

# Utility Grip™ 4-Jaw Lathe Chuck

## Product #CUG3418CC

*This heavy duty self-centering chuck will hold your work tight and secure on midi and full size woodworking lathes.*

### WARRANTY

Thank you for purchasing one of PSI's growing family of woodworking products. The CUG3418CC is engineered and manufactured to the highest standards of quality. You will find this product an essential accessory to your workshop.

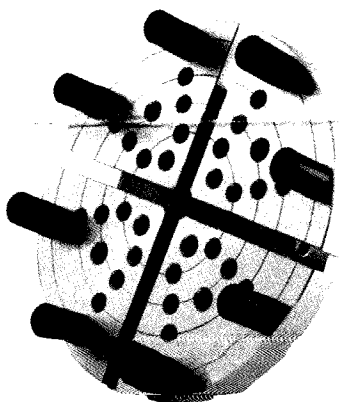
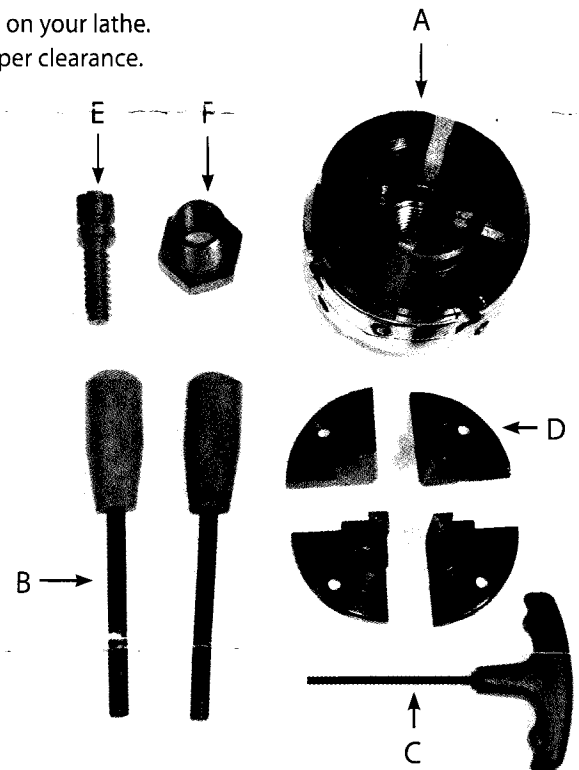
This product is warranted against defects in material and workmanship for a period of two years for all components. This warranty applies to the original purchaser of the product and is limited to the repair and/or replacement of the product, or its parts at the discretion of PSI Woodworking Products. Excluded are parts which have been misused, abused, altered, or consumed by normal operation of the chuck. Also excluded are direct or consequential damages to persons, properties, or materials. Your invoice serves as proof of purchase and must be referenced to authorize any warranty repair. Call your PSI dealer for proper authorization.

### Safety Instructions for the CUG3418CC Chuck

1. Do not wear gloves or loose clothing when turning
2. Do not wrap any strip-sandpaper or cloth around your hands or fingers while sanding or turning.
3. Use proper eye protection when turning.
4. Check your wood for splits, weakness, or cracking prior to mounting on the chuck.
5. Confirm that the wood is tightly gripped by the chuck before turning on your lathe.
6. Rotate the chuck manually prior to starting your lathe to confirm proper clearance.
7. Always check and re-tighten after any problem or catch.
8. Use appropriate speeds as referenced in instructions.
9. Always turn with sharp lathe chisels.
10. Capture fine particles from the air with a dust collector.

### Package Contents

- A. Chuck body with #2 jaws mounted with 8 socket head cap screws with 1" x 8" tpi mount.
- B. Tightening levers (2 each)
- C. Allen wrench
- D. 1 set (4 pieces) of #1 step jaws
- E. Screw chuck
- F. 3/4" x 16tpi adapter



### Optional Jaws

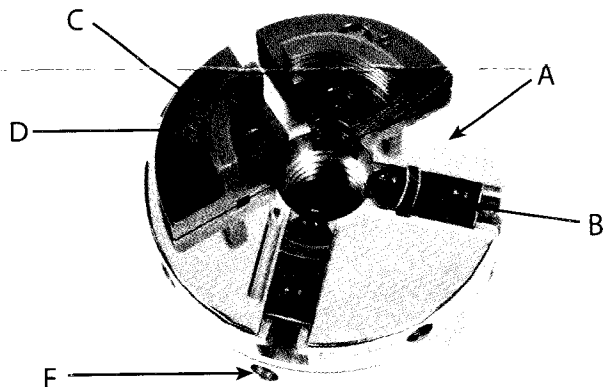
- 1. CFJAWFJ2- 8" Jumbo Flat Jaws

### Jaw Capacity Chart

Jaw Style	Gripping Dowel Internal Diameter	Gripping in Hole External Diameter
#1 Jaws	11/16" to 3-3/8"	0" to 1-7/8"
#2 Jaws	2" to 3-7/8"	1-1/2" to 3-3/8"

### Chuck System Description

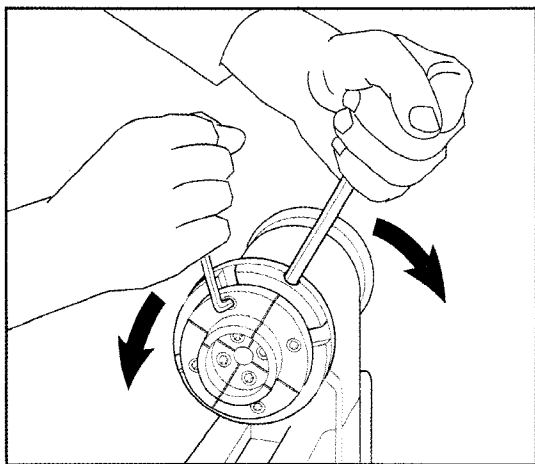
- A. Main body: designed to hold all jaws as an assembly.
- B. Carrier: to which the top jaws are each attached.
- C. Jaws: attached to the carrier, used for gripping the wood piece to be turned (#2 round jaws are shown in the photograph below).
- D. Socket head screws: attach jaws to chuck (2 per jaw).
- E. Lever tightening holes: insert and turn tightening levers to secure grip



(Shown with two #2 round jaws installed)

### Initial Jaw Removal

To remove jaws, mount the chuck on lathe. Loosen socket head screws using the tightening bar and the Allen wrench for maximum torque. See drawing below.



### Installing the Jaws

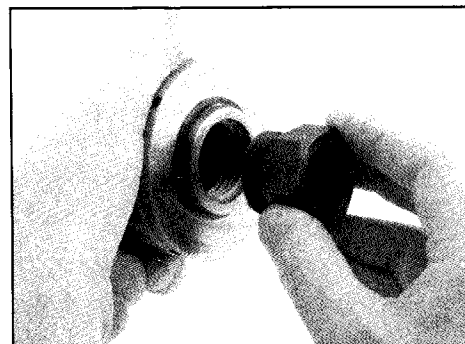
Select the appropriate jaw for your project. Place the selected jaw on top of the carrier, matching the number stamped on the main body to the number on each individual jaw. Using the provided hex socket head screws, hand tighten the jaws onto the chuck. Mount the chuck onto your lathe. Using the Allen wrench and tightening bar, firmly tighten the jaws down onto the surface of the carrier. See drawing above.

### Maintenance

Brushing is all that is needed to clean your chuck. If the chuck becomes sticky, soak in varsol or mineral spirits with 10% oil added. Soak for thirty minutes and blow dry.

### Mounting the Adapter

1. Wipe the inside of the threads and the outside of the adapter to insure both surfaces are clean.
2. Select the appropriate adapter for your lathe, 3/4"-16tpi adapter or 1"-8tpi adapter (pre-mounted).
3. Hold the chuck in your hand, screw and tighten



### Mounting the Chuck to Your Lathe

Screw the completed assembly onto your lathe. The chuck should go on effortlessly with no binding. Screw the chuck all the way until the adapter face contacts the shoulder of the lathe spindle. Lock the spindle, slightly unscrew the chuck and give it a firm turn. This will lock the chuck firmly into place.

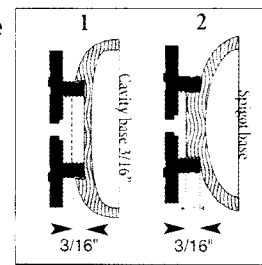
### Operating the Chuck

Your chuck has two movable discs. Each disc has 4 holes to accommodate the tightening levers. Insert a tightening lever into one of the holes on each level. Rotate the tightening levers away or toward each other to close or open the chuck.

### Chuck Gripping Depth

When turning a bowl, for safety reasons, allow a minimum amount of wood for the chuck to grab while turning.

1. Cavity base (inside grip) – for a 2" diameter base, minimum hole depth is 3/16".
2. Spigot base (outside grip) – for a 2" diameter base minimum grip is 3/16".



### Lathe Speeds

Turning: 500-1500 RPM  
 Sanding & Polishing: 1500-2500 RPM  
 Make sure your wood is properly aligned and balanced when mounted or re-mounted. Use slower speeds for larger work.

