

Drill Chucks

I have found 10 different Drill Chuck Assemblies. The part numbers listed below are for the complete Drill Chuck Assembly. Other part numbers can be found for drill chucks but those are for individual parts (the Drill Chuck minus the setscrew and key). Many of the different Drill Chuck Assemblies share the same part number. 7 different Drill Chuck Assemblies have part number 505633. Two part number changes occurred only because Magna Engineering changes their part numbering system November 1951 and Magna American changed their part numbering system in 1964. So there are single Drill Chuck Assemblies with more than one part number.

The first Chuck Assembly was the Jacobs 33B with an adapter to fit on the 5/8" spindle of the Shopsmith 10E. This was soon replaced by the Jacobs 3326 chuck made to go directly on the Shopsmiths spindle. There are 3 versions of the Jacobs 3326 Drill Chuck Assembly that had 5 different part numbers. The difference between these three Drill Chuck Assemblies has to do with the set screws. First it was a 3/8" set screw using a 3/16" Allen Wrench. That was followed in 1954 with a special 3/8" set screw that used a 5/32" Allen Wrench. Later the Jacobs 3326 was made for a standard 5/16" set screw using a 5/32" Allen Wrench. The Jacobs Multi-Craft Chucks and the Cushman Chuck were supplied mostly in the 1970's and 1980's. The two Jacobs Multi-Craft Chucks only difference is how they are labeled and their may be a third Multi-Craft Chuck again different in how it is labeled. The current chuck style first had an engraved SS logo followed by an etched SS logo outline then the current etched filled in SS. I have one Chuck of this style that has no markings but the etched logo may have rubbed off through use.

Part #	Description	Year
102-50	Jacobs No. 33B 102-33, Chuck Arbor 102-47X, Chuck Key 102-33K	1947
102-50X	Jacobs No. 3326, Ribbed side – 3/8" set screw w/ 3/16" hex	
107 100	Jacobs No. 3326, Ribbed Side – 3/8" set screw w/ 3/16" hex	1951
206100	Jacobs No. 3326, Ribbed side - Special 3/8" set screw w/ 5/32" hex	1954
206100	Jacobs No. 3326, Ribbed side – 5/16" set screw w/ 5/32" hex	
27100	Jacobs No. 3326, Ribbed side – 5/16" set screw w/ 5/32" hex	
505633	Jacobs No. 3326, Ribbed side – 5/16" set screw w/ 5/32" hex	1964
505633	Indented Label Strip - Jacobs Multi-Craft Chuck - (MC8K26 on nose)	
505633	Indented Label Strip - :: Jacobs :::: Multi-Craft Chuck :: MC8K26	
505633	Indented Knurled strip - Cushman Chuck	
505633	Ribbed side - longer nose - engraved SS logo	
505633	Ribbed side - longer nose - etched SS logo Outline	
505633	Ribbed side - longer nose - etched SS logo Filled	Current

All Chucks are up to 1/2" drill bit capacity. All 505633 Chucks have a 5/16" set screw using a 5/32" Allen Wrench. The current Chuck looks like a Jacobs 3326 style with a longer nose.

Drill Chuck Keys 3 drill Chuck key sizes

Jacobs 33B and 3326, larger gear with 1/4" pilot	Current Jacobs part # 30251
Cushman & Multi Craft Chucks, smaller gear with 9/32" pilot	Current Jacobs part # 30250
Current Chuck, larger gear with 9/32" pilot	Current Shopsmith part # 501419