

# Longworth Chuck

- Attach a bowl to lathe
- Access bottom of bowl

# References

<https://ravenview.com/how-to-make-a-longworth-chuck/>

# Commercial Longworth Chuck

Rockler Woodworking and  
Hardware



16" Longworth Style  
Chuck  
Item #48730  
IN STOCK  
\$199.99

# Other Alternatives

- ◆ Jam chuck
- ◆ Rubber Chuckie
- ◆ Cole (or super Cole) jaws
- ◆ Vacuum chuck (except for pierced or burl)

# Commercial Cole Jaws

Rockler Woodworking and  
Hardware

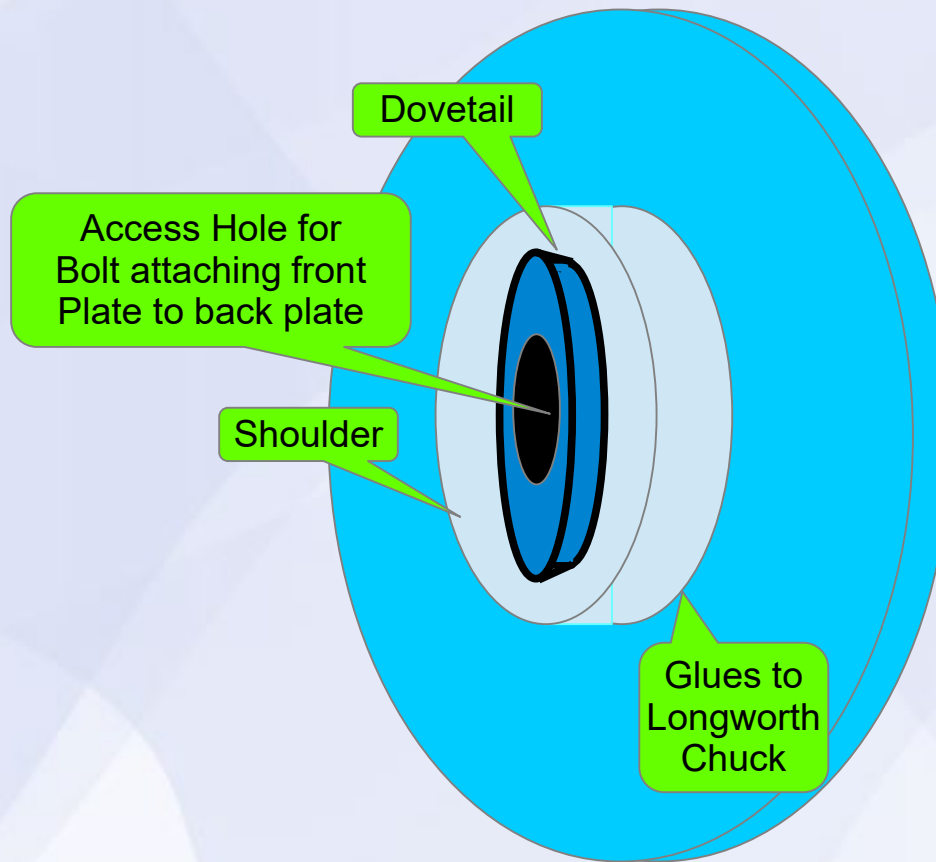


\$124.9  
9  
Each

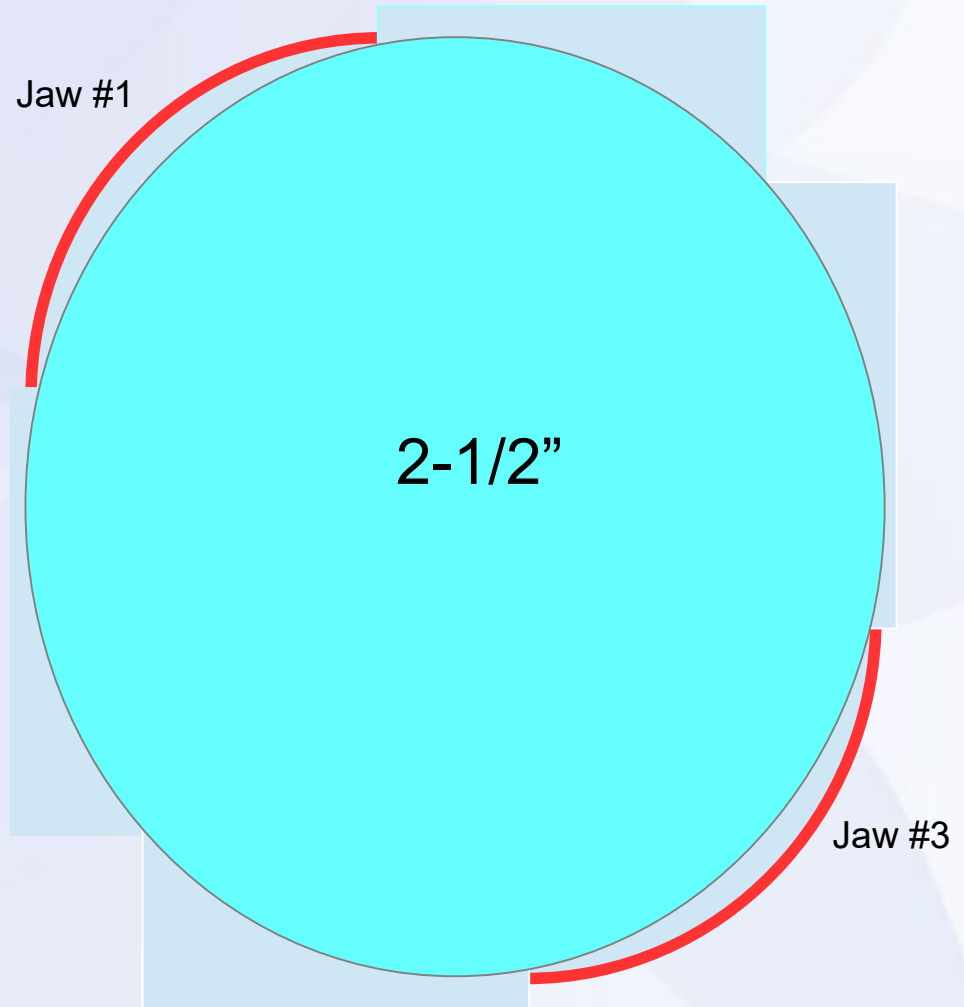
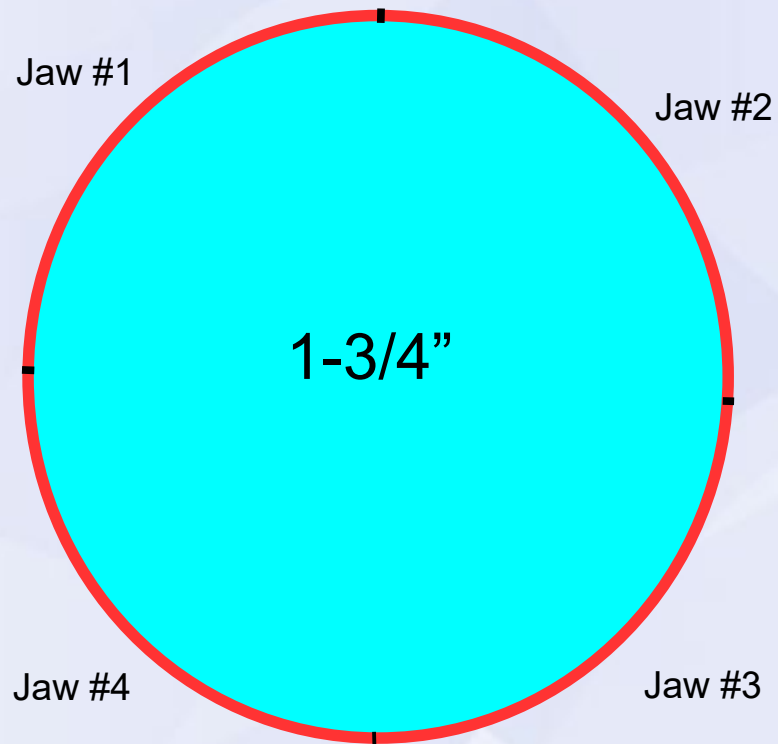
# Attach options

- Face plate
- Scroll chuck (compression but probably not expansion)
- Beall threads
- Morse Taper #2
  - Headstock
  - Tailstock (for gluing rings in segmented turning)

# Tenon



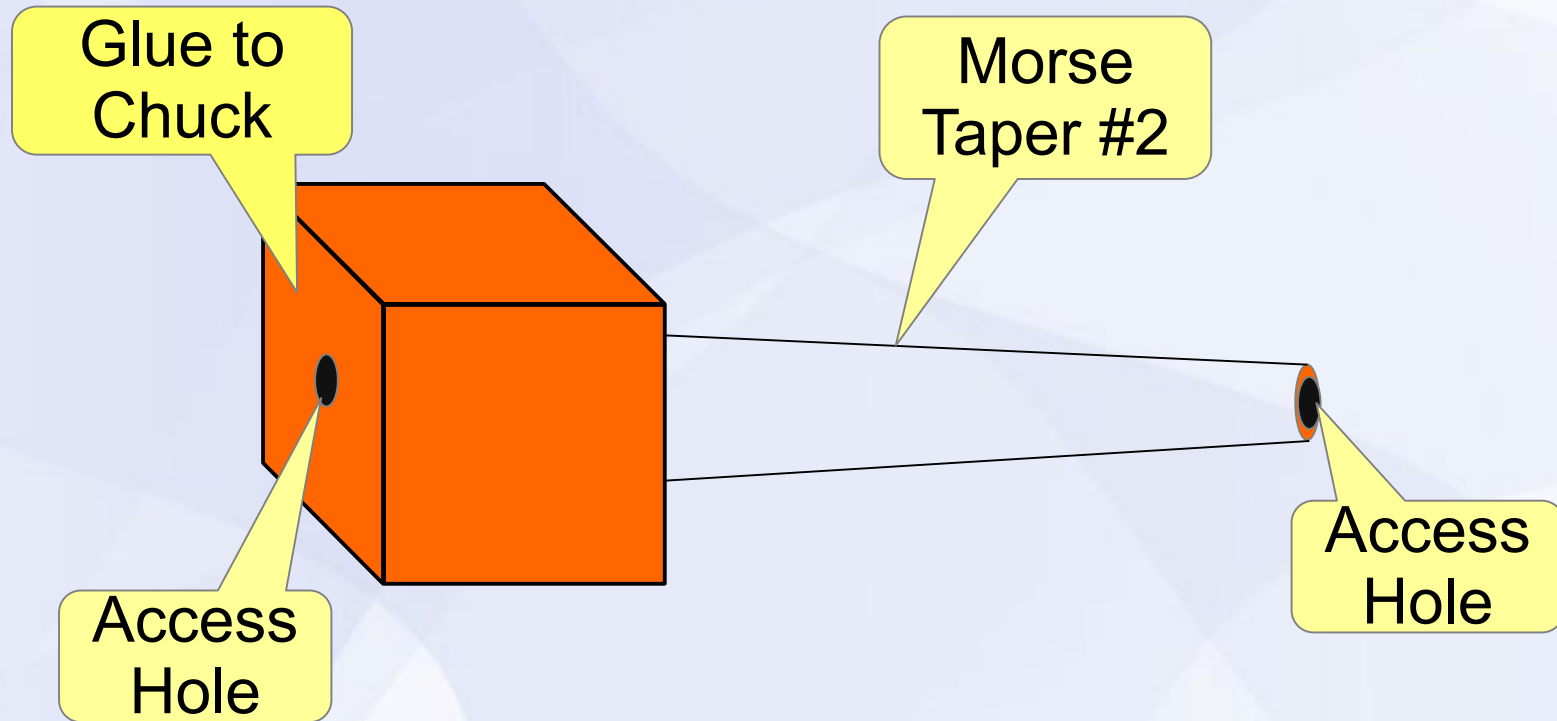
# Tenon Size



— Chuck Jaws  
— Tenon



# Morse Taper



# Design Features

- 4 Long Arcs, 4 Short Arcs
  - 8 bumpers for bowls  $> 3''$
  - 4 bumpers for bowls  $< 3''$
  - More strength in center of chuck
- Finger Holes
  - Partial Depth vs. Through Hole
  - Prevents “Finger Guillotine”

# Material

- Base
  - Baltic Birch Plywood
  - Corian
  - Plywood
    - Maple laminated on one side
    - Melamine laminated on other side
    - Available as a cut-off from Cabinets123

# Material (continued)

- Bumpers – pre-drilled silicon
- Hardware
  - 8 x 1/4" x 3-1/2" bolts for bumpers
  - 1-1/4" bolt & nylon nut to attach plates
  - 16 x 1/4" nylon washers for bumpers
  - 8 x 1/4" metal washer for bumpers (?)
  - 8 x 1/4" wingnuts for bumpers