

Note: Parts held with the pins are for laser marking purposes only. The pins are not intended to hold parts being machined.

**SHERLINE
PRODUCTS**
INCORPORATED 1974

Sherline Chuck Pin Jaws

P/N 1140

The Purpose of Pin Jaws

Sherline's pin jaws are intended for holding parts while they are marked with a laser, not for holding parts while they are being machined. Round parts can be held from the inside with just finger-tight grip of the pins while the outside is laser marked (Figure 1). Three sets of different length pins are provided depending on how far the part needs to be held from the chuck. The pins minimize the contact area with the part as well. They can also hold parts from the outside when they are being marked on the inside. The jaws can also be reversed in the chuck to hold larger objects.

You may purchase these jaws to fit an existing Sherline 3-Jaw Chuck, or you can order a new chuck with the jaws installed.

(If you purchased a chuck with the jaws already installed, you can skip to the section on use of the chuck.)

A Note on the Fit of the Jaws

The width of the jaws are sized to fit the average jaw opening in the chuck slots. They should enter the slots easily and should not bind. We recommend you lubricate them a little before inserting them to make the process easier. If for some reason you cannot get the jaws to fit, you may have to return the chuck to Sherline for us to install the jaws, as they may need to be ground a little thinner. If the jaws are a little loose, it would be a problem on a chuck being used for machining. On pin jaws, where only finger tight pressure is needed, a little looseness probably will not be a problem.

Installing the Chuck Jaws in Your Existing 3-Jaw Chuck

If you are installing these jaws in a chuck that was previously purchased with standard jaws, turn the chuck scroll counter-clockwise until the jaws are pushed completely out of the chuck. Note that each of the new jaws has a different pattern of teeth on the bottom. One has an engagement tooth that is closest to the pointed end of the jaw, and one has a first tooth that is farthest from the pointed end. The one with the tooth closest to the pointed end is the first jaw to be inserted. It is generally installed in the chuck slot marked with a dot or the letter "A."

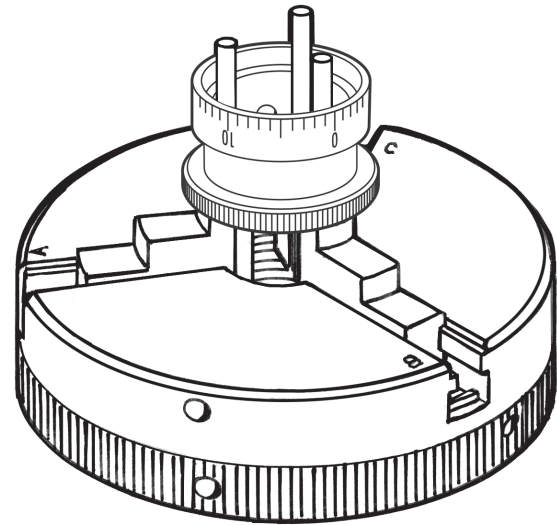


Figure 1—Round parts can be held by the pins from the inside so marks can be laser engraved all the way around the outside surface when the chuck is held on a Sherline CNC rotary table.

Turn the scroll until you can just see the beginning of the spiral tooth enter the "A" slot. Push the jaw into the slot and hold it while turning the scroll so the scroll tooth picks up the jaw tooth and begins pulling it into the chuck. Then continue to rotate the scroll until it just starts to enter the second slot. Now insert the middle jaw into that slot, push it in as far as it will go and turn the scroll to pull that jaw into the second slot. (You may have to push on the first jaw a little as well until it becomes aligned with its slot.)

Continue to turn the scroll until it comes to the third slot and do the same thing with the last jaw to get it started in the slot. You may need to wiggle the jaws a little and work the scroll back and forth a little while pushing the jaws squarely into their slots. Once you get them all going straight into their slots they scroll should begin to turn more easily.

Reversing the Jaws

These jaws can be reversed so the pin can be on the inside (standard relationship) or the outside. This allows for a larger clamping diameter range. With the jaws mounted in their standard relationship (with the pins towards the center of the chuck), the smallest O.D. that can be held is .226". The smallest I.D. that can be held is .476". The T.I.R. of these pins is .006 or less

To read about the procedure to install the jaws in the reversed position, see www.sherline.com/1040inst.pdf.

Other Laser Engraving Accessories

Many of our customers who have ordered these jaws have also ordered other Sherline accessories to aid them with their laser engraving challenges.

In order to laser engrave around the entire surface of your part you may find our CNC Rotary Table useful (P/N 8730 or 8700).

In order to laser engrave the inner surface of a ring or collar you may find our Tilting Angle Table useful (P/N 3750).

Our 3-Jaw Chucks are designed to mount easily and accurately to our Rotary Table and our Tilting Angle Table. Our Rotary Table can also be mounted to our Tilting Angle Table to give you a full range of angles along with 360 degree rotation.

To see a video demonstration of the Pin Jaws being used in conjunction with a laser engraver visit the Videos section of our website at www.sherline.com.

Thank you,
Sherline Products Inc.

3-Jaw Chuck Pin Jaws Parts List

| NO. REQ. | PART NO. | DESCRIPTION |
|----------|----------|------------------------------------|
| 3 | 11414 | 3-Jaw Chuck "Pin Jaws" |
| 3 | 11417 | 1/8" X 3/4" Hard Steel Dowel Pin |
| 3 | 11524 | 1/8" X 1" Hard Steel Dowel Pin |
| 3 | 11416 | 1/8" X 1-1/4" Hard Steel Dowel Pin |