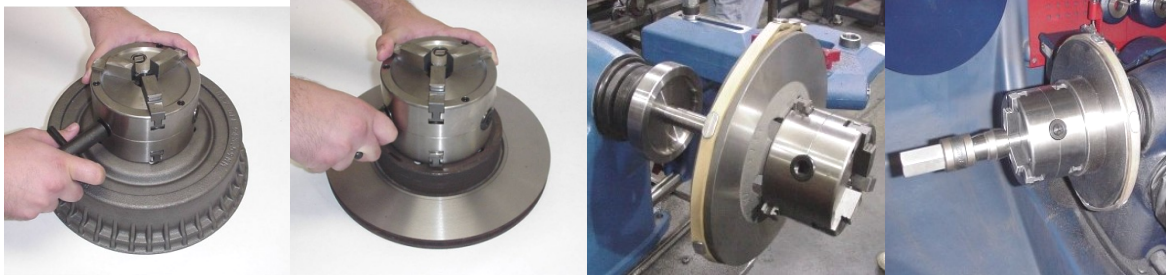




INSTRUCTIONS FOR THE QUICK CHUCK

1. Thoroughly clean the surface of the drum or rotor that will be mounted on the Double Chuck.
2. Place the hub-less drum or rotor on the flat clean surface. Install the Double Chuck by positioning the appropriate jaws in the center hole. Tighten the jaws by inserting the key in one of the slots in the side of the chuck turning counterclockwise. The Double Chuck will automatically center on the rotor or drum, make sure the jaws are tight. (Caution do not leave the key in the key slot when starting the brake lathe.)
3. Install the proper size backing plate onto the brake lathe arbor with the offset facing outward. Install the Double Chuck with the drum or rotor attached onto the 1" arbor using the necessary spacers supplied with the brake lathe out to the arbor threads. Using the adjusting nut supplied with the machine, tighten the nut against the spacers. After tightening the nut turn on the lathe to check for run-out on the rotor or drum. You are now ready to resurface.



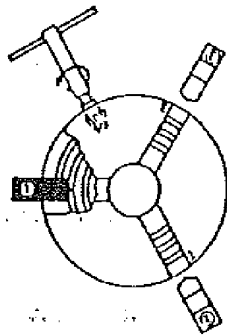
SPECIAL

NOTE: DOUBLE CHUCK Shown in Photos: The Quick Chuck will allow the turning of hub-less drums or rotors on any brand of brake lathe as long as it's equipped with a 1" arbor.

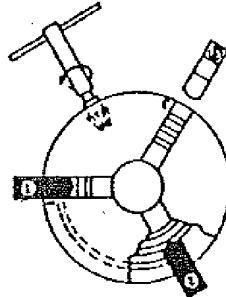
CAUTION: Always use the proper size backing plate. This will help eliminate the rotor or drum vibration while being turned. On some brake lathes a small spacer may be needed before the installation of the backing plate.

NOTE: The cleaning of the chuck is important. When the jaws have been removed to allow for cleaning of the chuck (the jaws are numbered on the side as 1, 2 and 3) it is VERY IMPORTANT that they be reinstalled in the same manor they were removed. To reinstall they must go in order 1, 2, and 3 counterclockwise. A slight amount of pressure may be required on each of the jaws to allow them to be reinstalled evenly and correctly.

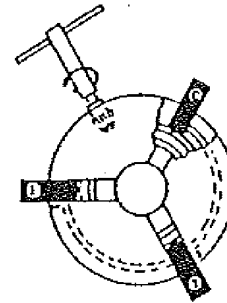
FIG#1, Steps in Mounting the Jaws



STEP 1. Enter jaw No. 1 in Slot No. 1 when scroll is in this position.



STEP 2. Enter Jaw No. 2 in Slot No. 2 when scroll is in this position.



STEP 3. Enter Jaw No. 3 in Slot No. 3 when scroll is in this position.