

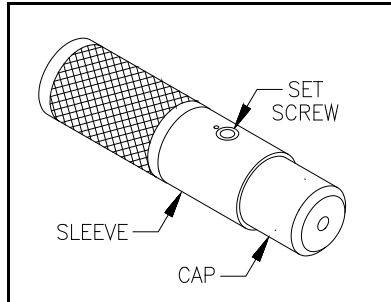
USER'S MANUAL for PRECISION CHUCK

Products No. P011 and P012

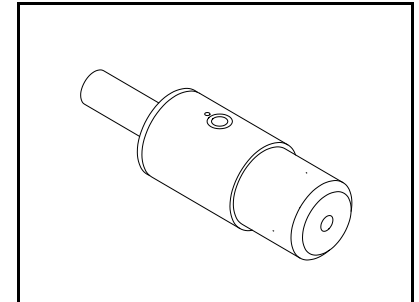
1.0 OVERVIEW

The WELLS PRECISION CHUCK is designed to hold 3/32" shanked burrs. It allows quick tool changes while the lathe is running.

P011 PRECISION CHUCK 3/8 TAPER fits a standard 3/8" jeweler's taper shaft.
 P012 PRECISION CHUCK 1/4 SHAFT fits any chuck that accepts a 1/4" shaft.



**Figure 1. Product No. P011
 PRECISION CHUCK 3/8 TAPER**



**Figure 2. Product No. P012
 PRECISION CHUCK 1/4 SHAFT**

2.0 OPERATION

With the lathe running, clasp the sleeve between the thumb and forefinger to open the chuck. Remove or insert the burr.

3.0 MONTHLY MAINTENANCE

- 3.1 With the rollers and cap in place, remove the set screw with a 3/32 hex wrench.
- 3.2 Put a small drop oil into the hole and put the set screw back to its original position flush with the surface of the sleeve. **Do not tighten the set screw below the surface of the sleeve.**
- 3.3 With the set screw in place, remove the Precision Chuck from the lathe and unscrew the cap.
- 3.4 Turn the sleeve clockwise and shake out the rollers.
- 3.5 The rollers should be kept clean and dry. Clean them in solvent and dry thoroughly.
- 3.6 While holding the sleeve to the clockwise position, put the rollers back into the base and screw on the cap.

4.0 TROUBLE-SHOOTING

- 4.1 If the sleeve does not return smoothly, the Precision Chuck should be disassembled and cleaned.
- 4.2 If the tool slips, make sure the rollers are clean and dry. If the tool still slips, replace the rollers with new ones.

5.0 DISASSEMBLY AND CLEANING (See the Parts List on the reverse side of this sheet.)

- 5.1 Remove the Precision Chuck from the lathe, remove the set screw and the cap.
- 5.2 Turn the sleeve clockwise and shake out the rollers.
- 5.3 Pull out the sleeve 1/4". With a penknife, lift the end of the spring from the hole in the base.
- 5.4 Remove the sleeve and spring taking care not to damage the spring.
- 5.5 With a penknife, carefully remove the spring from the sleeve.
- 5.6 Clean all parts in solvent and dry thoroughly.

6.0 ASSEMBLY (See the Parts List on the reverse side of this sheet.)

- 6.1 Insert the end of the spring into the small hole in the sleeve.
- 6.2 Work the sleeve and spring over the base and insert the other end of the spring into the hole in the base.
- 6.3 Turn the sleeve clockwise until the spring tightens and the slot in the base is in line with the set screw hole. Put in the set screw.
- 6.4 While holding the sleeve to the clockwise position, put the rollers back into the base and screw on the cap.
- 6.5 With the rollers and cap in place, remove the set screw and put a small drop oil into the hole. Put the set screw back to its original position flush with the surface of the sleeve. **Do not tighten the set screw below the surface of the sleeve.**

WELLS

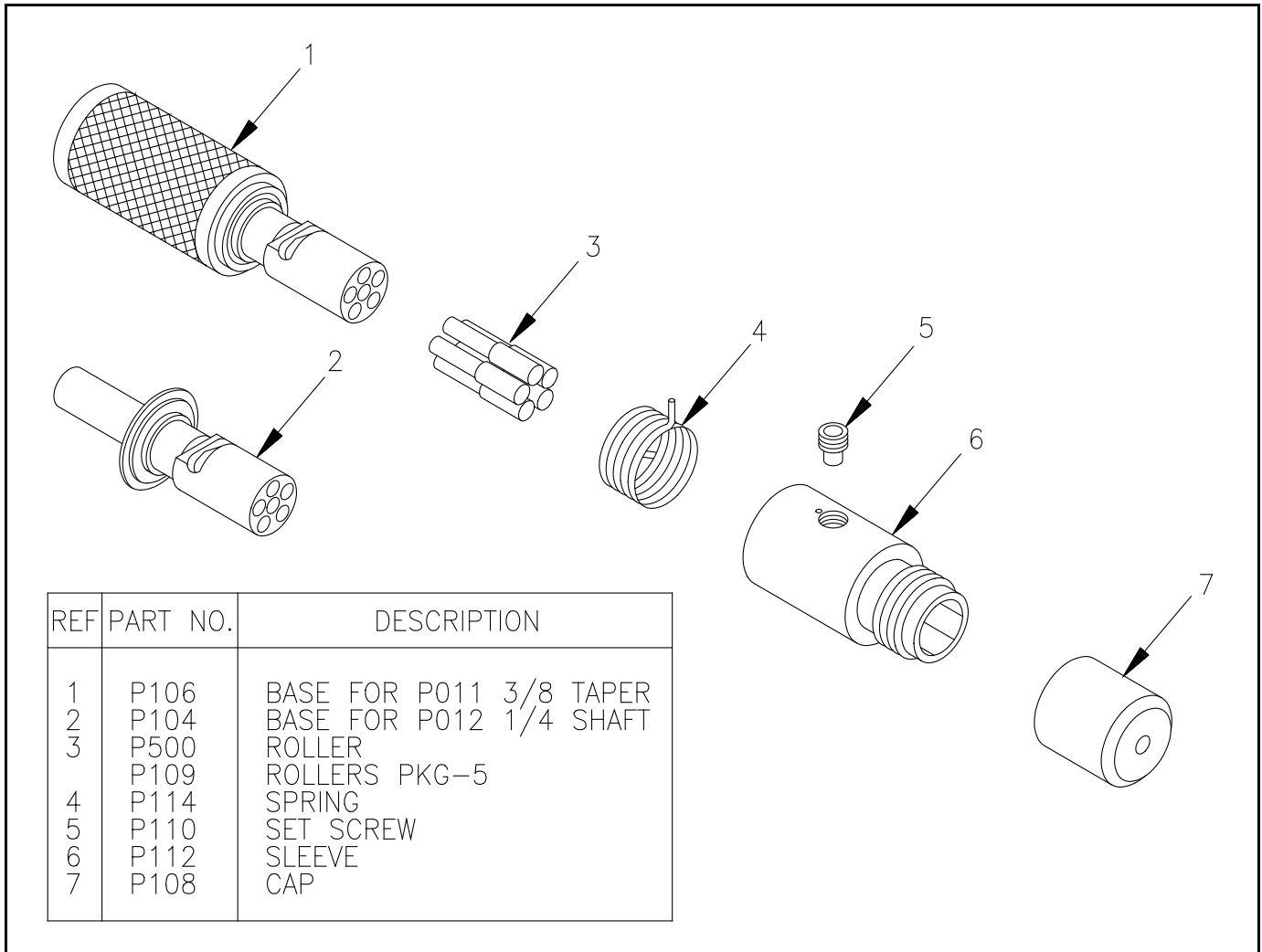
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PARTS LIST

PRECISION CHUCK 3/8 TAPER
Product No. P011

PRECISION CHUCK 1/4 SHAFT
Product No. P012



REF	PART NO.	DESCRIPTION
1	P106	BASE FOR P011 3/8 TAPER
2	P104	BASE FOR P012 1/4 SHAFT
3	P500	ROLLER
	P109	ROLLERS PKG-5
4	P114	SPRING
5	P110	SET SCREW
6	P112	SLEEVE
7	P108	CAP