

I have found 11 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 set screw and key). Many of the different Drill Chuck Assemblies share the same part number. 6 different Drill Chuck Assemblies have part number 505633. Two part number changes occurred only because Magna Engineering changed their part numbering system November 1951 and Magna American changed their part numbering system in early 1964. So, there are two Drill Chuck Assemblies each with more than one part number.

The first Drill Chuck Assembly was the Jacobs 33B (a threaded Chuck) with an adapter to fit on the 5/8" spindle of the Shopsmith 10E in 1947. This was soon replaced by the Jacobs 3326 Chuck made to go directly on the Shopsmith's spindle. It is listed in an early Montgomery Ward 10E Owner's Manual although the 33B and adapter is shown in the parts drawings. There are 3 versions of the Jacobs 3326 Drill Chuck Assembly that had 4 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 with 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 1960's to the 1980's but may have been out in the late 1950's. Three Jacobs Multi-Craft Chucks only differ in how they are labeled and there is a fourth Multi-Craft Chuck but with a different shaped nose. I do not know if this version of the Jacobs Multi-Craft Chuck was ever supplied with Shopsmith tools therefor in the list below it is shown without a part number. The Multi-Craft Chuck was first used in the 1960's and maybe earlier. A Multi-Craft Chuck came with an early 1963 Mark 5 Goldie.

The current chuck style first had an engraved SS logo followed by an etched SS logo outline then the current etched filled in SS logo. I have one Chuck of this style that has no markings but the etched logo may have worn off through use. I do not know who makes this Chuck for Shopsmith. The last Shopsmith Drill Chuck is the only one that is not a 1/2" capacity Drill Chuck but is 5/8" and Keyless.

Part #	Description	Year
102-50	Jacobs No. 33B 102-33, Chuck Arbor 102-47X, Chuck Key 102-33K	1947
102-50X	Jacobs No. 3326, 3/8" set screw w/ 3/16" hex	1948
107 100	Jacobs No. 3326, 3/8" set screw w/ 3/16" hex (same as above but new part number)	1951
206100	Jacobs No. 3326, Special 3/8" set screw w/ 5/32" hex	1954
206100	Jacobs No. 3326, 5/16" set screw w/ 5/32" hex	late 1954 or early 1955
27100	Jacobs No. 3326, 5/16" set screw w/ 5/32" hex *1 & 2	
27100	Indented Label Strip – (note – came with Mark 2) *3	Late 1950's
	JACOBS MULTI-CRAFT CHUCK HARTFORD CONN. U.S.A MC8K26 5/64 – 1/2 CAPACITY ::	
27100/505633	Indented Label Strip – (note – one came in Magna Am. Box P/N 27 100) *4	1963?
	JACOBS MULTI-CRAFT CHUCK HARTFORD CONN. U.S.A MC8K26 5/64 – 1/2 Capacity	
505633	Indented Label Strip has - JACOBS ::: MULTI-CRAFT CHUCK :::	
	On nose	MADE IN U.S.A = CAP. 5/64 – 1/2 = MC8K25 = 5/8 S.T. HOLE =
unknown	The barrel has –	Jacobs MULTI-CRAFT
	On nose	MC8K26 = 5/8 ST. HOLE = CAPACITY 5/64 – 1/2 = (different shaped nose) *5
505633	Indented Knurled strip - Cushman Chuck	1970's – 1980's?
505633	Similar to Jacobs 3326 - longer nose - engraved SS logo	
505633	Similar to Jacobs 3326 - longer nose - etched SS logo Outline	

505633	Similar to Jacobs 3326 - longer nose - etched SS logo Filled	Current
556273	5/8" Keyless Drill Chuck	2017/Current

NOTES:

All Chucks are up to 1/2" drill bit capacity except 556273. All 505633 Chucks have a 5/16" set screw using a 5/32" Allen Wrench. The current Chuck looks like an original Jacobs 3326 style with a longer nose.

*1 This Chuck shown in the November 1962 Catalog

*2 This Chuck shown in the February 1964 Catalog (same picture as the 1962 catalog)

This may be a case of the picture in the catalog being an older version and not the current part supplied.

Unknown when the Chuck changed from the regular Jacobs 3326 to the Multi-Craft Chuck.

*3 This chuck came with a Mark 2 Greenie

*4 This chuck was found in a Magna American Corporation Box P/N 27100.

Same Chuck that came with JPG's early 1963 Goldie and his Mark VII.

*5 I do not know if this version of the Jacobs Multi-Craft Chuck was ever supplied with Shopsmith tools therefor in the list it is shown without a part number.

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 SS Chuck, larger gear with 9/32" pilot

Current Shopsmith part # 501419

Drill Bits

Magna/Shopsmith has long sold its Brad Point Drill Bits going back to the Model 10 era and originally called them Auger Bits. They sold actual Auger Bits later for a time. A package of five bits included 1/4", 3/8", 1/2", 5/8" and 3/4" bits and still sold today as their standard package currently known as the Pro Premium Doweling Bits. It was previously known as the Basic set and the Pro Package. Currently they sell an additional package to supplement the Pro Premium Doweling Bits called the Pro Enhancer Premium Doweling Package which includes 3/16", 5/16", 7/16", 7/8" and 1" bits. It was previously called the Pro Enhancer Package. Both sets making a total of ten drill bits sells together as the Pro Ultra Premium Doweling Package for a small savings. They have had as many as 15 Brad Point Bits but are recently down to 12 sold individually. The additional 2 bits not included in the packages are a 1/8" and a 9/16" Brad Point Drill Bits. The 15 included the 1/8", 3/16", 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", 5/8", 11/16", 3/4", 13/16", 7/8", 15/16" and 1" bits. They no longer sell the 11/16", 13/16" or 15/16" brad point bits but have added a 9/32" twist drill bit to the list. Recently individual bits sold by SS have come from other suppliers. At one time (as shown in the 2008 catalog) Shopsmith Inc. sold a set of 14 Brad Point Drill Bits in a wood case that included all but the 1/8" bit.

References

Mark 5 S/N 281049 Sept 1954 still had Jacobs No. 3326, Special 3/8" set screw w/ 5/32" hex

Mark 2 S/N 84221 came with first version of the Jacobs Multi-Craft Chuck

Mark V S/N SS177057 May 1984 has Cushman Chuck