



## Gauge Kit Instructions:

Refer to the "Vacuum Chuck Assembly" diagram and assemble the parts as shown. Teflon tape or pipe dope can be used on the threads of the various parts to ensure a good seal, although this is not absolutely necessary.

A mounting bracket (part #2993) is provided. This is used to attach the Gauge to the lathe for two main reasons. Firstly so that the bleeder valve is within easy reach and secondly so that the gauge is within easy view while using your vacuum chucking system.

If you have a Large Size ONEWAY lathe, the centre hole of the mounting bracket can be attached to the lathe with one of the six bolts which hold the headstock onto the bed.

If you have a ONEWAY Mini Lathe with the Bench provided by ONEWAY, this mounting bracket can be discarded as there is direct mounting capabilities to the bench.

One 5' length of hose is provided. It needs to attach the Gauge to the hose barb of the Rotary air adaptor as well as from the Gauge to the hose barb of the Vacuum pump. Verify the length of hose needed in both places before cutting it.

The gauge provided is a German made model which reads in two different units. The black, outer ring markings designate pressure in inches of mercury, where as the red, inner markings designate pressure in kilo pascals. It is filled with liquid which dampens vibration which contributes to a longer life span for the gauge.

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There are many things to consider when deciding what pressure is required to hold a piece. A few variables to consider are: the weight of the work piece, the porosity of the wood being turned, the force of the gouge being used, and on what area of the piece the gouge is being used on. Different shapes will be more prone to being levered off of a drum chuck when vacuum chucking. It is always a good idea to grab a piece and try to yank it off the chuck. This will give you a good idea of how firmly a piece is being held.

More vacuum pressure is better than less pressure. Twenty inches of mercury is a good pressure to try on pieces that are not too thin. If you think there is a possibility that a thin piece will break from excess pressure do not use a vacuum chuck until you have enough experience to be confident turning a piece with reduced pressure.

### Your Gauge Kit Includes:

2 pcs Hose Barb	Part No. 2732
1 pce Close Nipple	Part No. 2971
1 pce Bleeder Valve	Part No. 2972
1 pce Four Way Cross	Part No. 2973
1 pce Pressure Gauge	Part No. 2974
1 pce Nipple	Part No. 2975
1 pce Elbow	Part No. 2976
5' Reinforced Hose	Part No. 2978
1 pce Mounting Bracket	Part No. 2993
1 pce Bulkhead Adaptor	Part No. 2994
2 pcs Coupling	Part No. 2995
3 pcs Steel Nipple	Part No. 2996

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