop conveniently and tangentially into the register holes on the rim of the chuck. The Axminster Indexing Arm is made from aluminium and anodised for protection, with a precision machined steel pin.

MADE IN AXMINSTER

Order no: 510217 Indexing Arm

MADE IN AXMINSTER

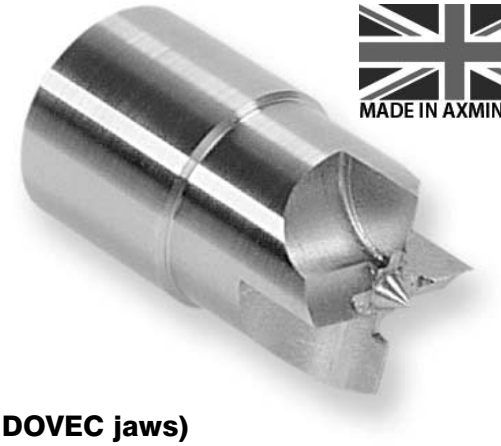
AXMINSTER **FACEPLATE RINGS**

Made to match the dovetail jaws, these rings do away with the need for a separate faceplate on which to mount a bowl blank prior to turning the outside. Simply screw the ring to the chosen blank with woodscrews and expand the dovetail jaws into the recess in the centre of the ring.

Order no: 500166 Faceplate Ring A Jaws
Order no: 500167 Faceplate Ring B Jaws
Order no: 500168 Faceplate Ring C Jaws
Order no: 500170 Faceplate Ring F Jaws

AXMINSTER **FOUR PRONG PARALLEL DRIVE CENTRE**

The Axminster four prong parallel drive centre has been designed to be used in the central bore of the C jaws fitted to the Carlton, Super Precision, Woodturner's and Clubman chucks. It has principally been produced for those lathes that do not have a hollow headstock, but can also be used for those combined jobs where spindle turning is necessary before mounting the workpiece in the chuck.



MADE IN AXMINSTER

Order no: 410052 Parallel Drive Centre (to suit DOVEC jaws)

Chuck Accessories...

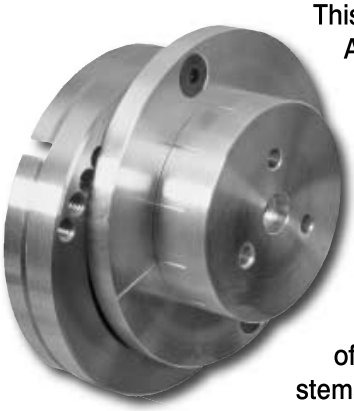
AXMINSTER **SCREW CHUCKS**

A replaceable stainless steel parallel screw mounted onto a boss which fits into either the 62mm recess of the A dovetails or the internal recess of the C dovetail jaws. Particularly useful for the initial mounting of bowl blanks whilst the outer form and the dovetail base are being shaped. Once this stage is completed the woodscrew chuck can be removed and the bowl mounted directly into the chuck jaws in a matter of seconds. Replacement screws, which are interchangeable, are available for all Axminster screw chucks and are listed below.

MADE IN AXMINSTER

Order no: 810383 (To Fit A Dovetail)
Order no: 810385 (To Fit C Dovetail)
Order no: 910458 Small Screw
Order no: 210886 Medium Screw
Order no: 910466 Large Screw

AXMINSTER **ECCENTRIC SPIRAL CHUCK**



This is a combination of the Axminster Eccentric Chuck (340152) and the Spiralling Attachment (340155) sold together with a price reduction over the two items sold separately. The chuck fits onto the C dovetail jaws and allows a variety of eccentric and spiralled stems to be produced. Full instructions from the designer, Tony Witham, are included.

MADE IN AXMINSTER

Order no: 900093

CHUCK **REMOVAL SPANNER**

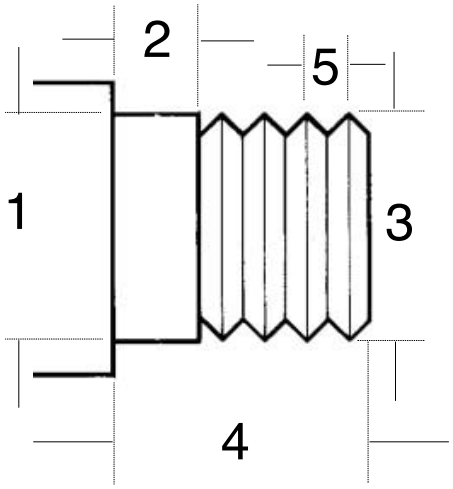
One important lesson for woodturners to learn is not to use the chuck key for removing the chuck from the headstock; doing this can damage the hole in the chuck as well as risking breaking the key. This C spanner has been specially produced for the 100mm Clubman, Goliath and previous model Woodturner's range of chucks. This should be classed as essential equipment for all users of these chucks.

Order no: 340220

Maintenance...

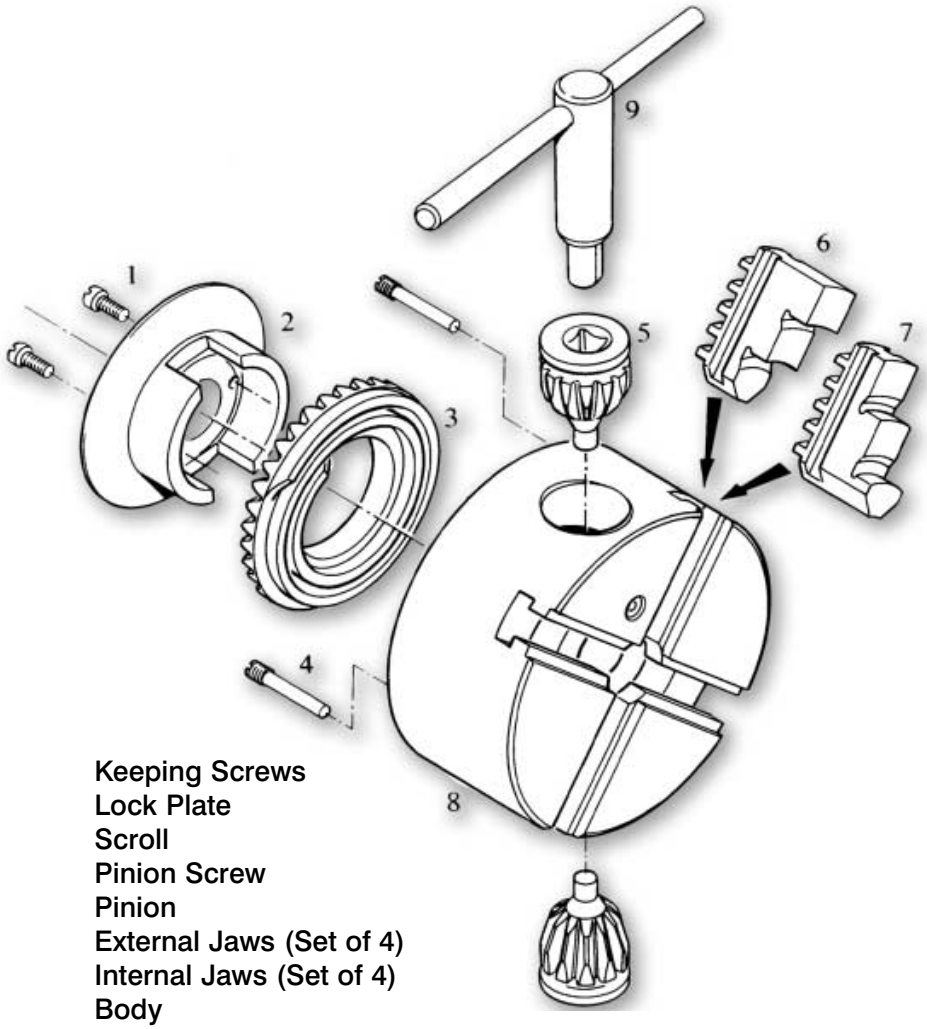
As mentioned on page seven, the four jaw chuck requires very little maintenance. In the event of the chuck requiring attention it will generally only be due to a build-up of dust it may be dismantled for cleaning with the aid of just a screwdriver. After cleaning, the chuck should be re-assembled adding a little dry lubricant or a smear of light machine oil. One component that may present difficulty is the refitting of the scroll ring, this item is a very precise fit and must be dropped on squarely. Do not attempt to drive the part on with a hammer or hard punch, but strike the front face of the chuck with a soft mallet or drop the chuck face down on to a firm surface.

Lathe Thread Information



This table lists all the stock thread types which can be used when ordering any of the threaded items, such as chucks, chuck backplates, faceplates and screw chucks, from the catalogue. If you are uncertain about which thread to specify please ring our Technical Department who will be pleased to help. They will need to know either the make of the lathe or the dimensions of the lathe spindle as shown in the diagram. The column heading numbers refer to the dimensions in the diagram as follows:

1. Register diameter.
2. Register length.
3. Thread diameter.
4. Combined length of thread and register.
5. Thread pitch, either threads per inch or thread pitch if metric.



Item No:	4” Part No.	
1	A891141	Keeping Screws
2	A891142	Lock Plate
3	A891143	Scroll
4	A891144	Pinion Screw
5	A891145	Pinion
6	SJEXT	External Jaws (Set of 4)
7	SJINT	Internal Jaws (Set of 4)
8	A891148	Body
9	A891149	Chuck Key (Std)
9A	LCK	Long Chuck Key

100247

Axminster Super Precision Woodturning Chuck

www.axminster.co.uk

FREEPHONE 0800 371822

Axminster Devon EX13 5PH UK

AXMINSTER TOOL CENTRE

Right Hand Threads

Thread Code	Thread Size	Lathe Type	1	2	3	4	Tpi/Pitch
T01	3/4" x 16tpi	Carbatec, Coronet, Record	3/4"	3/16"	3/4"	11/16"	16
T02	1 1/2" x 6tpi	NV28-40, Supalathe, Graduate	1 1/2"	3/8"	1 1/2"	1 1/8"	6
T03	1" x 12tpi	Myford ML8, Turnstyler	1 1/8"	3/8"	1"	1"	12
T04M	1" x 8tpi	APTC M Series Lathes, Delta	1"	1/4"	1"	1 1/8"	8
T06	1 1/2" x 8tpi	Powermatic	1 1/2"	3/8"	1 1/2"	1"	8
T23	1 1/4" x 8tpi	General 260	1 1/4"	1/8"	1 1/4"	1"	8
T37	30mm x 3.5mm	Minimax	30mm	18mm	30mm	40mm	3.5mm
T38	33mm x 3.5mm	Hegner, Kity, Konig, Jet 3520B,1642, 1442	34mm	16mm	33mm	30mm	3.5mm
T38W	33mm x 3.5mm	Woodfast,	33mm	6mm	33mm	29mm	3.5mm
T38PRO *	33mm x 3.5mm	4224 Professional, 3520A	33mm	4mm	33mm	37mm	3.5mm
T38V	Special Fitting	Vicmarc					
VB36	Special Fitting	VB36					

Please measure register diameter (1) to ensure the correct fitting

Right Hand/Left Hand Threads

Thread Code	Thread Size	Lathe Type	1	2	3	4	Tpi/Pitch
T02RL	1 1/2" x 6tpi	Harrison Graduate and APTC Woodfast Lathes to suit both sides of the headstock	1 1/2"	3/8"	1 1/2"	1 1/8"	6