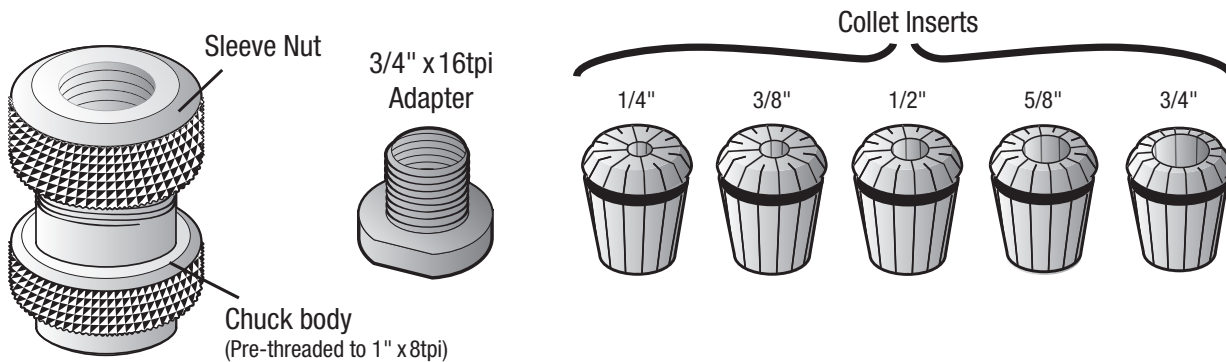


## PSI Collet Chucking System



### System includes:

- Collet chuck body pre-threaded for 1" x 8tpi headstock
- Chuck adapter for 3/4" x 16tpi headstock
- 5 collet inserts 1/4", 3/8", 1/2", 5/8" and 3/4"

### General Operating Instructions

- Thread the adapter into the body of the chuck if required.
- Thread the chuck body on to the headstock of the lathe.
- The system includes 5 different size collets to grip dowels and tenons.
- **This product does not assemble like any other compression type fitting. The selected collet must be assembled to the sleeve nut prior to screwing onto the chuck body. The collet will "SNAP" into place when correctly assembled.**
- Insert the dowel or tenon of your work piece into the collet; and tighten the sleeve nut down on it. You are now ready to turn with the collet chucking system.
- Insert the dowel into the opening at the collet, tighten the sleeve nut. Ideally, the nut sleeve surface should be flat with the surface of the collet for maximum support of the work piece.

Note: If the collet is jammed inside the body, pull on the groove at the top of the collet to release it (see Figure 1).

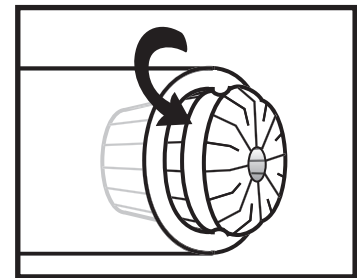


Fig. 1 Use the groove on the collet to remove.