

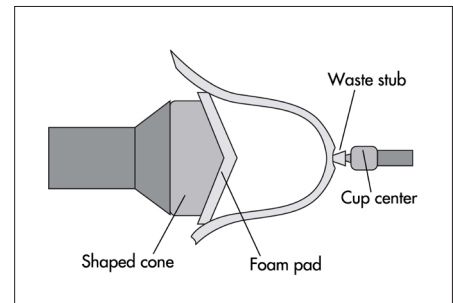
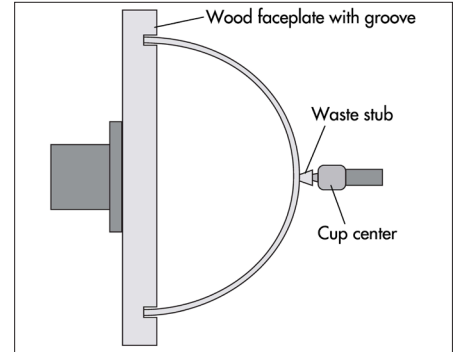
## The Jam Chuck

This is the simplest device for reverse chucking: it is a wooden disk with a groove turned into it to match the diameter of the bowl. The bowl is reversed onto the disk and held in the groove by a snug fit, the groove serving also to center the bowl. The tailstock is brought up to help keep the piece in place. At low revolutions and with light cuts, the foot is shaped, leaving a small stub at the tailstock point. (See Figure 1.) This stub will finally be chiseled off and the spot sanded to blend in.

The wooden disk can be held via faceplate or screw chuck. It can be any material – plywood is just fine. One jam chuck disk is used per bowl, so you end up with a pile of disks on various diameters, but they can be reused with smaller-diameter bowls.

The tailstock support also works for irregular – or natural-edged bowls, when a foam-padded cone is used inside the bowl to jam against. (See Figure 2.) The cone is readily made from scrap wood to match the unique size and shape of the bowl; at its simplest it is the waste block left behind when the bowl is parted off. This approach is pretty straight-forward and works well.

~ Peter M. Smith



This item has been adapted from the article, "Introduction to Chucking," by Peter M. Smith, which appeared in the June 1995 issue of *American Woodturner*.

## Better Success with Jam-Chucking

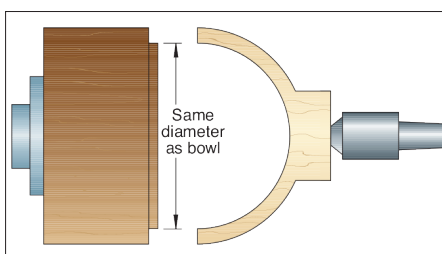
I've helped a few woodworkers who have had problems when turning with a jam chuck. This three-step process might help you be more successful.

**Step 1:** Turn a jam chuck with a small tenon that fits inside the bowl. Turn the outside diameter of the jam chuck so the diameter matches the outside diameter of the bowl.

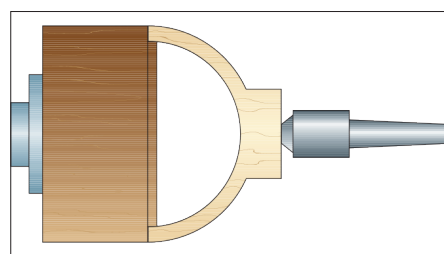
**Step 2:** Fit the bowl over the tenon and apply pressure with the tailstock. For added security and antislip protection, wrap the joint between the bowl and jam chuck with masking tape.

**Step 3:** With the foot turned, leave the masking tape in place but back off the tailstock. Slow the lathe speed and turn away the nub. When removing the nub, use light cuts that apply pressure toward the center of the form and toward the headstock. Then sand the bottom.

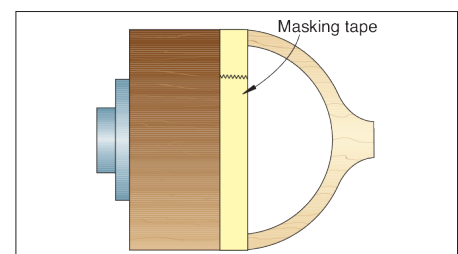
~ Chris Wright



Step 1



Step 2



Step 3