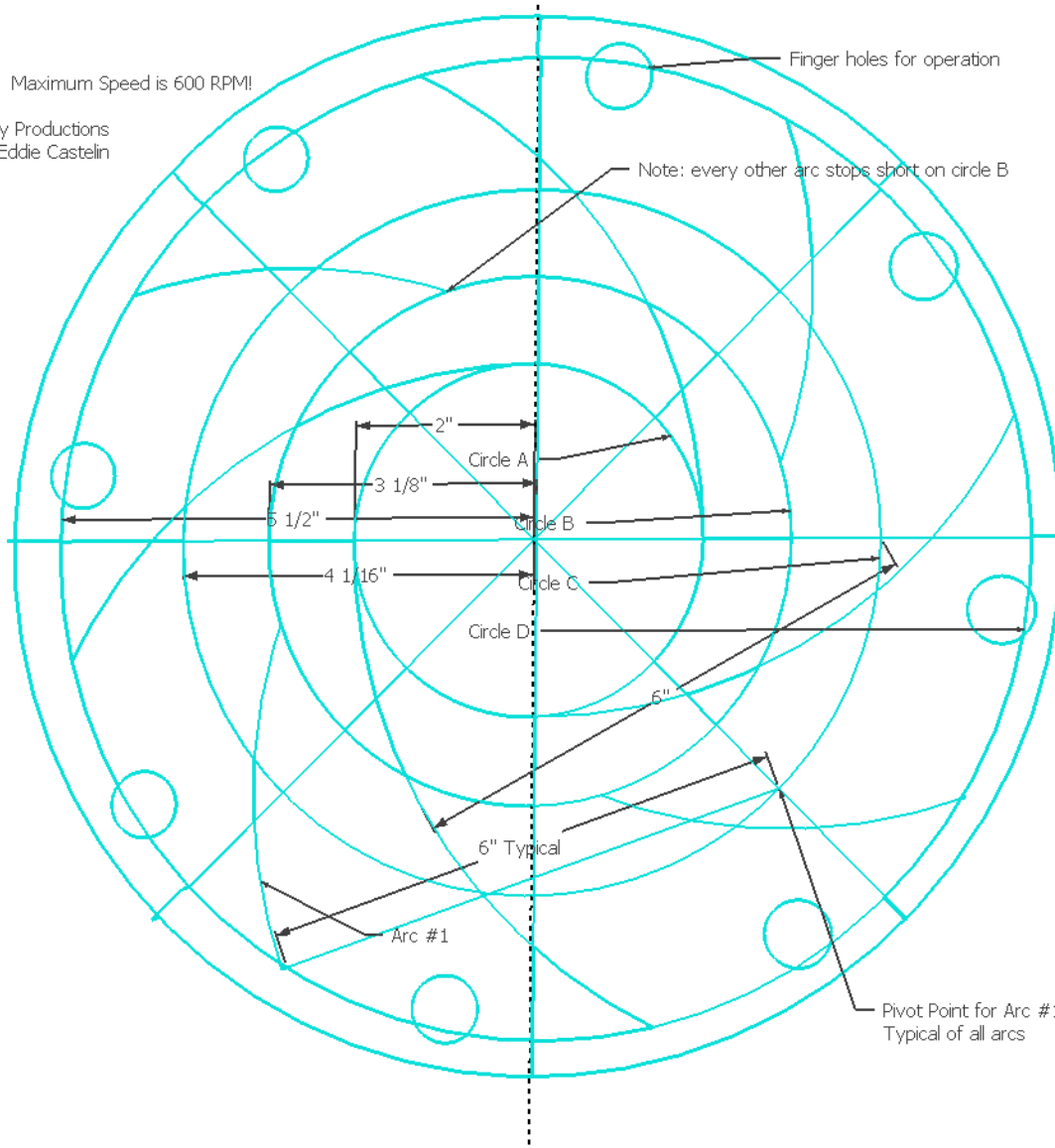


Note: Maximum Speed is 600 RPM!

Big Guy Productions
Cap'n Eddie Castelin



Longworth Chuck Layout Guide

Draw this pattern directly on your plywood

1. Circle A should be 1/2" larger than your faceplate
2. Circle D should be 1/2" smaller than overall width.
3. Circle C should be half-way between A & D.
4. Circle B should be half-way between A & C
5. The straight lines create 8 equal sections of the pattern.
6. The pivot point for Arc #1 is where Circle C and the straight lines cross
7. Ever other arc is cut short at Circle B to add Strength to the chuck
8. Drill 3/4" finger holes in both disc to aid in use
9. Following routing and drilling, sand and seal material.

Standard Size Guide				
Diameter	Cir A	Cir B	Cir C	Cir D
12"	4"	6-1/4"	8-1/8"	11-1/2"
16"	4"	6-7/8"	9-3/4"	15-1/2"
18"	6"	8-7/8"	11-3/4"	17-1/2"
20"	6"	9-7/8"	12-3/4"	19-1/2"

Longworth Chuck Hardware and Sketch package

Hardware pack includes:

- 8 pcs 1/4" X 3" Carriage Bolts
- 8 pcs 1/4" wing nuts
- 8 pcs #4 rubber stoppers with 13/64" hole
- 16 pcs 1/4" X 1-1/4" Fender washers
- 1 pc 1/4" X 3/8" Brass Bushing