

# Chuck-Stop Instructions

Model #      \* Tube OD"  
CSB \_\_\_\_ \*    .\_\_

Model #	Fits Kitagawa	Fits Samchully
CSB08	B08	
CSB208	B208	HS08
SBB208	BB208	MH208
CSB10	B10	
CSB210	B210	HCH-10 & HS-10
CSB212	B212	
CSB15	B15	

Tube OD	Tube ID	Chuck Ø
1.75"	1.50"	8"
2.00"	1.75"	8"
2.50"	2.25"	8"
2.75"	2.50"	10"
3.00"	2.75"	10"
3.50"	2.25"	12"
4.00"	3.75"	15"

## Installation Instructions

1. Remove chip guard off of your chuck
2. Clean chips out of draw tube
3. Slide Chuck-Stop in from front of chuck and use chip guard screws to bolt on.

## Operating Instructions to set length

1. Get ratchet with 5/8 socket and Push-Pull socket
2. Go to back of lathe, insert socket into Chuck-Stop and loosen 2 turns.
3. Push or pull to desired position and tighten.
4. Periodically remove and blow off Assembly and tube to ensure smooth operation.

**Danger: Do not leave Push-Pull socket in spindle of lathe!**  
**May cause Injury or Death!**

