



INTRODUCTION

Your new Keyless Drill Press Chuck will hold drill bits with shanks from 1/32" to 5/8" diameter. It mounts to the Quill Spindle of the Headstock with a setscrew, just like the standard Jacobs chuck. This Keyless Chuck can be used in either the Vertical Drill Press or the Horizontal Boring mode of the machine.

ASSEMBLY

To secure a drill bit in the Keyless Chuck, simply hold the top ring of the Chuck and rotate the outer body. With this motion you can either loosen or lock the jaws of the Chuck on your drill bit. Turning the Chuck body also rotates the jaws of the Chuck. To mount a tool with flats on the shank, you will want the jaws to hold stationary while adjusting. To do this, simply hold the body of the chuck and rotate the top ring as you tighten the chuck jaws on the shank of the bit.



PARTS LIST

Ref No.	Part No.	Item Description	Qty
1	522927	Keyless Chuck and Arbor	1
2	222458	5/16-18 x 1/4" Flat Point Setscrew ..	1

NOTE

If you have any questions, please call our Customer Service Department Toll Free 800-762-7555 or drop us an E-mail at techsupport@shopsmith.com. Visit our Website at www.shopsmith.com

