

## THE PROCEDURE FOR REMOVAL & RE-FITTING OF CENTRE LATHE CHUCKS

No	TASK	TICK BOX ON COMPLETION OF EACH TASK	YES	NO
1	Isolate the machine			
2	Lay a piece of wooden board on the bed under the spindle			
3	Place a lifting rod in the chuck and clamp			
4	Place the machine in neutral so that the spindle rotates easily by hand			
5	Select the correct size key to release the cam-locks			
6	Undo all the cam-locks by turning them anticlockwise until the location marks line up			
7	Using a hide mallet gently tap the chuck free from the taper whilst holding onto the rod			
8	Lower the chuck onto the wood then place the chuck in a safe and secure position.			
9	Clean the spindle nose removing any swarf or debris			
10	Select the - Chuck , Collet, Faceplate, Drive plate required for the task			
11	Place a lifting rod into the chuck and tighten			
12	Lift the chuck onto the wood using the rod			
13	Clean the location faces & taper ensuring they are free from swarf & debris			
14	Place the rod down the spindle and lever the chuck into position ensuring the alignment marks on the chuck and the spindle meet			
15	Evenly tighten the cam-locks by turning clockwise- when fully tightened the marks must be positioned between the vee's			
16	Remove the wooden plate & lifting rod and store safely			