

Other ONEWAY Accessories Include:

» Faceplates



» Chuck Spurs



» Drum Chucks (Vacuum System)



» Scroll Chucks (Talon Shown)



#### ONEWAY WARRANTY

Bearings are not made to last forever. Bearings used in the ONEWAY Live Centre are an off the shelf item, and we encourage you not to attempt to change the bearings yourself. Core assemblies are press fit into bodies and without the correct tools can be impossible to extract.

In order that we may warranty bearings, please send in the warranty card (below). ONEWAY will replace bearings within two years of the date of purchase, free of charge, not including the cost of shipping from the customer to ONEWAY. Live Centres must be returned to the address on this warranty, along with your name, purchase date, and where you made the purchase. Warranty work will not be completed if we have not received your warranty card. If the two year warranty period has expired, a cost of US\$35.00 plus shipping and handling will apply to replace bearings.

ONEWAY Manufacturing  
241 Monteith Avenue  
Stratford, ON, N5A 2P6, Canada

#### ONEWAY WARRANTY CARD

Name: \_\_\_\_\_

Purchased From: \_\_\_\_\_ Date: \_\_\_\_\_

Comments: \_\_\_\_\_

# LIVE CENTRE INSTRUCTIONS

Manufactured by ONEWAY Manufacturing

#### Included in this Package:

- » 1 Live Centre Body Assembly «
- » 1 Centre Point «
- » 1 Knock Out Rod «
- » 1 Reversible Bull Nose Cone «
- » 1 Full Point Cone «

**Note:** A Body Only Package does NOT include the Bull Nose or Full Point Cones.



For information on our product range, visit our Web Site:  
<http://www.oneway.on.ca>



ONEWAY Live Centres were designed specifically for the wood turner with accessories included to suit most applications. They have a threaded, rotating, cup centre. This cup centre is the only component which rotates. This feature contributes to a safer working environment. The unique, threaded cup centre gives several advantages to the wood turner. First, the full point and reversible bull nose cones can be easily attached and removed. Second, if turning outside the capacity of the provided cone, a user specific support can be made by drilling a hole in a

blank, attaching it to the live centre and turning it to suit your requirements.

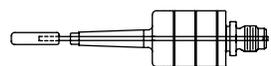
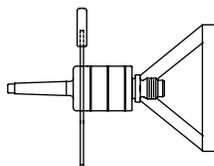
Two good quality bearings mounted in tandem and greased for life will give good play free performance and minimum vibration when turning.

The body is precision machined from premium alloy steel, then heat treated, ground, and electroless nickel plated. These processes give strength, accuracy and rust protection. The core is also made from high strength steel, then heat treated and ground

#### IMPORTANT NOTE

It is normal for ONEWAY Live Centres to run warm, however, if they run *HOT*, this is an indication there is a problem, and tailstock pressure should be eased off. Failing to do so could result in the bearings burning out.

*Attaching / Removing the aluminum Bull nose or Full point cone, or a custom centre:*  
Insert the knock out rod through the live centre body as shown. Turn clockwise to attach accessories and counter-clockwise to remove them.  
**CAUTION!** Hand tighten only.



*Removing the Point:* Insert the knock out rod and tap lightly to release.

#### MAKING A CUSTOM WOOD CENTRE

To make a custom wooden center, use a blank 1-1/2" minimum, 2" maximum thick. Drill a blind hole 11/16 diameter \* 7/8 deep. Insert the knock out rod through the body and screw the blank on to the threaded portion of the center. Insert a spur in the oneway chuck

or head stock to drive your blank and turn to shape required. Another method to drive your blank for turning is to drill a hole as shown and insert a drive pin between the jaws of your ONEWAY chuck.

#### HOW TO PRECISELY CENTRE A BOWL

Now available are Live Center Adaptors. These adaptors are threaded to screw onto ONEWAY Live Centers, effectively changing the 3/4 - 10 thread of the Live Center to the size of the spindle. With one of these adaptors, a very precise centering method can be used:

1. Attach a bowl blank to a faceplate.
2. Turn the outside of the bowl, including a foot or tenon to chuck it on.
3. Using the Live Center adaptor, attach a chuck or faceplate to the Live Center.
4. Move the tailstock (with the Live Center / chuck assembly attached) up to the bowl, and grab the foot or tenon on the bowl while it is still attached to the faceplate and lathe.
5. Remove the faceplate, bowl blank and chuck from the lathe.
6. Remove the faceplate from the bowl blank

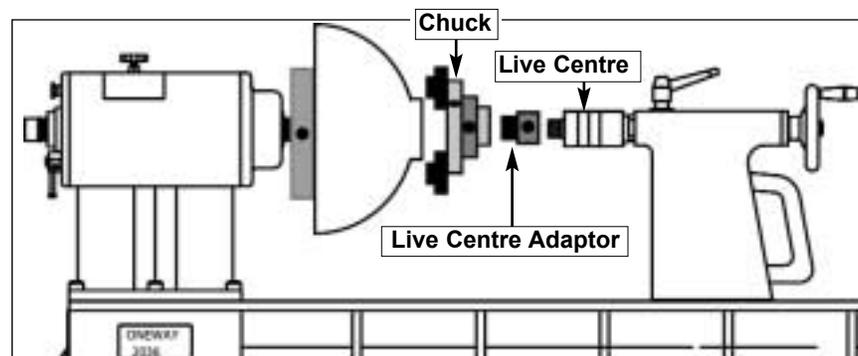
You can now screw the chuck onto the headstock, and your bowl will be very precisely centered and ready to be hollowed out.

Live Centre adaptors are available in the following thread sizes:

3/4" - 10 TPI to 1" - 8 TPI Part #3064

3/4" - 10 TPI to M33 \* 3.5 Part #3065

3/4" - 10 TPI to 1-1/4" - 8 TPI Part #3217



*NOTE: The Live Centre THREAD SIZE is 3/4 - 10*



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