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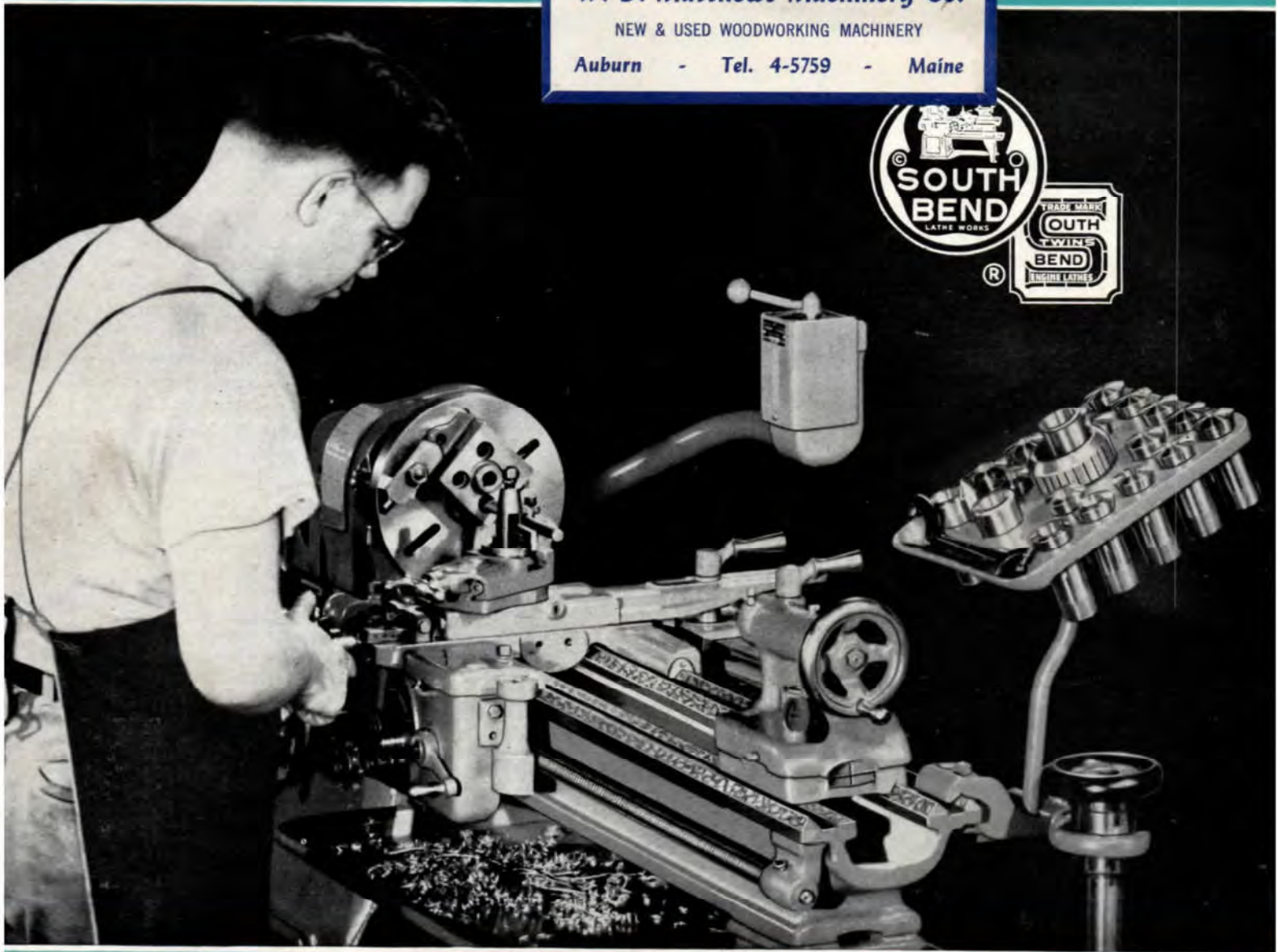
W. D. Matthews Machinery Co.  
New & Used Woodworking Machinery  
Auburn - Tel. 4-5759 - Maine

# ATTACHMENTS AND ACCESSORIES *for* SOUTH BEND LATHES

W. D. Matthews Machinery Co.

NEW & USED WOODWORKING MACHINERY

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**SOUTH BEND LATHE WORKS**

*Building Better Tools Since 1906*

425 E. MADISON ST., SOUTH BEND 22, IND., U.S.A.



# Who is South Bend Lathe Works?



It is a machine tool company with offices and factory at South Bend, Indiana. Founded in 1906 and incorporated in 1914 it remained a closely held enterprise until its stock was listed on The Chicago Stock Exchange in 1936. The Company is now owned by a diversified group of shareholders residing in all parts of the United States.

"South Bend" machine tools are used throughout the

world. Such wide acceptance is the result of a long series of progressive developments to which the best efforts of the South Bend Lathe Works have been devoted throughout its long history. Thus every "South Bend" purchaser receives a product backed by an organization which is not only financially sound, but strong in character, and rich in the machine tool tradition as well.

## Attachments and Accessories for South Bend Lathes

Many practical attachments and accessories designed especially for South Bend Lathes are shown in this catalog. Most of them may be ordered, either with the lathe or later. This complete line of attachments and accessories enables South Bend Lathes to handle many operations which otherwise might require special fixtures or machinery. Much time and expense can often be saved by selecting appropriate equipment for the lathe. A complete assortment of chucks and tools is essential for efficient lathe operation.

*Standard Extras* are items manufactured by us for use on South Bend Lathes, and include such items as draw-in collet chuck attachments, taper attachment, thread dial indicator, carriage stop, etc.

*Purchased Extras* are items which we do not manufacture but which we purchase from other manufacturers. In the case of such Purchased Extras we act only as a seller for the convenience of users of South Bend Lathes. Purchased Extras include motors and controls, lathe chucks, drill chucks, etc.

## Guarantee

The South Bend Lathe Works warrants its products to conform to or excel the specifications set forth in the manufacturer's catalogs in use at the time of sale and reserves the right, at its own discretion, without notice and without making similar changes in articles previously manufactured, to make changes in materials, design, finish, or specifications. The South Bend Lathe Works warrants products of its own factory against defects of material or workmanship for a period of

one year from the date of sale. The manufacturer's liability under this warranty shall be limited to replacing, free of charge, f.o.b., South Bend, Indiana, any such parts proving defective within the period of this warranty but the manufacturer will not be responsible for transportation charges or consequential damages. The South Bend Lathe Works makes no warranty with respect to electrical equipment or Purchased Extras as described in the manufacturer's catalogs.

## Prices

Prices of lathes, attachments, chucks, tools, and accessories in this catalog are net f.o.b. factory, South Bend, Indiana, U.S.A., and are subject to change without notice. All prices include packing and crating for domestic shipment to any point in the United States, Canada, or Mexico that can be reached by railroad freight. The prices listed do not include boxing and packing for overseas export shipment.

Purchased Extras listed in the catalog are items we do not manufacture but secure from other manufacturers. Since deliveries of such extras to us are not guaranteed, we cannot guarantee deliveries to our customers. When orders for purchased extras cannot be filled as a unit, we reserve the right to ship short and render invoices on the items shipped. Items omitted will be back-ordered and shipped as soon as available.

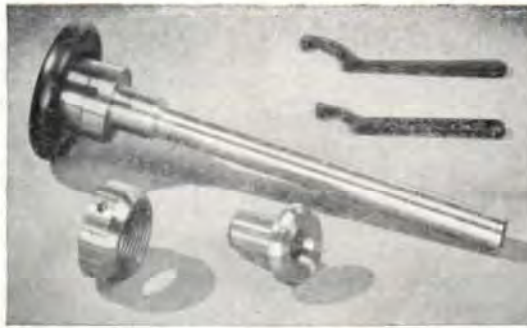


## SOUTH BEND LATHE WORKS

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## Handwheel Collet Attachment

The Handwheel Collet Attachment is a very accurate type of chuck. It is used for the chucking of small parts, especially when extremely close tolerances are required. Bar and tube stock can be fed through the hollow draw-bar that operates the collet. Equipment includes draw-bar, spindle nose cap, spanner wrench, and closing sleeve. Collets are not included.

Catalog No.	Size of Lathe	Collet Required	Max. Collet Capacity	Shipping Weight	Price Each
4306-W	9" & Series 900	No. 3	1/16"	5 lbs.	\$26.00
4310	10"-11 1/16" Collet	No. 2	1 1/16"	8 lbs.	42.00
4312	10"-1" Col. & Ser. 1000	No. 5	1"	10 lbs.	52.00
4313	13"-11 1/16" Collet	No. 2	1 1/16"	12 lbs.	42.00
4313-Q	13"-1" Collet	No. 5	1"	14 lbs.	52.00
4314	14 1/2"-3/4" Collet	No. 4	3/4"	14 lbs.	47.00
4314-M	14 1/2"-1" Collet	No. 5	1"	14 lbs.	52.00
4316	16", 2-H, & 16/24"	No. 5	1"	15 lbs.	52.00



## Handlever Collet Attachment

The Handlever Type Draw-in Collet Attachment permits releasing and feeding bar stock through the collet without stopping the lathe. The gripping action of the collet can be set to any desired tension by adjusting the cylinder of the adjustable chuck closer.

Equipment includes adjustable chuck closing mechanism and hollow draw-bar, spindle nose cap, spanner wrench for nose cap and tapered steel closing sleeve. Collets are not included. This attachment should be ordered with the lathe so that it can be properly fitted and tested at the factory.

Catalog No.	Size of Lathe	Collet Required	Max. Collet Capacity	Shipping Weight	Price Each
5206-W	9" and Series 900	No. 3	1/16"	10 lbs.	\$ 89.00
5210	10"-11 1/16" Collet	No. 2	1 1/16"	19 lbs.	126.00
5219	10"-1" Col. & Ser. 1000	No. 5	1"	20 lbs.	158.00
5213	13"-11 1/16" Collet	No. 2	1 1/16"	24 lbs.	126.00
5213-Q	13"-1" Collet	No. 5	1"	25 lbs.	158.00
5214	14 1/2"-3/4" Collet	No. 4	3/4"	29 lbs.	147.00
5214-M	14 1/2"-1" Collet	No. 5	1"	31 lbs.	188.00
5216	16", 2-H, & 16/24"	No. 5	1"	32 lbs.	188.00

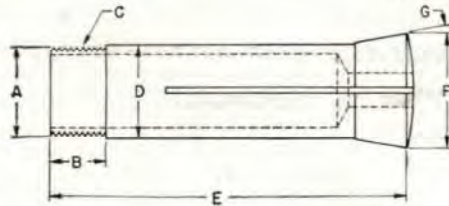
## Steel and Brass Collets

### For Use With Collet Attachments

South Bend Collets, manufactured with the same exacting care as South Bend Lathes, deliver long, dependable service on precision work. Each collet is carefully inspected and tested, and packed in a substantial plastic box with transparent lid through which the size can be read for easy selection.

Steel Collets are carefully heat-treated for maximum service and are precision ground to exceedingly close tolerances.

Brass Collets, a South Bend innovation, have many practical applications. Their low cost makes them desirable for odd sizes that are used only occasionally. They can be readily machined on the job for holding tapered or irregular shapes. When worn, they can be rebored to larger diameters.



### Specifications of Collets for South Bend Lathes

Collet No.	3	2	4	5
Sizes of Lathes used on*	9" & Series 900	10"-11 1/16" Col. & 13"-11 1/16" Col.	14 1/2" Col. & 3/4" Col.	10"-1" Col. & 13"-1" Col. & 14 1/2"-1" Col. & 16" Series 1000, No. 2-H, & 16/24"
A, Thread Diameter, in.	.550	.855	.950	1.250
B, Thread Length, in.	3/4	1 1/16	1 3/16	3/4
C, Threads per in.	26	20	20	20
D, Body Diameter, in.	.6495	.8595	.9495	1.2495
E, Collet Length, in.	2 1/16	3 3/16	3	3 3/8
F, Head Diameter, in.	.852	1.095	1.150	1.452
G, Angle of Head, deg.	12	15	10	10

\*Collets can also be used on any other lathe or machine which they will fit.

### Collets With Standard Hole Sizes for Round Work

Collet No.	Collet Capacity in 64ths for Round Work	Ship. Wt.	Brass Collets		Steel Collets	
			Cat. No.	Price	Cat. No.	Price
3	1/16" to 3/16"	6 ozs.	1696	\$2.00	609-W	\$3.75
2	1/8" to 1/4"	8 ozs.	1697	2.25	1721	4.00
4	3/16" to 1/2"	8 ozs.	1699	2.35	1713	4.25
5	1/4" to 1"	1 lb.	1698	2.50	1722	4.75

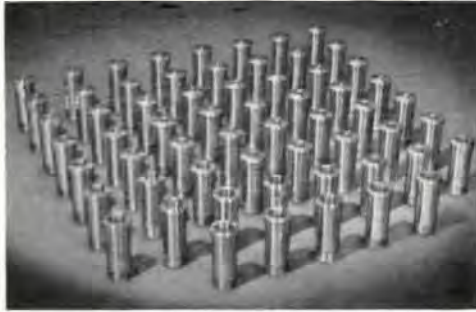
### Collets With Decimal Hole Sizes for Round Work

Collet No.	Collet Capacity for Round Work	Ship. Wt.	Brass Collets		Steel Collets	
			Cat. No.	Price	Cat. No.	Price
3	.0625" to .500"	6 ozs.	1856	\$2.15	769-W	\$4.00
2	.0625" to .6875"	8 ozs.	1857	2.40	769-N	4.25
4	.0625" to .750"	8 ozs.	1859	2.50	769-K	4.50
5	.0625" to 1.000"	1 lb.	1858	2.65	769-R	5.00

### Collets With Metric Hole Sizes for Round Work

Collet No.	Collet Capacity for Round Work	Ship. Wt.	Brass Collets		Steel Collets	
			Cat. No.	Price	Cat. No.	Price
3	1.5 mm to 12.5 mm	6 ozs.	1702	\$2.15	773-W	\$4.00
2	1.5 mm to 17.0 mm	8 ozs.	1703	2.40	773-N	4.25
4	1.5 mm to 19.0 mm	8 ozs.	1705	2.50	773-K	4.50
5	1.5 mm to 25.0 mm	1 lb.	1704	2.65	773-R	5.00





### Collets in Sets

Collets for South Bend Lathes can be supplied in sets as listed in the tabulation below. A complete set of collets is especially helpful for toolroom and maintenance work. Often the time saved in getting out a single rush job without having to wait for a collet to come from the factory will more than compensate for the cost of a full set of collets. Each collet is individually packed in a plastic box with transparent lid.

#### Steel Collets in Sets

Collet No.	Catalog No.	Collets in Set	Sizes of Collets	Ship. Wt.	Price per Set
3	2047	8	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	3 lbs.	\$27.00
	2476	7	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	3 lbs.	24.00
	2477	14	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	6 lbs.	46.00
2	2432	11	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	6 lbs.	39.00
	2478	10	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	6 lbs.	36.00
	2479	20	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	12 lbs.	71.00
4	2438	12	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	7 lbs.	46.00
	2480	11	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	7 lbs.	42.00
	2481	22	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	12 lbs.	81.00
5	2435	16	$\frac{1}{8}$ " to 1" in 16ths	11 lbs.	68.00
	2482	15	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	11 lbs.	64.00
	2483	30	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	20 lbs.	127.00

#### Brass Collets in Sets

Collet No.	Catalog No.	Collets in Set	Sizes of Collets	Ship. Wt.	Price per Set
3	2235	8	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	3 lbs.	\$15.00
	2534	7	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	3 lbs.	13.00
	2535	14	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	6 lbs.	24.00
2	2238	11	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	6 lbs.	23.00
	2536	10	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	6 lbs.	21.00
	2537	20	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	12 lbs.	40.00
4	2244	12	$\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths	7 lbs.	26.00
	2538	11	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	7 lbs.	24.00
	2539	22	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	12 lbs.	45.00
5	2241	16	$\frac{1}{8}$ " to 1" in 16ths	11 lbs.	37.00
	2540	15	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 32nds.	11 lbs.	35.00
	2541	30	$\frac{3}{16}$ " to $\frac{1}{2}$ " in odd 64ths.	20 lbs.	68.00

### Collets for Square and Hexagon Work

Collets for holding square and hexagon stock can be supplied to order, as listed below. These collets are made of steel, and are properly heat-treated for long service. Collets are made in sixty-fourths, from  $\frac{1}{8}$ " across flats up to maximum capacity shown in table.



Collet No.	Shipping Wt.	Collets for Square Work		Collets for Hexagon Work		Price Each
		Cat. No.	Max. Cap.	Cat. No.	Max. Cap.	
3	6 ozs.	2176	$\frac{11}{16}$ "	2181	$\frac{7}{16}$ "	\$6.75
2	8 ozs.	2177	$\frac{15}{16}$ "	2182	$\frac{17}{16}$ "	7.00
4	8 ozs.	2179	$\frac{17}{16}$ "	2184	$\frac{19}{16}$ "	7.25
5	1 lb.	2178	$\frac{35}{16}$ "	2183	$\frac{37}{16}$ "	7.75

### Collet Rack

This collet rack provides a convenient place for keeping collets, centers, spindle sleeve, and draw-bar. Tray along lower edge of collet rack is provided for holding spanner wrench. Clamp for attaching to back V-way of lathe bed is supplied. Price does not include collets or collet attachment.



#### Collet Racks for South Bend Lathes

Catalog Number	Size Lathe	Rack Holds	Ship. Wt.	Factory Price
1770-W	9" and Series 900	19 Collets	9 lbs.	\$13.00
1752	10" $\frac{1}{8}$ " Collet	17 Collets	10 lbs.	16.00
1753	10"-1" Collet & Series 1000	17 Collets	10 lbs.	18.00
1772	13" $\frac{1}{8}$ " Collet	17 Collets	11 lbs.	16.00
1772-O	13" 1" Collet	17 Collets	12 lbs.	18.00
1791	14" $\frac{1}{8}$ " Collet	17 Collets	13 lbs.	18.00
1774-M	14" $\frac{1}{2}$ "-1" Collet	17 Collets	14 lbs.	18.00
1774	16", No. 2-H, and 16/24"	17 Collets	15 lbs.	18.00

### Collet Chest

Protects Collets from Damage



for 9" Lathe Only

#### For Holding Collets and Collet Attachment

This is a well-constructed wooden chest for holding the handwheel collet attachment and up to 29 collets for a 9-inch South Bend Lathe. Hinged lid protects the collets and collet attachment from dust and dirt when not in use. Price does not include collet attachment or collets.

Cat. No. 2225. Shipping weight 7 lbs. .... \$7.50

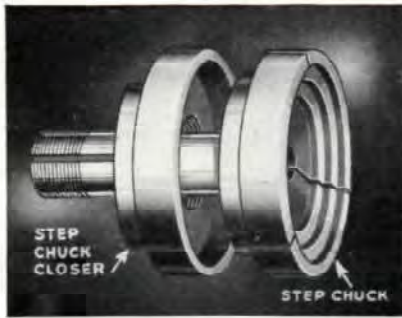
### Special Combination Sets

#### Collet Chest With Collet Attachment and Collets

The Collet Chest illustrated and described above can be supplied fitted with the handwheel type collet attachment for the 9-inch South Bend Lathe and various assortments of steel or brass collets. Space is provided for a full set of 29 collets, regardless of the number of collets included in the price of each of the smaller assortments. This permits adding collets as desired, until a full set is acquired.

Cat. No.	Description	Price
2220	Collet chest, 9" handwheel collet attachment, 29 steel collets for round work, $\frac{1}{8}$ " to $\frac{1}{2}$ " in 64ths. Shipping weight 14 lbs.	\$123.00
2228	Collet chest, 9" handwheel collet attachment, 8 steel collets for round work, $\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths. Shipping weight 12 lbs.	58.00
2290	Collet chest, 9" handwheel collet attachment, 29 brass collets for round work, $\frac{1}{8}$ " to $\frac{1}{2}$ " in 64ths. Shipping weight 14 lbs.	80.50
2293	Collet chest, 9" handwheel collet attachment, 8 brass collets for round work $\frac{1}{8}$ " to $\frac{1}{2}$ " in 16ths. Shipping weight 12 lbs.	47.00





## Step Chucks and Closers

Step Chucks and Closers are used with either the hand-wheel type or the handlever type draw-in chuck attachment for holding discs, gear blanks, and similar round, flat work. The closer screws onto the threaded end of the lathe spindle nose and the step chuck screws into the threaded hole in the draw bar of the draw-in collet chuck attachment.

Step chucks are made to order in various sizes, having a maximum capacity of 2", 3", 4", 5" and 6" respectively. The 2" size fits directly into the collet sleeve and does not require a closer, but all other sizes must be used with a closer of required size. See table below.

Step chucks are supplied with the head blank and must be machined by the user to hold the work.

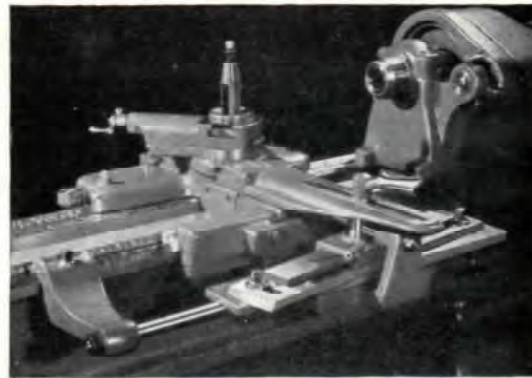
Step Chuck Closers

Cat. No.	Size Lathe	Takes Step Chuck Nos.	Ship. Wt.	Factory Price
6309-N 6311-N	9" and 900— $\frac{1}{2}$ " Collet	5917 or 5918 5919 or 5920	3 lbs. 5 lbs.	\$ 4.50 7.00
6309-R 6311-R	10"— $\frac{1}{4}$ " Collet	5922 or 5923 5924 or 5925	4 lbs. 5 lbs.	5.25 7.85
6309-L 6311-L	10", 1000, & 13"—1" Collet	5927 or 5928 5929 or 5930	4 lbs. 6 lbs.	6.50 8.95
6309-T 6311-T	13"— $\frac{1}{4}$ " Collet	5922 or 5923 5924 or 5925	4 lbs. 5 lbs.	5.35 7.95
6309-F 6311-F	14 $\frac{1}{2}$ "— $\frac{3}{4}$ " Collet	5932 or 5933 5934 or 5935	5 lbs. 7 lbs.	7.00 9.80
6309-H 6311-H	14 $\frac{1}{2}$ ", 16", 2-H, & 16/24"—1" Collet	5927 or 5928 5929 or 5930	5 lbs. 7 lbs.	7.50 10.25

Step Chuck Blanks

Cat. No.	Style No.	Style Lathe	Max. Cap.	Ship. Wt.	Factory Price
5916*	3	9" and 900	2"	2 lbs.	\$ 9.25
5917			3"	3 lbs.	10.75
5918			4"	5 lbs.	12.50
5919			5"	8 lbs.	14.00
5920			6"	12 lbs.	18.50
5921*	2	10" & 13"—11/16" Col.	2"	4 lbs.	10.50
5922			3"	4 lbs.	12.00
5923			4"	5 lbs.	13.50
5924			5"	9 lbs.	18.00
5925			6"	13 lbs.	17.00
5931*	4	14 $\frac{1}{2}$ "— $\frac{3}{4}$ " Col.	2"	4 lbs.	10.50
5932			3"	4 lbs.	12.00
5933			4"	5 lbs.	13.50
5934			5"	9 lbs.	18.00
5935			6"	13 lbs.	18.50
5926*	5	10", 1000, 13", 14 $\frac{1}{2}$ ", 16", 2-H, & 16/24"—1" Col.	2"	4 lbs.	11.50
5927			3"	4 lbs.	13.50
5928			4"	5 lbs.	15.50
5929			5"	9 lbs.	17.50
5930			6"	13 lbs.	19.50

\*This step chuck fits directly into collet sleeve and does not require a closer.



## Taper Attachment

Taper turning and boring are as easily accomplished as straight turning on lathes equipped with the South Bend Telescopic Taper Attachment. The taper attachment swivel bar is graduated in degrees on one end and taper in inches per foot on the other end.

A telescopic taper attachment is supplied on 10-inch and larger lathes. A telescopic cross-feed screw eliminates the necessity of disconnecting the cross-feed nut when the tapers are machined. The cross-feed screw may be used to adjust the lathe tool for the required diameter. When the binding lever is tightened, the cross slide base is rigidly locked to the taper attachment swivel slide, and the thrust is removed from the cross-feed screw.

A plain taper attachment is supplied for the 9-inch Lathes. This taper attachment has plain cross-feed screw and straight gibs. The cross-feed screw and nut must be disconnected before the taper attachment can be engaged for taper turning and boring.

The taper attachment is permanently mounted on the lathe carriage and is always ready for use. It does not in any way interfere with straight turning and boring, and only a few seconds are required to change over from straight to taper work. Accuracy and smooth operation are assured by the practical design and rugged construction of this attachment.

The taper attachment must be fitted to lathe at factory.

Taper Attachment With English Graduations

Cat. No.	Size of Lathe	Swing Over Cross Slide	Maximum Taper			Approx. Ship. Wt.	Factory Price
			At One Setting	Per Foot	In Degrees		
428-W	9"	5"	7"	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	35 lbs.	\$ 80.00
1845	10"	5 $\frac{1}{4}$ "	8 $\frac{1}{2}$ "	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	40 lbs.	145.00
379	13"	8"	9 $\frac{1}{2}$ "	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	65 lbs.	165.00
399	14 $\frac{1}{2}$ "	8 $\frac{1}{2}$ "	9 $\frac{1}{2}$ "	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	80 lbs.	177.00
381	16"	9 $\frac{1}{2}$ "	11 $\frac{1}{2}$ "	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	100 lbs.	198.00
381	16/24"	19"	11 $\frac{1}{2}$ "	3 $\frac{1}{2}$ "	16 $\frac{1}{2}$	100 lbs.	198.00

## Taper Attachment With Metric Graduations

Taper attachments similar to those described above can be supplied to order with metric graduations in addition to the usual English graduations. The metric graduations show the taper in mm per cm. Maximum taper is 3 mm per cm.

Taper Attachment With Metric Graduations

Catalog No.	Size of Lathe	Swing Over Cross Slide	Maximum Taper			Approx. Ship. Wt.	Factory Price
			At One Setting	Per cm	In Degrees		
428-ME	9"	5"	7"	3 mm	16 $\frac{1}{2}$	35 lbs.	\$ 80.00
1845-ME	10"	5 $\frac{1}{4}$ "	8 $\frac{1}{2}$ "	3 mm	16 $\frac{1}{2}$	40 lbs.	145.00
379-ME	13"	8"	9 $\frac{1}{2}$ "	3 mm	16 $\frac{1}{2}$	65 lbs.	168.00
399-ME	14 $\frac{1}{2}$ "	8 $\frac{1}{2}$ "	9 $\frac{1}{2}$ "	3 mm	16 $\frac{1}{2}$	80 lbs.	177.00
381-ME	16"	9 $\frac{1}{2}$ "	11 $\frac{1}{2}$ "	3 mm	16 $\frac{1}{2}$	100 lbs.	198.00
381-ME	16/24"	19"	11 $\frac{1}{2}$ "	3 mm	16 $\frac{1}{2}$	100 lbs.	198.00





### Automatic Carriage Stop

In shops where one man may operate two or more machines, it is sometimes desirable to have lathes equipped with automatic carriage stops, as shown above. This enables the operator to place the work in the lathe, engage the power longitudinal feed for the cut and then proceed to other work. When the end of the cut is reached, the power longitudinal carriage feed is automatically disconnected.

The automatic carriage stop is especially desirable for production operations which require fairly long cuts at one setting of the cutting tool. While a cut is being taken on one lathe, the operator can remove a finished piece from another lathe and replace it with a new piece. In this way both the machines and the operator are busy most of the time and the work is done efficiently.

This attachment must be ordered with the lathe and fitted at the factory.

Cat. No.	Size Lathe	Price	Cat. No.	Size Lathe	Price
1662-R	10"	\$158.00	1662-F	14 1/2"	\$170.00
1662-T	13"	164.00	1662-H	16"	176.00

### Four Position Carriage Stop



Much time can be saved in positioning the cutting tool for repetitive operations, by using this four position carriage stop. Each of the four adjustable stops may be set for a different tool position, and may be revolved into position to locate the carriage for each of four successive cuts. This attachment is especially

desirable for spacing shoulders in shafts and similar operations.

Catalog Number	Size Lathe	Shipping Weight	Factory Price
2185-N	9"	6 lbs.	\$18.00
2185-R	10"	6 lbs.	20.00
2185-T	13"	8 lbs.	21.00
2185-F	14 1/2"	10 lbs.	22.00
2185-H	16" & 16/24"	10 lbs.	23.00

### Thread Dial Indicator

Eliminates reversing of lathe spindle when cutting threads. Dial is numbered and graduated to show when to close half-nuts on lead screw to catch the thread on each successive cut, after returning carriage to the starting point.



Cat. No.	Size Lathe	Ship. Wt.	Price
810-W	9"	2 lbs.	\$ 9.00
1588	10"	3 lbs.	14.00
813	13"	5 lbs.	16.00
813	14 1/2"	5 lbs.	16.00
813	16" & 16/24"	5 lbs.	16.00

### Micrometer Stop



Patent Pending

This attachment is useful for accurate facing, turning, boring, etc. It is used for locating the carriage at any point along lathe bed. Can be used on either side of carriage. Has accurately graduated micrometer collar. Either English or metric graduations can be supplied.

The stop is hardened on both ends and may be locked for duplicate work.

Size Lathe	Ship. Wt.	Metric Graduations		English Graduations	
		Cat. No.	Price	Cat. No.	Price
9"	2 lbs.	968-ME	\$16.00	968-W	\$16.00
10"	4 lbs.	1518-ME	17.00	1518	17.00
13"	4 lbs.	973-ME	19.00	973	19.00
14 1/2", 16" & 16/24"	7 lbs.	975-ME	20.00	975-FH	20.00

### Plain Carriage Stop



This stop may be clamped onto the front V-way of the lathe bed, on either side of the saddle, to locate the position of the cutting tool for facing, necking, cutting shoulders, and similar operations.

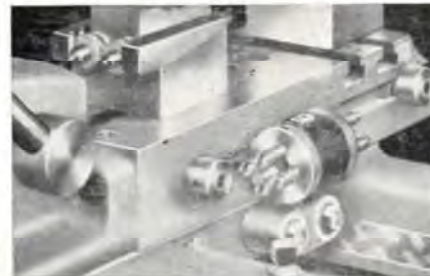
Catalog Number	Size Lathe	Shipping Weight	Factory Price
758-N	9"	2 lbs.	\$3.70
758-R	10"	4 lbs.	3.95
758-T	13"	4 lbs.	4.75
758-FH	14 1/2", 16" & 16/24"	7 lbs.	5.80

### Thread Cutting Stop



The Thread Cutting Stop is clamped onto the saddle cross-slide dovetail and is used for regulating the depth of cut for each successive chip when cutting screw threads. Price includes stop complete with clamp and knurled thumb screw.

Catalog Number	Size Lathe	Shipping Weight	Factory Price
2250-N	9"	1/2 lb.	\$4.00
2250-R	10"	1/2 lb.	4.25
2250-T	13"	1 lb.	4.75
2250-F	14 1/2"	1 lb.	5.50
2250-H	16" & 16/24"	2 lbs.	6.00

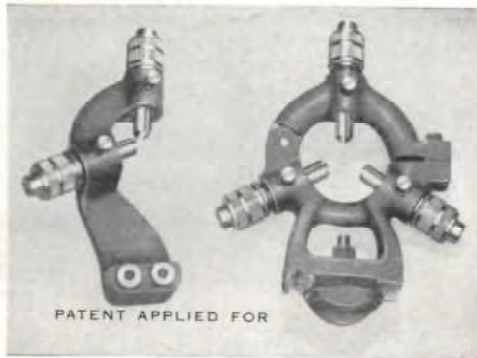


### Four Position Cross Slide Stop

This stop fits onto the handlever double tool cross slide (Cat. No. 2030-W or 2031) in place of the regular cross slide stop. It has four adjustable stops for locating the position of the cutting tools for each of four successive operations.

2154-NR. Four Position Stop for Handlever Cross Slide. Shipping weight 2 lbs. \$12.00





### Telescoping Jaw Center Rest and Follower Rest

To provide quicker and more efficient operation, the Telescoping Jaw Follower Rest and Center Rest have been developed. Principle features of both the Follower Rest and Center Rest are wrenchless adjustment and locking of the telescoping jaws. Each jaw has a large knurled knob for adjusting the jaw position, and a thumb screw for locking. An ingeniously designed double acting compound screw thread provides approximately 3/16" jaw movement for each revolution of the adjusting knob.

The jaws are made of brass and slide through precision steel sleeves which are pressed into the supporting frame. Manufactured to close tolerances throughout, the jaws and other parts are replaceable.

#### Center Rest

The Center Rest is clamped to the inside bed ways, and is used to support long, slender shafts mounted between the lathe centers. It is also used to support the outer end of a bar or shaft in such a way that it may be drilled, bored, reamed, etc., with tools mounted in the tailstock or in the tool post of the lathe. The top of the center rest is hinged to facilitate inserting and removing shafts.

#### Telescoping Jaw Center Rest

Catalog Number	Size Lathe	Maximum Capacity	Minimum Capacity	Shipping Weight	Factory Price
2400-N	9 in.	3 in.	3/8 in.	11 lbs.	\$11.00
2400-R	10 in.	3 in.	3/8 in.	13 lbs.	14.00
2400-T	13 in.	3 3/4 in.	3/8 in.	21 lbs.	17.00
2400-F	14 1/2 in.	4 1/4 in.	3/8 in.	28 lbs.	20.00
2400-H	16 in.	4 3/4 in.	3/8 in.	30 lbs.	22.00
2400-V	16/24 in.	4 3/4 in.	3/8 in.	47 lbs.	29.00

#### Follower Rest

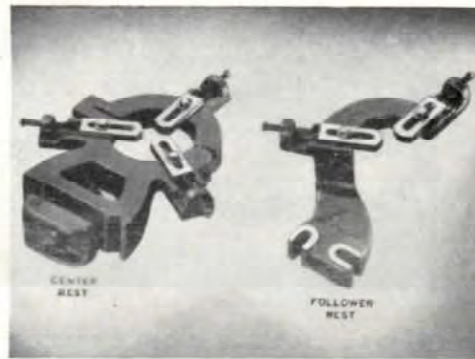
The Follower Rest is attached to the lathe carriage and travels with the carriage. The follower rest is used to support long, slender shafts while being machined between the lathe centers.

#### Telescoping Jaw Follower Rest

Catalog Number	Size Lathe	Maximum Capacity	Minimum Capacity	Shipping Weight	Factory Price
2395-N	9 in.	2 in.	3/8 in.	7 lbs.	\$ 7.00
2395-R	10 in.	2 1/2 in.	3/8 in.	9 lbs.	9.00
2395-T	13 in.	3 3/4 in.	3/8 in.	11 lbs.	10.00
2395-F	14 1/2 in.	4 1/4 in.	3/8 in.	15 lbs.	12.00
2395-H	16 in.	4 3/4 in.	3/8 in.	17 lbs.	13.00
2395-V	16/24 in.	4 3/4 in.	3/8 in.	21 lbs.	18.00



SOUTH BEND LATHE WORKS



### Regular Center Rest and Follower Rest

The Regular Center Rest and Follower Rest are ruggedly designed to provide a rigid support for the work. The jaws are made of cast iron, are machined all over and have adjusting screws and lock screws for setting and securing them in the desired position.

#### Center Rest

The Center Rest clamps onto the inside ways of the lathe bed and is used for supporting long shafts, boring spindles, etc. The top of the center rest is hinged to facilitate inserting and removing shafts.

#### Regular Center Rest

Catalog Number	Size Lathe	Maximum Capacity	Minimum Capacity	Shipping Weight	Factory Price
125-W	9 in.	3 in.	3/4 in.	10 lbs.	\$ 7.50
1177	10 in.	3 in.	3/4 in.	11 lbs.	11.00
341	13 in.	3 3/4 in.	3/4 in.	19 lbs.	14.00
1174	14 1/2 in.	4 3/4 in.	3/4 in.	27 lbs.	17.00
720	16 in.	4 3/4 in.	3/4 in.	29 lbs.	19.00
1175	16/24 in.	4 3/4 in.	3/4 in.	47 lbs.	26.00

#### Follower Rest

The Follower Rest is attached to the lathe carriage and travels with the carriage. The Follower Rest is used to support long, slender shafts while being machined between the lathe centers. Slots used for attaching follower rest to carriage permit attaching or removing quickly as it is not necessary to remove the screws from the saddle.

#### Regular Follower Rest

Catalog Number	Size Lathe	Maximum Capacity	Minimum Capacity	Shipping Weight	Factory Price
34-W	9 in.	2 in.	3/8 in.	4 lbs.	\$ 5.00
1353	10 in.	2 1/2 in.	3/8 in.	6 lbs.	7.50
376	13 in.	3 1/2 in.	3/8 in.	9 lbs.	8.50
1351	14 1/2 in.	4 1/4 in.	3/8 in.	12 lbs.	10.00
730	16 in.	4 1/4 in.	3/8 in.	13 lbs.	11.00
1352	16/24 in.	4 1/4 in.	3/8 in.	18 lbs.	16.00

### Extra Large Center Rest



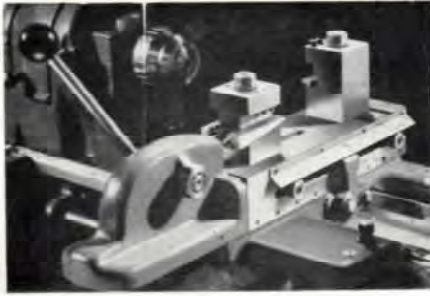
Similar to center rests described above, but with capacity for large diameter work. Takes from 4-3/4" diameter to 10-3/4" diameter.

2258-H. Extra Large Center Rest for 16" Lathe. Shipping weight 58 lbs. Price..... \$32.50

2258-V. Extra Large Center Rest for 16/24" Lathe. Shipping weight 74 lbs. Price..... \$39.00

SOUTH BEND 22, INDIANA, U.S.A.





### Handlever Double Tool Cross Slide for 9" and 10" South Bend Lathes

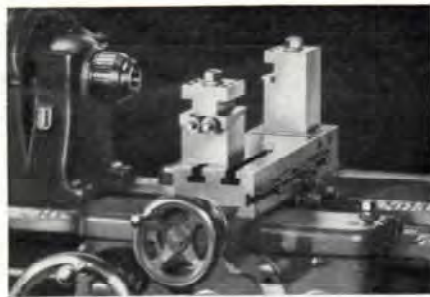
This Handlever Double Tool Cross Slide is mounted on the saddle cross slide dovetail in place of the compound rest assembly. It does not interfere with the power longitudinal carriage feeds. The power cross-feed can be used by removing the handlever and replacing it with the cross-feed screw. Adjustable stops limit the movement of the cross slide in either direction, in or out.\* The handlever can be used on either the right side or the left side of the cross slide.

This cross slide has front and back square tool blocks in which  $\frac{7}{16}$ " square cutter bits can be mounted. T-slots in the cross slide base permit adjusting the positions of the tool blocks. The front tool block takes two cutter bits, and the back tool block takes one cutter bit. Tapered wedges and thumb screws provide precision adjustment for the height of the cutter bits.

Cat. No. 2030-W. Handlever Cross Slide for 9" South Bend Lathe. Shipping weight 36 lbs. .... \$79.00

Cat. No. 2031. Handlever Cross Slide for 10" South Bend Lathe. Shipping weight 45 lbs. .... \$95.00

\*A Four Position Cross Slide Stop can be supplied. See page 6.



### Screw Feed Double Tool Cross Slide for 16" South Bend Lathes

This cross slide fits on the saddle dovetail in place of the compound rest assembly. The cross-feed may be operated by power through the friction clutch in the apron, as well as by the cross-feed handwheel. A large diameter micrometer graduated collar permits adjusting the cutting tools with extreme precision.

Adjustable stops are provided for locating the position of the front and rear tools for repetitive operations. The front tool block takes two  $\frac{5}{8}$ " square cutter bits and the back tool block takes one  $\frac{5}{8}$ " square cutter bit. Tapered wedges are provided for adjusting the height of the cutter bits. T-slots in the cross slide base are provided for adjusting the position of the tool blocks.

This attachment should be ordered with the lathe and fitted at the factory.

Cat. No. 2027. Screw Feed Double Tool Cross Slide for 16" Lathe. Shipping weight 95 lbs. .... \$131.00



Patent Pending

### Square Turret Tool Block for Compound Cross Slide

The Square Turret Tool Block shown above is designed for use on the base of the compound cross slide. It cannot be used on the double tool cross slide.

Four cutting tools can be mounted in the turret tool block. The turret indexes accurately, permitting each tool to be used in sequence for rough turning, finish turning, facing, boring, cutting-off, or other operations as required. A quick acting lever locks the turret securely in each of the four positions. Rocker adjustment is provided for adjusting the height of the cutting edge of each tool.

#### Square Turret Tool Block for Compound Cross Slide

Catalog Number	Size of Lathe	Size Square	Takes Tools	Ship. Wt.	Factory Price
40-NC	9" and Series 900	3"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	13 lbs.	\$48.00
41-NC	10" and Series 1000	3"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	15 lbs.	48.00
43-NC	13"	3"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	30 lbs.	53.00
44-NC	14 $\frac{1}{2}$ "	4"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	36 lbs.	75.00
42-NC	16" & 16/24"	4"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	40 lbs.	80.00



Patent Pending

### Square Turret Tool Block for Double Tool Cross Slide

The Square Turret Tool Block shown above is designed for use on the screw feed double tool cross slide. It cannot be used on the compound rest cross slide.

Four cutting tools can be mounted in the turret tool block. The turret indexes accurately, permitting each tool to be used in sequence for rough turning, finish turning, facing, boring, cutting-off, or other operations as required. A quick acting lever locks the turret securely in each of the four positions. Rocker adjustment is provided for adjusting the height of the cutting edge of each tool.

#### Square Turret Tool Block for Double Tool Slide

Catalog Number	Size of Lathe	Size Square	Takes Tools	Ship. Wt.	Factory Price
41-ND	9", Ser. 900, 10", & Ser. 1000	3"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	9 lbs.	\$42.00
42-ND	16" and No. 2-H	4"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	20 lbs.	75.00





### Handlever Bed Turret for 9", 10", and 13" South Bend Lathes

The Handlever Bed Turret mounts on the inside bed ways and can be locked in position at any point along the length of the bed. The turret base clears the saddle wings of the lathe carriage, which slides on the outer bed ways. This construction permits the turret to be placed close to the headstock and eliminates excessive overhang of the work or the turret tools.

With this turret mounted on the lathe, small precision parts can be economically manufactured. It equips the lathe for fast, efficient production, yet the lathe may easily be adapted to other classes of work.

The turret slide has gibs on both sides which provide adjustment for wear. Each face of the turret has an independently adjustable feed stop screw which accurately regulates the length of the cut. The stop screw roll rotates automatically so that each screw is brought in line with the stop as the corresponding face of the turret head is revolved to the working position.

Accurate indexing of the turret head (within plus or minus .0005" measured 4" from turret face) is assured by the use of hardened, ground, and superfinished index pin which operates in heat-treated steel bushings. The index bushings are replaceable. The turret head may be back-indexed or spun when it is desired to skip tool positions. A substantial binder permits locking the turret head securely for taking heavy cuts.

The effective feed of the turret slide is 4". Center of turret hole to top of turret slide 1 1/2". Takes standard turret tools with 3/8" diameter shank\*. Distance between opposite flats on turret head is 4 7/8". When turret is ordered separate from lathe, the purchaser must assume the responsibility of fitting and boring.

Cat. No. 1611-W. Handlever Bed Turret for 9" South Bend Lathe. Ship. wt. 76 lbs. Factory price.....\$210.00

Cat. No. 1612. Handlever Bed Turret for 10" South Bend Lathe. Ship. wt. 83 lbs. Factory price.....\$220.00

Cat. No. 1613. Handlever Bed Turret for 13" South Bend Lathe. Ship. wt. 130 lbs. Factory price.....\$237.00

\*Can be supplied to order with 3/4" holes in turret face. No extra charge.



### Precision Level

Precision tolerances can be maintained only when the lathe is properly leveled. Often the machine is mistakenly thought to be inaccurate when the entire difficulty is due to incorrect leveling. With this sensitive precision level, a lathe or other machine can be properly installed and leveled. The level has a ground and graduated vial mounted in a twelve inch cast iron frame with machined base having a V-way for leveling shafts. It has been carefully designed to provide just the right degree of sensitivity for quick and accurate leveling. We recommend that every shop be equipped with one of these levels.

Cat. No. 2218. Precision Level. Shipping weight 5 lbs. Factory price.....\$9.75



### Hand Feed Turnstile Bed Turret for 16" South Bend Lathe

The Hand Feed Turnstile Bed Turret is mounted on the inside bed ways of the lathe. The large turnstile is provided for hand operated turret slide feeds. No power feed is available\*.

The turret head is hexagonal in shape, having six accurately machined faces. It indexes automatically when the turret slide is returned to the starting position. An individual feed stop is provided for each face of the turret. The stop accurately regulates the length of the cut. The turret head may be back indexed or spun when it is desired to skip tool positions.

Accurate indexing (within plus or minus .0005" measured 4" from turret face) is assured by the use of a hardened, ground, and superfinished index pin which operates in heat-treated steel bushings. The indexing bushings are replaceable. The main central bearing is tapered for adjustment. The turret head is locked securely in position by a substantial binder. The turret slide has tapered gibs on both sides which provide adjustment for wear and alignment.

Effective feed of turret slide 6 1/8". Center of turret hole to top of turret slide 2 1/2". Takes standard turret tools with 1 1/2" diameter shank. Distance between opposite turret flats is 9 3/8". Maximum distance between spindle nose and turret face at beginning of indexing movement is 28 1/4" on 6' bed lathe. When turret is ordered separate from lathe, the purchaser must assume the responsibility of fitting and boring.

Cat. No. 1917. Hand Feed Turnstile Bed Turret for 16" South Bend Lathe. Ship. wt. 505 lbs. Factory price...\$525.00

\*If power feed is wanted, write for Turret Lathe Catalog No. 67-F.

### Compound Rest Cross Slide for No. 2-H Turret Lathe

The compound rest type cross slide can be supplied for use on the saddle cross slide dovetail of the No. 2-H Turret Lathe in place of the double tool cross slide. It provides hand and power cross-feed, 3 3/4" angular hand feed, and power longitudinal feed. Takes lathe tools with 5/8" x 1 3/8" shank. Swing over cross slide with dovetail chip guard is 9 5/8". Swing over cross slide with chip guard removed is 11 1/8". Both dovetails have adjustable tapered gibs and cross-feed screw has micrometer graduated collar.

Price includes compound rest top, swivel, and base assembly complete with tool post and cross-feed screw. Cannot be used with double tool slide. When this unit is required, it must be ordered with the lathe and fitted at the factory.

Cat. No. 2200. Compound Rest Cross Slide for No. 2-H Turret Lathe. Ship. wt. 22 lbs. Factory price.....\$190.00







## Handlever Tailstock

The Handlever Tailstock is a practical attachment for drilling, reaming, tapping, and centering operations. The convenient lever operation of the spindle saves much time on production work. The spindle may be set for drilling to any depth up to maximum length of feed. This tailstock is similar to the regular tailstock, except for the spindle construction. The tailstock top may be set over for taper turning. The spindle may be operated by the handlever or by turning the tailstock handwheel. This tailstock is interchangeable with the regular tailstock, and can be used for machining work between centers if desired.

### Handlever Tailstock for South Bend Lathes

Size Lathe	Length of Feed Inches	Shipping Weight Lbs.	In Lieu of Regular Tailstock		In Addition to Regular Tailstock	
			Cat. No.	Price	Cat. No.	Price
9"	2 $\frac{1}{2}$ "	25	519-W	\$83.00	1197-W	\$ 84.00
10"	2 $\frac{3}{4}$ "	33	1686	74.00	1194	100.00

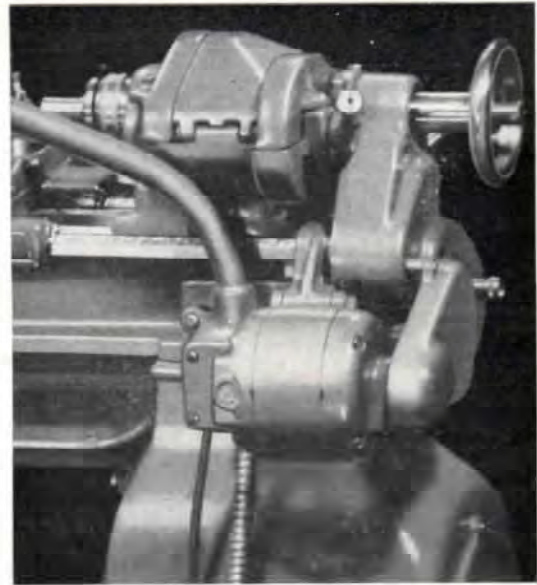


## Tailstock

### for South Bend Turret Lathes

Prices of South Bend No. 2-H, Series 900, and Series 1000 Turret Lathes do not include tailstock, but a standard set-over type tailstock as illustrated above can be supplied to order. The tailstock mounts on the lathe bed, in place of the turret, for machining work between centers. Tailstock spindle is graduated in 16ths of an inch, and is fitted with a 60° hardened center. Tailstock top has set-over for taper turning. This unit should be ordered with the lathe and fitted at the factory.

Catalog No.	Size Lathe	Size Center	Shipping Weight	Factory Price
2036-H	No. 2-H	No. 3 M.T.	133 lbs.	\$132.00
2036-R	Series 1000	No. 2 M.T.	42 lbs.	59.00
2036-N	Series 900	No. 2 M.T.	22 lbs.	33.00



## Independent Power Feed Attachment for 10-Inch Swing South Bend Lathe

Extremely fine feeds can be obtained by using the independent power feed attachment for the 10-inch swing lathe. This attachment is especially desirable for manufacturing dental amalgam, diamond turning and diamond boring operations, and other work requiring extremely smooth, fine feeds, or high spindle speeds. It consists of a separate motor drive and necessary gearing to permit operating the power carriage feed mechanism independently from the lathe spindle.

A  $\frac{1}{4}$  h.p. motor is mounted on the back of the lathe and geared directly to the quick change gear mechanism. The quick change gear box provides 48 changes for both the power longitudinal feeds and the power cross-feeds. The approximate range of power longitudinal feeds is from .725" to .40" per minute.

The feed in thousandths of an inch per revolution of the spindle is obtained by dividing the feed per minute by the r.p.m. of the lathe spindle. Usually the lathe is operated at a spindle speed higher than standard in order to obtain extremely fine feeds. For example, when the spindle revolves at 2500 r.p.m., the approximate power longitudinal feeds range from .00029" to .016" per revolution of the spindle.

The independent power feed attachment can be disconnected when it is not needed, and the regular power feed gearing connected with the lathe spindle for cutting screw threads or regular turning feeds.

This attachment should be ordered with the lathe and fitted at the factory. Prices with popular motors are listed below. Prices with motors having other current characteristics will be quoted on request.

### Independent Power Feed Attachment for 10-Inch Lathe

Catalog Number	Motor Specifications				Price
	Current	Phase	Cycle	Voltage	
333-CR	A.C.	3	50	220	\$165.00
333-DR	A.C.	3	60	220	165.00
333-ER	A.C.	3	50	440	168.00
333-FR	A.C.	3	60	440	168.00
331-AR	A.C.	1	50	115	159.00
331-BR	A.C.	1	60	115	157.00
331-CR	A.C.	1	50	230	161.00
331-DR	A.C.	1	60	230	159.00
331-KR	A.C.	1	25	230	172.00
331-YR	A.C.	1	40	115	170.00
331-ZR	A.C.	1	40	230	172.00
331-BAR	A.C.	1	60	150	159.00
330-KR	D.C.	..	..	115	179.00
330-LR	D.C.	..	..	230	181.00





### Coolant Pump and Reservoir

The coolant equipment listed below is for use with South Bend Lathes equipped with oil pans. The oil pump is self-priming as it is below the oil level. Equipment includes coolant pump, tubing, reservoir, 1/4 h.p. motor, and switch. Prices include fitting to lathe at factory.

Coolant Pump and Reservoir Fitted to 10" or Larger Floor Leg Lathes, No. 2-H, or Series 1000 Floor Leg Turret Lathes

Cat. No.	Current	Phase	Cycle	Voltage	Price
503-C	A.C.	3	50	220	\$141.00
503-D	A.C.	3	60	220	141.00
503-E	A.C.	3	50	440	141.00
503-F	A.C.	3	60	440	141.00
503-G	A.C.	3	50	550	141.00
503-H	A.C.	3	60	550	141.00
502-C	A.C.	2	50	220	141.00
502-D	A.C.	2	60	220	141.00
501-A	A.C.	1	50	115	128.00
501-B	A.C.	1	60	115	126.00
501-C	A.C.	1	50	230	129.00
501-D	A.C.	1	60	230	128.00
500-K	D.C.	...	...	115	153.00
500-L	D.C.	...	...	230	153.00

Coolant Pump and Reservoir Fitted to 9" or Series 900 U.M.D. Lathes, or 10" or Series 1000 Bench Lathes on Tubular Steel Bench

Cat. No.	Current	Phase	Cycle	Voltage	Price
513-C	A.C.	3	50	220	\$141.00*
513-D	A.C.	3	60	220	141.00*
513-E	A.C.	3	50	440	141.00*
513-F	A.C.	3	60	440	141.00*
513-G	A.C.	3	50	550	141.00*
513-H	A.C.	3	60	550	141.00*
512-C	A.C.	2	50	220	141.00*
512-D	A.C.	2	60	220	141.00*
511-A	A.C.	1	50	115	128.00*
511-B	A.C.	1	60	115	126.00*
511-C	A.C.	1	50	230	129.00*
511-D	A.C.	1	60	230	128.00*
510-K	D.C.	...	...	115	153.00*
510-L	D.C.	...	...	230	153.00*

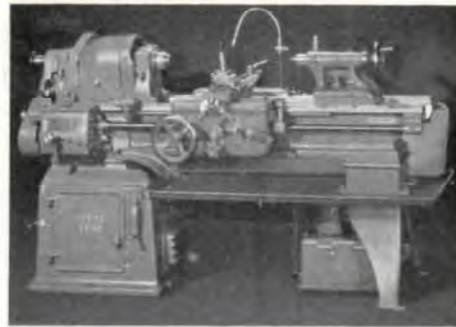
\*When ordered for 9-inch U.M.D. Lathes or 10-inch U.M.D. Lathes on steel bench, there is an additional charge for making chip pan oil tight and installing necessary drain pipes, splash guards, and oil tight seal. This does not apply to turret lathes.

Cat. No. 2195-N. Making chip pan oil tight on 9" Lathe. Price \$25.00  
 Cat. No. 2195-R. Making chip pan oil tight on 10" Lathe. Price \$25.00

### Coolant Pump Not Fitted to Lathe

The above coolant equipment may be ordered for application to lathes or other machine tools. Reservoir may be set on floor or attached to machine. Equipment consists of: coolant pump, tubing, reservoir, tray, 1/4 h.p. motor, switch, and wire for connecting motor and switch. Shipping weight approximately 110 lbs.

Cat. No.	Current	Phase	Cycle	Voltage	Price
2003-C	A.C.	3	50	220	\$123.00
2003-D	A.C.	3	60	220	123.00
2003-E	A.C.	3	50	440	123.00
2003-F	A.C.	3	60	440	123.00
2003-G	A.C.	3	50	550	123.00
2003-H	A.C.	3	60	550	123.00
2002-C	A.C.	2	50	220	123.00
2002-D	A.C.	2	60	220	123.00
2001-A	A.C.	1	50	115	111.00
2001-B	A.C.	1	60	115	109.00
2001-C	A.C.	1	50	230	112.00
2001-D	A.C.	1	60	230	111.00
2000-K	D.C.	...	...	115	135.00
2000-L	D.C.	...	...	230	135.00



### Oil Pans, Splash Pans, and Chip Pans

Oil Pans, Splash Pans, and Chip Pans for South Bend Lathes are made of heavy gauge sheet steel with welded corners and roll rim. Pans should be specified at the time the lathe is ordered so that they can be properly fitted at the factory.

Oil Pans are designed for collecting both oil and chips and are oil tight. Oil pans extend from the headstock leg to the tailstock end of bed as shown. Oil return troughs are provided at the headstock end of the lathe.

Splash Pans are an essential addition to the oil pans for all lathes that are equipped with taper attachments and for all turret lathes. The splash pans are attached to the back of the oil pans, as shown in the illustration above.

Chip Pans are intended for collecting chips only and are not necessarily oil tight. Chip pans extend from the headstock leg to the tailstock end of bed.

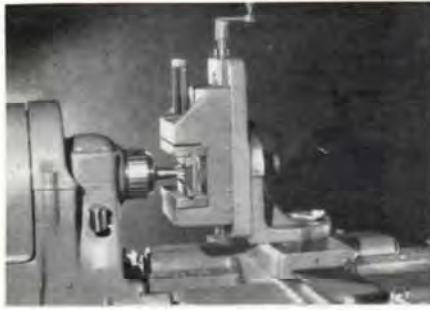
Pans for Floor Leg South Bend Lathes

Size Lathe	Oil Pan		Chip Pan		Splash Pan	
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
Series 900					2057-Z	\$14.00
9" x 3 1/2"					2057-Z	14.00
10" x 3"	2020-Y	\$63.00	1987-Y	\$29.00	2059-R	17.00
10" x 3 1/2"	2020-Z	65.00	1987-Z	30.00	2059-Z	17.00
Series 1000					2059-Z	17.00
10" x 4"	2020-A	66.00	1987-A	31.00	2059-R	21.00
10" x 4 1/2"	2020-R	67.00	1987-R	32.00	2059-R	21.00
13" x 4"	2022-A	77.00	1989-A	39.00	2060-A	23.00
13" x 5"	2022-B	79.00	1989-B	41.00	2060-B	25.00
13" x 6"	2022-C	81.00	1989-C	43.00	2060-C	26.00
13" x 7"	2022-D	85.00	1989-D	45.00	2060-D	27.00
14 1/2" x 5"	2023-B	84.00	1990-B	41.00	2062-B	25.00
14 1/2" x 6"	2023-C	89.00	1990-C	46.00	2062-C	29.00
14 1/2" x 7"	2023-D	93.00	1990-D	51.00	2062-D	29.00
14 1/2" x 8"	2023-E	98.00	1990-E	56.00	2062-H	35.00
16" x 6"	2024-C	90.00	1991-C	47.00	2062-C	29.00
16" x 7"	2024-D	96.00	1991-D	53.00	2062-D	29.00
16" x 8"	2024-E	102.00	1991-E	59.00	2062-H	35.00
16" x 10"	2024-G	114.00	1991-G	71.00	2062-H	35.00
16" x 12"	2024-H	132.00	1991-H	90.00	2062-H	35.00
16 24" x 6"			1991-C	47.00		
16 24" x 7"			1991-D	53.00		
16 24" x 8"			1991-E	59.00		
16 24" x 10"			1991-G	71.00		
16 24" x 12"			1991-H	90.00		
2-H x 7"					2062-D	29.00
2-H x 8"					2062-H	35.00

Pans for South Bend Bench Lathes

Size Lathe	Oil Pan		Chip Pan		Splash Pan	
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
9" x 3"			1297-Y	\$23.00	2056-Y	\$12.00
9" x 3 1/2"			1297-Z	25.00	2057-Z	14.00
9" x 4"			1297-A	27.00	2057-R	14.00
9" x 4 1/2"			1297-R	28.00	2057-R	14.00
10" x 3"			1377-Y	25.00	2057-Z	14.00
10" x 3 1/2"			1377-Z	27.00	2057-Z	14.00
Series 1000					2057-Z	14.00
10" x 4"			1377-A	29.00	2057-R	14.00
10" x 4 1/2"			1377-R	30.00	2057-R	14.00





## Milling and Keyway Cutting Attachment

The Milling and Keyway Cutting Attachment is excellent equipment for the shop that does not have a milling machine. It is mounted on the compound rest base of the lathe, permitting the power cross-feeds and power longitudinal feeds to be employed for milling and boring operations on work held in the milling attachment vise.

The angle plate to which the vertical slide is attached is graduated 180° in both the horizontal plane and vertical plane, permitting the vise to be swiveled in any direction. The vertical slide adjusting screw is equipped with a micrometer graduated collar.

The equipment included consists of: milling and keyway cutting attachment, two V-blocks for holding round work, one crank handle for feed screw, one double end wrench, and necessary bolts and nuts for installing attachment on lathe. Milling cutters and arbors are not included.

### Milling and Keyway Cutting Attachment

Cat. No.	Size Lathe Ins.	Vert. Feed Ins.	Cross-Feed Ins.	Vise Holds Ins.	Jaw Depth Ins.	Jaw Width Ins.	Ship. Wt. Lbs.	Factory Price
9-W	9	2 1/2	5 1/4	1 1/2	1 5/8	3	13	\$37.00
1-N	10	3	5 1/4	1 3/4	1 5/8	3 1/2	25	47.00
3	13	4 1/4	8 1/4	2 1/2	1 1/8	4 3/4	40	58.00
4-K	14 1/2	6	10	4	2	5 1/4	50	68.00
5	16	6	10 1/2	4	2	5 3/4	65	79.00
5	16/24	6	10 1/2	4	2	5 3/4	65	79.00

## Metric Milling Attachment

The milling and keyway cutting attachments shown above can be supplied with metric graduations in lieu of English graduations. Prices and specifications are same as listed above. Specify catalog numbers listed below for milling attachments with metric graduations.

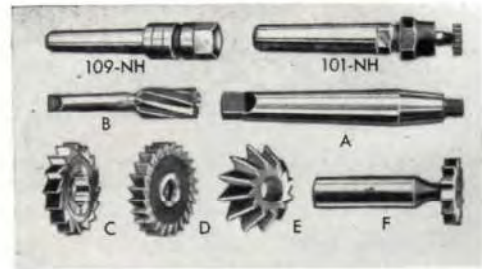
Cat. No.	9-ME	1-ME	3-ME	4-ME	5-ME
Size Lathe	9"	10"	13"	14 1/2"	16", 16/24"



## Milling Attachment Chest

This substantially constructed wooden chest holds the 9-inch milling attachment, milling attachment crank, and milling attachment wrench. This protects the attachment from dirt, dust, and other abuse, when it is not in use. Price does not include milling attachment.

2224. Hinged Wooden Chest for No. 9-W Milling and Keyway Cutting Attachment. Shipping weight 4 lbs. Price . . . . . \$5.00



## Milling Arbors and Cutters

Milling Arbors 109-NH, 101-NH, and A

All arbors and chucks listed below have No. 3 Morse taper shanks.

109-NH. Plain Arbor for milling cutters with 1-inch hole. Shipping weight 3 lbs. Price . . . . . \$7.50  
 829-R. Screw Arbor (A) for angular cutters (E) with right-hand thread. Shipping weight 2 lbs. Price . . . . . \$3.50  
 829-L. Screw Arbor (A) for angular cutters (E) with left-hand thread. Shipping weight 2 lbs. Price . . . . . \$3.50  
 101-NH. Collet Chuck for Woodruff Cutters (F) with 1/2" diameter shank. Shipping weight 2 lbs. Price . . . . . \$5.00

### Spiral End Mills (B)

High Speed Steel, Right-hand Cut, Right-hand Spiral

Cat. No.	Dia. Mill	Morse Taper	Factory Price	Cat. No.	Dia. Mill	Morse Taper	Factory Price
868-B	1/2"	No. 2	\$5.60	870-A	1/2"	No. 3	\$ 8.20
868-J	3/8"	No. 2	5.75	870-B	3/8"	No. 3	8.20
868-L	1/4"	No. 2	5.75	870-C	1/4"	No. 3	8.55
868-F	1"	No. 2	6.65	870-D	1 1/8"	No. 3	9.85
868-N	1"	No. 2	7.70	870-E	1 1/8"	No. 3	11.20

### Plain Milling Cutters (C)

High Speed Steel With 1" Hole. Cut on Face Only

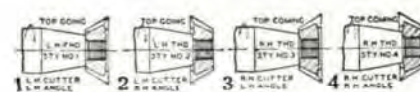
Cat. No.	Face Width	O.D.	Factory Price	Cat. No.	Face Width	O.D.	Factory Price
849-A	1/2"	2 1/8"	\$4.00	849-X	1/2"	2 1/8"	\$ 6.30
849-B	3/4"	2 1/8"	5.30	849-F	3/4"	2 1/8"	6.60
849-C	1"	2 1/8"	5.55	849-N	1"	2 1/8"	7.40
849-J	1 1/2"	2 1/8"	5.85	849-P	1 1/2"	2 1/8"	7.75

### Side Milling Cutters (D)

High Speed Steel With 1" Hole. Cut on Face and Sides

Cat. No.	Face Width	O.D.	Factory Price	Cat. No.	Face Width	O.D.	Factory Price
850-A	1/2"	3"	\$8.20	850-J	1/2"	3"	\$10.30
850-B	3/4"	3"	8.60	850-N	3/4"	4"	16.95
850-C	1"	3"	8.80	850-P	1"	4"	18.10
850-F	1 1/2"	3"	9.55				

### Angular Cutters (E)



High Speed Steel With Threaded Hole  
 1 1/4" O.D., 3/16" Face, 60° Included Angle

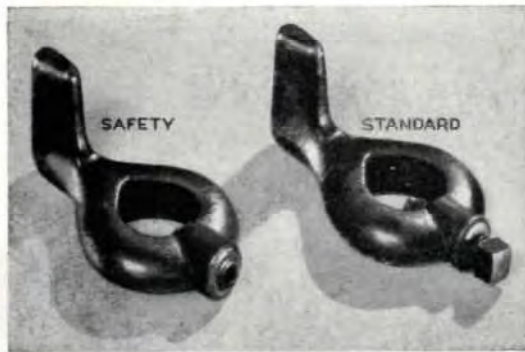
Cat. No.	Style	Description	Factory Price
867-S1	1	L.H. thread, L.H. angle . . . . .	\$6.35
867-S2	2	L.H. thread, R.H. angle . . . . .	6.35
867-S3	3	R.H. thread, L.H. angle . . . . .	6.35
867-S4	4	R.H. thread, R.H. angle . . . . .	6.35

### Woodruff Keyseat Cutters (F)

High Speed Steel With 1/2" Diameter Straight Shanks  
 Right-hand Cutters

Cat. No.	Cutter Dia.	Cutter Face	Factory Price	Cat. No.	Cutter Dia.	Cutter Face	Factory Price
897-A	1/2"	1/2"	\$3.20	897-I	1"	1 1/4"	\$4.35
897-B	3/8"	3/8"	3.20	897-J	1"	1 1/4"	4.60
897-C	1/4"	1/4"	3.20	897-K	1 1/8"	1 3/8"	4.80
897-D	3/16"	3/16"	3.55	897-L	1 1/8"	1 3/8"	4.80
897-E	1/8"	1/8"	3.55	897-M	1 1/4"	1 3/4"	5.05
897-F	3/16"	3/16"	3.95	897-N	1 1/4"	1 3/4"	5.30
897-G	1/4"	1/4"	3.95	897-O	1 1/2"	1 3/4"	5.30
897-H	1"	1"	4.35	897-P	1 1/2"	1 3/4"	5.65





## Standard and Safety Lathe Dogs

Lathe dogs should correspond in capacity to the diameter of the work if the work is to be held securely. These lathe dogs are made of heavy malleable iron and are properly designed for maximum strength and long service. Tail of dog is shaped to fit slot in drive plate. The Standard Lathe Dog has square head alloy steel set screw. The Safety Lathe Dog has a headless alloy steel set screw. Wrenches required for headless set screws are listed in right-hand columns.

Lathe Dogs for 13" and Larger Lathes

Cap. In.	Ship. Wt.	STANDARD		SAFETY		Wrenches for Safety Dogs	
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
1/2	1 lb.	3843	\$0.85	3826	\$0.85	2385	\$0.05
3/4	1 lb.	3844	1.00	3827	1.00	2386	.06
1	2 lbs.	3845	1.10	3828	1.10	2387	.07
1 1/4	2 lbs.	3846	1.25	3829	1.25	2388	.08
1 1/2	3 lbs.	3847	1.50	3830	1.50	2389	.11
1 3/4	3 lbs.	3848	1.65	3831	1.65	2389	.11
2	4 lbs.	3849	1.80	3832	1.80	2389	.11
2 1/2	5 lbs.	3850	2.05	3833	2.05	2390	.16
3	6 lbs.	3851	2.30	3834	2.30	2390	.16
3 1/2	7 lbs.	3852	3.15	3835	3.15	2390	.16
4	9 lbs.	3853	4.25	3836	4.25	2390	.16

Lathe Dogs for 9" and 10" Lathes

Cap. In.	Ship. Wt.	STANDARD		SAFETY		Wrenches for Safety Dogs	
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
3/8	1 lb.	3837	\$0.75	3820	\$0.75	2385	\$0.05
1/2	1 lb.	3838	.80	3821	.80	2385	.05
3/4	2 lbs.	3839	.95	3822	.95	2386	.06
1	2 lbs.	3840	1.05	3823	1.05	2387	.07
1 1/4	3 lbs.	3841	1.15	3824	1.15	2388	.08
1 1/2	3 lbs.	3842	1.45	3825	1.45	2388	.08

## Clamp Lathe Dog

Made of heavy drop-forged steel, carefully machined and hardened. Practical for holding round, hexagonal or rectangular work. Screws have U. S. Standard thread and are hardened and tempered. The nuts permit adjusting screws for minimum projection of screw heads beyond body of lathe dog. Each clamp lathe dog is boxed separately.



Clamp Lathe Dogs

Catalog Number	Capacity		Size Lathe Used With	Shipping Weight	Factory Price
	Maximum Opening	Distance Between Screws			
160	1 3/8"	1 3/4"	9" & larger	1 lb.	\$2.95
161	1 7/8"	2 1/4"	13" & larger	2 lbs.	3.85
162	2 1/2"	2 3/4"	13" & larger	3 lbs.	4.85
163	3 1/4"	3 1/2"	14 1/2" & larger	4 lbs.	7.00



## Sets of Lathe Dogs

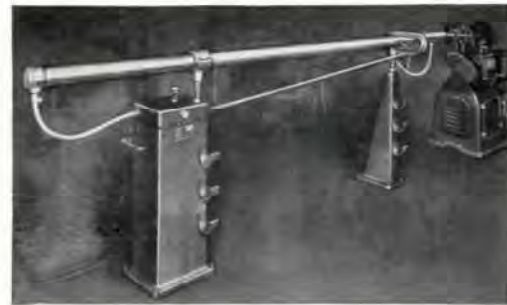
A complete set of dogs for each lathe will save time and contribute to efficient operation. Having the correct size of lathe dog at hand for any job will more than compensate for the cost of a full set. Two or more dogs of each size will often save time on production work, as this permits changing one dog while the other is in use.

Cat. No. 2102-TH. Set of 11 Standard Lathe Dogs, 1/2" to 4" capacity for 13" and larger lathes. Ship. wt. 36 lbs. Price. \$20.50

Cat. No. 2103-TH. Set of 11 Safety Lathe Dogs, 1/2" to 4" capacity for 13" and larger lathes. Ship. wt. 36 lbs. Price. \$20.50

Cat. No. 2105-NR. Set of 6 Standard Lathe Dogs, 3/8" to 1 1/2" capacity for 9" and 10" lathes. Ship. wt. 6 lbs. Price. \$6.00

Cat. No. 2107-NR. Set of 6 Safety Lathe Dogs, 3/8" to 1 1/2" capacity for 9" and 10" lathes. Ship. wt. 6 lbs. Price. . . . \$6.00



## Pneumatic Bar Feed

This Pneumatic Bar Feed unit takes a twelve foot bar of stock, any shape or size, up to the maximum capacity through the bar feed cylinder, provided the bar is no larger than the hole through the lathe spindle or collet. Air pressure forces the stock forward instantly when the collet or chuck is opened. The stock is held firmly against the stop until the collet is closed.

Low air pressure is required for operating the pneumatic bar feed unit. (Price does not include air compressor). Shipped direct from factory in New York.

Cat. No. 1881-A. Liipe Pneumatic Bar Feed Unit, 1" maximum bar capacity. Shipping weight 385 lbs. Price. . . \$270.00

Cat. No. 1881-B. Liipe Pneumatic Bar Feed Unit, 2" maximum bar capacity. Shipping weight 410 lbs. Price. . . \$275.00

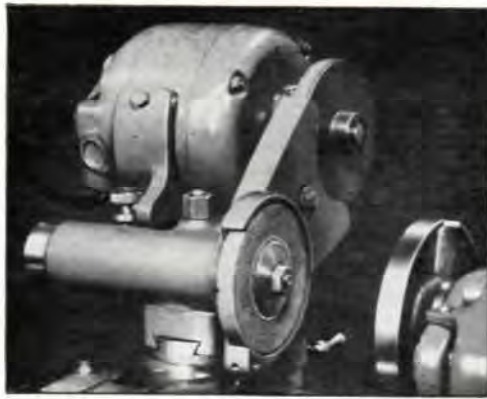
## Taper Reducing Sleeve

Standard Morse Taper Reducing Sleeves for fitting drills, reamers, and other taper shank tools to spindle taper.



Catalog No.	Morse Taper		Shipping Weight	Factory Price
	Outside	Inside		
118-A	2	1	8 ozs.	\$0.75
118-B	3	1	12 ozs.	1.00
118-D	3	2	12 ozs.	1.00





## External Grinding Attachment

This powerful and efficient grinding attachment is recommended for refacing valves, sharpening reamers and cutters, and other external grinding. Designed to fit the various sizes of South Bend Lathes, it is easily adaptable for use on other makes of lathes. The spindle revolves in pre-lubricated, precision ball bearings which are sealed to protect them from damage by dust, grit and metal particles produced when grinding. Supplied with  $\frac{1}{4}$  h.p., constant speed continuous duty motor, and 4" x  $\frac{1}{2}$ " No. 2759 general purpose grinding wheel. Prices with motors for current characteristics other than those listed below quoted on request. Shipping weight approximately 55 lbs.

### External Grinding Attachment and Motors

Catalog Number	Size Lathe	Dia. Will Grind	Motor Specifications			Factory Price
			Volts	Phase	Cycle	
300-KN	9"	5 1/4"	115 D.C.	..	..	\$73.00
300-LN	9"	5 1/4"	230 D.C.	..	..	73.00
301-AN	9"	5 1/4"	115 A.C.	1	50	53.00
301-BN	9"	5 1/4"	115 A.C.	1	60	52.00
301-CN	9"	5 1/4"	230 A.C.	1	50	56.00
301-DN	9"	5 1/4"	230 A.C.	1	60	55.00
303-CN	9"	5 1/4"	220 A.C.	3	50	60.00
303-DN	9"	5 1/4"	220 A.C.	3	60	60.00
303-FN	9"	5 1/4"	440 A.C.	3	60	60.00
300-KR	10"	5 1/2"	115 D.C.	..	..	73.00
300-LR	10"	5 1/2"	230 D.C.	..	..	73.00
301-AR	10"	5 1/2"	115 A.C.	1	50	53.00
301-BR	10"	5 1/2"	115 A.C.	1	60	52.00
301-CR	10"	5 1/2"	230 A.C.	1	50	56.00
301-DR	10"	5 1/2"	230 A.C.	1	60	55.00
303-CR	10"	5 1/2"	220 A.C.	3	50	60.00
303-DR	10"	5 1/2"	220 A.C.	3	60	60.00
303-FR	10"	5 1/2"	440 A.C.	3	60	60.00
300-KT	13"	8"	115 D.C.	..	..	73.00
300-LT	13"	8"	230 D.C.	..	..	73.00
301-AT	13"	8"	115 A.C.	1	50	53.00
301-BT	13"	8"	115 A.C.	1	60	52.00
301-CT	13"	8"	230 A.C.	1	50	56.00
301-DT	13"	8"	230 A.C.	1	60	55.00
303-CT	13"	8"	220 A.C.	3	50	60.00
303-DT	13"	8"	220 A.C.	3	60	60.00
303-FT	13"	8"	440 A.C.	3	60	60.00
300-KF	14 1/2"	9"	115 D.C.	..	..	73.00
300-LF	14 1/2"	9"	230 D.C.	..	..	73.00
301-AF	14 1/2"	9"	115 A.C.	1	50	53.00
301-BF	14 1/2"	9"	115 A.C.	1	60	52.00
301-CF	14 1/2"	9"	230 A.C.	1	50	56.00
301-DF	14 1/2"	9"	230 A.C.	1	60	55.00
303-CF	14 1/2"	9"	220 A.C.	3	50	60.00
303-DF	14 1/2"	9"	220 A.C.	3	60	60.00
303-FF	14 1/2"	9"	440 A.C.	3	60	60.00
300-KH	16"	9 1/2"	115 D.C.	..	..	73.00
300-LH	16"	9 1/2"	230 D.C.	..	..	73.00
301-AH	16"	9 1/2"	115 A.C.	1	50	53.00
301-BH	16"	9 1/2"	115 A.C.	1	60	52.00
301-CH	16"	9 1/2"	230 A.C.	1	50	56.00
301-DH	16"	9 1/2"	230 A.C.	1	60	55.00
303-CH	16"	9 1/2"	220 A.C.	3	50	60.00
303-DH	16"	9 1/2"	220 A.C.	3	60	60.00
303-FH	16"	9 1/2"	440 A.C.	3	60	60.00
300-KH	16/24"	18 3/4"	115 D.C.	..	..	73.00
300-LH	16/24"	18 3/4"	230 D.C.	..	..	73.00
301-AH	16/24"	18 3/4"	115 A.C.	1	50	53.00
301-BH	16/24"	18 3/4"	115 A.C.	1	60	52.00
301-CH	16/24"	18 3/4"	230 A.C.	1	50	56.00
301-DH	16/24"	18 3/4"	230 A.C.	1	60	55.00
303-CH	16/24"	18 3/4"	220 A.C.	3	50	60.00
303-DH	16/24"	18 3/4"	220 A.C.	3	60	60.00
303-FH	16/24"	18 3/4"	440 A.C.	3	60	60.00

## Extra Grinding Wheels



For rapid grinding and smooth finish, the correct grade of grinding wheel should be selected. The grinding wheels listed cover the more important classes of work. Wheels listed in table are 4" in diameter with  $\frac{1}{2}$ " face and  $\frac{1}{2}$ " hole, to fit above external grinding attachment. Shipping weight 2 lbs.

Cat. No.	Type of Work	Class of Work	Price
2759	General Work.....	Rough or Finish	\$1.75
2758	Cutting Tools.....	Rough or Finish	1.75
2774	Automobile Valves.....	Rough or Finish	1.75
2757	Cast Iron.....	Finish Grinding	1.75
2769	Soft Steel.....	Finish Grinding	1.75

No. 3236. Cup Grinding Wheel, 3 1/4" O.D., 3" I.D., 1 1/4" face, 1/2" hole for sharpening reamers and cutters. Price . \$3.45

## Reamer Grinding Stops

For sharpening valve seat reamers, milling cutters, etc., having either straight or spiral flutes. Also used for holding the No. 18 Diamond Dresser listed below.



Cat. No.	Size Lathe	Ship. Wt.	Factory Price
1512-N	9"	7 lbs.	\$16.00
1512-R	10"	9 lbs.	17.00
1512-T	13"	14 lbs.	19.00
1512-F	14 1/2"	20 lbs.	21.00
1512-H	16"	24 lbs.	21.00
1512-V	16/24"	30 lbs.	31.00



## Diamond Dresser



For satisfactory operation, the grinding wheel should be trued frequently with a diamond dresser. This dresser must be mounted in the Reamer Grinding Stop fixture, listed above. Price does not include the fixture.



No. 18. Diamond Dresser only. Shipping weight 1 lb. ....\$6.75

## Tailstock Diamond Holding Fixture

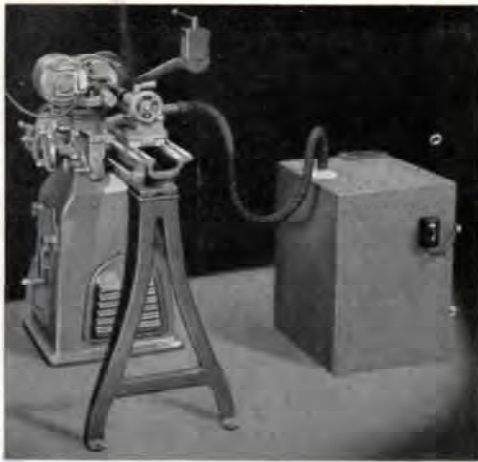
Clamps to tailstock spindle of lathe for holding the No. 406 diamond dresser (shown in inset) for truing grinding wheel. Cannot be used while work is mounted between the lathe centers. Price does not include diamond dresser, which is listed below.

Cat. No.	Size Lathe	Ship. Wt.	Factory Price
91-W	9"	3 lbs.	\$6.50
91-N	10"	3 lbs.	6.50
91-D	13"	4 lbs.	7.50
91-K	14 1/2"	4 lbs.	7.50
91-F	16" & 16/24"	5 lbs.	8.50



No. 406. Diamond Dresser. Shipping weight 1/2 lb. . . \$6.75





## Dust Collecting Unit for Electric Grinding Attachment

Abrasive dust from the grinding wheel and grindings from the work can be collected and filtered from the air with this unit. This provides greater comfort for the operator and protects the lathe from the abrasive action of emery dust and grindings.

The dust collecting unit consists of a steel cabinet containing highly efficient chemically treated spark resistant filters and a powerful blower driven by a 1/3 h.p. electric motor. A non-collapsible flexible exhaust tube carries the dust from the grinding wheel to the dust collecting unit. The grinding wheel is almost totally enclosed in a guard to which the exhaust tube is connected.

Equipment included in price consists of dust collecting unit complete with motor, switch, blower, filters, exhaust tube, and special grinding wheel guard, but does not include grinding attachment.

### Dust Collecting Unit for Use With Electric Grinding Attachment

Cat. No.	Current	Phase	Cycle	Voltage	Ship. Wt.	Price
311-B	A.C.	1	60	115	160 lbs.	Price on request
311-D	A.C.	1	60	230	160 lbs.	
313-D	A.C.	3	60	220	160 lbs.	
313-F	A.C.	3	60	440	160 lbs.	
313-K	A.C.	3	25	220	160 lbs.	
313-VA	A.C.	3	25	440	160 lbs.	

## Wall Charts

These wall charts are printed on heavy paper, deep blue with white lines to simulate blue-prints. Suitable for framing.

Wall Chart 250-BP, "How to Become a Machinist." Size 13" wide by 22" high. Price each postpaid... 10c

Wall Chart 777-BP, "Decimal Equivalents." Size 13" wide by 19" high. Price each postpaid... 10c

Wall Chart 890-BP, "Principal Parts of a Lathe." Size 21 1/2" wide by 17 1/2" high. Price each postpaid... 10c

Wall Chart 199-BP, "Tap Drill Sizes." Size 13" wide by 19" high. Price each postpaid... 10c

DECIMAL EQUIVALENTS	
1/16" = .0625	1/8" = .1250
3/16" = .1875	1/4" = .2500
1/4" = .2500	3/8" = .3750
5/16" = .3125	1/2" = .5000
3/8" = .3750	5/8" = .6250
7/16" = .4375	3/4" = .7500
1/2" = .5000	7/8" = .8750
9/16" = .5625	1" = 1.0000
5/8" = .6250	
11/16" = .6875	
3/4" = .7500	
13/16" = .8125	
7/8" = .8750	
15/16" = .9375	
1" = 1.0000	

SOUTH BEND LATHE WORKS  
SOUTH BEND, INDIANA, U. S. A.

## Sleeve for 10"-11/16" Collet Lathe

Cat. No. 205-T. Special Spindle Sleeve with No. 3 Morse taper inside for fitting Piston Adapter Shank, Milling Arbor, etc. to spindle of 10"-11/16" Collet Lathe. Shipping weight 1 lb. Factory price... \$3.00



Adapter Shank      Cone Ring      Driving Dog

## Self-Centering Piston Adapters

For Mounting Pistons in the Lathe

The Self-Centering Piston Adapter, shown at right is used for mounting semi-machined pistons in the lathe for machining to finished size. The long tapered shank fits into the lathe spindle and the short pilot centers various sizes of cone rings. The driving dog screws into the threaded hole in the end of the adapter, and is adjustable for driving any size of piston having a center hole in head.



Cat. No. 144-NH. Self-Centering Piston Adapter complete, consisting of Adapter Shank with No. 3 Morse taper, No. 1-D Cone Ring for pistons 2 1/4" to 3 1/8" in dia., and Driving Dog. Shipping weight 7 lbs. .... \$13.00

## Extra Cone Rings

Cone Rings are used on the piston adapter, shown above, to center pistons in the lathe. Cone rings are listed below for centering pistons from 2 1/4" to 5" outside diameter. The No. 1-D Cone Ring is included in the price of the piston adapter listed above.

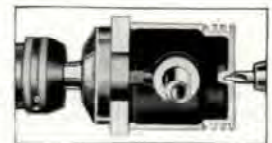


### Extra Cone Rings

Catalog Number	For Pistons Diameter	Shipping Weight	Price Each
1-D	2 1/4" to 3 1/8"	2 lbs.	\$2.50
2-D	3 1/8" to 3 3/4"	3 lbs.	2.65
3-D	3 3/4" to 4 1/2"	3 lbs.	3.15
4-D	4 1/2" to 5"	4 lbs.	3.80

## Piston Centering Ring

The Piston Centering Ring and Eye Bolt Driver are used with the No. 144-NH Piston Adapter shank for holding pistons when it is necessary to drill a center hole in the head of the piston in order to mount it in the lathe. Centering Ring is 5 7/16" in diameter.



Cat. No. 1-Z. Centering Ring and Eye Bolt Driver. Shipping weight 8 lbs. .... \$4.35

## Jacobs Valve Chuck

Chuck has 1 1/2"-8 thread to fit spindle nose of 9-inch lathe only. Has hollow body for holding automobile engine valves for refacing. Also used for holding small rods, bars, and tubes for machining. 5/8" chuck can be used in tailstock of lathe when fitted with solid arbor No. 2304 or 2305. Price and weight includes pinion key.



Cat. No.	Capacity	Ship. Wt.	Price
907-W	1/2" to 3/4"	3 1/4 lbs.	\$16.50
925-W	3/4" to 1 1/4"	4 1/4 lbs.	19.75



## Mica Undercutting Attachment



Any shop that repairs armatures for motors, generators or starters will have a lot of use for this practical attachment. It attaches to the saddle of the lathe for undercutting armature commutators. Hand operated, easy to use, and efficient. Cutter blade can be aligned with commutator segments, even though they are not parallel with the armature shaft. This prevents cutting into copper and throwing up burrs. A screw adjustment is provided for regulating the depth of the cut. When not in use, the undercutter may be tilted back out of the way. Price includes one cutter blade .020" thick.

### Mica Undercutting Attachment

Catalog No.	Size Lathe	Ship. Weight	Factory Price
675-N	9"	7 lbs.	\$19.00
675-R	10"	10 lbs.	19.00
675-T	13"	12 lbs.	30.00
675-F	14 1/2"	15 lbs.	21.00
675-H	16"	17 lbs.	22.00

2028. Extra cutter .015" thick. Ship. wt. 1/2 lb. . . . \$0.20

2029. Extra cutter .020" thick. Ship. wt. 1/2 lb. . . . \$0.30

## Adjustable Collet Bushing Chuck



The adjustable Collet Bushing Chuck provides an extremely accurate, but inexpensive equipment for mounting centerless armature shafts, and similar parts in the lathe. Can be used in either head or tail spindle of lathe. Collets are made of brass, and may be adjusted for either running fit or driving fit on shaft.

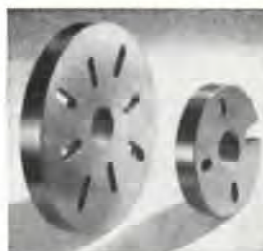
Description	Cat. No.	Shank	Price
Adjustable Collet Bushing Chuck Only.....	1615-NR	No. 2	\$6.60
	1615-TH	No. 3	7.15
Adjustable Collet Bushing Chuck with set of 3 collets, 3/8", 5/8", and .637" capacity for popular armatures.....	1608-NR	No. 2	9.45
	1608-TH	No. 3	9.95

Cat. No. 1659 Extra Collets for round work, any capacity 1/4" to 1" round by 16ths, price each..... \$1.10

## Cutter Bits for Truing Commutators

- 1363-W. Ground Cutter Bit, 1/4" square. Ship. wt. 2 oz. \$40  
 1365. Ground Cutter Bit, 5/16" square. Ship. wt. 2 1/2 oz. \$50  
 1366. Ground Cutter Bit, 3/8" square. Ship. wt. 3 oz. \$70

## Face Plates



Face Plates are heavily constructed and ribbed on the back. Threaded to fit spindle nose of the lathe. Large Face Plates have slots for clamping work or special face plate fixtures. Small Face Plates have slots for driving lathe dog.

### Small Face Plates for South Bend Lathes

Cat. No.	Size Lathe	Out-side Dia.	Thread	Ship-ping Weight	Fac-tory Price
2175-N	9" & Series 900	5 1/2"	1 1/2"-8	4 lbs.	\$ 5.25
2175-R	10" 11/16" Collet	5 3/4"	1 1/2"-8	5 lbs.	6.50
2175-L	10"-1" Collet & Series 1000	5 3/4"	2 1/4"-8	5 lbs.	9.50
2175-T	13" 11/16" Collet	6 1/2"	1 1/2"-8	8 lbs.	9.50
2175-O	13"-1" Collet	6 1/2"	2 1/4"-8	8 lbs.	9.50
2175-F	14 1/2" 1" Collet	8 1/2"	2 1/4"-6	10 lbs.	13.00
2175-H	14 1/2"-1" Collet, 16", 16/24" & No. 2-H	8 1/2"	2 1/4"-6	13 lbs.	14.00

### Large Face Plates for South Bend Lathes

Cat. No.	Size Lathe	Out-side Dia.	Thread	Ship-ping Weight	Fac-tory Price
2180-N	9" & Series 900	7 1/2"	1 1/2"-8	8 lbs.	\$ 7.50
2180-R	10" 11/16" Collet	8 1/2"	1 1/2"-8	10 lbs.	7.50
2180-L	10"-1" Collet & Series 1000	8 1/2"	2 1/4"-8	10 lbs.	13.00
2180-T	13" 11/16" Collet	10 1/2"	1 1/2"-8	19 lbs.	13.00
2180-O	13"-1" Collet	10 1/2"	2 1/4"-8	19 lbs.	14.00
2180-F	14 1/2" 1" Collet	13 1/2"	2 1/4"-6	30 lbs.	16.00
2180-H	14 1/2"-1" Col. 16", 16/24" & No. 2-H	13 1/2"	2 1/4"-6	38 lbs.	19.00
2180-P*	16/24"	22 1/2"	2 1/4"-6	96 1/2 lbs.	42.00

\*This is an extra large face plate for mounting large diameter work in 16/24" Lathe only.

## Multi-Tapped Face Plate



This heavily constructed face plate has six slots and thirty tapped holes for clamping work or special work holding fixtures. The cored slots are 3/16" wide, and the tapped holes have 5/16"-18 threads. The face plate is made of cast iron, and is accurately machined all over. It has a precision milled thread for the spindle nose of the lathe, and is 7/8" thick.

Cat. No.	Size Lathes	Out-side Dia.	Spindle Thread	Ship-ping Weight	Fac-tory Price
1483-N	9" & Ser. 900	8 1/2"	1 1/2"-8	13 lbs.	\$ 6.50
1483-R	10" 11/16" Col.	8 1/2"	1 1/2"-8	13 lbs.	13.00
1483-L	10" & 13", 1" Col. & Ser. 1000	8 1/2"	2 1/4"-8	13 lbs.	15.00

## Fixture Plate



This Fixture Plate is used for mounting special fixtures, jigs, holding devices, and tools on the spindle nose of the lathe. Being accurately machined all over, and threaded to fit the spindle nose of the lathe, its use will save much time and expense

when tooling up a lathe for a production operation which calls for a special holding fixture fitted to the spindle nose.

Cat. No.	Size Lathe	Out-side Dia.	Spindle Thread	Ship-ping Weight	Fac-tory Price
46-N	9" & Ser. 900	7 1/2"	1 1/2"-8	9 lbs.	\$3.75
46-R	10" 11/16" Col.	9"	1 1/2"-8	14 lbs.	8.00
46-L	10"-1" Col. & Ser. 1000	9"	2 1/4"-8	14 lbs.	9.25
46-T	13" 11/16" Col.	10 1/2"	1 1/2"-8	22 lbs.	8.00
46-Q	13"-1" Collet	10 1/2"	2 1/4"-8	22 lbs.	10.00
46-F	14 1/2" 1" Col.	10 1/2"	2 1/4"-6	22 lbs.	9.25
46-H	14 1/2", 16" & 16/24", 1" Collet & No. 2-H	11 1/2"	2 1/4"-6	29 lbs.	10.75





### Lathe Centers and Drill Pads

- G—Drill Pad, used in tailstock to support flat work for drilling.
- H—Crotch Center, used in tailstock for drilling round work.
- I—60° Center made of tool steel, heat-treated, hardened, and ground all over. For use in headstock or tailstock.
- J—60° Hollow Center for supporting centerless armature shafts, etc.
- L—Screw Center for wood turning.
- M—Spur Center for wood turning.
- N—Cup Center for wood turning.
- P—Carbide Tipped Center for heavy duty use in tailstock.
- Q—Half Center, used in tailstock for facing ends of shafts.

Catalog Number	Description	Morse Taper	Ship. Wt.	Factory Price
727-NR	G—Drill Pad.....	No. 2	3 lbs.	\$2.65
727-TH	G—Drill Pad.....	No. 3	4 lbs.	2.90
728-NR	H—Crotch Center.....	No. 2	2 lbs.	2.65
728-TH	H—Crotch Center.....	No. 3	3 lbs.	3.50
728-NR	I—60° Center.....	No. 2	1 lb.	2.40
728-TH	I—60° Center.....	No. 3	2 lbs.	3.15
1896-NR	J—Hollow Center.....	No. 2	2 lbs.	2.15
1896-TH	J—Hollow Center.....	No. 3	2 lbs.	2.90
731-NR	L—Screw Center.....	No. 2	3 lbs.	3.15
731-TH	L—Screw Center.....	No. 3	4 lbs.	3.50
732-NR	M—Spur Center.....	No. 2	2 lbs.	3.15
732-TH	M—Spur Center.....	No. 3	5 lbs.	3.50
733-NR	N—Cup Center.....	No. 2	1 lb.	2.15
733-TH	N—Cup Center.....	No. 3	2 lbs.	2.90
1889	P—Carbide Center.....	No. 2	1 lb.	4.75
1890	P—Carbide Center.....	No. 3	2 lbs.	8.50
926-NR	Q—Half Center.....	No. 2	1 lb.	2.40
926-TH	Q—Half Center.....	No. 3	2 lbs.	3.15

### Ball Bearing Live Centers

Designed for maximum strength and rigidity, the Ball Bearing Live Centers are recommended for high speeds and heavy roughing cuts. Two styles are available, one having a 60° external point as shown above at right, and one having a 60° hollow as shown in the lower illustration. Both styles are made with No. 2 and No. 3 Morse standard tapers. The substantial precision ball bearing in which the center runs is easily replaceable.



Patent Pending



Patent Pending

Catalog Number	Style of Center	Morse Taper	Shipping Weight	Factory Price
3900	60° Point	No. 2	3 lbs.	\$13.75
3901	60° Point	No. 3	5 lbs.	16.25
3903-NR	60° Hollow	No. 2	3 lbs.	13.75
3903-TH	60° Hollow	No. 3	5 lbs.	16.25

### Die Holder

For holding standard 1½" diameter button dies in tailstock spindle of lathe for cutting screw threads on work held in lathe chuck. Die holder has ½" hole, 3" deep for stock clearance. Made of a single piece of steel.



Catalog Number	Taper Shank	Shipping Weight	Factory Price
1838	No. 2	2 lbs.	\$4.25
1839	No. 3	3 lbs.	4.75

### Pipe Centers

For mounting tubing, pipe, etc., between the lathe centers for machining. Centers have accurately ground 45° cone, and revolve on steel shanks.



#### Pipe Centers

Cat. No.	Takes Pipe	Requires Shank	Shipping Weight	Factory Price
2160	½" to 3"	2172-NR	4 lbs.	\$4.75
2161	3" to 5"	2172-TH	6 lbs.	6.50
2162	5" to 8"	2173-TH	17 lbs.	9.75

#### Pipe Center Shanks

Cat. No.	Shank Taper	Takes Centers	Shipping Weight	Factory Price
2172-NR	No. 2	2160 & 2161	2 lbs.	\$4.75
2172-TH	No. 3	2160 & 2161	3 lbs.	4.75
2173-TH	No. 3	2162	4 lbs.	8.00



### Knock-out Bar

For removing headstock center and sleeve from spindle. Made of steel, with knurled handle and brass bushing.

Catalog Number	Size Lathe	Outside Dis.	Total Length	Ship. Weight	Factory Price
1475-N	9"	3 3/8"	16"	4 lbs.	\$2.65
1475-R	10" & 1 1/8" Col.	3 3/8"	17 1/2"	5 lbs.	2.90
1475-L	10" & 1" Col.	1 3/8"	17 1/2"	7 lbs.	3.25
1475-T	13"	1"	23 1/2"	6 lbs.	3.75
1475-F	14 1/2"	1 1/8"	26 1/2"	6 lbs.	4.50
1475-H	16" & 16/24"	1 3/8"	28 1/2"	7 lbs.	4.75

### Combination Center Drill and Countersink



For drilling center hole and countersinking 60° angle for lathe center. Made of high speed tool steel.

Dia. of Drill	Dia. of Body	Single Drill			Lot of Twelve		
		Cat. No.	Ship. Wt.	Price Each	Cat. No.	Ship. Wt.	Price Lot
3/16"	1/8"	2087	4 ozs.	\$ 0.95	2555	8 ozs.	\$ 8.40
1/8"	15/64"	2041	4 ozs.	.95	2556	8 ozs.	8.40
3/16"	15/64"	2088	4 ozs.	.95	2557	8 ozs.	8.40
1/4"	.302"	2042	4 ozs.	.95	2558	8 ozs.	8.40
5/16"	.302"	2043	4 ozs.	.95	2559	1 lb.	8.40
3/8"	7/16"	2044	6 ozs.	1.45	2560	2 lbs.	12.60

Cat. No. 2554—Set of 6 Combination Center Drills and Countersinks, one of each. Price per set..... \$5.50

### Center Drill Holder



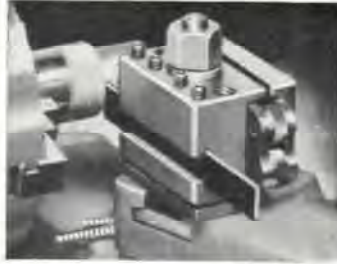
The Center Drill Holder is designed for greater accuracy in center drilling operations. Holds drill rigidly.

Catalog Number	Taper Shank	Diameter Will Hold	Shipping Weight	Factory Price
2338	No. 2	3/8"	1 lb.	\$2.65
2340	No. 2	15/64"	1 lb.	2.65
2339	No. 2	15/64"	1 lb.	2.65
2341	No. 2	.302"	1 lb.	2.65
2342	No. 2	7/16"	1 lb.	2.65
2346	No. 3	3/8"	2 lbs.	3.40
2343	No. 3	15/64"	2 lbs.	3.40
2347	No. 3	15/64"	2 lbs.	3.40
2344	No. 3	.302"	2 lbs.	3.40
2345	No. 3	7/16"	2 lbs.	3.40

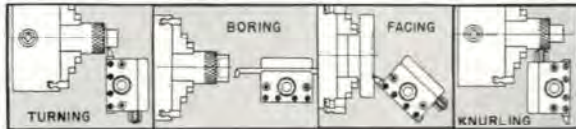


## Universal Tool Block

This new Universal Tool Block replaces the conventional tool post and various tool holders ordinarily used for general lathe work. It provides rigid support for turning, boring, threading, and cut-off tool bits. In addition, it is equipped with a self-aligning knurling head having No. 3151 medium diamond knurls.



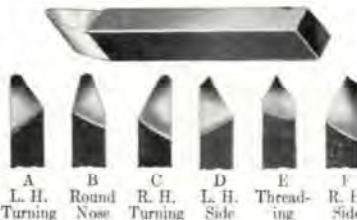
Screw adjustments for tool height are easily made, and they stay put. No readjustment is required when replacing tools. This tool block can be adapted to fit other makes of lathes.



Cat. No.	Size Lathe Inches	Holds Cutter Bits Inch	Holds Boring Bars Inches	Holds Cut-off Blades Inch	Ship. Wt. Lbs.	Factory Price
1413-N	9	3/8 x 3/8	3/8 to 3/4	3/8 x .595	5 lbs.	\$11.80
1413-R	10	3/8 x 3/8	3/8 to 3/4	3/8 x .595	5 lbs.	12.50
1413-T	13	3/8 x 3/8	1/2 to 1 1/4	1/2 x .735	7 lbs.	14.50
1413-F	14 1/2	3/8 x 3/8	1/2 to 1 1/4	1/2 x .870	10 lbs.	16.50
1413-H	16 & 16/24	3/8 x 3/8	1/2 to 1 1/4	1/2 x .870	10 lbs.	17.00

## Ground Cutter Bits

These cutter bits are made of good quality high speed steel and are heat-treated and hardened.



When ordering, be sure to specify the catalog numbers and the letters designating shapes of bits wanted.

### Ground High Speed Steel Cutter Bits

Size Square Inch	Length Cutter Inches	Single Bit			Set of 6 Bits		
		Cat. No.	Ship. Wt.	Price Each	Cat. No.	Ship. Wt.	Price Set
1/4	2	1305	2 ozs.	\$0.35	1779	10 ozs.	\$1.90
3/8	2 1/2	1313	2 1/2 ozs.	.50	1777	10 1/2 ozs.	2.75
1/2	3	1316	3 ozs.	.70	1778	11 ozs.	3.95

## Unground Cutter Bits

These cutter bits are the same quality as those listed above but they are not ground. They are heat-treated and hardened and are ready for use when sharpened. Specify catalog number and size when ordering cutter bits.

### Unground High Speed Steel Cutter Bits

Catalog Number	Size Square	Length Cutter	Shipping Weight	Price Each
1067	3/8"	1"	2 ozs.	\$0.11
454	1/2"	1 1/2"	2 ozs.	.14
1460	3/4"	2"	2 ozs.	.25
1422	1"	2 1/2"	2 1/2 ozs.	.35
1423	1 1/4"	3"	3 ozs.	.55
2260	1 3/4"	3 1/2"	4 ozs.	.80
2016	2"	4 1/2"	5 ozs.	2.15

### Unground High Speed Steel Cutter Bits in Lots

Size Square	Length Cutter	Lot of 6 Bits			Lot of 24 Bits		
		Cat. No.	Ship. Wt.	Price	Cat. No.	Ship. Wt.	Price
1/4	2"	1629	10 ozs.	\$1.20	2372	1 lb.	\$4.45
3/8	2 1/2"	1632	10 1/2 ozs.	1.90	2373	2 lbs.	6.65
1/2	3"	1633	11 ozs.	2.95	2374	4 lbs.	10.75
3/4	3 1/2"	.....	.....	.....	2375	5 lbs.	17.25
1"	4 1/2"	.....	.....	.....	2376	7 lbs.	48.25

## Turning Tool Holders

Drop-forged steel, heat-treated and hardened lathe tool holders. Supplied in three styles: straight, right-hand, and left-hand as illustrated.

Price includes: tool holder with hardened steel set screw, one unground hardened high-speed steel cutter bit, and a hardened drop-forged steel wrench.



Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Straight Shank Turning Tool Holders					
847-S	9"	3/8" x 13/16"	1/2" x 1/2"	1 lb.	\$2.10
846-S	10"	3/8" x 13/16"	1/2" x 1/2"	2 lbs.	4.55
852-S	13"	1/2" x 1 1/8"	3/8" x 3/8"	3 lbs.	5.20
853-S	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x 3/8"	3 lbs.	6.40

Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Right-Hand Turning Tool Holders					
847-R	9"	3/8" x 13/16"	1/2" x 1/2"	1 lb.	2.10
846-R	10"	3/8" x 13/16"	1/2" x 1/2"	2 lbs.	4.55
852-R	13"	1/2" x 1 1/8"	3/8" x 3/8"	3 lbs.	5.20
853-R	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x 3/8"	3 lbs.	6.40

Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Left-Hand Turning Tool Holders					
847-L	9"	3/8" x 13/16"	1/2" x 1/2"	1 lb.	2.10
846-L	10"	3/8" x 13/16"	1/2" x 1/2"	2 lbs.	4.55
852-L	13"	1/2" x 1 1/8"	3/8" x 3/8"	3 lbs.	5.20
853-L	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x 3/8"	3 lbs.	6.40

## Cutting-off Tool Holders

Cutting-off tool holders are made of drop-forged steel, heat-treated and hardened. Supplied in three styles: straight, right-hand, and left-hand as illustrated.

Price includes: tool holder, one cutter blade, and wrench.



Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Straight Shank Cutting-off Tool Holders					
833-S	9"	3/8" x 13/16"	3/8" x .595"	1 lb.	\$2.50
736-S	10"	3/8" x 13/16"	3/8" x .475"	2 lbs.	4.55
883-S	13"	1/2" x 1 1/8"	3/8" x .735"	3 lbs.	5.75
884-S	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x .870"	3 lbs.	7.20

Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Right-Hand Cutting-off Tool Holders					
833-R	9"	3/8" x 13/16"	3/8" x .595"	1 lb.	2.50
736-R	10"	3/8" x 13/16"	3/8" x .475"	2 lbs.	4.55
883-R	13"	1/2" x 1 1/8"	3/8" x .735"	3 lbs.	5.75
884-R	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x .870"	3 lbs.	7.20

Cat. No.	Size Lathe	Size Shank	Size Cutter	Ship. Wt.	Price*
Left-Hand Cutting-off Tool Holders					
736-L	10"	3/8" x 13/16"	3/8" x .475"	2 lbs.	4.55
883-L	13"	1/2" x 1 1/8"	3/8" x .735"	3 lbs.	5.75
884-L	14 1/2", 16" & 16/24"	3/8" x 1 1/8"	3/8" x .870"	3 lbs.	7.20

## Blades for Cutting-off Tool Holders

Made from high-speed steel, heat-treated, hardened, ground on the edges, ready to use in tool holders or Universal Tool Block.



Cat. No.	Size of Blade	Ship. Wt.	Price*
876	3/8" x .595" x 5"	5 ozs.	\$1.05
1192	3/8" x .475" x 4 1/2"	5 ozs.	.95
878	1/2" x .735" x 6"	6 ozs.	1.45
879	1/2" x .870" x 7"	8 ozs.	2.10

\*Subject to customer discount. See Customer Discount Sheet.



## Style "B" Boring Tool

*Purchased Extra*

Made of drop-forged steel. Cutter can be set either straight or at a 45-degree angle. Price includes: drop-forged steel boring tool holder with hardened steel set screws, sleeve bar, end cap, two wrenches, and two unground high speed steel cutter bits. Will take the following sizes of boring bars: No. 423,  $\frac{1}{8}$ " to  $\frac{1}{2}$ "; No. 431,  $\frac{3}{4}$ " to  $\frac{3}{4}$ "; No. 432,  $\frac{3}{8}$ " to 1".



Cat. No.	Size of Lathe	Size of Shank, Inches	Size Bar, Inches	Size of Cutter, Inch	Ship. Wt. Lbs.	Price*
423	9" & 10"	$\frac{3}{8}$ x $\frac{3}{4}$	$\frac{1}{2}$ x 7 $\frac{1}{2}$	$\frac{1}{8}$ x $\frac{1}{8}$	2	\$7.85
431	13"	$\frac{1}{2}$ x 1 $\frac{1}{2}$	$\frac{3}{4}$ x 11	$\frac{3}{8}$ x $\frac{3}{8}$	5	9.30
432	14 $\frac{1}{2}$ ", 16", 16/24"	$\frac{5}{8}$ x 1 $\frac{3}{4}$	$\frac{15}{16}$ x 13 $\frac{1}{4}$	$\frac{5}{16}$ x $\frac{5}{16}$	8	12.25

## Style "D" Boring Tool

*Purchased Extra*

For boring work of small internal diameter. Price includes drop-forged steel boring tool holder, one boring bar, and wrench. Will take the following sizes of boring bars: No. 505-F,  $\frac{1}{8}$ " to  $\frac{1}{2}$ "; No. 505-C,  $\frac{3}{4}$ " to  $\frac{3}{4}$ "; No. 505-D,  $\frac{3}{8}$ " to 1".



Cat. No.	Size of Lathe	Size of Shank, Inches	Size Bar, Inches	Ship. Wt. Lbs.	Price*
505-F	9" & 10"	$\frac{3}{8}$ x $\frac{3}{4}$	$\frac{1}{2}$ x 5	2	\$5.00
505-C	13"	$\frac{1}{2}$ x 1 $\frac{1}{2}$	$\frac{3}{4}$ x 7	4	6.78
505-D	14 $\frac{1}{2}$ ", 16", 16/24"	$\frac{5}{8}$ x 1 $\frac{3}{4}$	$\frac{15}{16}$ x 8	6	6.50

## Solid Boring Bar

*Purchased Extra*

For use with Style "B" and "D" Boring Tools and in the Universal Tool Block. High speed steel tip welded onto carbon steel shank. Can be ground for either boring or internal thread cutting operations.



Cat. No.	Bar Inches	Ship. Wt.	Price*
3856-E	$\frac{1}{8}$ x 4	3 ozs.	\$0.60
3856-F	$\frac{3}{16}$ x 4 $\frac{1}{2}$	4 ozs.	.80
3856-A	$\frac{1}{4}$ x 5	5 ozs.	1.00
3856-B	$\frac{5}{16}$ x 6	5 ozs.	1.20
3856-C	$\frac{3}{8}$ x 7	8 ozs.	1.60
3856-D	$\frac{1}{2}$ x 8	1 lb.	2.20

## Sleeve Boring Bar

*Purchased Extra*

For use with Style "B" and "D" Boring Tools, and in the Universal Tool Block. Sleeve can be adjusted to hold square high speed steel cutter bit at 45° and 90° angles for boring and inside thread cutting operations. Price includes two cutter bits and wrench.



Cat. No.	Size of Bar	Size of Cutter Bit	Ship. Wt.	Price*
2420-NR	$\frac{1}{8}$ " x 7 $\frac{1}{2}$ "	$\frac{1}{8}$ " x $\frac{1}{8}$ "	1 lb.	\$4.80
2420-T	$\frac{3}{8}$ " x 11"	$\frac{3}{8}$ " x $\frac{3}{8}$ "	2 lbs.	6.00
2420-FH	$\frac{15}{16}$ " x 13 $\frac{1}{4}$ "	$\frac{5}{16}$ " x $\frac{5}{16}$ "	4 lbs.	8.65

## Plain Boring Bar

*Purchased Extra*

For use with Universal Tool Blocks and Boring Tool Holders. Bars will hold cutter bit at 45° and 90° angles. Price includes cutter bit and wrench.



Cat. No.	Bar Size	Cutter Bit	Ship. Wt.	Price*
2119	$\frac{1}{8}$ " x 12 $\frac{1}{2}$ "	$\frac{1}{8}$ " x $\frac{1}{8}$ "	3 lbs.	\$ 7.60
2121	1 $\frac{1}{2}$ " x 18"	$\frac{3}{8}$ " x $\frac{3}{8}$ "	8 lbs.	21.90
2123	1 $\frac{1}{2}$ " x 20"	$\frac{3}{8}$ " x $\frac{3}{8}$ "	13 lbs.	27.15

\*Subject to customer discount. See Customer Discount Sheet.

## Knurling Tool

*Purchased Extra*

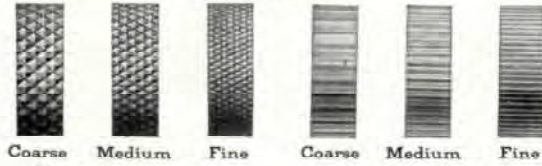
Knurling tool holder is made of drop-forged steel, heat-treated and hardened. Knurls are made of tool steel, hardened and tempered. Price includes: holder with choice of knurls in coarse, medium, or fine; straight, or diamond shape. When ordering specify pattern of knurls wanted; otherwise medium diamond knurls will be supplied.



Cat. No.	Size Lathe	Shank Size	Ship Wt.	Price*
820	9"	$\frac{3}{8}$ " x $\frac{3}{4}$ "	2 lbs.	\$ 5.00
865	10"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	2 lbs.	9.00
893	13"	$\frac{1}{2}$ " x 1 $\frac{1}{2}$ "	2 lbs.	10.80
894	14 $\frac{1}{2}$ ", 16" & 16/24"	$\frac{5}{8}$ " x 1 $\frac{3}{4}$ "	3 lbs.	12.80

## Extra Knurls for Knurling Tool

*Purchased Extras*



Diamond Pattern

Straight Pattern

For use with Knurling Tools listed above, or with Universal Tool Block listed on preceding page. Illustrations above show actual size of knurling produced. Supplied in pairs.

Cat. No.	Pattern	Size	Fits Knurling Tools	Ship. Wt.	Price Per Pair*
3150†	Fine Diamond	$\frac{3}{8}$ " x $\frac{3}{8}$ "	820 & 665	4 ozs.	\$1.60
3151†	Med. Diamond	$\frac{1}{2}$ " x $\frac{1}{2}$ "	820 & 665	4 ozs.	1.60
3152†	Coarse Diamond	$\frac{3}{4}$ " x $\frac{3}{4}$ "	820 & 665	4 ozs.	1.60
3153†	Fine Straight	$\frac{3}{8}$ " x $\frac{3}{8}$ "	820 & 665	4 ozs.	1.60
3154†	Med. Straight	$\frac{1}{2}$ " x $\frac{1}{2}$ "	820 & 665	4 ozs.	1.60
3155†	Coarse Straight	$\frac{3}{4}$ " x $\frac{3}{4}$ "	820 & 665	4 ozs.	1.60
3156	Fine Straight	$\frac{3}{8}$ " x $\frac{3}{8}$ "	893 & 894	5 ozs.	1.85
3157	Med. Straight	$\frac{1}{2}$ " x $\frac{1}{2}$ "	893 & 894	5 ozs.	1.85
3158	Coarse Straight	$\frac{3}{4}$ " x $\frac{3}{4}$ "	893 & 894	5 ozs.	1.85
3159	Fine Straight	$\frac{3}{8}$ " x $\frac{3}{8}$ "	893 & 894	5 ozs.	1.85
3160	Med. Straight	$\frac{1}{2}$ " x $\frac{1}{2}$ "	893 & 894	5 ozs.	1.85
3161	Coarse Straight	$\frac{3}{4}$ " x $\frac{3}{4}$ "	893 & 894	5 ozs.	1.85

† Fits all sizes of Universal Tool Blocks.

## Threading Tool

*Purchased Extra*

Made of drop-forged steel. Cutter requires grinding on top edge only to sharpen. Price includes: threading tool holder with hardened steel set screw; wrench; and one high speed steel single point cutter. Choice of 60° cutter for U.S. Standard, V, or metric thread; or 55° cutter for Whitworth Standard thread. When ordering specify cutter wanted. The 60° cutter will be furnished unless otherwise specified.



Cat. No.	Size of Lathe	Size of Shank	Ship. Wt.	Price*
845	9"	$\frac{3}{8}$ " x $\frac{3}{4}$ "	2 lbs.	\$ 4.20
848	10"	$\frac{1}{2}$ " x $\frac{1}{2}$ "	2 lbs.	6.65
867	13"	$\frac{1}{2}$ " x 1 $\frac{1}{2}$ "	3 lbs.	8.00
868	14 $\frac{1}{2}$ ", 16" & 16/24"	$\frac{5}{8}$ " x 1 $\frac{3}{4}$ "	4 lbs.	10.25

## Extra Cutters for Threading Tool

*Purchased Extras*

For use with threading Tools listed above. Made of high speed steel, thread angle ground to correct form and backed off for proper clearance. 60° cutters are for U.S. Standard, V, or metric threads. 55° cutters are for Whitworth Standard threads.



Catalog Number		Fits Thread Tools	Shipping Weight	Price*
60° Angle	55° Angle			
862-NR	1457-NR	845 & 648	3 ozs.	\$2.75
862-T	1457-T	867	4 ozs.	5.00
862-FH	1457-FH	868	5 ozs.	6.85

\*Subject to customer discount. See Customer Discount Sheet.



## 4-Jaw Independent Lathe Chucks

These chucks have four reversible jaws with individual screw adjustment. Chuck body is ground and chuck jaws are hardened and ground.

Prices include wrench, and chuck plate fitted to lathe spindle and chuck. Size chuck recommended for each size lathe is shown in bold face type.



Catalog No.	Size of Chuck	Type of Chuck	Size of Lathe	Shp. Wt.	Factory Price
4006-W	6"	Med. Duty	9"	13 lbs.	\$ 35.50
4206-W	6"	Reg. Duty	9"	18 lbs.	63.50
4006-N	6"	Med. Duty	10"-11 1/2" Col.	13 lbs.	41.00
4206-N	6"	Reg. Duty	10"-11 1/2" Col.	18 lbs.	69.00
4207-N	7 1/2"	Reg. Duty	10"-11 1/2" Col.	37 lbs.	79.00
4006-R	6"	Med. Duty	10"-1" Col.	13 lbs.	42.00
4206-R	6"	Reg. Duty	10"-1" Col.	18 lbs.	70.00
4207-R	7 1/2"	Reg. Duty	10"-1" Col.	38 lbs.	80.00
4206-C	6"	Reg. Duty	13"-11 1/2" Col.	18 lbs.	69.00
4207-C	7 1/2"	Reg. Duty	13"-11 1/2" Col.	38 lbs.	79.00
4209-C	9"	Reg. Duty	13"-11 1/2" Col.	46 lbs.	87.00
4206-R	6"	Reg. Duty	13"-1" Col.	18 lbs.	70.00
4207-R	7 1/2"	Reg. Duty	13"-1" Col.	38 lbs.	80.00
4209-O	9"	Reg. Duty	13"-1" Col.	46 lbs.	88.00
4206-D	6"	Reg. Duty	14 1/2"-3 3/4" Col.	18 lbs.	70.00
4207-D	7 1/2"	Reg. Duty	14 1/2"-3 3/4" Col.	38 lbs.	80.00
4209-D	9"	Reg. Duty	14 1/2"-3 3/4" Col.	46 lbs.	88.00
4210-D	10"	Reg. Duty	14 1/2"-3 3/4" Col.	57 lbs.	101.00
4207-E	7 1/2"	Reg. Duty	14 1/2"-1" Col.	38 lbs.	81.00
4209-E	9"	Reg. Duty	14 1/2"-1" Col.	46 lbs.	89.00
4210-E	10"	Reg. Duty	14 1/2"-1" Col.	57 lbs.	102.00
4207-E	7 1/2"	Reg. Duty	16" & 16/24"	38 lbs.	81.00
4209-E	9"	Reg. Duty	16" & 16/24"	46 lbs.	89.00
4210-E	10"	Reg. Duty	16" & 16/24"	57 lbs.	102.00
4212-E	12"	Reg. Duty	16" & 16/24"	96 lbs.	117.00

## 3-Jaw Universal Lathe Chucks



Universal Chucks are supplied either with two sets of jaws or with one set of reversible jaws as indicated in table below. Chuck body is ground and jaws are hardened. Chuck jaws are moved simultaneously by a scroll, and work is automatically centered. Prices include wrench and threaded chuck

plate fitted to lathe spindle. Size of chuck recommended for each size lathe is shown in bold face type.

Catalog No.	Size of Chuck	Type of Chuck	Size of Lathe	Shp. Wt.	Factory Price
3005-W	5"	Med. Duty	9"	13 lbs.	\$ 51.50
3505-W	5"	Reg. Duty	9"	19 lbs.	82.50
3506-W	6"	Reg. Duty	9"	28 lbs.	85.50
3005-N	5"	Med. Duty	10"-11 1/2" Col.	13 lbs.	57.00
3505-N	5"	Reg. Duty	10"-11 1/2" Col.	19 lbs.	88.00
3506-N	6"	Reg. Duty	10"-11 1/2" Col.	28 lbs.	91.00
3005-R	5"	Med. Duty	10"-1" Col.	13 lbs.	58.00
3505-R	5"	Reg. Duty	10"-1" Col.	19 lbs.	89.00
3506-R	6"	Reg. Duty	10"-1" Col.	28 lbs.	92.00
3508-C	5"	Reg. Duty	13"-11 1/2" Col.	19 lbs.	88.00
3506-C	6"	Reg. Duty	13"-11 1/2" Col.	28 lbs.	91.00
3507-C	7 1/2"	Reg. Duty	13"-11 1/2" Col.	47 lbs.	104.00
3505-R	5"	Reg. Duty	13"-1" Col.	19 lbs.	89.00
3506-R	6"	Reg. Duty	13"-1" Col.	28 lbs.	92.00
3507-O	7 1/2"	Reg. Duty	13"-1" Col.	47 lbs.	105.00
3505-D	5"	Reg. Duty	14 1/2"-3 3/4" Col.	19 lbs.	89.00
3506-D	6"	Reg. Duty	14 1/2"-3 3/4" Col.	28 lbs.	92.00
3507-D	7 1/2"	Reg. Duty	14 1/2"-3 3/4" Col.	47 lbs.	105.00
3509-D	9"	Reg. Duty	14 1/2"-3 3/4" Col.	59 lbs.	136.00
3505-E	5"	Reg. Duty	14 1/2"-1" Col.	19 lbs.	90.00
3506-E	6"	Reg. Duty	14 1/2"-1" Col.	28 lbs.	93.00
3507-E	7 1/2"	Reg. Duty	14 1/2"-1" Col.	47 lbs.	106.00
3509-E	9"	Reg. Duty	14 1/2"-1" Col.	59 lbs.	137.00
3505-E	5"	Reg. Duty	16" & 16/24"	19 lbs.	90.00
3506-E	6"	Reg. Duty	16" & 16/24"	28 lbs.	93.00
3507-E	7 1/2"	Reg. Duty	16" & 16/24"	47 lbs.	106.00
3508-E	9"	Reg. Duty	16" & 16/24"	59 lbs.	137.00

### Universal Chucks With Two Sets of Jaws

Catalog No.	Size of Chuck	Type of Chuck	Size of Lathe	Shp. Wt.	Factory Price
6005-W	5"	Light Duty	9"	12 lbs.	\$ 38.50
6506-W	6"	Med. Duty	9"	26 lbs.	64.50
6005-N	5"	Light Duty	10"-11 1/2" Col.	12 lbs.	44.00
6005-R	5"	Light Duty	10"-1" Col.	12 lbs.	45.00
6005-C	5"	Light Duty	13"-11 1/2" Col.	12 lbs.	44.00
6506-N	6"	Med. Duty	10"-11 1/2" Col.	26 lbs.	70.00
6506-R	6"	Med. Duty	10"-1" Col.	26 lbs.	71.00
6506-C	6"	Med. Duty	13"-11 1/2" Col.	26 lbs.	70.00

## Face Plate Chuck



This inexpensive Face Plate Chuck can be used for holding round, square, or irregular work. Maximum capacity for round work is 7 1/2" in diameter. Face plate is 8" in diameter, with annular lines to aid in centering.

Cat. No.	Size Lathe	Spindle Th'd.	Shp. Wt.	Price
2155-N	9"	1 1/2"-8	14 lbs.	\$15.75
2155-R	10"-11 1/2" Col.	1 7/8"-8	16 lbs.	18.00
2155-L	10"-1" Col.	2 1/4"-8	16 lbs.	20.00

## 3-Jaw Drill Chucks

These drill chucks are so constructed that they will hold the drill securely and accurately. Jaws are tempered steel. Price includes pinion key, but does not include arbor.



Cat. No.	Make of Chuck	Capacity of Chuck	Net Wt. Lbs.	Shp. Wt. Lbs.	Factory Price
1200	Jacobs	0 to 3/8 in.	1 1/4	1 7/8	\$ 6.50
1201	Jacobs	0 to 1/2 in.	1 3/4	2 1/8	6.84
1202	Jacobs	3/8 to 3/4 in.	3 1/8	3 1/2	12.00
1206	Jacobs	3/8 to 1 in.	6 3/8	7 1/2	24.00
219	Almond	0 to 3/8 in.	1 3/8	1 7/8	5.50
220	Almond	0 to 1/2 in.	1 3/4	2 1/2	7.50
327	Almond	3/8 to 3/4 in.	3 1/8	3 3/4	10.00
328	Almond	3/8 to 1 in.	5 3/8	6 3/8	15.00

## Taper Arbors for Drill Chucks

For fitting drill chuck to taper of lathe headstock spindle or tailstock spindle.



For Drill Chuck	No. 2 Morse Taper			No. 3 Morse Taper		
	Cat. No.	Shp. Wt.	Price	Cat. No.	Shp. Wt.	Price
1200	2300	3/8 lb.	\$0.90	2301	3/4 lb.	\$1.35
1201	2302	1/2 lb.	.90	2303	3/4 lb.	1.35
1202	2304	1/2 lb.	.90	2305	3/4 lb.	1.35
1206	2306	1 1/8 lbs.	.90	2307	1 1/8 lbs.	1.35
219	2300	3/8 lb.	.90	2301	3/4 lb.	1.35
220	2302	1/2 lb.	.90	2303	3/4 lb.	1.35
327	2308	3/4 lb.	.90	2309	1 1/8 lbs.	1.35
328	2308	3/4 lb.	.90	2309	1 1/8 lbs.	1.35

## Straight Arbors for Drill Chucks

For Fitting Drill Chuck to Hole in Turret Head

For Drill Chucks	3/8" Diameter		3/4" Diameter		1 1/2" Diameter	
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
1200 or 219	2360	\$0.90	2361	\$0.90	2377	\$1.95
1201 or 220	2362	.90	2363	.90	2378	1.95
1202	2364	.90	2365	.90	2379	1.95
1206	2366	.90	2367	.90	2380	1.95
327 or 328	2368	.90	2369	.90	2381	1.95

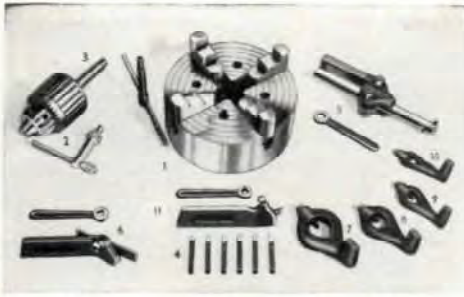
## Semi-Machined Drill Chuck Arbors

For fitting drill chucks and other tools to lathe spindle or turret head. Must be machined to fit drill chuck or other tool.



Cat. No.	Shank	Shp. Wt.	Price
1500	No. 2 Morse Taper	1 lb.	\$0.90
1501	No. 3 Morse Taper	2 lbs.	1.35
2325	3/8" Diameter Straight	1 lb.	1.20
2326	3/4" Diameter Straight	1 lb.	1.25





## Chuck and Tool Assortments

The chucks and tools in the assortments listed are recommended for use with the various sizes of South Bend Lathes. They include the basic equipment required for the average shop for general machine work, such as turning, boring, drilling, cutting-off, chucking, etc.

### 11-Tool Assortment with Independent Lathe Chuck

Item	Description
1	4-Jaw Independent Lathe Chuck fitted to lathe. Sizes: 6 in. on 9" and 10" Lathes; 7 1/2 in. on 13" Lathe; 9 in. on 14 1/2" Lathe; 10 in. on 16" and 16 1/4" Lathes.
2	Jacob's 3-Jaw Drill Chuck. Sizes: 1/2 in. on 9" and 10" Lathes; 3/4 in. on 13" and 14 1/2" Lathes; 1 in. on 16" and 16 1/4" Lathes.
3	Arbor Fitted to above Drill Chuck.
4	6 Ground Cutter Bits for Tool Holder.
5	Boring Tool Holder, Style "B." 9" Lathes take Style "D."
6	Cutting-off Tool Holder, Right-Hand.
7-10	4 Malleable Lathe Dogs. Sizes: 1 1/2", 1", and 1 1/4" on 9" and 10" Lathes; 1 1/2", 1", and 1 1/4" on all others.
11	Straight Shank Tool Holder.

### Prices of Complete Assortments as Listed Above

Cat. No.	Size Lathe	Ship. Wt.	Factory Price
105-WT	9"	28 lbs.	\$ 57.00
110-T	10" & 10 1/2" Col.	35 lbs.	96.00
110-L	10" & 1" Col.	35 lbs.	97.00
113-T	13" & 13 1/2" Col.	70 lbs.	116.00
113-TO	13" & 1" Col.	70 lbs.	117.00
114-T	14 1/2" & 14 1/4" Col.	75 lbs.	131.00
114-TM	14 1/2" & 1" Col.	75 lbs.	132.00
116-T	16" & 16 1/4"	80 lbs.	157.00

### 11-Tool Assortment with Universal Chuck for 9-inch Swing Lathes Only

This assortment is exactly the same as the No. 105-WT assortment listed above, except that a 5" 3-jaw universal chuck is supplied in lieu of the 6" 4-jaw independent chuck.

No. 105-F. Eleven Tool Assortment with Universal Chuck for 9-inch Lathe. Shipping weight 20 lbs. .... \$72.50

## Wood Turning Rests

The Wood Turning Rest mounts on the compound rest base of the lathe to permit the use of hand tools for wood turning. Prices listed below include socket, one small rest 4" wide, and one large rest 12" wide. See page 17 for spur centers and cup centers for wood turning.



Cat. No.	Size Lathe	Shipping Weight	Factory Price
896-W	9"	6 lbs.	\$10.00
1069	10"	7 lbs.	13.00
1073	13"	9 lbs.	15.00
1165	14 1/2"	12 lbs.	19.00
1075	16" & 16 1/4"	14 lbs.	19.00



## 20-Tool Assortment for 9-inch Lathes

This is a more complete assortment than those listed at left, and consists of the following equipment:

Item	Cat. No.	Description
1	4006-W	6" Four-Jaw Independent Lathe Chuck, fitted.
2	3005-W	5" Three-Jaw Universal Lathe Chuck, fitted.
3	1201	Jacob's Three-Jaw Drill Chuck, 1/2" capacity.
4	2302	Taper Shank Arbor (No. 2 M.T.), fitted to Drill Chuck.
5	847-S	Straight Shank Turning Tool Holder.
6	847-R	Right-Hand Turning Tool Holder.
7	847-L	Left-Hand Turning Tool Holder.
8	833-R	Right-Hand Cutting-off Tool Holder.
9	833-S	Straight Shank Cutting-off Tool Holder.
10	1779	Set (6) Ground Cutter Bits for Turning Tools.
11, 12	1629	Two Sets (6) Unground Cutter Bits for Turning Tools.
13	505-F	Style "D" Boring Tool Holder.
14	423	Style "B" Boring Tool Holder.
15	1-MJ	1/2" Standard Lathe Dog.
16	2-MJ	3/4" Standard Lathe Dog.
17	4-MJ	1" Standard Lathe Dog.
18	6-MJ	1 1/4" Standard Lathe Dog.
19	8-MJ	1 3/4" Standard Lathe Dog.
20	10-MJ	2" Standard Lathe Dog.

No. 105-H. Twenty Tool Assortment as listed above for 9-inch Lathe. Shipping weight 52 lbs. .... \$125.00

## Cutter Bit Grinding Gauge

For grinding the correct front clearance, side clearance, front rake, and back rake on lathe tool cutter bits for machining iron and steel. Made of steel. Instructions for using are packed with each gauge.

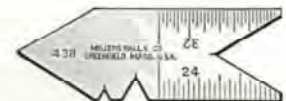
No. 2169. Shipping weight 1/2 lb. Factory price ..... \$0.50



## Center Gauge

The center gauge is a useful tool for the lathe operator. The 60° included angle is used for checking the angle of the lathe center point. The two small 60° notches in the side of the tool are used for grinding and setting the point of the lathe tool for cutting screw threads. Engine divided graduations in each corner are in 32nds, 24ths, 20ths, and 14ths respectively. Made of good quality tool steel, hardened and tempered. Accurately ground on all faces, and lapped in the notches to a light tight fit with a standard.

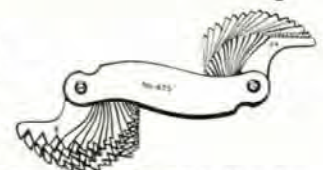
No. 650. Center Gauge. Shipping weight 2 ozs. Factory price ..... \$0.75



## Starrett Screw Thread Pitch Gauge

For checking the pitch of V, American National and U.S. Standard Threads. Has 30 pitches as follows: 6, 7, 8, 9, 10, 11, 11 1/2, 12, 13, 14, 15, 16, 18, 20, 22 in one end of the case; 24, 26, 27, 28, 30, 32, 34, 36, 38, 40, 42, 48, 50, 56, 60 in the other.

No. 2171. Ship. wt. 5 ozs. Factory price ..... \$2.65







### Tubular Steel Benches

Sturdy welded steel construction with tubular frame. Provides rigid support for lathe. Benches for 9-inch Horizontal Motor Driven Lathes have six drawers 10 1/2" wide, 15 3/4" long, 5 1/2" deep (inside dimensions) as illustrated. A built-in chip pan forms the top of the bench. Benches for 10-inch Underneath Motor Driven Lathes are similar, but instead of drawers on left side, space with door is provided for motor drive mechanism. Prices of 9-inch Lathes do not include benches. Prices of 10-inch Lathes include benches.

Cat. No.	Lathe Size	Size of Bench	Shipping Weight	Factory Price
1786-A	9" x 3" 9" x 3 1/2"	32" high 27" wide 51 1/4" long	268 lbs.	\$145.00
1795	10" x 3" 10" x 3 1/2"	32" high 22" wide 51 1/4" long	278 lbs.	110.00
1796	10" x 4" 10" x 4 1/2"	32" high 22" wide 64 1/4" long	300 lbs.	120.00



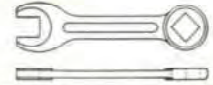
### Angle Steel Bench With Wood Top

Heavy angle steel construction, 29 3/16" high, with hardwood top 26" x 60" x 1 3/16" thick. For 9" Horizontal Motor Driven Bench Lathes, any bed length. Bench top is edge glued and has oil finish. Price does not include drawer, which is listed separately below.

1780. Steel Bench with wood top (less drawer). Shipping weight, 84 lbs. Price.....\$32.75

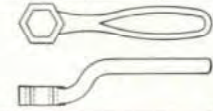
1780-D. Drawer for above bench, 20 1/8" wide, 14" long, 3 3/16" deep. Shipping weight, 9 lbs. Price.....\$6.25

### Tool Post Wrenches



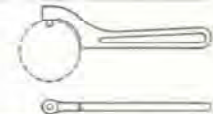
Cat. No.	Size Lathe	Open End	Closed End	Lgth.	Thick-ness	Ship. Wt.	Fac. Price
2650-N	9"	3/8"	3/8"	4"	3/8"	4 ozs.	\$0.55
2650-R	10"	3/8"	3/8"	4"	3/8"	6 ozs.	.65
2650-T	13"	3/8"	3/8"	6"	3/8"	1 lb.	1.25
2650-FH	14 1/2", 16" & 16 1/4"	3/8"	3/8"	6"	3/8"	1 lb.	1.35

### Tailstock Wrenches



Cat. No.	Size Lathe	Open- ing	Ex- treme Lgth.	Thick-ness	Ship. Wt.	Fac- tory Price
2653-N	9"	1 1/8"	5 3/8"	7/8"	6 ozs.	\$0.50
2653-R	10"	1 1/8"	6 3/8"	7/8"	1 lb.	.60
2653-T	13"	1 1/8"	7 3/8"	1 1/8"	2 lbs.	.85
2653-FH	14 1/2", 16" & 16 1/4"	1 1/8"	9 1/8"	1"	2 lbs.	1.15

### Spanner Wrenches



Catalog No.	Circle Diameter	Extreme Length	Pin Size	Shipping Weight	Factory Price
2739	1 1/8"	4"	3/16"	5 ozs.	\$0.65
2740	1 1/2"	5"	3/16"	6 ozs.	.85
2734	2 1/8"	6 1/2"	1/8"	1 lb.	.85
2735	2 1/4"	7 1/2"	1/8"	1 lb.	.90
2736	3"	8"	3/16"	1 lb.	1.00
2737	3 1/4"	8 1/2"	3/16"	1 lb.	1.05
2738	3 3/8"	9"	1/2"	2 lbs.	1.20

### Hollow Hexagon Head Set Screw Wrenches



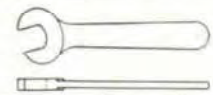
Cat. No.	Size Hex.	Ex- treme Lgth.	Ex- treme Ht.	Fits Safety Lathe Dog Nos.	Ship. Wt.	Fac- tory Price
2391	3/8"	3 1/2"	3/8"	.....	3 ozs.	\$0.05
2392	1/2"	2 1/2"	1/2"	.....	3 ozs.	.05
2385	5/8"	2 1/2"	1 1/8"	3820, 3821 & 3826	3 ozs.	.05
2386	3/4"	2 1/2"	1 1/8"	3822 & 3827	4 ozs.	.06
2387	7/8"	2 1/2"	1 1/8"	3823 & 2828	4 ozs.	.07
2388	1 1/8"	3 1/2"	1 1/8"	3824, 3825 & 3829	4 ozs.	.08
2389	1 1/4"	4 1/2"	1 1/8"	3830, 3831 & 3832	4 ozs.	.11
2390	1 3/8"	4 1/2"	1 1/8"	3833, 3834, 3835 & 3836	6 ozs.	.16

### Double End Wrenches



Catalog No.	Large Opening	Small Opening	Length	Thick-ness	Shipping Weight	Factory Price
2655	1 1/2"	3/4"	4 7/8"	1/4"	8 ozs.	\$0.60
2656	2 1/2"	1 1/2"	6 1/2"	1/2"	1 lb.	1.25

### Single End Wrenches



Catalog Number	Opening	Length	Thickness	Shipping Weight	Factory Price
2657	3/8"	5 1/2"	1 1/8"	7 ozs.	\$0.65
2658	1/2"	5 1/2"	1 1/8"	8 ozs.	.75
2672	1 1/8"	4 1/2"	1 1/8"	5 ozs.	.65
2673	1 1/4"	5 1/2"	1 1/8"	6 ozs.	.75
2674	3/4"	5 7/8"	1 1/8"	1 lb.	.85
2670	1 1/8"	6 1/2"	1 1/8"	1 lb.	.95
2671	1 1/4"	8 1/2"	1 1/8"	1 lb.	1.25

### Open End Box Wrench

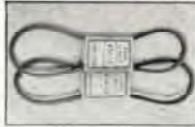


2675. Open End Box Wrench. 3/8" opening, 3/8" close, 1/2" thick, 10 1/2" long. Shipping weight 1 lb.....\$1.85



## V-Belts

Rubber V-Belts for use with South Bend Lathes and other power driven machinery. Specify catalog number, maximum width, and outside circumference when ordering. Ship. wt. each, approximately  $\frac{1}{2}$  lb.



Catalog No.	Maximum Width	Outside Circumference	Price*
4522-A	$\frac{3}{8}$ in.	22 in.	\$0.98
4523-A	$\frac{3}{8}$ in.	23 in.	0.98
4527-A	$\frac{3}{8}$ in.	27 in.	1.02
4535-C	$\frac{5}{8}$ in.	35 in.	1.60
4537-C	$\frac{5}{8}$ in.	37 in.	1.70
4540-D	$\frac{11}{16}$ in.	40 in.	1.84
4541-D	$\frac{11}{16}$ in.	41 in.	1.90
4542-D	$\frac{11}{16}$ in.	42 in.	1.97
4543-D	$\frac{11}{16}$ in.	43 in.	2.02
4544-B	$\frac{1}{2}$ in.	44 in.	1.60
4544-D	$\frac{11}{16}$ in.	44 in.	2.08
4545-B	$\frac{1}{2}$ in.	45 in.	1.62
4545-D	$\frac{11}{16}$ in.	45 in.	2.12
4546-B	$\frac{1}{2}$ in.	46 in.	1.64
4546-D	$\frac{11}{16}$ in.	46 in.	2.16
4547-B	$\frac{1}{2}$ in.	47 in.	1.67
4547-D	$\frac{11}{16}$ in.	47 in.	2.20
4548-B	$\frac{1}{2}$ in.	48 in.	1.70
4849-B	$\frac{1}{2}$ in.	49 in.	1.74
4549-D	$\frac{11}{16}$ in.	49 in.	2.30
4550-C	$\frac{5}{8}$ in.	50 in.	2.35
4551-C	$\frac{5}{8}$ in.	51 in.	2.39
4552-C	$\frac{5}{8}$ in.	52 in.	2.44
4553-B	$\frac{1}{2}$ in.	53 in.	1.12
4554-B	$\frac{1}{2}$ in.	54 in.	1.89
4554-C	$\frac{5}{8}$ in.	54 in.	2.53
4555-C	$\frac{5}{8}$ in.	55 in.	2.58
4556-B	$\frac{1}{2}$ in.	56 in.	1.94
4558-B	$\frac{1}{2}$ in.	58 in.	2.00
4559-C	$\frac{5}{8}$ in.	59 in.	2.77
4560-B	$\frac{1}{2}$ in.	60 in.	2.06
4564-B	$\frac{1}{2}$ in.	64 in.	2.18
4568-B	$\frac{1}{2}$ in.	68 in.	2.30
4570-B	$\frac{1}{2}$ in.	70 in.	2.36
4571-B	$\frac{1}{2}$ in.	71 in.	2.39
4578-B	$\frac{1}{2}$ in.	78 in.	2.62
4580-B	$\frac{1}{2}$ in.	80 in.	2.70
4598-B	$\frac{1}{2}$ in.	98 in.	3.12

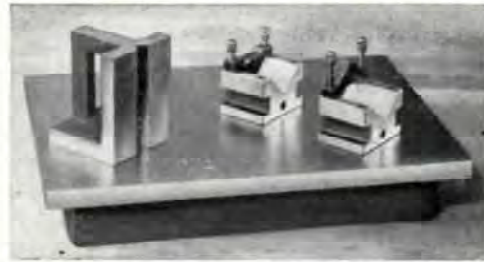
\*Subject to customer discount. See customer discount sheet.

## Motor Pulleys for V-Belts

These motor pulleys are machined all over and have accurately reamed holes so that they will fit standard sizes of motor shafts properly and will run true. They are made of cast iron or aluminum, depending on size. Pulleys having  $\frac{1}{8}$ " bore have a set screw for locking to motor shaft, all others have standard keyways.



Cat. No.	Dia.	Bore	Price	Cat. No.	Dia.	Bore	Price
<b>1-Groove Pulleys for <math>\frac{1}{2}</math>" V-Belts</b>							
Approx. ship. wts., 2 $\frac{1}{2}$ " and 2 $\frac{3}{4}$ " pulleys $\frac{1}{2}$ lb., 3" and 3 $\frac{1}{2}$ " pulleys 1 $\frac{1}{4}$ lbs.							
6342	2 $\frac{1}{2}$ "	$\frac{1}{2}$ "	\$0.80	6348	3"	$\frac{1}{2}$ "	\$1.05
6343	2 $\frac{3}{4}$ "	$\frac{1}{2}$ "	.80	6349	3"	$\frac{3}{8}$ "	1.05
6344	2 $\frac{1}{2}$ "	$\frac{3}{8}$ "	.80	6350	3"	$\frac{1}{4}$ "	1.15
6345	2 $\frac{3}{4}$ "	$\frac{3}{8}$ "	.90	6351	3 $\frac{1}{2}$ "	$\frac{1}{2}$ "	1.15
6346	2 $\frac{1}{2}$ "	$\frac{1}{4}$ "	.90	6352	3 $\frac{1}{2}$ "	$\frac{3}{8}$ "	1.15
6347	2 $\frac{3}{4}$ "	$\frac{1}{4}$ "	.90	6353	3 $\frac{1}{2}$ "	$\frac{1}{4}$ "	1.15
<b>2-Groove Pulleys for <math>\frac{1}{2}</math>" V-Belts</b>							
Approx. ship. wts., 2 $\frac{1}{2}$ " pulleys 1 $\frac{1}{4}$ lbs., 2 $\frac{3}{4}$ " pulleys 2 lbs.							
6354	2 $\frac{1}{2}$ "	$\frac{1}{2}$ "	\$1.60	6357	2 $\frac{3}{4}$ "	$\frac{3}{8}$ "	\$1.85
6355	2 $\frac{1}{2}$ "	$\frac{3}{8}$ "	1.60	6358	2 $\frac{3}{4}$ "	$\frac{1}{4}$ "	1.85
6356	2 $\frac{3}{4}$ "	$\frac{1}{2}$ "	1.60	6359	2 $\frac{3}{4}$ "	$\frac{1}{4}$ "	1.85
<b>4-Groove Pulleys for <math>\frac{1}{2}</math>" V-Belts</b>							
Approx. ship. wts., 2 $\frac{1}{2}$ " and 2 $\frac{3}{4}$ " pulleys 2 lbs., 3 $\frac{1}{2}$ " and 3 $\frac{3}{4}$ " pulleys 4 lbs.							
6360	2 $\frac{1}{2}$ "	$\frac{3}{8}$ "	\$3.40	6366	3 $\frac{1}{2}$ "	$\frac{3}{8}$ "	\$4.05
6361	2 $\frac{1}{2}$ "	$\frac{1}{4}$ "	3.40	6367	3 $\frac{1}{2}$ "	$\frac{1}{4}$ "	4.05
6362	2 $\frac{3}{4}$ "	$\frac{3}{8}$ "	3.40	6368	3 $\frac{1}{2}$ "	$\frac{1}{4}$ "	4.05
6363	2 $\frac{3}{4}$ "	$\frac{1}{4}$ "	3.95	6369	3 $\frac{1}{2}$ "	$\frac{3}{8}$ "	4.30
6364	2 $\frac{1}{2}$ "	$\frac{1}{4}$ "	3.95	6370	3 $\frac{1}{2}$ "	$\frac{1}{4}$ "	4.30
6365	2 $\frac{3}{4}$ "	$\frac{1}{4}$ "	3.95	6371	3 $\frac{1}{2}$ "	$\frac{1}{4}$ "	4.30



## Surface Plate

A heavy cast iron surface plate for laying out work, surfacing, checking flat surfaces, and general shop use. Top surface is precision ground and has wooden cover. Edges are machined and under side of edge is finished all around. Size 12" x 17" x 3", with top  $\frac{3}{4}$ " thick. Approximate net wt. 64 lbs. 2215. Shipping weight 75 lbs. .... \$37.50

## V-Blocks

These toolmaker's V-Blocks provide a rigid support for holding cylindrical parts and shafts for laying out and machining. Made of hardened steel with all surfaces precision ground. Each block is 2-15/16" wide, 1-15/16" high, 2 $\frac{1}{4}$ " long. Holds round work  $\frac{1}{4}$ " to 2" in diameter. Sold only in numbered sets. 2216. Set of two V-Blocks. Shipping weight 8 lbs. .... \$32.00

## Angle Plate

Precision ground on six sides, this rigidly constructed cast iron angle plate has many uses. It serves as a square for laying out and setting up work. Size 3 $\frac{1}{4}$ " x 3 $\frac{1}{4}$ " x 4 $\frac{1}{4}$ " with  $\frac{3}{8}$ " V-groove. 2214. Shipping weight 7 lbs. .... \$20.00

## Flat Leather Belts

Price includes belt lace and lacing instructions. Ship. wt. each, approx.  $\frac{1}{2}$  lb.



Cat. No.	For Use On	Size and Kind of Belting	Price
2311	9" Horiz. M.D. Lathes— $\frac{1}{4}$ or $\frac{1}{2}$ h.p. motor.	Single Ply—Oak Tan $1\frac{1}{2}$ " x 50"	\$ 1.50
2310	9" Horiz. M.D. Lathes with metric transp. gears— $\frac{1}{4}$ or $\frac{1}{2}$ h.p. motor.	Single Ply—Oak Tan $1\frac{1}{2}$ " x 55"	1.50
2321	9" Horiz. M.D. Lathes with taper attachment, $\frac{1}{4}$ or $\frac{1}{2}$ h.p. motor.	Single Ply—Oak Tan $1\frac{1}{2}$ " x 53"	1.50
2323	9" Horiz. M.D. Lathes with $\frac{1}{2}$ h.p. motor.	Single Ply—Oak Tan $1\frac{1}{2}$ " x 58"	1.50
2312	9" Horiz. M.D. Lathes with $\frac{1}{2}$ h.p. motor.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 58"	5.40
2313	9" UMD Lathes.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 66 $\frac{1}{4}$ "	7.25
2314	10" UMD Bench Lathes.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 64 $\frac{1}{4}$ "	7.50
2315	10" UMD Floor Lathes.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 67 $\frac{1}{4}$ "	7.75
2316	13" UMD Lathes.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 67 $\frac{1}{2}$ "	10.50
2317	14 $\frac{1}{2}$ " UMD Lathes.	Double Ply—Vim Oak $1\frac{1}{2}$ " x 70 $\frac{1}{2}$ "	10.75
2318	16" UMD Lathes.	Double Ply—Vim Oak $2\frac{1}{2}$ " x 74 $\frac{1}{2}$ "	14.75
2319	16/24" UMD Lathes.	Double Ply—Vim Oak $2\frac{1}{2}$ " x 82 $\frac{1}{2}$ "	16.75
2320	16" UMD Lathes with 3 step cone pulley, or 2-H Turret Lathes.	Double Ply—Vim Oak $2\frac{1}{2}$ " x 74 $\frac{1}{2}$ "	20.00

## Belt Splicing Cement

Waterproof belt splicing cement for gluing endless leather belts with lapped joint. Four ounce can. Cannot be shipped by parcel post. 1433. Shipping weight 6 ozs. .... \$0.60







## Motors for South Bend Lathes

All motors listed below are of the instant reversing type with the exception of Cat. No. 3251, which is a start-stop reversing motor. Single-phase A.C. motors  $\frac{3}{4}$  h.p. and smaller are capacitor type. Prices of motors for current characteristics other than those listed below will be quoted on request.

Catalog Number	Current Characteristics				Factory Price
	Current	Phase	Cycle	Volts	
2-1 h.p. 2-speed Motors for 16" and 16 $\frac{1}{4}$ " Lathes					
2130	A.C.	3	60	220	\$138.00
1 $\frac{1}{2}$ h.p. Motors for 16", 16 $\frac{1}{4}$ ", and 14 $\frac{1}{2}$ " Lathes					
2545-D	A.C.	3	60	220	69.00
2848-B	A.C.	1	60	115	135.00
2548-D	A.C.	1	60	230	135.00
1 h.p. Motors for 13" Lathes					
2625-D	A.C.	3	60	220	69.00
2628-B	A.C.	1	60	115	104.00
2628-D	A.C.	1	60	230	104.00
$\frac{3}{4}$ h.p. Motors for 10" Lathes					
2801-D	A.C.	3	60	220	45.10
2804	A.C.	1	60	115	56.10
2805	A.C.	1	60	230	56.10
$\frac{1}{2}$ h.p. Motors for 9" Lathes					
3227-D	A.C.	3	60	220	35.20
3228	A.C.	1	60	115	44.20*
$\frac{1}{4}$ h.p. Motors for 9" Lathes					
3250-D	A.C.	3	60	220	24.20
3251	A.C.	1	60	115	18.70*
3252	A.C.	1	60	115	23.10*
3253	A.C.	1	60	230	23.10

\*Equipped with 6-ft. extension cord and plug when ordered with lathe.

## Controls for Operating Motors

790. Heavy Duty Drum Reversing Control Switch for  $\frac{1}{4}$  h.p. to 1 $\frac{1}{2}$  h.p. motors... \$8.25

789. Drum Reversing Control Switch for use with  $\frac{1}{4}$  h.p. and  $\frac{1}{2}$  h.p. 115 v. motors for 9" Horizontal Motor Driven Bench Lathes only. \$4.25

2567. Push-button operated Linestarter for 2-1 h.p. motor No. 2130 only... \$129.80



## Touch-Up Enamel

For touching up and refinishing South Bend Lathes and other machine tools. This is our standard machine tool gray enamel which we use for finishing lathes at the factory. Cannot be shipped by parcel post.



Cat. No.	Size Container	Ship. Wt.	Price
2455	1 Pint. ....	2 lbs.	\$ 1.25
2456	1 Quart. ....	4 lbs.	1.90
2457	1 Gallon. ....	12 lbs.	6.75
2470	Case of 6 Pints. ....	10 lbs.	7.00
2471	Case of 12 Pints. ....	19 lbs.	12.90
2472	Case of 6 Quarts. ....	19 lbs.	10.75
2473	Case of 12 Quarts. ....	39 lbs.	19.35
2474	Case of 2 Gallons. ....	24 lbs.	12.35
2475	Case of 4 Gallons. ....	50 lbs.	22.25

## How to Run a Lathe

### A Practical Handbook on Lathe Operation

"How to Run a Lathe" is a complete reference book and manual on the care and operation of the back-geared screw-cutting lathe. It is a practical handbook for the machinist, lathe operator, apprentice, or shop man. Clearly written in simple, non-technical language, the instruction material is easy for the beginner to understand. This authoritative text is illustrated with more than 360 photographs, diagrams, and sketches.



Now in its 45th edition, this book has been improved and perfected by suggestions, criticisms, and ideas that have been submitted by hundreds of practical shop men. The latest shop practices and methods used in modern industry are accurately described.

### Partial List of Contents

History of the Lathe	Machining Work Between Centers
Erecting and Leveling the Lathe	Chuck Work
Operation of Lathe Controls	Taper Turning and Boring
Lathe Tools and Their Application	Drilling, Reaming, and Tapping
How to Take Accurate Measurements	Cutting Screw Threads
	Special Classes of Work

How to Run a Lathe—Edition 45, 128 pages 5 $\frac{1}{8}$ " x 7 $\frac{3}{8}$ ", more than 360 illustrations. Price postpaid to any address 25c in paper binding, \$1.00 in leatherette binding.

## How to Get the Most Out of Your Lathe

These bulletins are supplied without charge to shop men and others who are interested in the care of the lathe.

Bulletin H-1—"Keep your Lathe Clean." Shows importance of protecting lathe from abrasive dirt.

Bulletin H-2—"Oiling the Lathe." Explains the necessity for adequate lubrication of the lathe.

Bulletin H-3—"The Installation and Leveling of the Lathe." Gives detailed information on correct installation and leveling of the lathe.

Bulletin H-4—"Keep Your Lathe in Trim." Tells how to keep the lathe in best operating condition.



## Machinery's Handbook

An engineering reference book for machinists, students, designers, engineers, and executives. It is a practical guide for use in conjunction with engineering and vocational courses. Has 1815 pages, 1310 illustrations.

Cat. No. 700. Machinery's Handbook. Price.....\$6.00





Right—Index Chart Showing Metric Screw Threads Cut with Metric Transposing Gears

**METRIC SCREW THREADS**  
ENGLISH PITCH LEAD SCREW

SIZE	PITCH	FIG. 1	FIG. 2
4.0	48	FIG. 1	FIG. 2
4.5	48	FIG. 1	FIG. 2
5.0	48	FIG. 1	FIG. 2
5.5	48	FIG. 1	FIG. 2
6.0	48	FIG. 1	FIG. 2
6.5	48	FIG. 1	FIG. 2
7.0	48	FIG. 1	FIG. 2
7.5	48	FIG. 1	FIG. 2
8.0	48	FIG. 1	FIG. 2
8.5	48	FIG. 1	FIG. 2
9.0	48	FIG. 1	FIG. 2
10.0	48	FIG. 1	FIG. 2
11.0	48	FIG. 1	FIG. 2
12.0	48	FIG. 1	FIG. 2
13.0	48	FIG. 1	FIG. 2
14.0	48	FIG. 1	FIG. 2
15.0	48	FIG. 1	FIG. 2
16.0	48	FIG. 1	FIG. 2
18.0	48	FIG. 1	FIG. 2
20.0	48	FIG. 1	FIG. 2
22.0	48	FIG. 1	FIG. 2
24.0	48	FIG. 1	FIG. 2
26.0	48	FIG. 1	FIG. 2
28.0	48	FIG. 1	FIG. 2
30.0	48	FIG. 1	FIG. 2
32.0	48	FIG. 1	FIG. 2
34.0	48	FIG. 1	FIG. 2
36.0	48	FIG. 1	FIG. 2
38.0	48	FIG. 1	FIG. 2
40.0	48	FIG. 1	FIG. 2
45.0	48	FIG. 1	FIG. 2
50.0	48	FIG. 1	FIG. 2
55.0	48	FIG. 1	FIG. 2
60.0	48	FIG. 1	FIG. 2
65.0	48	FIG. 1	FIG. 2
70.0	48	FIG. 1	FIG. 2
75.0	48	FIG. 1	FIG. 2
80.0	48	FIG. 1	FIG. 2

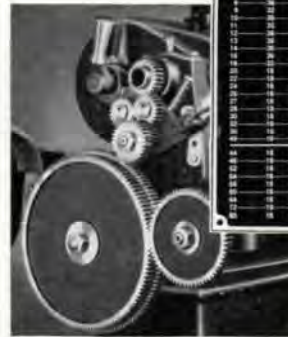


Left—South Bend Lathe Equipped with Metric Transposing Gears

Right—Index Chart Showing English Screw Threads Cut with English Transposing Gears

**ENGLISH SCREW THREADS**  
METRIC PITCH LEAD SCREW

SIZE	TPI	FIG. 1	FIG. 2
4	48	FIG. 1	FIG. 2
5	48	FIG. 1	FIG. 2
6	48	FIG. 1	FIG. 2
7	48	FIG. 1	FIG. 2
8	48	FIG. 1	FIG. 2
9	48	FIG. 1	FIG. 2
10	48	FIG. 1	FIG. 2
11	48	FIG. 1	FIG. 2
12	48	FIG. 1	FIG. 2
13	48	FIG. 1	FIG. 2
14	48	FIG. 1	FIG. 2
15	48	FIG. 1	FIG. 2
16	48	FIG. 1	FIG. 2
18	48	FIG. 1	FIG. 2
20	48	FIG. 1	FIG. 2
22	48	FIG. 1	FIG. 2
24	48	FIG. 1	FIG. 2
26	48	FIG. 1	FIG. 2
28	48	FIG. 1	FIG. 2
30	48	FIG. 1	FIG. 2
32	48	FIG. 1	FIG. 2
34	48	FIG. 1	FIG. 2
36	48	FIG. 1	FIG. 2
38	48	FIG. 1	FIG. 2
40	48	FIG. 1	FIG. 2
45	48	FIG. 1	FIG. 2
50	48	FIG. 1	FIG. 2
55	48	FIG. 1	FIG. 2
60	48	FIG. 1	FIG. 2
65	48	FIG. 1	FIG. 2
70	48	FIG. 1	FIG. 2
75	48	FIG. 1	FIG. 2
80	48	FIG. 1	FIG. 2



Left—South Bend Lathe Equipped with English Transposing Gears

### Metric Transposing Gears For Cutting Metric Screw Threads

Right-hand and left-hand metric screw threads ranging from 6 mm pitch to 0.20 mm pitch, as listed in the index chart above, can be cut (in addition to the regular English pitches) on any size or type of South Bend Lathe having an English lead screw, when equipped with set of metric transposing gears.

When lathes are ordered with metric transposing gears, the graduations on the tailstock spindle, the cross-feed screw, and the compound rest screw can be supplied to read in the metric system, or in the English system, as desired.

#### Metric Transposing Gears Ordered with Lathe

Size Lathe	With Metric Graduations		With English Graduations	
	Cat. No.	Price	Cat. No.	Price
9" Model A	1941-W	\$11.00	1955-W	\$11.00
9" Model B	2263	13.00	2261	13.00
9" Model C	2264	13.00	2262	13.00
10" Quick Change	1941-N	42.00	1963	42.00
13" Quick Change	1943	47.00	1957	47.00
14 1/2" Quick Change	1949	53.00	1961	53.00
16" & 2-H Q. C.	1945	58.00	1959	58.00
16/24" Quick Change	1948	53.00	1960	53.00

### English Transposing Gears For Cutting English Screw Threads

Right-hand and left-hand English screw threads ranging from 4 to 80 threads per inch, as listed in the index chart above, can be cut (in addition to the regular metric pitches) on any size or type of South Bend Lathe having a metric lead screw, when equipped with a set of English transposing gears.

When lathes are ordered with English transposing gears, the graduated collars on the tailstock spindle, the cross-feed screw, and the compound rest screw can be supplied to read in the English system, or in the metric system, as desired.

#### English Transposing Gears Ordered with Lathe

Size Lathe	With Metric Graduations		With English Graduations	
	Cat. No.	Price	Cat. No.	Price
9" Model A	1971-W	\$11.00	1981-W	\$11.00
9" Model B	2255	13.00	2253	13.00
9" Model C	2256	13.00	2254	13.00
10" Standard	1281-N	38.00	1291-N	38.00
13" Standard	1283	42.00	1293	42.00
14 1/2" Standard	1284	48.00	1294	48.00
16" & 2-H Std.	1285	52.00	1295	52.00
16/24" Standard	1286	52.00	1296	52.00

#### Metric Transposing Gears Ordered Separate from Lathe

Size Lathe	Ship. Wt.	With Metric Graduations		With English Graduations	
		Cat. No.	Price	Cat. No.	Price
9" Model A	8 lbs.	1941-WS	\$11.00	1955-WS	\$11.00
9" Model B	21 lbs.	2263-S	18.00	2261-S	18.00
9" Model C	21 lbs.	2264-S	18.00	2262-S	18.00
10" Quick Change	51 lbs.	1941-NS	53.00	1963-S	53.00
13" Quick Change	73 lbs.	1943-S	58.00	1957-S	58.00
14 1/2" Quick Change	121 lbs.	1949-S	74.00	1961-S	74.00
16" & 2-H Q. C.	121 lbs.	1945-S	84.00	1959-S	84.00
16/24" Quick Change	65 lbs.	1948-S	53.00	1960-S	53.00

#### English Transposing Gears Ordered Separate from Lathe

Size Lathe	Ship. Wt.	With Metric Graduations		With English Graduations	
		Cat. No.	Price	Cat. No.	Price
9" Model A	8 lbs.	1971-WS	\$11.00	1981-WS	\$11.00
9" Model B	21 lbs.	2255-S	18.00	2253-S	18.00
9" Model C	21 lbs.	2256-S	18.00	2254-S	18.00
10" Standard	51 lbs.	1281-NS	38.00	1291-NS	38.00
13" Standard	73 lbs.	1283-S	42.00	1293-S	42.00
14 1/2" Standard	121 lbs.	1284-S	48.00	1294-S	48.00
16" & 2-H Std.	121 lbs.	1285-S	52.00	1295-S	52.00
16/24" Standard	65 lbs.	1286-S	52.00	1296-S	52.00

### Spanish and Portuguese Catalogs

Catalogs describing South Bend Lathes and accessories are available in both the Spanish and Portuguese languages. These condensed catalogs contain illustrations, specifications, and brief descriptions of popular sizes and types of lathes and attachments. Specify Catalog 25-S in Spanish, or Catalog 25-P in Portuguese. Mailed to any address on request.



### Metric Thread Dial

This attachment saves much time when cutting long screw threads. Instead of reversing the lathe to return the cutting tool to the starting point, the half-nuts may be opened and the carriage moved quickly by hand. The graduated dial shows when to engage the half-nuts so the cutting tool will follow the original cut.



Cat. No. 2265-N. Metric Thread Dial for 9" South Bend Lathe with metric lead screw. Ship. wt. 3 lbs. Factory price... \$14.00



## Specifications

### CAPACITY

Maximum drill size...  $\frac{1}{2}$ "  
 Drills to center of  
 .....  $14\frac{1}{2}$ " circle  
 Chuck takes..... 0 to  $\frac{1}{2}$ "  
 Chuck to table, maximum  
 Bench model.....  $11\frac{1}{2}$ "  
 Floor model.....  $40\frac{1}{2}$ "

### SPINDLE

Speeds, four  
 ..... 655 to 4530 r.p.m.  
 Maximum travel..... 4"

### TABLE

Work area.....  $10$ " x  $10$ "  
 Tilt..... any angle

### BASE

Work area, bench  
 model.....  $7$ " x  $10$ "  
 Work area, floor  
 model.....  $8$ " x  $12$ "

### COLUMN

Diameter.....  $2\frac{3}{4}$ "

### OVER-ALL SIZE

Height, bench model  $35\frac{1}{2}$ "  
 Height, floor model...  $65\frac{1}{2}$ "  
 Width, bench model  $12\frac{1}{4}$ "  
 Width, floor model...  $15$ "  
 Depth, bench model  $27\frac{3}{4}$ "  
 Depth, floor model...  $27\frac{3}{4}$ "

### MOTOR

Speed recommended  
 ..... 1725 r.p.m.  
 Size recommended...  $\frac{1}{2}$  h.p.  
 Optional size.....  $\frac{3}{4}$  h.p.



## 14-inch Precision Drill Press

The new South Bend 14-inch Precision Drill Press is the result of several years of careful research and thorough testing. Designed by the same engineering staff and produced with the same excellent manufacturing facilities employed in the production of the well-known line of South Bend Precision Lathes, this drill press is a superior tool unsurpassed for accuracy, ease of operation, versatility and dependable performance. It is ruggedly constructed, and will maintain its precision accuracy indefinitely under severe industrial service.

The drill press is supplied with or without motor, as desired. Prices listed below do not include motor.

Cat. No. 400-B. 14-inch South Bend Precision Bench Drill Press with  $\frac{1}{2}$ " Jacobs Chuck, motor base, motor pulley, lamp, V-belt, and toggle switches. Price f.o.b. factory..... \$98.00

Cat. No. 400-F. 14-inch South Bend Precision Floor Drill Press with  $\frac{1}{2}$ " Jacobs Chuck, motor base, motor pulley, lamp, V-belt, and toggle switches. Price f.o.b. factory..... \$113.00



## Belt Guard for Drill Press

This belt guard is used on the South Bend Drill Press to provide complete enclosure for the V-belt. The guard is hinged so that it may be raised for shifting the belt to change spindle speeds. Sufficient clearance is provided inside the guard to permit its use with the Multi-Speed Attachment.

Cat. No. 9136. Belt Guard for Drill Press. Shipping weight 30 lbs. Factory price..... \$13.50

## Motors for Drill Presses

The 14" South Bend Drill Presses require  $\frac{1}{2}$  h.p., or  $\frac{3}{4}$  h.p. 1725 r.p.m. vertical mounting ball bearing motors as listed below. Prices of motors for current characteristics other than those listed will be quoted on request.



Cat. No.	H.P.	Current	Phase	Cycle	Volts	Price
4910-B	$\frac{1}{2}$	A.C.	1	60	115	\$31.30
4912-D	$\frac{1}{2}$	A.C.	3	60	220	32.50
4920-B	$\frac{3}{4}$	A.C.	1	60	115	42.80
4924-D	$\frac{3}{4}$	A.C.	3	60	220	39.80

## Swivel Vise for Drill Press

For holding work on drill press table, milling machine, shaper, etc. Swivel is graduated  $180^\circ$  to permit setting vise at any angle with slots in table. Jaws are hardened and are replaceable. Jaws are 4" wide and 1" deep. Maximum jaw opening is 4".



9100. Swivel Drill Press Vise. Ship. wt. 18 lbs..... \$21.50

## Extra Spindles for Drill Press

Two extra spindles are available for use with either the bench or floor model drill press. Each spindle has a maximum travel of 4". Greater versatility is assured for the drill press when equipped with extra spindles.

9125. Spindle with No. 2 Morse taper hole for holding drill chucks, drills, reamers, milling cutters, or other tools having standard No. 2 Morse taper shanks. Price includes drift. Ship. wt. 2 lbs..... \$5.50

9126. Utility Spindle with  $\frac{1}{2}$ " x  $1\frac{3}{8}$ " deep straight hole for holding routing tools, blacksmith's drills, straight shank drum sanders etc. Ship. wt. 2 lbs..... \$4.00



## Drill Chuck and Arbor

1201. Jacobs 3-jaw smooth body drill chuck, 0 to  $\frac{1}{2}$ " capacity, with pinion key. Ship. wt.  $2\frac{3}{8}$  lbs. Price. \$6.84



9110. No. 2 Morse taper shank arbor with tang, for fitting above chuck to drill press spindle No. 9125. Ship. wt.  $\frac{3}{4}$  lb. Price..... \$0.95

## Multi-Speed Attachment

This attachment increases the range of spindle speeds for the drill press, providing twelve spindle speeds ranging from 310 r.p.m. to 9525 r.p.m. (approximate) when used with a 1725 r.p.m. motor. Consists



of an eccentric spindle which is mounted in the drill press column to support a 4-step auxiliary cone pulley with two V-belts.

9135. Multi-Speed Attachment. Ship. wt. 8 lbs..... \$13.00





### Twist Drill Sets

South Bend straight shank jobber length twist drills are made of high quality, high speed steel and are properly heat-treated for maximum strength and durability. Each drill is carefully finished and ground, and is stamped indicating its size. Drills are coated with rust resisting compound and packed in conveniently indexed steel cases. The drill size and decimal equivalent of each drill are clearly stamped in the case, indicating the hole into which the drill fits. The case for the number drill set is also stamped with tap drill and body drill sizes used for screw threads from No. 2-56 to No. 14-20 inclusive. Sold only in sets as listed. Individual drills are not supplied.

#### Sets of High Speed Steel Jobber Length Straight Shank Twist Drills in Metal Cases

Catalog Number	Description	Shipping Weight	Factory Price
6129	Set of 29 drills, fractional sizes, 1/16" to 1/2" inclusive by 64ths	5 lbs.	\$28.25
6113	Set of 13 drills, fractional sizes, 1/16" to 1/4" inclusive by 64ths	1 lb.	5.75
6121	Set of 21 drills, fractional sizes, 1/16" to 1/8" inclusive by 64ths	3 lbs.	14.25
6115	Set of 15 drills, fractional sizes, 1/16" to 1/2" inclusive by 32nds	3 lbs.	15.50
6260	Set of 60 drills, No. 1 to No. 60 inclusive	2 lbs.	22.00
8326	Set of 26 drills, A to Z letter sizes, inclusive	5 lbs.	25.25

### Lubricating Oil

Recommended for South Bend Lathes and other machinery requiring a high quality lubricant. Lubricating oil cannot be shipped by parcel post.



Cat. No.	Quantity	Ship. Wt.	Price
Oil for General Lubrication of Lathe and Other Machinery			
1603	1 quart	3 lbs.	\$0.80
1906	12 quarts	31 lbs.	8.50
Oil for Spindle Bearings of 9" Lathes and Apron Clutch Mechanism of All Sizes of Lathes			
1602	1 quart	3 lbs.	.80
1904	12 quarts	31 lbs.	8.50
Oil for Spindle Bearings of 10" and Larger Lathes			
1600	1 quart	3 lbs.	.80
1905	12 quarts	31 lbs.	8.50

### Threaded Chuck Plate



Semi-machined threaded chuck plates are supplied for those who wish to fit their own chucks to South Bend Lathes. These are heavily constructed cast-iron plates, accurately threaded to fit the spindle nose of the lathe. The back of the plate is finished, and the outside diameter and face are rough machined. When ordering, be sure to specify the correct plate to fit the diameter of the recess in back of chuck. Stock is allowed for finishing to diameter shown in the table.

Catalog Number	Size Lathe	Spindle Nose Th'd	O.D. of Plate	Shipping Weight	Factory Price
1919-C	9" and Series 900	1 1/2"-8	3 1/2"	3 lbs.	\$ 3.25
1919-G			5"	4 lbs.	3.25
1919-P			7 1/2"	10 lbs.	3.25
1933-C	10"-1" Col. Ser. 1000	2 1/4"-8	3 1/2"	4 lbs.	8.75
1933-G			5"	5 lbs.	8.75
1933-J			5 1/2"	6 lbs.	8.75
1933-L			6 1/4"	7 lbs.	8.75
1933-P			7 1/2"	11 lbs.	8.75
1933-U			9"	13 lbs.	8.75
1933-X	10 1/4"	18 lbs.	8.75		
1932-C	10"-1 1/8" Col. Ser. 1000	1 7/8"-8	3 1/2"	4 lbs.	7.50
1932-G			5"	6 lbs.	7.50
1932-J			5 1/2"	8 lbs.	7.50
1932-L			6 1/4"	9 lbs.	7.50
1932-P			7 1/2"	12 lbs.	7.50
1932-U			9"	16 lbs.	7.50
1932-X	10 1/4"	20 lbs.	7.50		
1946-C	14 1/2"-3 1/4" Col.	2 1/4"-6	3 1/2"	5 lbs.	8.75
1946-G			5"	6 lbs.	8.75
1946-J			5 1/2"	7 lbs.	8.75
1946-K			6"	8 lbs.	8.75
1946-L			6 1/4"	9 lbs.	8.75
1946-P			7 1/2"	12 lbs.	8.75
1946-X			10 1/4"	21 lbs.	8.75
1939-G			14 1/2" & 16" 1" Col., 2-H, 16/24"	2 1/2"-6	5"
1939-J	5 1/2"	8 lbs.			10.00
1939-K	6"	9 lbs.			10.00
1939-L	6 1/4"	9 lbs.			10.00
1939-P	7 1/2"	13 lbs.			10.00
1939-X	10 1/4"	20 lbs.			10.00
1939-Z	11 1/4"	24 lbs.			10.00

### Chuck Plates Fitted to Chucks

Prices listed below apply when chucks are shipped to us to be fitted with chuck plates threaded to fit South Bend Lathes.

Cat. No.	Size Lathe	Factory Price	Cat. No.	Size Lathe	Factory Price
2935	9" & Ser. 900	\$ 5.50	2932	13"-1 1/8" Col.	\$11.00
2932	10"-1 1/8" Col.	11.00	2946	14 1/2"-3 1/4" Col.	12.00
2933	10"-1" Col.	12.00	2939	14 1/2"-1" Col.	13.00
2933	13"-1" Col.	12.00	2939	16" & 16/24" No. 2-H	13.00
2933	Series 1000	12.00	2939		13.00

### Motion Picture Films On Lathe Operation



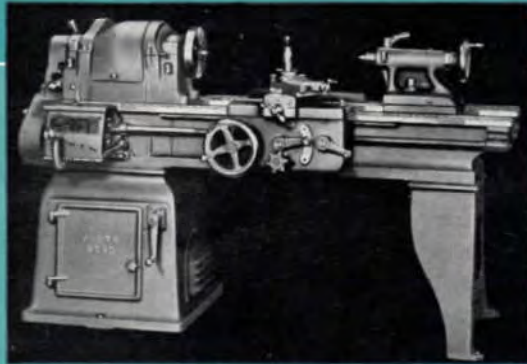
The South Bend motion pictures on lathe operation may be borrowed without charge by industrial organizations, industrial and vocational schools, colleges, universities, Army and Navy training schools, industrial apprentice schools, and other recognized organizations teaching machine shop practice.

When films are supplied on a free loan basis, the borrower pays the shipping charges both ways. All films supplied on a free loan basis are 16 mm sound films in full color. Those who desire to keep these films permanently may purchase them at prices listed below.

Subject	Color Films		Black and White Films	
	Catalog Number	Factory Price	Catalog Number	Factory Price
Film No. I, "The Metal Working Lathe"	1620-C	\$100.00	1620-B	\$40.00
Film No. II, "Plain Turning"	1621-C	110.00	1621-B	43.00
Film No. III, "Grinding Cutter Bits"	1663-C	115.00	1663-B	47.00



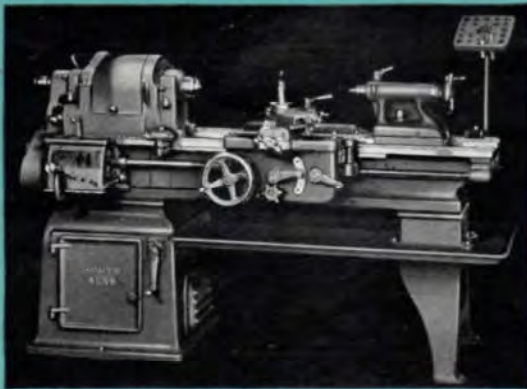
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