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## VINWOX SCR4-4

# VINWOX SCR4-4 4-Jaw Self-Centering Wood Lathe Chuck User Manual

Model: SCR4-4

## 1. INTRODUCTION

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The VINWOX SCR4-4 4-Jaw Self-Centering Wood Lathe Chuck is engineered for secure and precise gripping of various woodturning projects. This manual provides essential information for the safe and effective use, setup, operation, and maintenance of your chuck. Please read all instructions carefully before use.

## 2. PRODUCT COMPONENTS

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The VINWOX SCR4-4 Wood Lathe Chuck set includes the following components:

- Chuck Body
- One set of 2" Dovetail Jaws (mounted)
- Two Tightening Levers
- T Allen Wrench
- Screw Chuck
- Adapter (converts 1" x 8TPI to 3/4" x 16TPI)
- Free Automatic Spring Loaded Center Punch



Figure 2.1: All components included with the VINWOX SCR4-4 Chuck.



Figure 2.2: Detailed view of the chuck, adapter, worm screw, and T-handle wrench.

### 3. SETUP

Before attaching the chuck to your wood lathe, it is crucial to verify the spindle thread size of your lathe. This chuck is designed for **1" x 8TPI** or **3/4" x 16TPI** wood lathe spindle threads. An adapter is included to facilitate conversion from 1" x 8TPI to 3/4" x 16TPI.

**IMPORTANT: Ensure your wood lathe spindle thread matches the chuck's requirements to prevent damage and ensure safe operation. This chuck is NOT compatible with 1-1/2"x8TPI, 1"x12TPI, 1-1/4"x8TPI, or M18x2.5 threads.**

1. Clean the lathe spindle and the chuck's internal threads to remove any debris.
2. If your lathe has a 3/4" x 16TPI spindle, first thread the provided adapter onto the chuck body.
3. Carefully thread the chuck (or chuck with adapter) onto the lathe spindle. Tighten securely by hand.
4. Use the tightening levers in the designated holes to ensure the chuck is firmly seated on the spindle.



Figure 3.1: The VINWOX SCR4-4 chuck securely mounted on a wood lathe.

## 4. OPERATING INSTRUCTIONS

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The 4-jaw self-centering design allows for versatile gripping options for various woodturning applications.

### 4.1. Internal Gripping (Expanding Jaws)

For internal gripping, the jaws expand into a pre-drilled recess or mortise in your workpiece. This method is ideal for turning the outside of bowls or other hollow forms.

- The internal jaws can tighten around workpieces varying from **1-1/2" to 3"**.
- Create a recess in your workpiece that allows the chuck jaws to fit snugly when expanded.
- Insert the workpiece into the chuck, ensuring the jaws align with the recess.
- Use the tightening levers to expand the jaws firmly against the inside of the recess. The self-locking system provides a powerful and positive grip.

### 4.2. External Gripping (Contracting Jaws)

For external gripping, the jaws contract around a tenon or spigot on your workpiece. This method is commonly used for turning the inside of bowls or for spindle turning.

- The external jaws can spread inside of workpieces with pilot holes ranging from **2" to 3-5/8"**.
- Ensure your workpiece has a tenon or spigot that fits within the chuck's contracting range.
- Place the workpiece into the chuck, allowing the jaws to close around the tenon.
- Use the tightening levers to contract the jaws firmly around the workpiece. The tapered ends of the jaws ensure a strong grip.

### 4.3. Using the Screw Chuck

The included screw chuck provides additional options for supporting your projects, especially for initial turning or for smaller pieces.

- Thread the screw chuck into the center of the main chuck body.
- Carefully screw your workpiece onto the screw chuck.
- Ensure the workpiece is securely attached before beginning any turning operations.



Figure 4.1: Demonstrations of the chuck's gripping capabilities for various workpiece sizes.



Figure 4.2: The chuck securely holding a workpiece during a turning operation.

## 5. MAINTENANCE

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Proper maintenance ensures the longevity and optimal performance of your VINWOX chuck.

- **Cleaning:** After each use, clean the chuck to remove wood dust, chips, and debris. A brush or compressed air can be used.
- **Lubrication:** Periodically apply a light machine oil to the moving parts of the chuck, including the jaw slides and scroll mechanism, to ensure smooth operation and prevent rust.
- **Rust Prevention:** The chuck body is made from high-grade K1045 steel with electric Nickel plating for long-term anti-rust performance. However, always store the chuck in a dry environment to prevent corrosion.
- **Inspection:** Regularly inspect the jaw teeth and guides for wear or damage. Both sides of the jaw teeth and guides are ground, and all guideways and bearing surfaces are precisely machined for stable service and long life.

## 6. TROUBLESHOOTING

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If you encounter issues with your VINWOX chuck, consider the following common problems and solutions:

Problem	Possible Cause	Solution
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Problem	Possible Cause	Solution
Chuck does not thread onto lathe spindle.	Incorrect spindle thread size.	Verify your lathe's spindle thread size. This chuck requires 1" x 8TPI or 3/4" x 16TPI (with adapter). It is not compatible with 1-1/2"x8TPI, 1"x12TPI, 1-1/4"x8TPI, or M18x2.5 threads.
Workpiece slips in the chuck.	Insufficient tightening or incorrect jaw engagement.	Ensure the chuck is fully tightened using the levers. For internal gripping, ensure the recess is properly sized. For external gripping, ensure the tenon is adequate. The self-locking system provides strong grip when properly engaged.
Jaws are stiff or difficult to move.	Accumulated debris or lack of lubrication.	Clean the chuck thoroughly to remove any debris. Apply a light machine oil to the jaw slides and scroll mechanism.

## 7. SPECIFICATIONS

Feature	Detail
Brand	VINWOX
Model Number	SCR4-4
Item Diameter	4 Inches
Thread Size	1"x8TPI, 3/4"x16TPI (with adapter)
Internal Jaw Capacity	1-1/2" to 3"
External Jaw Capacity	2" to 3-5/8" (pilot holes)
Lock Type	Self Centering
Material	High-grade K1045 Steel with Nickle Coating
Item Weight	6.57 pounds (approx. 2.99 kg)
Included Components	Chuck body, 2" Dovetail Jaw, Tightening Levers, T Allen Wrench, Screw Chuck, 1"x8TPI to 3/4"x16TPI Adapter, Automatic Spring Loaded Center Punch

## 8. WARRANTY AND SUPPORT

VINWOX is committed to providing excellent customer service. All customers can expect quick response and worry-free service from VINWOX's Professional Service Team and Qualified Engineers. For any questions, concerns, or support needs, please contact our service team through the platform where you purchased the product.

