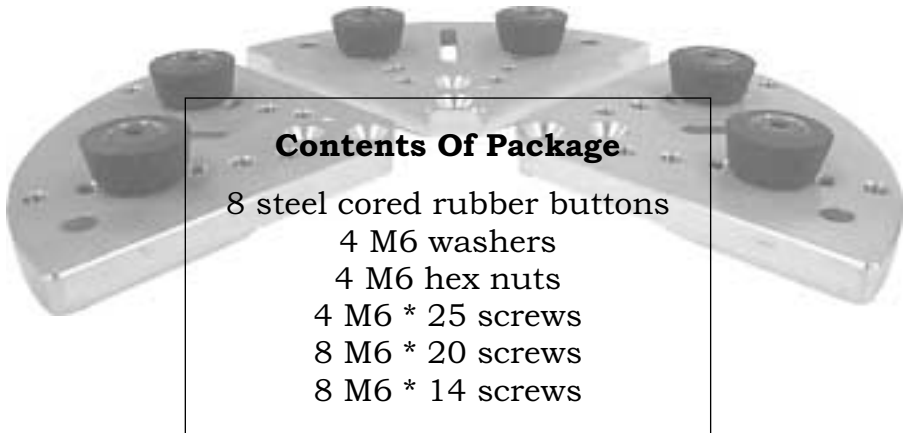


JUMBO JAW (22754, 31246, 31662)

INSTRUCTIONS

Jumbo Jaws are used to do light finishing on the bottom of plates, bowls, picture frames etc.. The rubber buttons can be mounted directly onto the chuck or onto the Jumbo Jaws allowing you to hold any item from 1/2" diameter up to 10-1/2" dia. if you have purchased 12" Jumbo Jaws or 15" dia. if you have purchased Mega Jumbo Jaws for a STRONG-HOLD chuck, if held on the inside of the rim.



Using Your Jumbo Jaws

The following pages show suggested set ups for holding various parts to be turned. Please note that items with outflowing lines should be gripped on the outside of the piece, while items with turned in rims should be gripped on the inside of the piece. Always hold on the outside diameter if in doubt as to which is best.

Note: Do not use a power screw driver to put the screws into the jumbo jaws. This can result in cross threading which will ruin the jaws.

Jumbo JAWS

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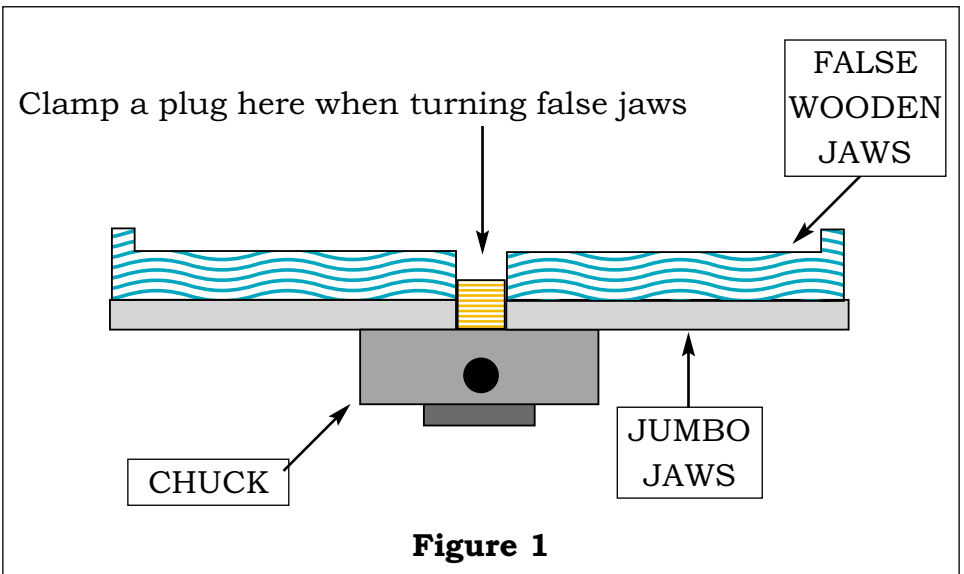
Recommended Speeds:

Your Jumbo Jaws are made from high strength aluminum plate and will not bend or break under normal use. We suggest however that the base jaws, scroll, teeth, screws and the wooden bowls or plates are the limiting factors for the speed you can use. We recommend holding your lathe speed under 1250 RPM for small bowls, under 900 RPM for large bowls, and slower for over 12" bowls.

Figure 1 represents false wooden jaws that can be mounted onto your Jumbo Jaws.

Important: When making false jaws, please **DO NOT** use the plates as a drill jig as the threads may be damaged.

Mark your hole locations with a suitable punch or pencil. For false jaws, we recommend that to prevent accidents you use only high grade plywood.

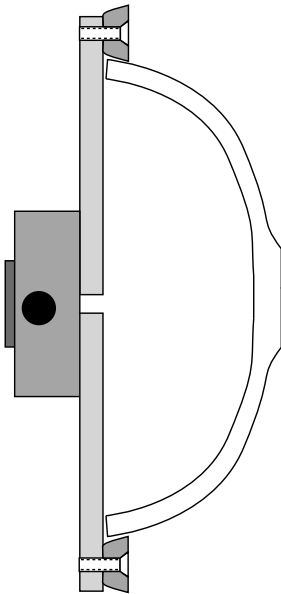


Jumbo JAWS

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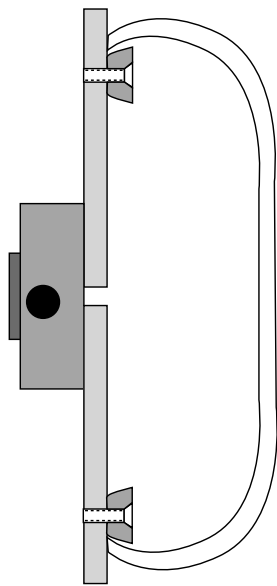
Figure 2A and 2B

Shown in Figure 2A and 2B are the rubber buttons mounted to the Jumbo Jaws for turning larger objects. Install the plates on the base jaws with 8 standard M6 * 14 screws. Mount the buttons on the plates at the required diameter with the M6 * 20 screws. Figure 2A shows an outflowing bowl being held on the outside of the piece. Maximum and minimum diameters that can be held will vary depending on which chuck and jaws you have purchased. Refer to the capacity chart on page 7 for these numbers. Please note that no washers or nuts are required for this set up.



- Shown are rubber buttons mounted to the Jumbo Jaws which are mounted to the chuck
- an outflowing bowl is shown being gripped on the outside

Figure 2A



- Shown are rubber buttons mounted to the Jumbo Jaws which are mounted to the chuck
- an inflowing bowl is shown being gripped on the inside

Figure 2B

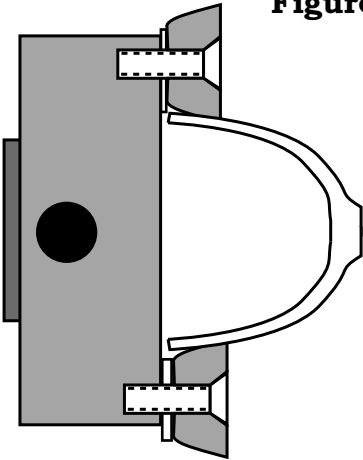
Jumbo JAWS

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Figure 3A and 3B

Figure 3A and 3B depict the rubber buttons mounted directly to your base jaws for turning very small objects. In this set up **a washer must be placed under the buttons** to prevent the 20 mm screws from bottoming out and causing the buttons to be loose and screw thread damage to occur.

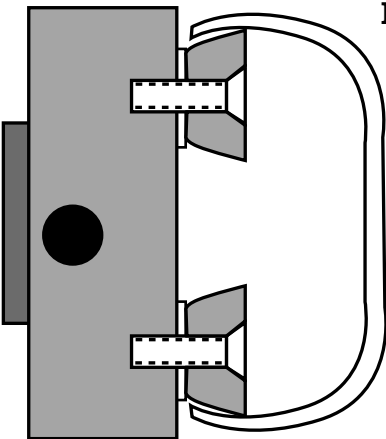
Figure 3A



Here we show how you can hold objects with a minimum diameter of $3/8$ " with the buttons mounted on the inside holes and up to a maximum diameter of 3" with the buttons mounted on the outside holes.

DO NOT exceed these diameters under any circumstances.

Figure 3B

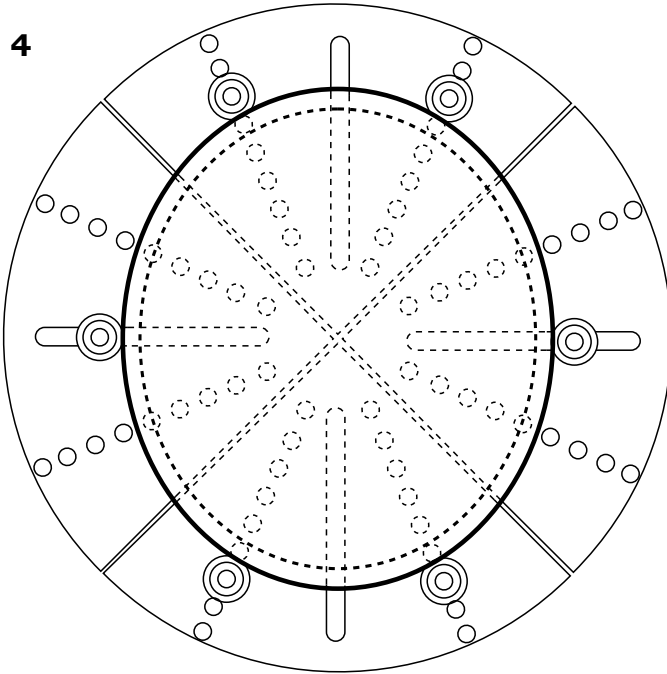


This is how a bowl or similar item with an inner diameter of up to $3-5/8$ " can be held.

Jumbo JAWS

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Figure 4



Screw Hole Mounted Buttons:

- M6 * 20 screw
- rubber button

Slot Mounted Buttons:

- M6 * 25 screw
- M6 nut
- washer
- rubber button

Figure 4 shows an out of round bowl mounted on the Jumbo Jaws by utilizing the slots and screw holes. This figure demonstrates the most stable method of using the buttons to grip an out of round bowl. Four screw hole and two slot mounted buttons are used. You may use four slot mounted buttons, but your stability will be compromised. Screw hole mounted buttons use an M6 * 20 screw, and slot mounted buttons use an M6 * 25 screw, washer and nut.

Jumbo JAWS

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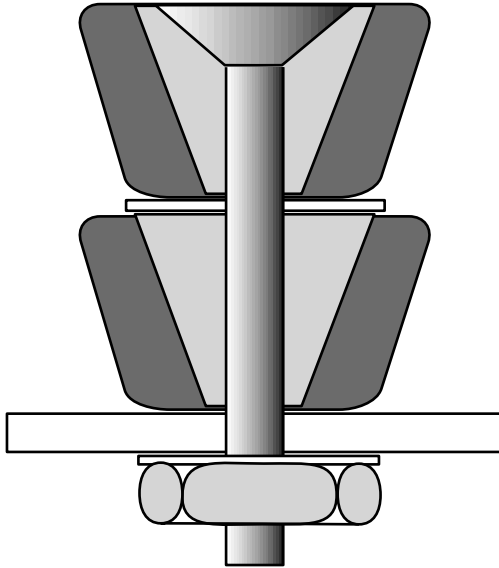


Figure 5

Available are optional extra button sets which can be stacked to hold parts with larger radius rims where the height of standard buttons may not be sufficient. Make your set up as with single buttons, except use M6 * 35 screws, 2 buttons and a washer for space. Refer to figure 5 to the left for an illustration of this set-up.

Jumbo JAWS

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ONEWAY Manufacturing Limits Jumbo Jaws

Current production Jaw plates are machined from aluminum bar made to mill limits. Bow up to 1/16" may be present and considered acceptable. All machine tolerances are +/- 0.005". With the Jumbo Jaws mounted on your chuck and chucking a 3/4" dowel with the jaws closed radial runout will be +/- 0.005" or less. There will be runout on the faces as to back and forth movement (tailstock to headstock) and sideways or radial movement caused by the required clearance of the base jaws.

Expect maximum values at periphery of the jaws closed, but not gripping, back and forth and sideways maximum total 0.085". Mis-alignment of jaw face to face in relaxed position 0.060".

CAPACITY CHART

Jumbo Jaws for ONEWAY Chuck

external chucking	2-3/4"	10-1/2"
internal chucking	4-3/4"	11-1/2"

Jumbo Jaws for STRONGHOLD Chuck

external chucking	2-3/4"	10-3/4"
internal chucking	4-3/4"	12"

Mega Jumbo Jaws

external chucking	2-3/4"	14"
internal chucking	4-3/4"	15"

OTHER RELATED ONEWAY PRODUCTS

Scroll Chuck

- » Oneway, Talon, & Stronghold



Scroll Chucks - Body Only Packages

- » Oneway, Talon, & Stronghold

A must if you're sick and tired of swapping your top jaws on your chuck.



Extra Button Set

- » By using an extra button set, it is possible to stack buttons which further accommodates odd shapes.

ONEWAY Manufacturing

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1-800-565-7288

For more information on this or any other ONEWAY product,
visit our website

www.oneway.on.ca

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