

Buck Chuck Compay
Jaws

METHODS OF FORMING CHUCK JAWS

Select jaws for maximum keyway engagement in body.

FOR O.D. GRIPPING - Pre-load jaws by gripping O.D. of thin wall ring. Use dowel pins in jaw bolt holes on top jaw style #7 or drill holes in solid jaw #5 for pre-load dowel pins. Pre-load pressure should be same as that used in gripping parts.

FOR I.D. GRIPPING – Use thin wall ring on chuck O.D. over jaw ends and grip on I.D. of ring for pre-load.

After turning or grinding jaws, check pre-load by gripping a round part wrapped with thin paper. Jaws should “print” heavier on surface farthest from chuck face. If jaws do not check properly, re-bore using heavier pre-load pressure.

FOR ALL CHUCKS WITH SOFT JAWS

If your chuck has master jaws with soft tops or solid soft jaws, be sure to align O.D. of chuck true before machining soft jaws. If you have several jobs using soft jaws or soft top jaws which have been hardened, they can be realigned in your chuck without returning or regrinding by making use of the adjusting screws.