

RECORD POWER
ESTABLISHED 1909[®]

Original Instruction Manual

RP2000 Compact Scroll Chuck

Version 3.0

August 2013



To register this product please visit
www.recordpower.info

It is important to register your product as soon as possible in order to receive efficient after sales support and be entitled to the full **5 year guarantee**. Your statutory rights are not affected. Please see back cover for contact details.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

Important

For your safety read instructions carefully before assembling or using this product.
Save this manual for future reference.

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1. Explanation of Symbols

The symbols and their meanings shown below may be used throughout this manual.

Please ensure that you take the appropriate action wherever the warnings are used.

Mandatory Instructions



Read and fully understand the instruction manual before attempting to use the machine.



Indicates an instruction that requires particular attention



Wear protective eyewear



Use respiratory protective equipment



Use hearing protection



Use suitable protective footwear



Use protective work gloves

Warnings



Indicates a risk of severe personal injury or damage to the machine



Indicates a risk of severe personal injury from electrical shock



Risk of personal injury from lifting of heavy items



Indicates a risk of severe personal injury from airborne objects



Risk of fire

2. General Health & Safety Guidance

Ensure that you carefully read and fully understand the instructions in this manual before assembly, installation and use of this product. Keep these instructions in a safe place for future reference.

WARNING: for your own safety, do not attempt to operate this machine until it is completely assembled and installed according to these instructions.

WARNING: When using any machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.

Safe Operation

1. Use Personal Protective Equipment (PPE)

- The operation of any machine can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Protective eyewear or other suitable eye protection or face shield should be used at all times. Everyday spectacles only have impact resistant lenses. They are not protective eyewear and do not give additional lateral protection.
- Use respiratory protective equipment (dust mask etc.) if the machining operation creates dust. Exposure to high levels of dust created by machining hardwoods, softwoods and man made composite boards can result in serious health problems. Some imported hardwoods give off highly irritating dust, which can cause a burning sensation. The use of respiratory protective equipment should not be seen as an alternative to controlling the risk of exposure at source by using adequate dust extraction equipment.
- The use of ear plugs or ear defenders is recommended when the machine is in use, particularly if the noise level exceeds 85dB.
- Wear suitable protective gloves when handling cutting tools or blades. Gloves

should NOT be worn when using the machine as they can be caught in moving parts of the machine.

- Non-slip safety footwear is recommended when using the machine and handling large work pieces.

2. Dress appropriately

- Do not wear loose clothing, neckties or jewellery; they can be caught in moving parts of the machine.
- Roll up long sleeves above the elbow.
- Wear protective hair covering to contain long hair.

3. Safety warnings

- Find and read any warning labels on the machine.
- It is important that any labels bearing health and safety warnings are not removed, defaced or covered. Replacement labels can be obtained by contacting our Customer Service Department.

4. Familiarise yourself with the machine

- If you are not thoroughly familiar with the operation of this machine, obtain advice from your supervisor, instructor, or other qualified person or contact your retailer for information on training courses. Do not use this machine until adequate training has been undertaken.

5. Take care when moving or positioning the machine

- Some machines can be very heavy. Ensure the floor of the area in which the machine is to be used is capable of supporting the machine.
- The machine and its various components can be heavy. Always adopt a safe lifting technique and seek assistance when lifting heavy components. In some cases it may be necessary to use mechanical handling equipment to position the machine within the work area.

2. General Health & Safety Guidance

- Some machines have optional wheel kits available to allow them to be manoeuvred around the workshop as required. Care should be taken to install these according to the instructions provided.
- Due to the nature of the design of some machines the centre of gravity will be high making them unstable when moved. Extreme care should be taken when moving any machine.
- If transportation of the machine is required then all precautions relating to the installation and handling of the machine apply. In addition, ensure that any vehicles or manual handling equipment used for transportation are of adequate specification.

6. The machine should be level and stable at all times

- When using a leg stand or cabinet base that is designed to be fitted to the machine, always ensure that it is securely fastened to the machine using the fixings provided.
- If the machine is suitable to be used on a workbench, ensure that the workbench is well constructed and capable of withstanding the weight of the machine. The machine should always be securely fastened to the workbench with appropriate fixings.
- Where possible, floor standing machines should always be secured to the floor with fixings appropriate to the structure of the floor.
- The floor surface should be sound and level. All of the feet of the machine should make contact with the floor surface. If they do not, either re-locate the machine to a more suitable position or use packing shims between the feet and the floor surface to ensure the machine is stable.

7. Remove adjusting keys and wrenches

- Ensure that all adjusting wrenches and keys are removed before switching the

machine 'ON'. There is a risk of severe personal injury or damage to the machine from airborne objects.

8. Before switching the machine 'ON'

- Clear the machine table of all objects (tools, scrap pieces etc.)
- Make sure there is no debris between the work piece and the table / work support.
- Ensure that the work piece is not pressed against, or touching the saw blade or cutting tool.
- Check all clamps, work holding devices and fences to ensure that they are secure and cannot move during machining operations.
- Plan the way that you will hold and feed the work piece for the entire machining operation.

9. Whilst machining

- Before starting work, watch the machine while it runs. If it makes an unfamiliar noise or vibrates excessively, switch the machine 'OFF' immediately and disconnect it from the power supply. Do not restart until finding and correcting the source of the problem.

10. Keep the work area clear

- Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely operate your machines in any foreseeable operation.
- Cluttered work areas and benches create the risk of accidents. Keep benches clear and tidy away tools that are not in use.
- Ensure that the floor area is kept clean

2. General Health & Safety Guidance

and clear of any dust and debris that may create trip or slip hazards.

11. Consider the work area environment

- Do not expose the machine to rain or damp conditions.
- Keep the work area well lit and ensure that there is artificial lighting available when there is insufficient natural light to effectively light the work area. Lighting should be bright enough to eliminate shadow and prevent eye strain.
- Do not use the machine in explosive environments eg. in the presence of flammable liquids, gases or dust.
- The presence of high levels of dust created by machining wood can present a risk of fire or explosion. Always use dust extraction equipment to minimise the risk.

12. Keep other persons away (and pets)

- The machine is designed to be used by one person only.
- Do not let persons, especially children, touch the machine or extension cable (if used) and keep visitors away from the work area.
- Never leave the machine running unattended. Turn the power supply off and do not leave the machine unattended until it comes to a complete stop.
- If the work area is to be left unattended, all machinery should be switched 'OFF' and isolated from the mains power supply.

13. Store machines safely when not in use

- When not in use, machines should be stored in a dry place, out of reach of children. Do not allow persons unfamiliar with these instructions or with the machine to operate it.

14. Do not overreach

- Choose a working position that allows your body to remain balanced and feed the work piece in to the machine without

overreaching.

- Keep proper footing and balance at all times.

15. Electrical supply

- Electrical circuits should be dedicated to each machine or large enough to handle combined motor amp loads. Power outlets should be located near each machine so that power or extension cables are not obstructing high-traffic areas. Observe local electrical guidelines for proper installation of new lighting, power outlets, or circuits.
- The machine must be connected to an earthed power supply.
- The power supply must be equipped with a circuit breaker that provides short circuit, overload and earth leakage protection.
- The voltage of the machine must correspond to the voltage of the mains power supply.
- The mains plug fitted to the machine should always match the power outlet. Do not modify the plug in any way. If a replacement plug is required it should be fitted by a competent person and of the correct type and rating for the machine.
- If you are unsure about any electrical connections always consult a qualified electrician.

16. Avoid unintentional starting of the machine

- Most machines are fitted with a no-volt release (NVR) switch to prevent unintentional starting. If in doubt always ensure the machine switch is in the 'OFF' position before connecting it to the power supply. This means the machine will not automatically start up after a power cut or switching on of the power supply, unless you first reset the start switch.

17. Outdoor use

- Your machine should not be used outdoors.

18. Extension cables

2. General Health & Safety Guidance

- Whenever possible, the use of extension cables is not recommended. If the use of an extension cable is unavoidable, then it should have a minimum core cross section of 2.5mm² and limited to a maximum length of 3 metres.
- Extension cables should be routed away from the direct working area to prevent a trip hazard.

19. Guard against electric shock

- Avoid body contact with earthed or grounded surfaces such as pipes and radiators. There is an increased risk of electric shock if your body is earthed or grounded.

20. Always work within the machine's intended capacities

- Operator safety and machine performance are seriously adversely affected if attempts to make the machine perform beyond its limits are made.

21. Do not abuse the power cable

- Never pull the power cable to disconnect it from the power socket. Always use the plug.
- Keep the power cable away from heat, oil and sharp edges.
- Do not use the power cable for carrying or moving the machine.

22. Secure the work piece

- Ensure that the work piece is securely held before starting to machine it.
- When working within 300 mm of the machining area, always use a push stick to feed the work piece in to the blade or cutting tool. The push stick should have a minimum length of 400 mm. If the push stick becomes damaged, replace it immediately.
- Use extra supports (roller support stands etc.) for any work pieces large enough to tip when not held down to the table top.
- Do not use another person as a substitute for a table extension, or as additional

support for a work piece that is longer or wider than the basic table, or to help feed, support, or pull the work piece.

- Do not attempt to machine more than one work piece at a time.
- When feeding the work piece towards the blade or cutting tool never position your hands in direct line of the cutting path. Avoid awkward operations and hand positions where a sudden slip could cause your hand or fingers to move into the machining area.

23. Stay alert

- Safety is a combination of operator common sense and alertness at all times when the machine is being used.
- Use all machines with extreme care and do not use the machine when you are tired or under the influence of drugs, alcohol or medication.

24. Use the correct tool for the job

- Do not use the machine for any purpose other than which it was designed.
- When selecting replacement cutting tools and blades, always ensure that they are designed to cut the material that you intend to use them for. If in any doubt seek further advice from the manufacturer.

25. Connect dust extraction equipment

- Always use dust extraction equipment. The dust extractor should be of suitable size and capacity for the machine that it is connected to and have a filtration level appropriate to the type of waste being collected. Refer to the relevant section of the manual for details of the specific dust extraction requirements for this machine.
- The dust extractor should be switched 'ON' before starting the machine that it is connected to. The dust extractor should be left running for 30 seconds after the last machining operation is complete in order to clear any residual waste from the machine.

2. General Health & Safety Guidance

26. Ensure that the machine is correctly guarded

- Never use the machine if any of the standard safety guards and equipment are removed or damaged.
- Some machines incorporate safety interlocks to prevent the machine from being used without the guards in place. Never attempt to bypass or modify the interlocks to allow the machine to be used without the guards in place.

27. Maintain your machine with care

- This manual gives clear instructions on installation, set up and operation of the machine and also details any routine and preventative maintenance that should be performed periodically by the user.
- Remember always to switch off and unplug the machine from the power supply before carrying out any setting up or maintenance operations.
- Follow any instructions for the maintenance of accessories and consumables.
- Do not use compressed air to clean the machine. Always use a brush to dislodge dust in places that are awkward to reach and a dust extractor to collect the waste.
- Inspect electric cables periodically and, if damaged, have them replaced by an authorised service facility or qualified electrician.
- Inspect extension cables (if used) periodically and replace if damaged.

28. Keep cutting tools sharp and clean

- Correctly maintained cutting tools are easier to control and less likely to bind.
- Cutting tools and blades can become hot during use. Take extreme care when handling them and always allow them to cool before changing, adjusting or sharpening them.

29. Disconnect the machine from the

power supply

- When not in use, before servicing, changing blades etc. always disconnect the machine from the power supply.

30. Check for damaged parts

- Before each use of the machine, it should be carefully checked to determine that it will operate properly and perform its intended function.
- Check for alignment of moving parts, binding of moving parts, breakage of parts and any other conditions that may affect the operation of the machine.
- A guard or other part that is damaged should be properly repaired or replaced by a qualified person unless otherwise indicated in this instruction manual.
- Do not use the machine if the switch does not turn the machine 'ON' and 'OFF'.
- Have defective switches replaced by a qualified person.

31. Warning!

- The use of any accessory or attachment, other than those recommended in this instruction manual, or recommended by our Company may present a risk of personal injury or damage to the machine and invalidation of the warranty.

32. Have your machine repaired by a qualified person

- This machine complies with the relevant safety rules and standards appropriate to its type when used in accordance with these instructions and with all of the standard safety guards and equipment in place. Only qualified persons using original spare parts should carry out repairs. Failure to do this may result in considerable danger to the user and invalidation of warranty.

33. Caution! Motor may become hot during use

- It is normal for motors on some machines to become hot to the touch during use. Avoid touching the motor directly when in use.

3. Additional Health & Safety for Woodturning Lathes

Safe Operation

Familiarise yourself with the machine

- Machining operations using wood turning lathes have a history of serious accidents. Most serious accidents resulted from the work piece being thrown from the lathe whilst turning. Other accidents can be caused by loose clothing being drawn in to the rotating work piece or hands becoming trapped between the rotating work piece and fixed parts of the lathe.

2. Before switching the machine 'ON'

- Before attaching a work piece to a faceplate, always prepare it to be as round as possible. This will minimise vibration whilst turning. For further instructions please see the section of this manual entitled **Intended Use of the Lathe & Basic Woodturning Instructions**.
- Adjust the tool rest to the correct height and distance from the work piece and check that all fixings are secure.
- Check that the size of the work piece is within the safe working capacities of the lathe as detailed in the manual.
- Select the correct speed according to the size and type of work piece. The slowest speed is the safest speed to start any new work piece.
- Always rotate the work piece by hand before starting the lathe to ensure it does not come into contact with the tool rest. If the work piece strikes the tool rest during operation, it could be split and thrown from the lathe.
- When using a faceplate always ensure the work piece is well secured with screws of a suitable diameter and length.
- Remove any loose knots and bark from the work piece before mounting it to the lathe.

- If mounting a work piece between centres, always ensure that the tailstock is correctly adjusted and fully secure. Check that the locking handle for the tailstock barrel is fully tightened.

3. Whilst using the lathe

- Do not allow the turning tool to dig in to the work piece, which could result in the work piece splitting or being thrown from the lathe. Always position the tool rest at the correct height. For further instructions please see the section of this manual entitled **Intended Use of the Lathe & Basic Woodturning Instructions**.
- Before starting to machine a work piece that is off centre or not perfectly round, always set the machine to the slowest speed and gradually increase speed as the work piece becomes more balanced as material is removed. Running the lathe too fast could cause the work piece to be thrown from the lathe or the turning tool to be snatched from your hands.
- Always store turning tools in a safe place away from the work area of the lathe. Never reach over the rotating work piece to reach for turning tools or accessories.
- Never attempt to adjust the position of the tool rest whilst the machine is running. Always switch the machine 'OFF' and wait until the work piece has stopped rotating before attempting any adjustments.
- Do not mount a work piece that contains excessive splits or loose knots or bark.
- Keep firm hold and control of the turning tool at all times. Use extreme caution when knots and voids are exposed in the work piece.

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- Finish all hand sanding before removing the work piece from the lathe. Do not exceed the speed used for the last cutting operation. For further instructions please see the section of this manual entitled **Intended Use of the Lathe & Basic Woodturning Instructions**.
 - Do not attempt to remount a work piece that has been turned on a faceplate unless you are deliberately turning eccentric work. You cannot remount faceplate turned work and expect it to run true, as the timber will have expanded or contracted.
 - Do not remount a work piece that has been turned between centres if the original centres have been altered or removed, unless you are deliberately turning eccentric work.
 - If re-mounting any work piece, always set the machine to the slowest speed and gradually increase the speed as the work piece becomes more balanced as material is removed.
 - Use extra caution when mounting a work piece that has been turned between centres to a faceplate, or when mounting a faceplate turning between centres, for subsequent machining operations. Always ensure that the lathe is set to the slowest speed before switching ON.
 - Do not attempt to perform any machining operations when holding the work piece by hand.
 - Do not mount a reamer, milling cutter, wire wheel, buffing wheel, drill bit or any other tool to the headstock spindle.
 - Always ensure that the turning tool is in contact with the tool rest and fully supported before applying the tool to the work piece.
 - When the tool rest base unit is not in use (e.g. when sanding), it should be moved away from the headstock, and the tool rest removed.
- ## 4. Maintenance
- Before attempting any maintenance and particularly when cleaning the machine, always remove any accessories and tooling from the machine.
 - Always ensure that any accessories used on the lathe are kept clean and free from rust and deposits of resin.
 - Keep all turning tools sharp and in good condition. Check that the handles are secure and not split or damaged.
- ## 5. This machine falls under the scope of the 'Health & Safety at Work etc. Act 1974', and the 'Provision & Use of Work Equipment Regulations 1998'. In addition the elimination or control of risks from wood dust is included in the above regulations and the 'Control of Substances Hazardous to Health (COSHH) Regulations 2002'. We recommend that you study and follow these regulations.
- Further guidance is available from The Health & Safety Executive and their website www.hse.gov.uk and from the authorised distributor in your country (details on back cover of the manual).

4. Record Power Guarantee

“Products” means the Products sold by Record Power subject to these terms and conditions;

“Record Power” is Record Power Limited, whose company registration number is 4804158 and registered office address is Centenary House, 11 Midland Way, Barlborough Links, Chesterfield, Derbyshire, S43 4XA and sells through a network of Authorised Dealers;

“Authorised Distributor” is the nominated importer for your region who will generally sell through a network of Authorised Dealers. Details of Authorised Distributors for specific countries can be found in the Product manual or at www.recordpower.info;

“Authorised Dealer” is a retailer or business authorised to sell Record Power Products to end users.

1 Guarantee

1.1 Record Power guarantees that for a period of 5 years from the date of purchase the components of qualifying Products (see clauses 1.2.1 to 1.2.9) will be free from defects caused by faulty construction or manufacture.

1.2 During this period Record Power, its Authorised Distributor or Authorised Dealer will repair or replace free of charge any parts which are proved to be faulty in accordance with paragraphs 1.1 above provided that:

- 1.2.1** you follow the claims procedure set out in clause 2 below;
- 1.2.2** Record Power, our Authorised Distributor or Authorised Dealer are given a reasonable opportunity after receiving notice of the claim to examine the Product;

1.2.3 if asked to do so by Record Power, its Authorised Distributor or Authorised Dealer, you return the Product, at your own cost, to Record Power’s premises or other approved premises such as those of the Authorised Distributor or supplying Authorised Dealer, for the examination to take place;

1.2.4 the fault in question is not caused by industrial use, accidental damage, fair wear and tear, wilful damage, neglect, incorrect electrical connection, abnormal working conditions, failure to follow our instructions, misuse, or alteration or repair of the Product without our approval;

1.2.5 the Product has been used in a domestic environment only;

1.2.6 the fault does not relate to consumable Products such as blades, bearings, drive belts or other wearing parts which can reasonably be expected to wear at different rates depending on usage (for full details contact Record Power or your local Authorised Distributor);

1.2.7 the Product has not been used for hire purposes, by you or by a previous owner;

1.2.8 the Product has been purchased by you as the guarantee is not transferable from a private sale.

1.2.9 where the Product has been purchased from a retailer, the 5 year guarantee is transferable and begins on the date of the first purchase of the Product and in the event of a claim under this guarantee proof of the original purchase date will be required to validate the warranty period.

4. Record Power Guarantee

2 Claims Procedure

- 2.1** In the first instance please contact the Authorised Dealer who supplied the Product to you. In our experience many initial problems with machines that are thought to be due to faulty parts are actually solved by correct setting up or adjustment of the machines. A good Authorised Dealer should be able to resolve the majority of these issues much more quickly than processing a claim under the guarantee.
- 2.2** Any damage to the Product resulting in a potential claim under the guarantee must be reported to the Authorised Dealer from which it was purchased within 48 hours of receipt.
- 2.3** If the Authorised Dealer who supplied the Product to you has been unable to satisfy your query, any claim made under this Guarantee should be made directly to Record Power or its Authorised Distributor (for details of the Authorised Distributor in your country please see your Product manual or check www.recordpower.info for details). The claim itself should be made in a letter setting out the date and place of purchase, and giving a brief explanation of the problem which has led to the claim. This letter should then be sent with proof of the purchase date (preferably a receipt) to Record Power or its Authorised Distributor. If you include a phone number or email address this will help to speed up your claim.
- 2.4** Please note that it is essential that the letter of claim reaches Record Power or its Authorised Distributor on the last day of this Guarantee at the latest. Late claims will not be considered.

3 Limitation of Liability

- 3.1** We only supply Products for domestic and private use. You agree not to use the Product for any commercial, business or re-sale purposes and we have no liability to you for any loss of profit, loss of business, business interruption or loss of business opportunity.
- 3.2** This Guarantee does not confer any rights other than those expressly set out above and does not cover any claims for consequential loss or damage. This Guarantee is offered as an extra benefit and does not affect your statutory rights as a consumer.
- 4 Notice**
This Guarantee applies to all Products purchased from an Authorised Dealer of Record Power within the United Kingdom of Great Britain and Northern Ireland. Terms of Guarantee may vary in other countries – please check with the Authorised Distributor in your country (details of the Authorised Distributor for your country can be found in the manual or at www.recordpower.info).

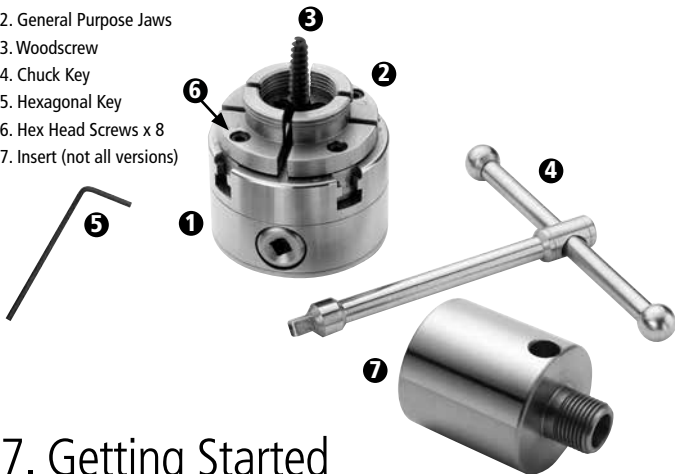
5. Using the Chuck Safely

1. The machine should be disconnected from the mains power supply when fitting or removing the chuck.
2. Do not run the machine with the chuck mounted unless the workpiece is in position, otherwise the component parts may become dangerously loose.
3. Before starting the machine ensure that the workpiece is firmly secured by the chuck, that there are no loose components in the chuck and that the chuck is firmly secured to the machine spindle nose.
4. Turn the workpiece by hand to ensure that nothing obstructs its rotation, check that all other parts of the machine (especially the toolrest) are firmly clamped.
5. Stand clear of the line of rotation when starting and when first applying the tool. If in doubt about whether it is safe to proceed - stop the machine and check the workpiece to see if it is still secure.
6. The Chuck should never be run in reverse or it could become dangerously loose.
7. Larger workpieces should be run on the slowest speed until the operator is sufficiently experienced to increase the speed safely.
8. When turning be careful not to touch any part of the chuck particularly in the vicinity of the spaces between the jaws.
9. Do not sand a spiral shaped workpiece when the machine is running. This is a very dangerous practice as the spiral acts as a fast feed mechanism directing anything in the spiral along its length.
10. When turning heavy, out of balance timber, security of the mounting is most important. However, since each piece of timber is unique it is difficult to lay down precise rules. It is advised that the newcomer to large diameter turning should gain experience with smaller work to start with - gradually working up to the maximum size that they are interested in. Make frequent checks on the security of the timber, gaining a knowledge of what is adequate and what is not for the particular type of work being done.

6. Contents of the Package

The RP2000 Mini Chuck Package consists of the following items:

1. RP2000 Chuck
2. General Purpose Jaws
3. Woodscrew
4. Chuck Key
5. Hexagonal Key
6. Hex Head Screws x 8
7. Insert (not all versions)



7. Getting Started

The RP2000 chuck and accessories are coated in a protective oil to prevent the various components from rusting whilst in storage. It is recommended that the chuck and its components are cleaned with white spirit or similar to remove any excess deposits of the oil before using the chuck.

Please take time to check and familiarise yourself with all of the components of the chuck before use for the first time. You should also check all of the components on a regular basis, and any components showing signs of wear or damage should be replaced immediately. Failure to do so may result in injury.

Never attempt to fit any jaws or accessories that are not genuine Record Power

accessories or replacement parts. The RP2000 is not designed to accept any jaws other than those supplied with it and the optional jaws available.

A kit of spares is available for this chuck, **RP2000-S** Chuck Spares Replacement Pack which contains 8 hex head screws, safety pin and hex key.

8. Basic Operation

8.1 Using the chuck:

The RP2000 mini chuck is supplied with all of the necessary tools required for operation.

A square drive chuck key is supplied to operate the scroll of the chuck to open and close the jaws. Insert the chuck key into either of the two corresponding square drive locations on the side of the chuck. To close the jaws, turn the chuck key in the clockwise direction and to open the jaws turn the chuck key in the counter-clockwise direction.



PLEASE NOTE – always ensure that the chuck key is removed from the chuck before starting the lathe.



Failure to do so may cause serious injury to the user.

A 3mm hex key is provided for the removal and fitting of the different jaw sets. It is recommended that the Hexagonal Key should not be extended in anyway to increase leverage as this may cause damage to the fixing screws.

Always ensure that the speed selected for any turning operation is the slowest speed possible. Always check the correct speed is selected **BEFORE** starting the lathe, particularly when mounting a work piece that is not balanced or concentric. If in any doubt, always start the machine on the lowest available speed and slowly increase the speed as the work piece becomes more balanced and for finishing processes.

8.2 Mounting the RP2000 on the lathe:

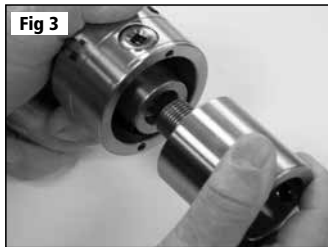
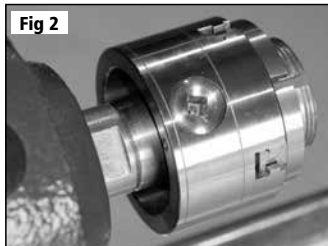
Ensure the thread of your chuck matches that of your lathe. Care should be taken not to cross thread the chuck on to the lathe spindle, and the chuck body should not be forced on to the spindle thread. If the threads feel too tight when first engaged, always unscrew the chuck completely and start again to ensure the correct alignment of the threads.

When you are happy that the thread is correctly engaged, fully tighten the chuck

body on to the lathe spindle so that the rear face of the chuck body is tight against the location face behind the spindle thread (**Fig 2**).



If an adaptor is to be used to fit the chuck to the lathe, first fit the adaptor to the chuck, ensuring that the threads are free from dirt and grease and are as clean as possible. Carefully thread the adaptor on to the chuck, taking care to align the threads correctly, (**Fig 3**). Tighten by hand only as the rotation of the lathe when in use will further tighten the adaptor to the chuck. When removing the chuck, lock the spindle of the lathe and use a tommy bar in the hole on the side of the adaptor to loosen the chuck and adaptor from the spindle.



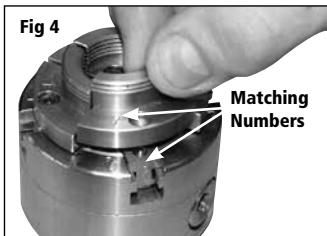
8. Basic Operation

8.3 Mounting alternative jaws to the chuck body:

The RP2000 chuck is supplied with the standard general purpose jaws already mounted. Each of the jaws is secured to the backing jaws by means of two hex head screws (M4 x 12mm). To remove the jaws simply unscrew both the screws from each jaw.

Before mounting new jaws, always clean the front surface of the chuck body with white spirit, to remove any deposits of resin or dirt that may have built up with use. Also clean the mating surfaces of the four backing jaws and the new jaws being fitted, to ensure a good contact and maintain accuracy once the jaws are fully tight.

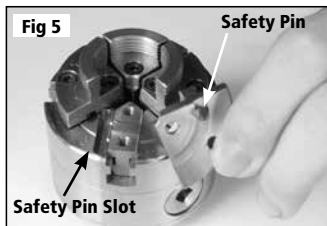
When re-fitting the new jaws, you should note that each of the backing jaws is numbered from 1 to 4, and likewise the jaws sets are also numbered 1 to 4. To ensure accurate and balanced running of the chuck always ensure that the number on the jaw corresponds to the number on the backing jaw (**Fig 4**).



In all cases the jaw numbered 4 has a safety pin located in the back (**Fig 5**). Always check that this is in place and that it is not damaged. If in doubt, the pin should be replaced immediately. When mounting the jaw to the backing jaw, ensure that the pin locates in the machined slot in the face of the chuck body. For your own safety the chuck should never be used without this pin in place.

To secure the jaws to the backing jaws, simply re-fit the hex head screws – again always check the screws for signs of wear or damage and replace any screws immediately as necessary. Take care not to over tighten the screws when mounting the jaws as this may damage the threads and affect the safety of the chuck.

Always ensure that each jaw is secured with two screws – NEVER attempt to use the chuck unless all of the screws are in place and fully tightened.



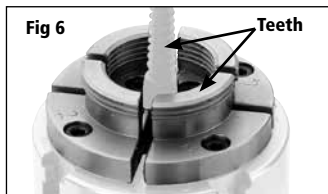
Once the new jaws are mounted, check the correct alignment by fully closing the jaws before mounting a work piece to the chuck. Check that the four jaws meet when fully closed and that there are no spaces between them. If there are any spaces present, firstly check that the numbers on the jaws correspond with those on the backing jaws. To correct any minor misalignment, loosen the mounting screws with the jaws still closed – it may be necessary to try to close the jaws a little further to achieve the correct alignment. Once the jaws are correctly aligned, re-tighten the screws to secure them.



PLEASE NOTE: When fitting the optional pin jaw set, only one screw is used to locate each of the jaws to the backing jaws - the screw locates on the outer hole of the backing jaw. To ensure correct alignment of this jaw set, do not fully tighten the screws until all of the jaws have been mounted and the jaws closed together.

9. Explanation of the Optional Jaw Sets

9.1 General Purpose Jaws



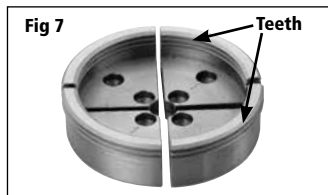
These are the standard jaws that are supplied already mounted to the chuck. The jaws can be used for holding a work piece in either compression (gripping on to a spigot) or expansion mode (expanding in to a recess). The jaws feature serrations or 'teeth' on the internal and external area of the jaws to improve gripping of the work piece. (Fig 6)

In the expanding mode any recess diameter can be turned between 35mm and 58mm. The optimum size for the recess is 35mm as this is the true circle of the jaws and will give the best contact with the workpiece.

In the compression mode, any spigot diameter can be turned between 23mm and 47mm. The optimum size for the spigot is 24mm as this is the true circle of the jaws and will give the best contact with the workpiece.

The maximum diameter of the work piece that can be used safely with the general purpose jaws is 180mm (7").

9.2 RP200C Wide Grip Jaw Set (Optional)



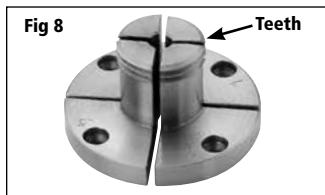
This is the largest diameter jaw set available for the RP2000 chuck. The jaws can be used for holding a work piece in either compression (gripping on to a spigot) or expansion mode (expanding in to a recess). The jaws feature serrations or 'teeth' on the internal and external area of the jaws to improve gripping of the work piece (Fig 7).

In the expanding mode any recess diameter can be turned between 71mm and 88mm. The optimum size for the recess is 72mm as this is the true circle of the jaws and will give the best contact with the workpiece.

In the compression mode, any spigot diameter can be turned between 52mm and 70mm. The optimum size for the spigot is 55mm as this is the true circle of the jaws and will give the best contact with the workpiece.

The maximum diameter of the work piece that can be used safely with the wide grip jaws is 305mm (12").

9.3 RP2000A Pin Jaw Set (Optional)



This jaw set can be used for holding a work piece in either compression (gripping on to a spigot) or expansion mode (expanding in to a recess). In compression mode, the jaws can also be used for holding square section blanks.

The jaws feature serrations or 'teeth' on the external area of the jaws to improve gripping of the work piece. The internal area of the pin

9. Explanation of the Optional Jaw Sets

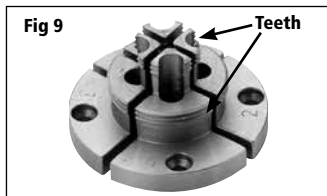
jaws is a smooth radius and the increased length of the jaws provides a larger contact area when working with small diameter work pieces (**Fig 8**).

In the expanding mode any recess diameter can be turned between 23mm and 45mm. The optimum size for the recess is 23mm as this is the true circle of the jaws and will give the best contact with the workpiece.

In the compression mode, any spigot diameter can be turned between 6mm and 28mm. The optimum size for the spigot is 6mm as this is the true circle of the jaws and will give the best contact with the jaws. Square section blanks up to 25mm square can also be gripped in compression mode.

The maximum diameter of the work piece that can be used safely with the pin jaws is 200mm (8").

9.4 RP2000B Step Jaw Set (Optional)



This jaw set can be used for holding a work piece in either compression (gripping on to a spigot) or expansion mode (expanding in to a recess). The jaws feature serrations or 'teeth' on the internal and external gripping area of the jaws to improve gripping of the work piece. The internal gripping area of the stepped jaws has a larger serrated area and the increased length of the jaws provides a larger contact area when working with small diameter work pieces. (**Fig 9**).

This jaw set has two different diameter gripping areas when used in expansion mode.

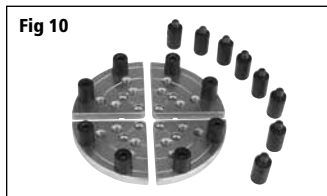
For the larger gripping area of the jaw any

recess diameter can be turned between 31mm and 53mm. The optimum size for the recess is 31mm as this is the true circle of the jaws and will give the best contact with the workpiece.

For the smaller gripping area of the jaw any recess diameter can be turned between 17mm and 38mm. The optimum size for the recess is 18mm as this is the true circle of the jaws and will give the best contact with the workpiece. In the compression mode, any spigot diameter can be turned between 2mm and 24mm. Due to the nature of the internal gripping area of the stepped jaws, there is no optimum size for the spigot. Square section blanks up to 24mm square can also be gripped in compression mode.

The maximum diameter of the work piece that can be used safely with the stepped jaws is 200mm (8") when using the larger gripping area of the jaws.

9.5 RP2000D Remounting Jaw Set (Optional)



These jaws can be used for contracting around the workpiece or expanding into it without leaving marks. They are ideal for remounting bowls and other items, such as goblet bases without marking, thanks to the rubber sleeved stops supplied with the jaws.

Two sets of these stops are supplied – Eight standard length and eight long stops which give added grip. Each of the jaws features scribe rings at different diameters to give a useful guide when centralising the workpiece in the jaws. See **Fig 10**.

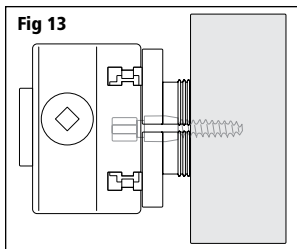
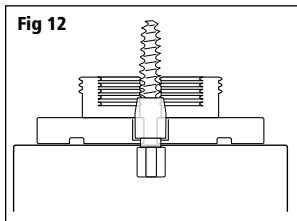
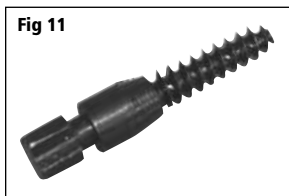
9. Explanation of the Optional Jaw Sets

9.6 Wood Screw

The RP2000 chuck can be used as a wood screw chuck by using the woodscrew supplied with the chuck. (**Fig 11**).

The woodscrew can be used with the general purpose jaws or the wide grip jaws as both of these jaws sets incorporate a recess in the middle to securely hold the woodscrew in place. To grip the woodscrew in either of the jaws, ensure that the four flutes on the end of the woodscrew, line up with the four lugs in the middle of the jaws. When gripped, the lugs of the jaws should grip the flute of the woodscrew and the round section of the woodscrew should locate in the recess in the middle of the jaws. (**Fig 12**).

The woodscrew should be located in the jaws before attempting to mount a work piece. To mount a work piece on to the screw, first drill a 2mm diameter pilot hole, 20 to 25mm deep in the work piece and then thread the work piece on to the woodscrew. Fully screw the work piece on to the screw until the surface of the piece makes contact with the front edge of all four jaws (**Fig 13**).



10. Maintenance

Before using any of the components of the chuck, always carry out a visual check to identify any items that are showing signs of wear or damage. Any such components should be replaced immediately.

When removing the jaw fixing screws, check the threads for signs of wear and replace as necessary. It is advisable to use a small amount of grease or copper lubricant under the head of the screw to aid removal when changing jaws.

Regularly check the rear of the chuck and remove any excess waste material from the gearing for the scroll. Lubricate the pinion gears in the back of the chuck with a small amount of grease.

When changing the jaws, both the chuck body and the replacement jaws should be cleaned with white spirit to remove any deposits of resin or dirt that may prevent the jaws from seating accurately on the backing jaws.

If storing the chuck for long periods, it is advisable to clean and lubricate the chuck with CWA195 silicon rich spray or a suitable spray oil to prevent any surface rust from forming whilst not in use. If possible the chuck should be stored in its original case.

If parts are lost or damaged, a kit of spares is available for this chuck, **RP2000-S** Chuck Spares Replacement Pack which contains 8 hex head screws, safety pin and hex key.



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