

OPERATION AND
MAINTENANCE MANUAL

SOUTH BEND FOURTEEN

BULLETIN 7014-A

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SECTION 1 SAFETY INSTRUCTIONS

We urge that this machine be operated and equipped in strict accordance with all local, state and federal safety regulations. One good reference is National Safety Council Data Sheet 264 "Engine Lathes" which is available from

National Safety Council
425 N. Michigan Ave.
Chicago, Ill. 60611

Don't neglect your responsibility to see that this machine is operated, maintained, and equipped with total regard for operator safety. No one can be responsible for your neglect but you.

SAFETY CONSIDERATIONS IN OPERATING A LATHE

- | | |
|--|---|
| <ol style="list-style-type: none">1. Study this manual before attempting to run the machine.2. Be alert for loose, worn, or broken parts. Report all of these items and any unusual noise or action of the machine to your supervisor.3. Keep your lathe properly maintained. Perform all maintenance in accordance with this manual.4. Make sure this lathe is lubricated as outlined in this manual.5. Keep your lathe clean. Keep the work areas of the lathe clear of piled up chips.6. Never wear loose clothing or jewelry which could become entangled in the machine or work piece. | <ol style="list-style-type: none">7. Never lay tools on the machine where they might interfere with the operation of the machine or where they might become entangled in the work, chuck or chips.8. Always check the tightness of the chuck mounting, the rigidity of the work piece mounting and all adjustments and clamps before starting the machine.9. Be alert whenever operating the machine. If talking is necessary, stop the lathe and step aside until the conversation is completed.10. Never reach into the work area of the machine while the spindle is turning.11. Wear safety glasses for eye protection. |
|--|---|

SECTION 2 PREPARATION FOR USE

LOCATION

Although the quality of the work turned out by any machine tool depends principally upon the skill of its operator, it is important to provide the best possible environment for both man and machine. Lighting is very important, natural North light is ideal, but artificial light can be very satisfactory if harsh shadows are eliminated.

Your new 14" Lathe should be located in a warm and dry area which provides adequate clearance on all sides, and is free from shop traffic. Vibration is very undesirable for a lathe. A site on a concrete ground floor is the most desirable. Other floors can be satisfactory if they are sufficiently rigid or can be braced to provide a solid foundation.

UNCRATING

As soon as the machine is received, look for any signs of damage on the skid, crate, and wrapping. Then look for any signs of damage on the machine. If found, notify the carrier and the shipper immediately, and save the damaged packing to substantiate any claims which might arise.

Remove all packing materials and crating except the mounting skid to which the lathe is bolted; then prepare the foundation for the lathe.

Do not discard any wrappings before looking through them closely for shipping documents, instructions, and small parts shipped with the machine. Check off all items against the bill of lading.

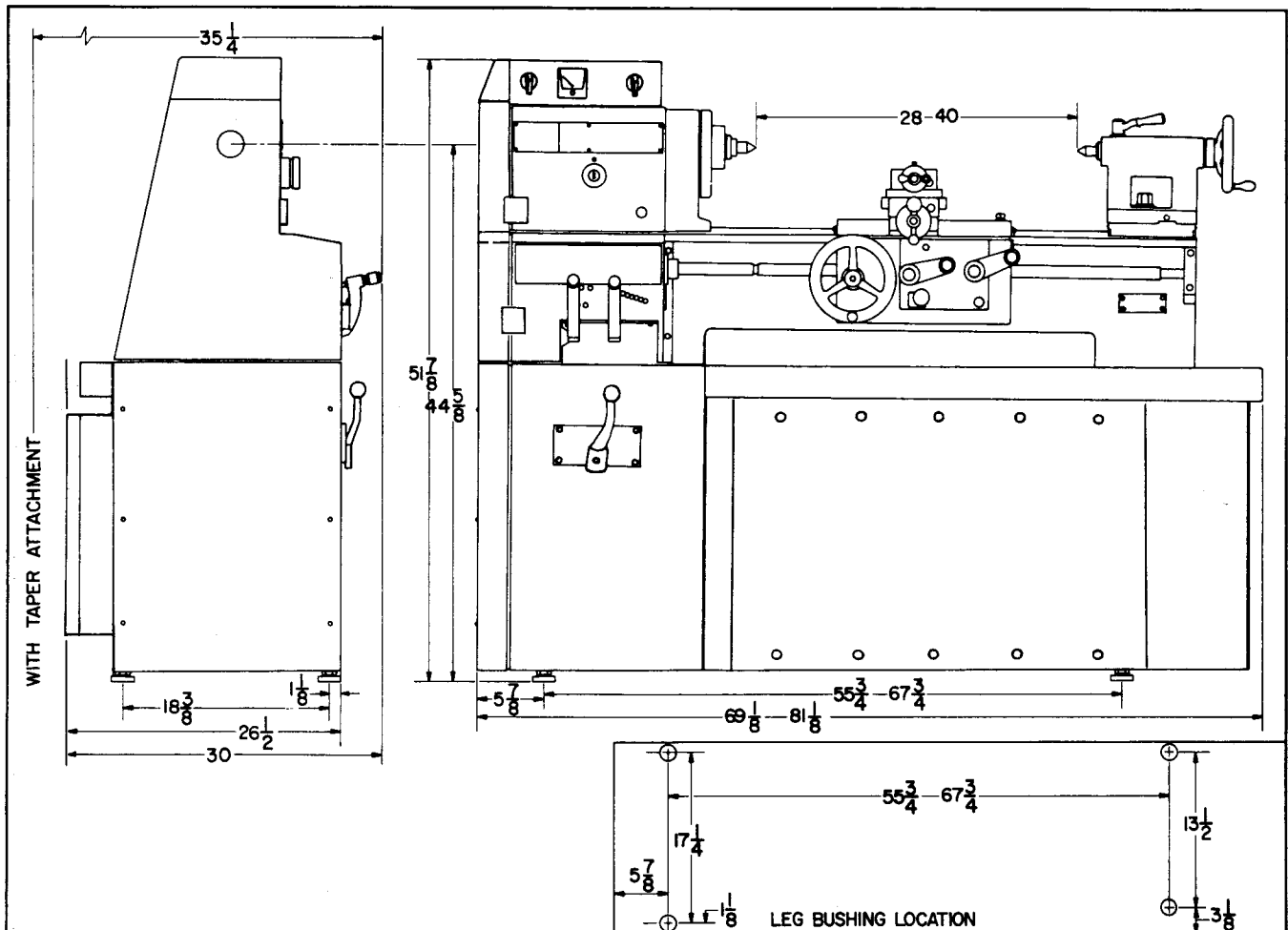


Figure 1 — Dimensional Diagram (Approx. Dimensions)

CAUTION

Do not move the carriage, tailstock, or cross slide until the lathe has been thoroughly cleaned and lubricated as instructed in the following section.

INITIAL CLEANING

The lathe must be cleaned after uncrating to ensure that the carriage cross slide and tailstock will not be damaged by being moved along dirty ways. Remove all protective wrappings and brush all machined surfaces with a degreasing solvent to soften the coating of protective grease. Wipe all surfaces dry with a clean cloth, and lubricate the lathe as instructed below before moving the tailstock or carriage and before connecting power to the motor.

CAUTION

Do not use compressed air to blow off dust or dirt or to evaporate solvent after cleaning. An air blast tends to drive abrasive particles into inaccessible places where they produce unnecessary wear or other damage.

INITIAL LUBRICATION

After the initial cleaning, it is advisable to manually lubricate all wear surfaces with a good machine oil. Check the oil level in all reservoirs and lubricate all points as described on the lubrication chart which is on the front of the gear box.

ANCHOR BOLTING

Four 1/2" anchor bolts may be installed in the floor beneath each leg of the lathe. Each should project from the floor at least 3". Anchor bolts set in a concrete floor should be sunk about 6" deep. Lag screws can be used when mounting the lathe to a wooden floor, but bolts anchored to 1/2" thick plates on the underside of the floor are preferable.

LIFTING LATHE

Remove the end panels to gain access to the bolts which secure the lathe to its shipping skid. Remove the shipping bolts. The leveling bushings and support pads should be installed as shown below.

The lathe may be picked up with a fork lift under the base. If a hoist and sling is used, blocks should be placed between the sides of the bed and the sling to avoid putting pressure on the lead screw.

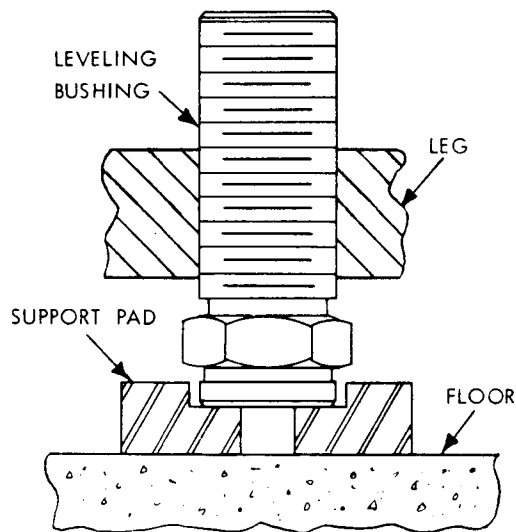


Figure 2 — Leveling Leg Bushing

LEVELING

Careful leveling of the lathe is essential to its accurate operation. This machine is equipped with four leveling bushings (2 at the headstock end and 2 at the tailstock end). Use a South Bend 12" Precision Level (Cat. No. CE2218) or equal. A carpenter's level or the level in a machinist's combination square is not accurate enough.

The following procedure should be followed:

- A. Place the level across the bed ways near the headstock.
- B. Adjust the two leveling bushings which are at the headstock end until the level shows the bed to be level.
- C. Place the level across the bed way at the tailstock end. Do not turn the level end for end.

- D. Adjust the two leveling bushings at the tailstock end until the bed is level.
- E. Recheck and readjust as above until the bed is level in both places.

ELECTRICAL HOOKUP

The power supply should conform to the voltage requirements which are shown on the tag which is attached to the junction box which is on the rear side of the base.

The power should be connected to the three wires which are inside the junction box. If spindle rotation is the reverse of that shown on the switch plate, reverse any two leads of the supply.

SECTION 3 OPERATION

SCOPE

This section is provided to help the operator become familiar with the usage and function of the various controls on this Lathe.

See Fig. 3 to identify and locate the various Lathe components.

It is beyond the scope of this manual to provide detailed instructions for turning out each of the many types of work of which the 14" Lathe is capable. It is assumed that the reader is already familiar with the use of screw-cutting lathes.

TURNING ON THE DRIVE

To turn on the machine, simply move the switch which is in the panel on the top of the headstock to "Forward" or "Reverse". This selects the direction of spindle rotation and turns on the spindle.

SELECTING SPINDLE SPEEDS

To select the high or low spindle speed ranges (50 to 300 rpm or 300 to 1800 rpm), put the speed range selector lever (on the base next to the gear box) in either high or low. There is a neutral position on this handle midway between high and low. Do not change speed ranges while the motor is on.

To set the speed in either range, turn the motor on. Note the speed indicated on the speed indicator (in the middle of the panel which is on top of the head). To increase the speed, push the speed indicator switch up. When the desired speed is reached, push the switch into the centered position. To decrease the speed, push the switch down until the desired speed is reached and then push the switch to the centered position. Note: The speed cannot be changed unless the motor is running.

SELECTING FEED AND THREAD DIRECTION

The feed and thread direction is controlled by the knob which is on the front of the headstock. When the knob is set at "Forward-RH", the lathe will cut right hand threads, feed toward the headstock or feed out. When set at "Reverse-LH", it will cut left hand threads, feed toward the tailstock or in. Do not change direction while motor is on.

SELECTING FEED AND THREAD PITCH

To select the feed or thread pitch desired, locate that feed or pitch on the chart which is on the front of the gear box and note the accompanying letter and number. Move the left hand tumbler so that its plunger goes into the hole under the letter required and move the right hand tumbler so that its plunger goes in the hole which is under the number required. Do not change ranges while motor is on.

SELECTING & ENGAGING FEEDS

To feed in the longitudinal direction, put the lever on the apron in the upper hole. To feed on the cross slide, put the lever on the apron in the lower hole. To engage feed, pull the clutch handle (at the bottom center of the apron) up. To disengage feed, push it down.

ENGAGING FOR THREADS

To engage for threading, put the selector lever in the center (neutral) position. Pull up on the half nut handle. To disengage threading, push the half nut handle down.

NOTE

The controls in the apron are interlocked so that the half nuts cannot be closed until the selector lever is in neutral.

HEADSTOCK, APRON AND TRANSMISSION OIL LEVEL WINDOWS

Three oil level windows are provided. One is located in the lower right hand corner of the headstock; one, located in the right hand corner of the apron; the other, located in the right hand corner of the transmission. All three reservoirs should be kept full.

Recommended lubricants are described on a plate fastened to the gear box. For more detailed instructions on lubrication see Section 4.

TAILSTOCK

To position the tailstock on the bed, loosen the clamp nut, slide to position and retighten. To extend or retract the spindle, release the spindle binding lever (15) (to the right) and turn the handwheel. To lock, push the lever to the left. The spindle extends to a maximum of 4 1/4". The tailstock can be set over 15/16" for taper turning, by adjusting screws (17).

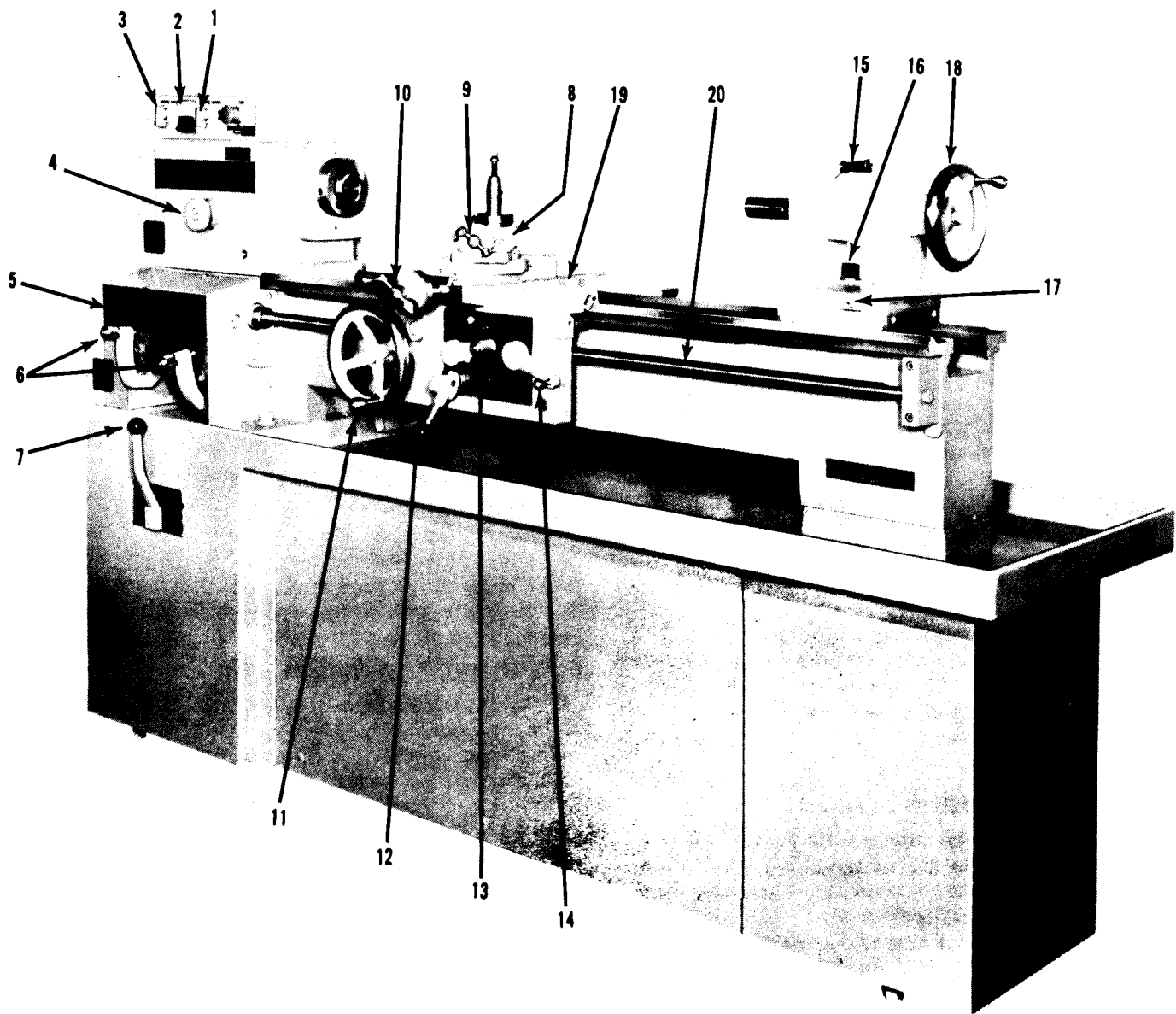


Figure 3 — Major Components

- | | |
|-----------------------------------|-------------------------------------|
| 1. Motor Switch | 11. Apron Handwheel |
| 2. Speed Indicator | 12. Apron Feed Clutch Control |
| 3. Speed Selector Switch | 13. Apron Feed Change Lever |
| 4. Feed & Thread Direction Knob | 14. Half Nut Lever |
| 5. Thread Feed Chart | 15. Tailstock Spindle Locking Lever |
| 6. Feed-Thread Selection Tumblers | 16. Tailstock Clamp Nut |
| 7. High-Low Speed Change Lever | 17. Tailstock Set Over Screws |
| 8. Compound Rest | 18. Tailstock Handwheel |
| 9. Compound Feed Ball Crank | 19. Saddle Lock |
| 10. Cross Feed Ball Crank | 20. Lead Screw |

THREAD DIAL INDICATOR

The thread dial indicates relative position of lead screw, spindle and carriage through gear meshing with lead screw, thus allowing disengagement of half nuts at end of threading cut, returning the carriage quickly to the starting point by hand without reversing the lathe spindle and re-engaging half nuts in correct position for subsequent cuts.

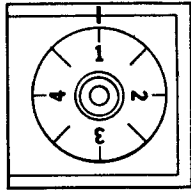


Figure 4

Thread must be started with a graduation on dial lined with witness mark on frame of indicator as follows:

For all even numbered threads close half nuts at any line on dial, or each $1/8$ revolution.

For all odd numbered threads, close the half nuts at any numbered line on dial or each $1/4$ revolution.

For all threads involving one-half of a thread per inch, such as $4\ 1/2$, close the half nuts at the lines numbered one or three or each $1/2$ revolution.

For all threads involving one-fourth of a thread in each inch, such as $4\ 3/4$, return to the original starting point before closing half nuts.

For all other threads, including $1\ 3/8$, $1\ 7/16$, $1\ 5/8$, $1\ 11/16$, $1\ 7/8$, $2\ 7/8$ and $3\ 3/8$ from the gear box index plate, the thread dial indicator cannot be used. (Leave half nuts engaged when cutting these threads and return to starting point by reversing the lathe spindle.)

TAPER ATTACHMENT

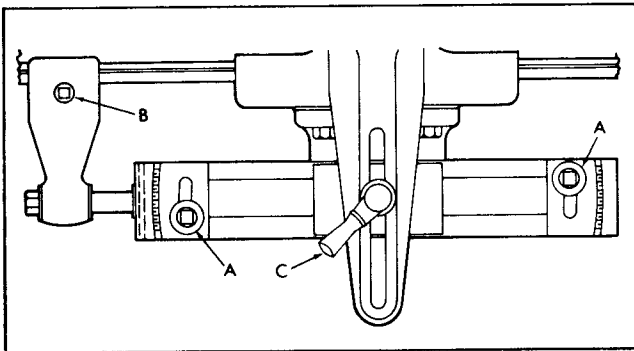


Figure 5 — Taper Attachment

The South Bend telescopic taper attachment is permanently mounted on the lathe carriage and is always ready for use. It does not interfere with any lathe operations. The swivel bar is graduated in degrees and in inches per foot. The maximum taper is $3\ 1/2$ " per foot and the maximum travel is $9\ 1/4$ " at one setting. To use the taper attachment, follow these steps:

1. Position the carriage in proper relation to the work. (Be sure the length of the cut does not exceed the travel of the taper attachment).
2. Loosen square head screws "A", set swivel bar to required angle in degrees or taper per foot and lock screws "A".
3. Adjust cross feed screw for required diameter.
4. Tighten bed clamp screw "B".
5. Tighten binder clamp "C".

Engage feed with tool ahead of the beginning of the cut to be sure all the backlash is removed before tool starts to cut.

To change from taper to straight turning, follow these steps:

1. Loosen binder clamp "C"
2. Loosen bed clamp "B"

SECTION 4 LUBRICATION

HEADSTOCK

Pressure lubrication is provided by an automatic pump which circulates oil from the reservoir in the base of the headstock to the spindle bearings. The oil level in the reservoir should be 1/2 up on the sight window located at the lower right hand of the front of the headstock.

GEAR BOX

The gear box is oiled through three ball oilers on top of the gear box, which provides lubrication direct to the bearings and shafts. Oil daily with a good quality machine oil of 150 - 240 viscosity.

CARRIAGE

All apron gears are self-lubricated from the apron reservoir. The apron oil level should be 1/2 up on the sight window located on the right front of the apron. Lubrication of half nuts, cross feed screws, cross slide ways, taper attachment, bedways and all other moving parts of this assembly is accomplished by hand oiling and should be done daily. See Fig. 6.

When taper attachment is not in use, the machined surfaces of the taper attachment should be protected with a coat of rust preventive oil to prevent tarnishing.

TAILSTOCK

Two ball type oilers are provided in the top of the barrel in the tailstock. A good grade machine oil of the recommended viscosity applied here will lubricate the tailstock spindle screw and thrust bearing.

This is only a partial listing of the many oil companies and their grades of machine oils that conform to our specifications. You may use the chart for comparative purposes to procure the proper grade of machine oil from any

LUBRICATION INSTRUCTION PLATE

Condensed instructions for lubricating the lathe are given in tabular form on instruction plate mounted on the front of the gearbox. Expanded instructions for carrying out the recommendations on the plate are provided in the lubrication chart Fig. 6.

DAILY CARE OF THE LATHE

Each day before beginning work on the 14" Lathe, the operator should clean and lubricate the machine as described in the chart to keep it in tiptop working condition. Neglect of this routine will harm much more than just the appearance of the machine. Rust or accumulations of chips, dust and oxidized lubricants can damage the precision ground way surfaces in a short time, and will destroy the accuracy of the lathe. In the event the lathe is used more than one shift per day, the daily procedures described should be repeated at the beginning of each shift.

The South Bend lubricants recommended in this manual have been determined after more than 60 years of experience with the engineering of precision machine tools. Order lubricants by catalog numbers from your South Bend distributor.

oil company.

Oils developed for automotive crank case lubrication are not recommended for machine tool lubrication.

RECOMMENDED LUBRICANTS

Company Name	Viscosity 140-170 at 100° F Headstock Transmission	Viscosity 150-240 Gearbox—Apron	Viscosity 240-500 Saddle—Compound Feed Screw— Bedway End Gearing—Tailstock	Ball Bearing Grease Belt Tension Pulley
South Bend Lathe	Cat. No. CE7053—1 qt.	Cat. No. CE1602—1 qt.	Cat. No. CE1603—1 qt.	
	Cat. No. CE7054—1 gal.	Cat. No. CE2018—1 gal.	Cat. No. CE2019—1 gal.	
American Oil Co.	Indust. Oil # 15	Indust. Oil # 15	Indust. Oil # 31	Rykon Grease # 2
Socony Mobil Oil Co.	Mobil DTE Oil, Lt. Wt.	Gg. Vactra Oil, Light	Gg. Vactra oil, Heavy Medium	Mobilux Grease # 2
Citgo	Pacemaker # 1 Hyd. Oil	Sentry Oil # 5	Sentry Oil # 8	Trojan M2 Grease
South Penn Oil Co.	Pennbell # 1 Hyd. Oil	Pennbell # 3 Hyd. Oil	Pennbell # 3 Hyd. Oil	Pennzoil Multi-Lub. # 303
Texaco, Inc.	Texaco Regal AR & O	Texaco Regal PCR & O	Texaco PCR & O	Multifax Grease # 2
Shell Oil Co.	Shell Tellus Oil # 27	Shell Vitra # 27	Shell Vitra # 33	Shell Alvania Grease # 2

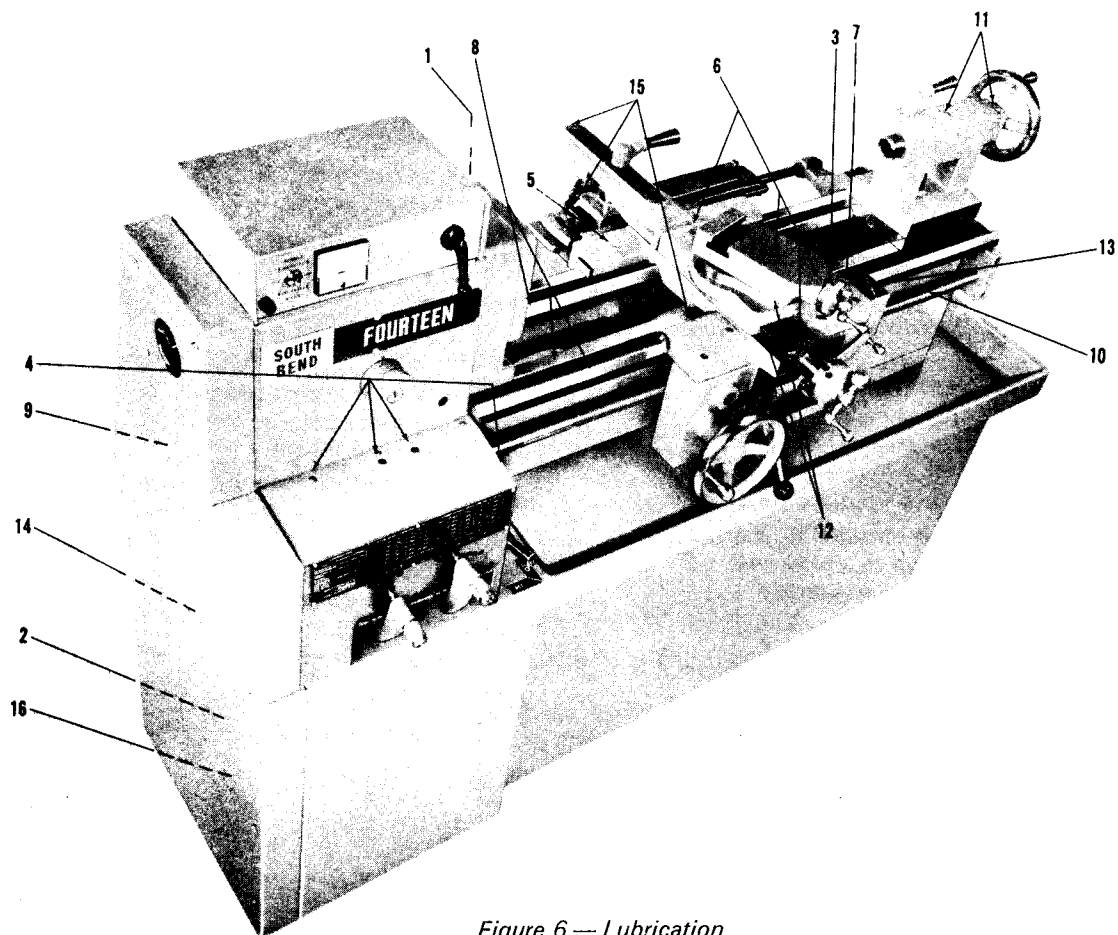


Figure 6 — Lubrication

LUBRICATION POINT	UNIT LUBRICATED	TYPE OF LUBRICANT	INTERVAL	INSTRUCTIONS
1	Headstock	*140-170	Keep Full	*Check oil level in sight window
2	Transmission	*140-170	Keep Full	Level should be ½ Full
3	Apron	*150-240	Keep Full	Drain and refill every 6 months
4	Gear Box	150-240	Daily	Use Pump Oil Can
5	Saddle	240-500	Daily	Use Pump Oil Can
6	Compound & Feed Screws	240-500	Daily	Use Pump Oil Can
7	Half Nuts	240-500	Daily	Use Pump Oil Can
8	Bedways	240-500	Daily	Use Pump Oil Can
9	End Gearing	240-500	Daily	Oil Can
10	Lead Screw	240-500	Daily	Clean Threads Before Oiling Use Pump Oil Can
11	Tailstock	240-500	Daily	Use Pump Oil Can
12	Carriage & Compound Dovetails	240-500	Daily	Pump Oil Can
13	Thread Dial	240-500	Daily	Pump Oil Can
14	Belt Tension Pulley Bearing	B/B Grease	6 months	Fitting
15	Taper Attach.	240-500	Daily	Pump Oil Can
16	Motor Bearings	B/B Grease	Every 2 years	Follow Instruction Tag Attached to Motor

SECTION 5 MAINTENANCE

INSPECTION AND ADJUSTMENTS

The 14" Lathe is designed to operate with a minimum of attention for many years. The adjustments and inspections described in the following paragraphs are all that will normally be required to accommodate wear and maintain the precision of the machine. None of the operations described here will require more than half an hour's time by a competent machinist, and most of them can be performed with common hand tools by the lathe operator.

SADDLE GIB CLEARANCE ADJUSTMENT

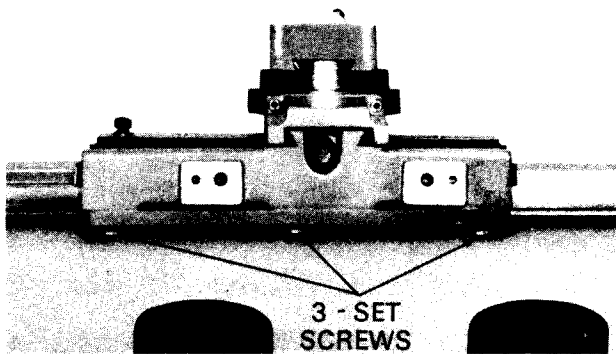


Figure 7 — Saddle Gib Adjustment

The V way of the lathe bed keeps the saddle permanently aligned in the horizontal plane, but occasional adjustments may be required to compensate for wear of the saddle surfaces.

The saddle gib adjustment is located on the rear of the saddle. To take up excessive play tighten the three socket head screws. Move the carriage back and forth and adjust until a slight drag is felt, then back off just enough until it disappears. Fig. 7.

DRIVE BELT TENSION

This is adjusted by moving the idler pulley which is behind the cover on the left end of the headstock. The belts should be tensioned such that when you push on the long span (front) of the belts with 9 or 10 pounds, the belts will deflect $7/16$ ". Fig. 8.

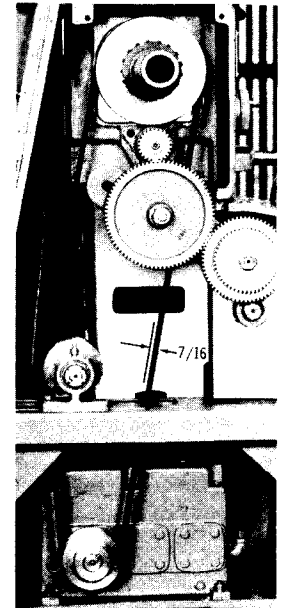


Figure 8 — Drive Belt Tension Adjustment

CROSS SLIDE GIB ADJUSTMENT

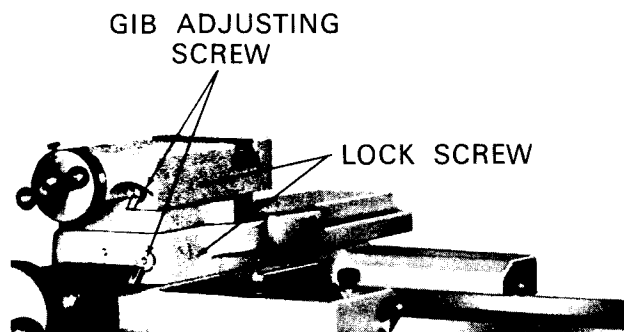


Figure 9 — Cross Slide Gib Adjustment

The dovetail in the saddle which guides the cross slide across the lathe during cross-feeding and taper turning operations is subject to a certain amount of wear which can be compensated for by means of a tapered gib on the right side. No play should be detectable in the cross slide. If found, take up the slack by means of the two screws provided in the right front of the compound rest base. Fig. 9.

First, loosen the lock screw, then turn the gib adjustment screw inward as required until no play is detectable, but not so far as to restrict the free movement of the compound rest base across the saddle. Retighten the set screw to lock the gib in the desired adjustment.

COMPOUND REST TOP GIB ADJUSTMENT

To eliminate play in the dovetail of the compound rest top, first loosen the lock screw in the right hand side of the compound rest top. Fig. 9. Then while turning the feed screw back and forth with one hand, turn the gib adjusting screw inward until no play is detectable but not far enough to restrict free movement, then retighten set screw.

ADJUSTING APRON FEED CLUTCH

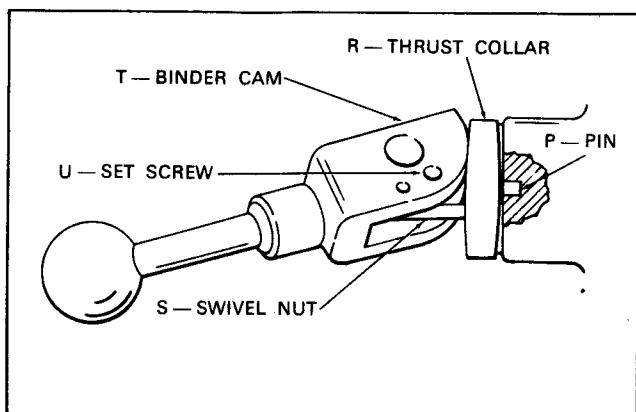


Figure 10 — Clutch Adjustment

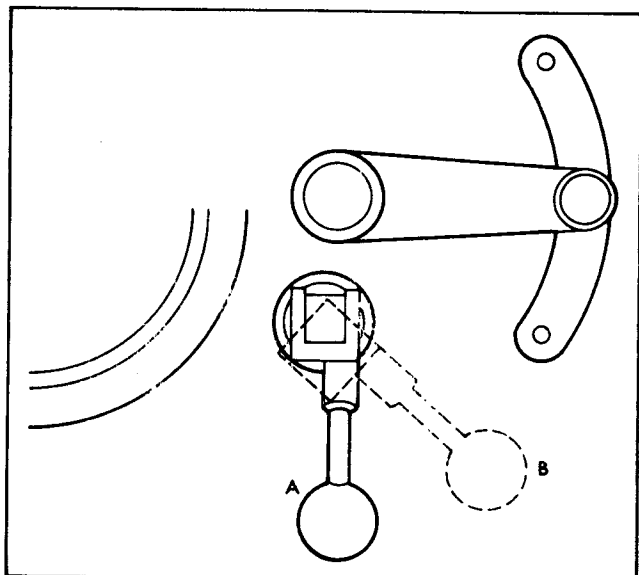


Figure 11 — Clutch Lever Adjustment

TO ADJUST CLUTCH

1. With allen wrench, loosen set screw "U" and turn clutch lever clockwise until clutch engages in proper position. (See Figs. 10-11). Clutch lever should not go beyond the perpendicular to the thrust collar "R".
2. Clutch lever should be just tight enough to stay engaged in a heavy cut. If clutch is too loose, repeat the steps outlined above. If too tight, turn clutch lever counter-clockwise in steps outlined above.

TO ADJUST DIRECTION OF CLUTCH LEVER SWING

1. After binder cam "T" is adjusted to proper position, it may not be as in "A" Fig. 11.
2. To return binder to position "A", unscrew binder cam "T" so there is enough clearance between binder and thrust collar "R" to disengage pin from rear of collar "R".
3. Rotate collar "R" and threaded shaft until pin "P" engages in proper hole (holes are spaced 90° apart).
4. Retighten binder cam "T" to proper position and tighten set screw "U" as much as possible.

ADJUSTING MICRO LIMIT SWITCHES

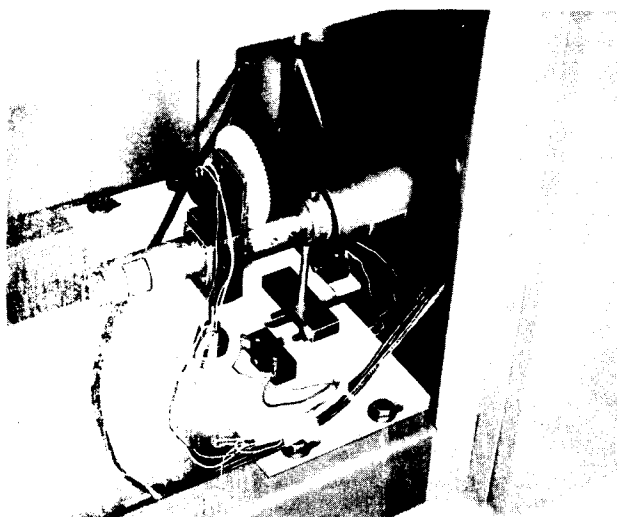


Figure 12 — Micro Limit Switches Adjustment

To adjust micro switch on the high speed range, turn on the main drive motor. Turn item 1 by hand, away from sheave until it won't go any further, then back off approximately 1/4 turn. Loosen the jam nut on micro limit switch, item 2 and adjust set screw to make contact with switch so speed change motor will stop just before reaching maximum rpm. Tighten jam nut.

To adjust the micro switch on the low speed range, turn item 1 by hand toward the sheave until there is approx. 1/32" clearance between item 1 and item 3. Adjust the set screw on micro switch, item 4, using the same procedure as above.

SPINDLE SPEED CALIBRATION

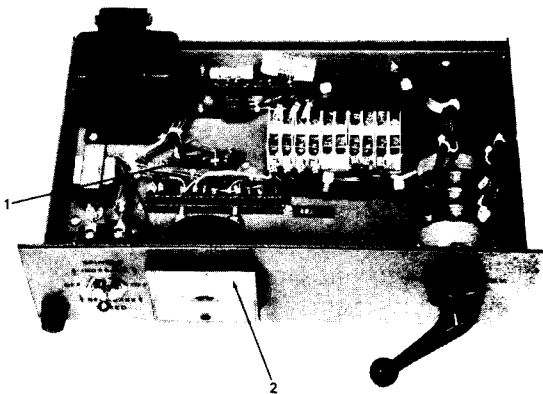


Figure 13

When spindle speed calibration is required under normal operating conditions, with spindle actually running 1200 rpm, adjust "R1" trim resistor until meter reads 1200.

To adjust "R1", loosen screw "1" and move the slider back and forth until speed indicator "2" reads 1200 RPM, tighten lock screw "1".

Refer to electrical wiring diagram furnished with lathe.



Turn power off when adjusting R1.

REPLACEMENT PARTS AND SERVICE

Should replacement parts or service ever be needed for this machine, please specify the serial number of this machine. The serial number is stamped between the front ways of the machine at the tailstock end of the lathe.

SECTION 6

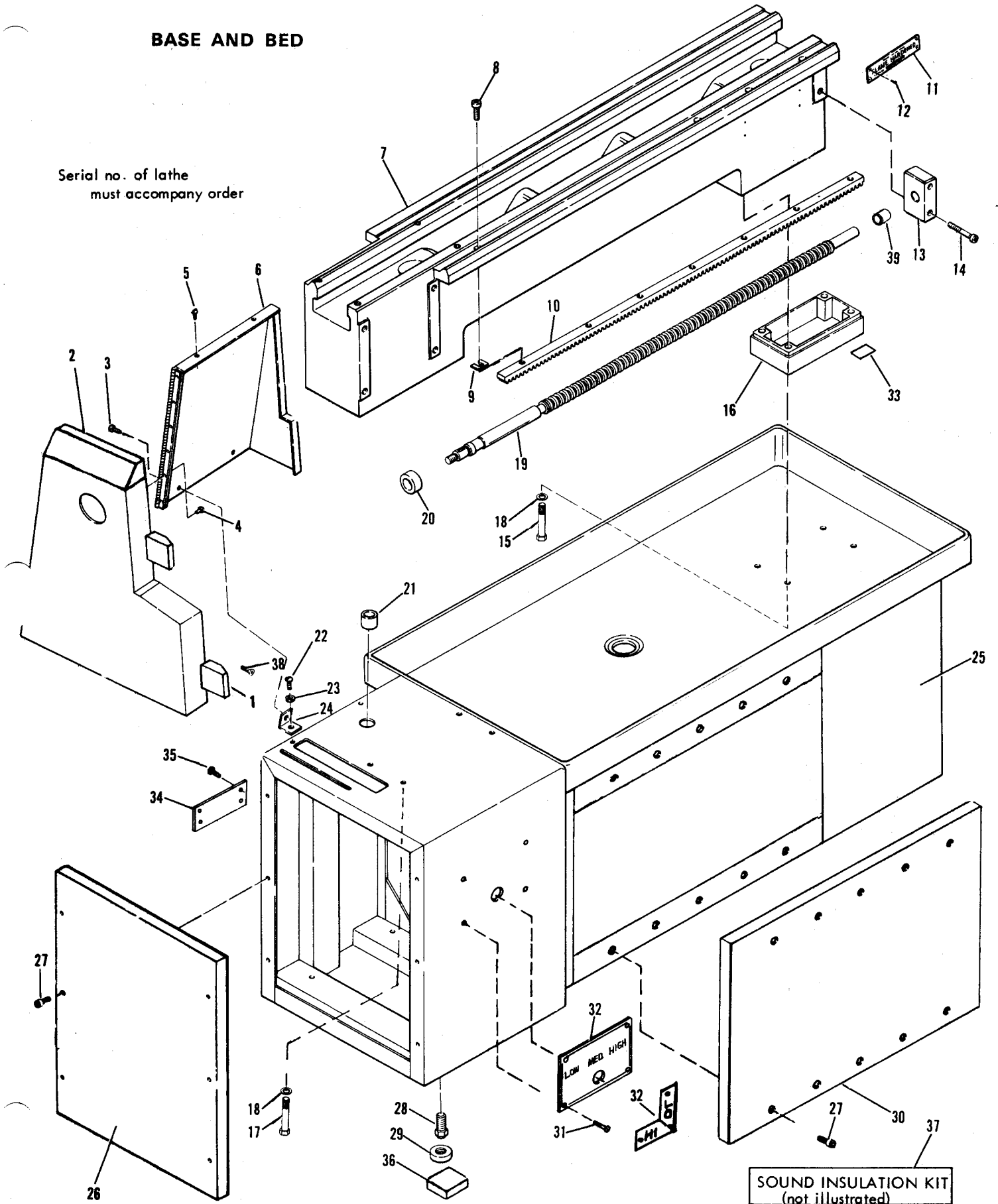
ILLUSTRATIONS AND PARTS LISTS

Replacement parts can be identified readily for ordering purposes from the illustrations and parts listings which follow.

When ordering replacement parts, please specify the part number, part name, and the quantity needed. Please also specify the serial number of the machine which these parts are to be used on. The serial number is stamped on the plate which is on the front side of the bed.

BASE AND BED

Serial no. of lathe
must accompany order



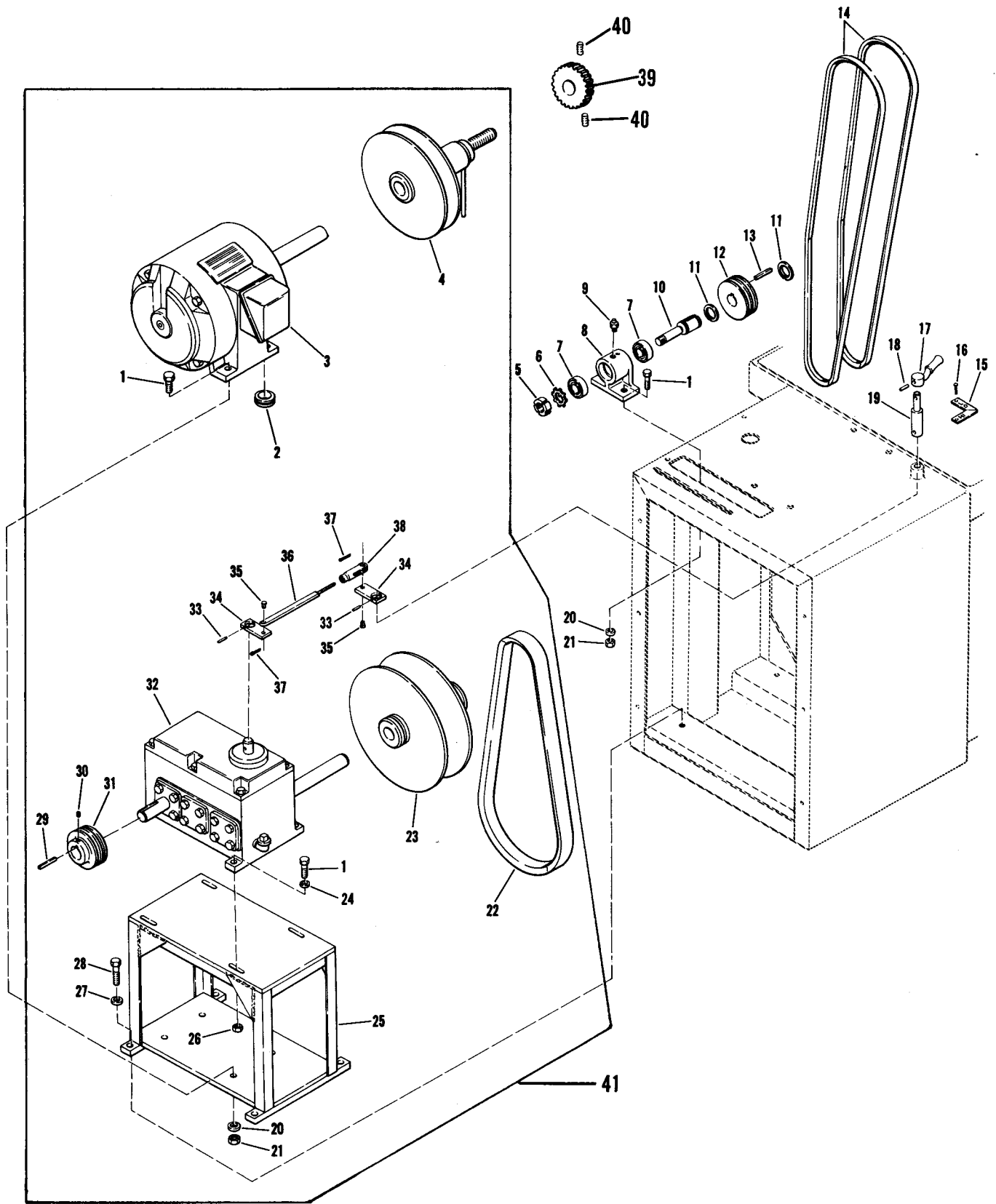
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" BASE AND BED

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	PT7985-1	Draw Catch	2
2	*AS8672TT4	End Gear Cover Assy (1, 38)	1
3	101 x 706	Button Soc Hd. Screw 5/16 -18 x 5/16	2
4	134 x 2	Pop Rivet 1/8 x 1/8	6
5	132 x 1405	Self Tapping Screw 10-32 x 5/8	2
6	PT8680TT2	Back Guard	1
7	PT8560TT205	Bed For 28" Between Centers	1
7	PT8560TT206	Bed For 40" Between Centers	1
8	116 x 620	Soc Hd Cap Screw	7
9	PT8564TT105	Shim .005 Thick	7
9	PT8564TT107	Shim .007 Thick	7
9	PT8564TT120	Shim .020 Thick	7
10	PT8561TT205	Rack For 28" Between Centers	1
10	PT8561TT206	Rack For 40" Between Centers	1
11	PT8566TT3	Bed Plate	1
12	132 x 1101	Self Tapping Screw 6-32 x 1/4	4
13	*PA8563TT2	Support Bracket (39)	1
14	114 x 144	Soc Hd Cap Screw 5/16 -18 x 2-3/4	2
15	114 x 456	Hex Hd Cap Screw 1/2 - 13 x 3-1/2	4
16	PT8565TT1	Spacer	1
17	114 x 424	Hex Hd Cap Screw	4
18	161 x 30	Flat Washer	8
19	*PA8562TT205	Lead Screw For 28" Between Centers (20)	1
19	*PA8562TT206	Lead Screw For 40" Between Centers (20)	1
19	*PA3537TT105	Metric Lead Screw For 28" Between Centers (20)	1
19	*PA3537TT106	Metric Lead Screw For 40" Between Centers (20)	1
20	PT39T2	Collar	1
21	160299	Nylon Snap Bushing	1
22	101 x 710	Button Soc Hd Screw 8-32 x 7/16	2
23	182 x 301	Washer	2
24	PT8705TT1	Bracket	2
25	PT8739TT605	Base For 28" Between Centers	1
25	PT8739TT606	Base For 40" Between Centers	1
26		Door - Part Of Bench Assy	1
27	101 x 612	Button Soc Hd Screw 1/4 -20 x 3/4	16
28	PT6669GJ2	Leveling Screw	4
29	PT4243DP1	Leveling Pad, Pkg of 4	1
30		Removable Panel Part of Bench	1
31	132 x 1101	Self Tapping Screw 6-32 x 1/4	4
32	PT8761TT3	Speed Range Plate	1
32	PT8761TT2	Speed Range Plate Old Style	1
33	PT9373-1	Shim .005 Thick	4
33	PT9374-1	Shim .010 Thick	4
33	PT9375-1	Shim .015 Thick	4
33	PT9376-1	Shim .025 Thick	4
34	PT7917-1	Voltage and Wiring Diagram Plate	1
35	132 x 100	Self Tapping Screw 2-56 x 3/16	4
36	PT8842TT1	Pad	4
37	PA3508TT1	Sound Insulation Kit For 28" Between Centers	4
37	PA3519TT1	Sound Insulation Kit For 40" Between Centers	1
38	116 x 506	Flt Hd Soc Cap Screw 6-32	4
39	PT3660H1	Bushing	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

DRIVE UNIT



Parts illustrated on this page were used prior to Nov. 1974, approx. ser no. 74TT1260.

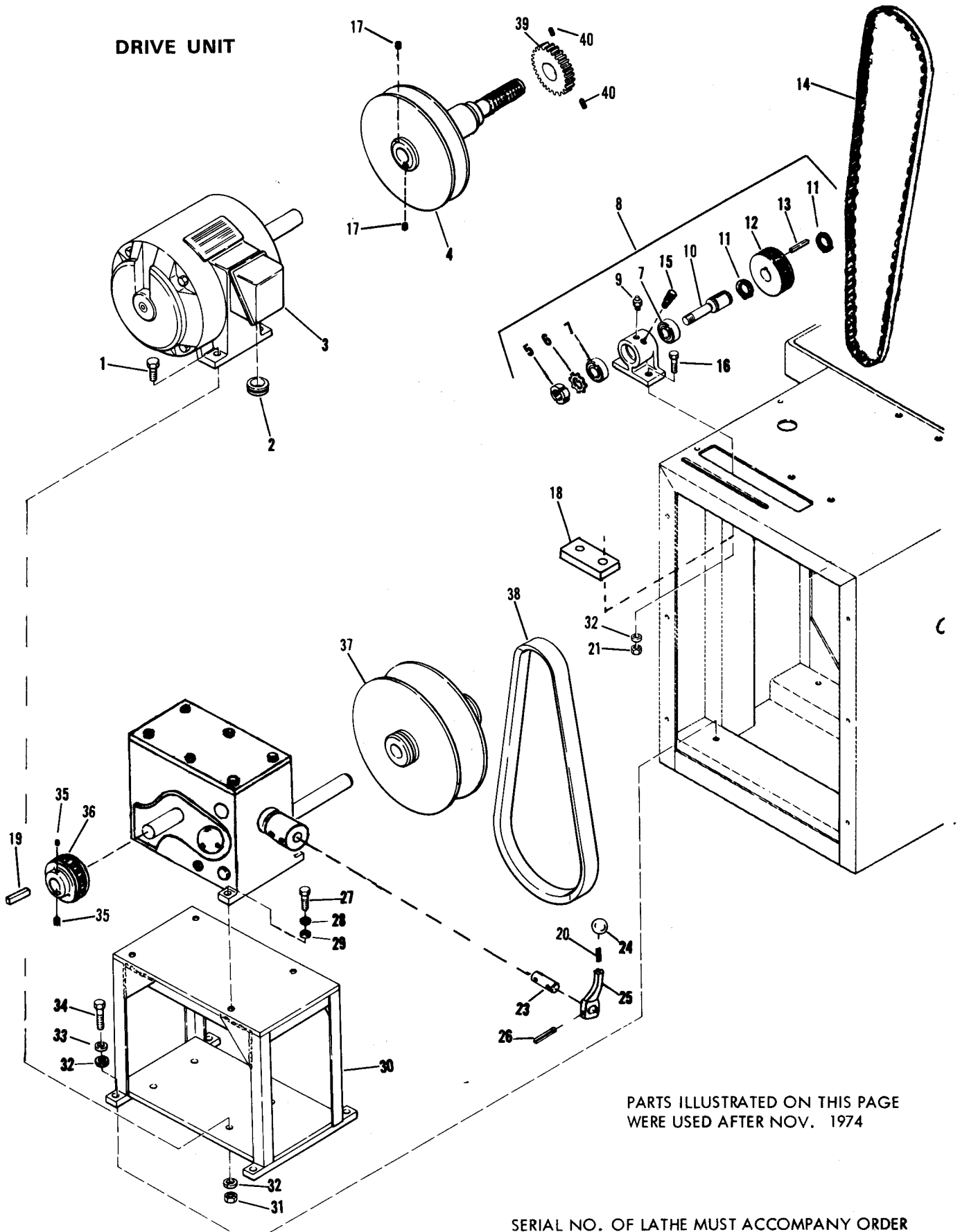
SERIAL NUMBER OF LATHE 'MUST' ACCOMPANY ORDER

DRIVE UNIT

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
1	112 x 224	Hex hd cap screw	10
2	PT1115	Grommet	1
3		See Motor Identification Plate	1
4	PT8755TT1	Pulley	1
5	650103	Lock nut	1
6	650203	Washer	1
7	PT7817GJ1	Bearing	2
8	*PA8742TT1	Bracket(5, 6, 7, 8, 10, 11)	1
9	190 x 1634	Fitting	1
10	PT8744TT1	Shaft	1
11	165 x 100	Retaining Ring	2
12	PT8743TT1	Idler pulley	1
13	163 x 31	Key	1
14	PT8747TT1	DC Belts 68.90"	2
14	PT8747TT2	AC Belts. AC belts start at serial no 73TT876(approx.) 66.93 "	2
15	PT8761TT2	Plate	1
16	132 x 1101	Self tapping screw	3
17	PT54T2	Lever	1
18	160 x 251	Straight pin	1
19	PT8750TT2	Shaft	1
20	180 x 302	Washer	6
21	138 x 27	Nut	6
22	PT8756TT1	Var. speed drive belt center distance 10.50"	1
23	PT8754TT1	Pulley	1
24	180 x 300	Washer	4
25	PT8745TT1	Cradle	1
26	138 x 23	Nut	4
27	180 x 302	Washer	4
28	112 x 236	Cap screw	4
29	163 x 32	Key	2
30	120 x 106	Set screw	1
31	PT8746TT1	Pulley	1
32		(Reference only)	
33	159 x 19	Roll pin	2
34	PT8749TT1	Arm shaft	2
35	PT8760TT1	Pin	2
36	PT8751TT1	Link arm	1
37		Cotter pin	2
38	PT8748TT1	Yoke	1
39	PT9985TT2	Gear	1
40	120 x 907	Set screw 10-32 x 1/2	2
41	VDH101TT	Complete drive assy.	1

* AVAILABLE ONLY AS SUB-ASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.

DRIVE UNIT



PARTS ILLUSTRATED ON THIS PAGE
WERE USED AFTER NOV. 1974

SERIAL NO. OF LATHE MUST ACCOMPANY ORDER

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

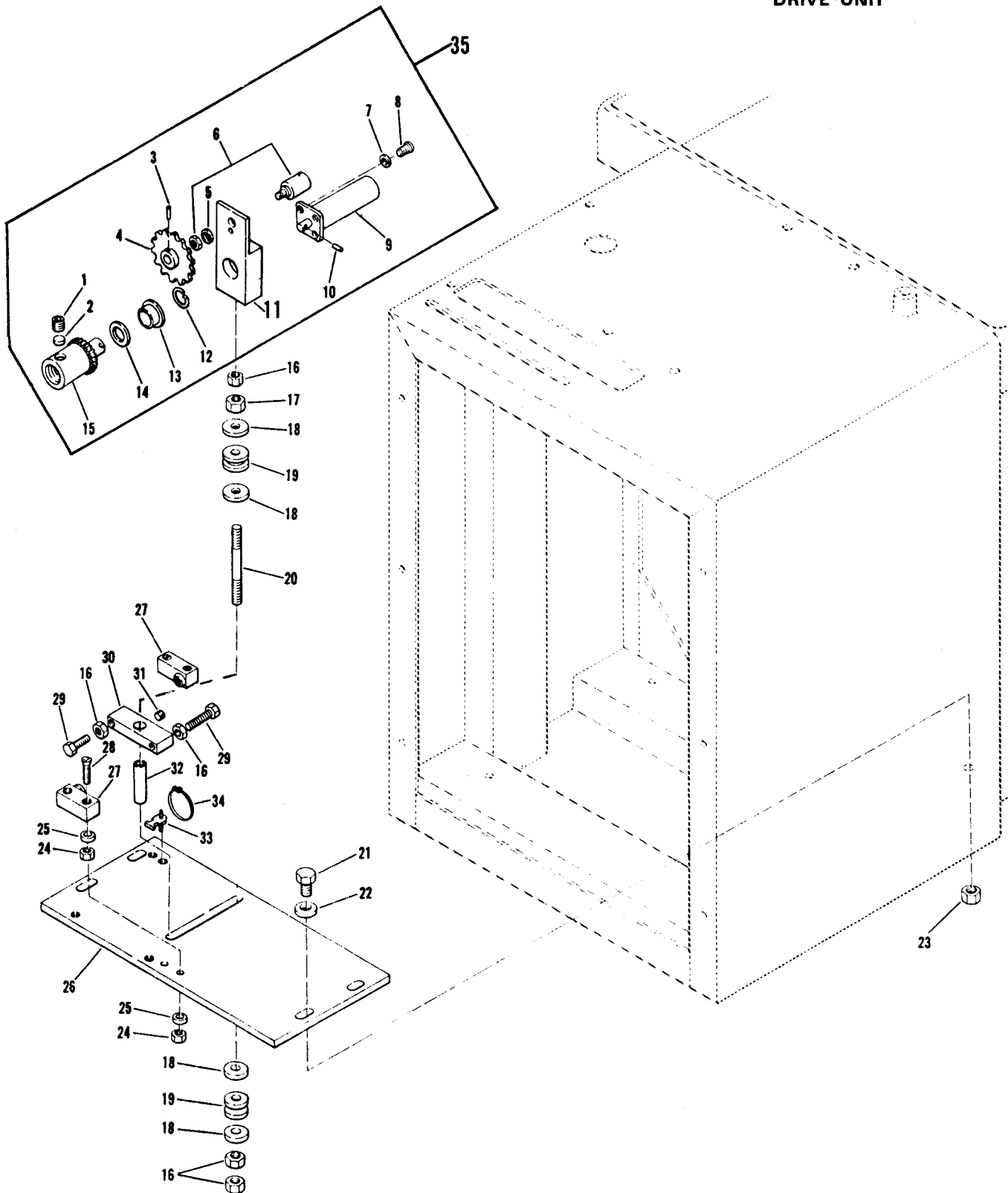
Parts listed below were not used prior to 1973
approx. Serial No. 73TT875

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
3	120 x 904	Soc cup pt set screw 10-32 x 1/4	2
4	PT1078NK1	Shoe	2
5	PA9756DD2	Gear assy. (interchangeable with PA9756DD1)	1
6	PT9772-1	Gear motor	1
7	112 x 14	Hex hd cap screw 1/4-20 x 7/8	3
8	114 x 12	Soc hd cap screw	3
9	PT5504TT1	Nylon gear	1
10		Nut-part of item 13	1
11		Lock nut-part of item 13	1
12	PT9945DD1	Bracket	1
13	PT8715TT1	Potentiometer, 2 watt, Bourn cat no. 3507S	1
14	120 x 12	Hex cap screw 1/4-20 x 3/4	2
15	139 x 23	Hex nut	2
16	*PA8770DD1	Switch arm	1
17	138 x 24	nut	1
18	101 x 308	Soc button hd screw 10-32 x 1/2	2
19	PT5559-1	Terminal Block	1
20	196 x 5038	Tubing approx. 2" long, cut to fit	1
21	101 x 80	Soc button hd screw 6-32 x 1.25	4
22	160220	Switch (BZ2RDA2)	2
23	PT9984TT1	Mounting plate	1
24	180 x 317	Lock Washer	4
25	138 x 13	Hex nut	4
26	161 x 7	Flat washer	5
27	180 x 300	Lock washer	5
28	138 x 23	Hex nut	5
29	112 x 220	Hex hd cap screw 3/8-16 x 1.25	4
30	180 x 302	Washer	4
31	132 x 27	Hex nut	4

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

DRIVE UNIT



Serial No. of Lathe
must accompany order

Parts illustrated on this page were used
prior to 1973 approx. Serial No. 73TT875

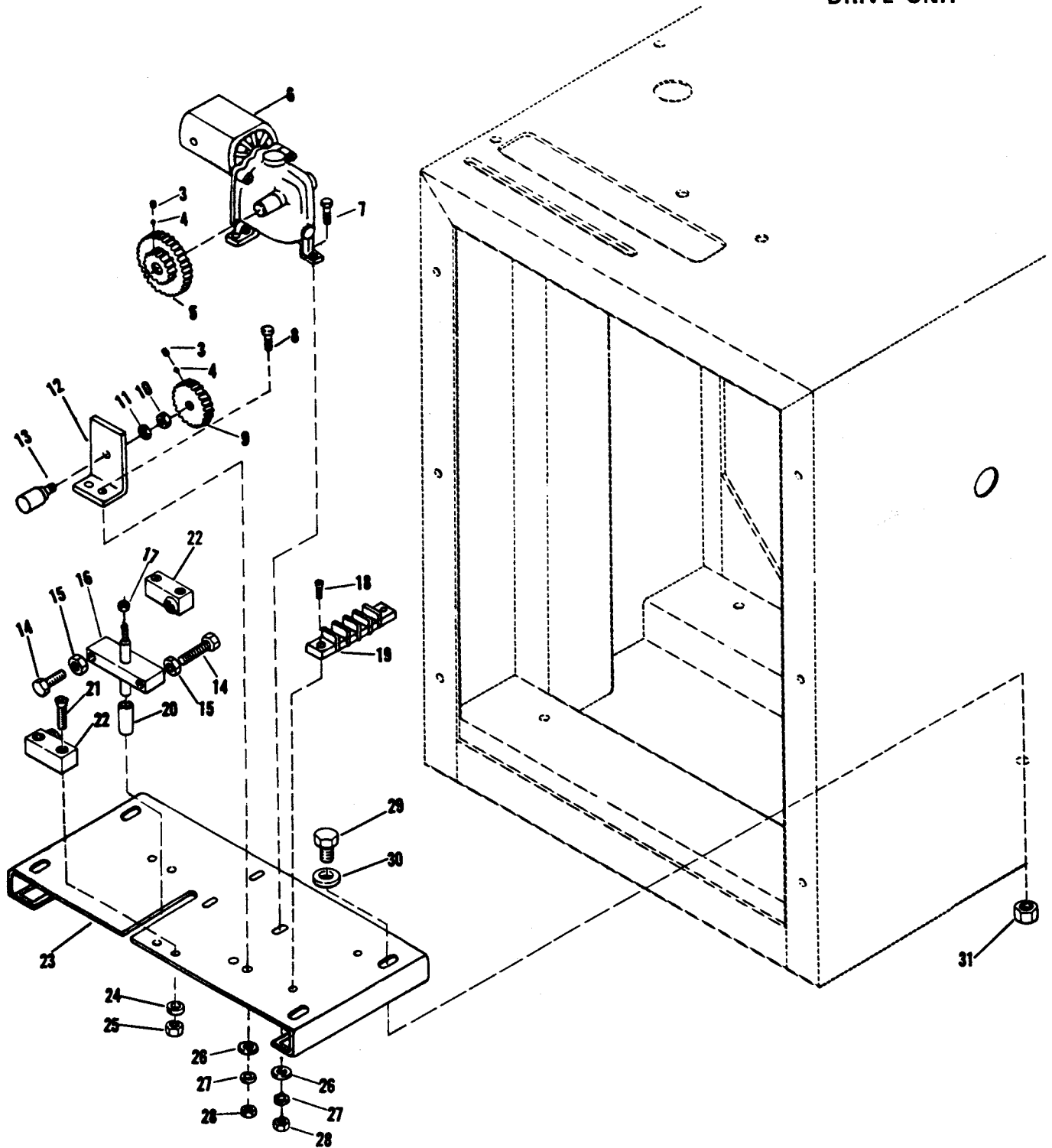
DRIVE UNIT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	120 x 6	Set screw	1
2	PT1082FH1	Shoe	1
3	120 x 904	Set screw	1
4	PT8718TT2	Gear	1
5	180 x 331	Lock washer	1
6	PT8715TT2	Potentiometer, Burns Resistor 35095-1-502 Resis 5K	1
7	180 x 330	Lock washer	4
8	101 x 405	Screw	4
9	PT8716TT2	Motor, 24V DC	1
10	159 x 9	Roll pin	1
11	PT8719TT3	Bracket	1
12	165 x 75	Retaining ring	1
13	PT8757TT1	Bronze bearing	1
14	PT6788GJ1	Thrust bearing	1
15	PT8717TT3	Gear	1
16	139 x 23	Jam nut	3
17	187 x 202	Lock nut	1
18	161 x 14	Washer	4
19	PT1110	Grommet	2
20	PT8758TT2	Rod	1
21	112 x 216	Screw	4
22	180 x 302	Washer	4
23	132 x 27	Nut	4
24	138 x 13	Nut	4
25	180 x 317	Washer	4
26	PT8759TT3	Bracket	1
27	160220	Switch	2
28	101 x 80	Screw	4
29	112 x 28	Screw	2
30	PT8770TT1	Switch arm on DC	1
30	*PA8770DD1	Switch arm on AC	1
31	120 x 906	Set screw	2
32	196 x 300	Tubing approx. 2" long cut to length	1
33	SE8129	Knock out	4
34	SE8130	Strap	4
35	*PA8719TT2	Complete assy. bracketed with DC motor	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

Conversion unit DC to AC LCK101TT1

DRIVE UNIT



Serial No. of Lathe Must accompany order.

PARTS ILLUSTRATED ON THIS PAGE WERE NOT USED PRIOR TO 1973

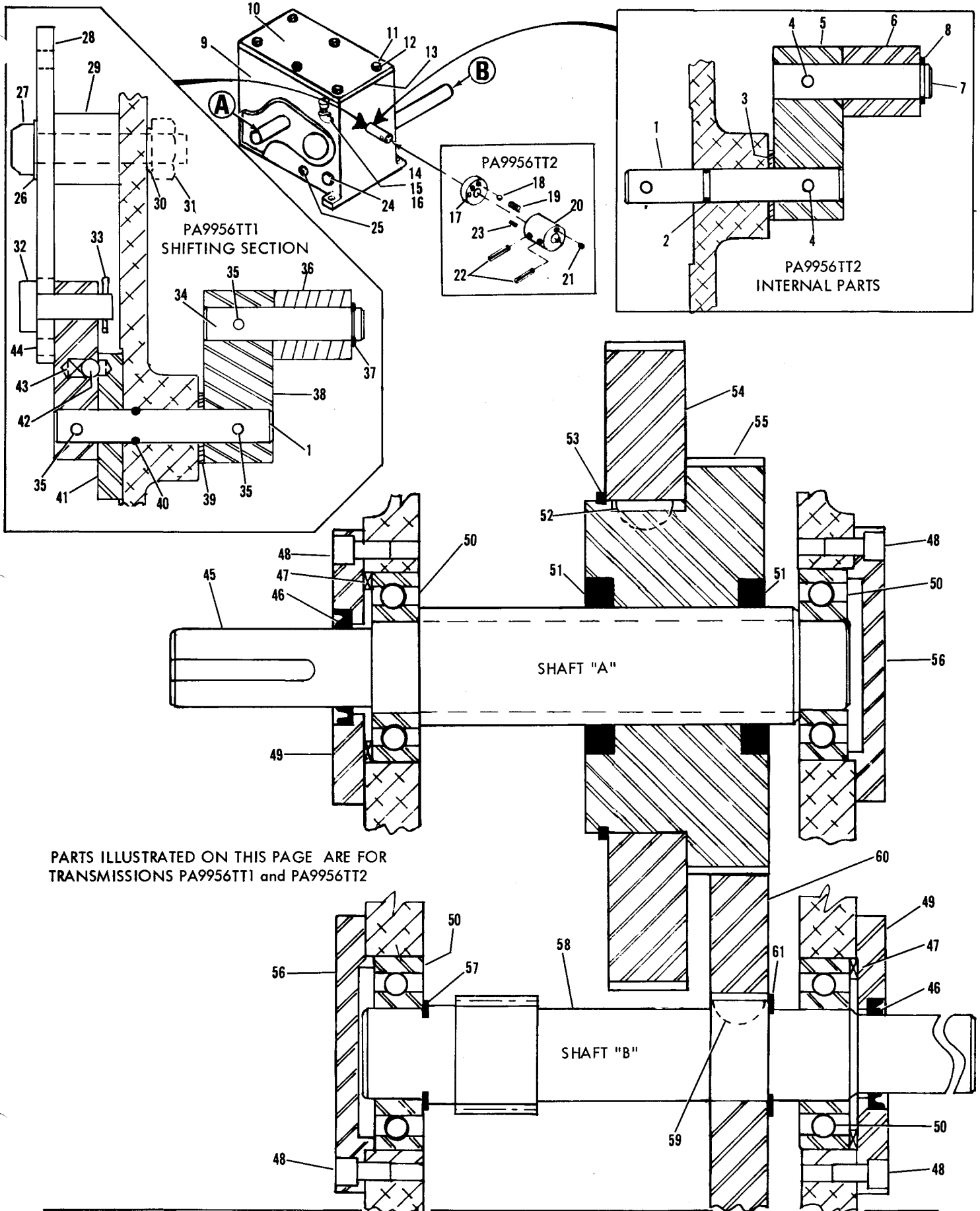
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

Parts listed below were not used prior to 1973
approx. Serial No. 73TT875

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
3	120 x 904	Soc cup pt set screw 10-32 x 1/4	2
4	PT1078NK1	Shoe	2
5	PA9756DD2	Gear assy. (interchangeable with PA9756DD1)	1
6	PT9772-1	Gear motor	1
7	112 x 14	Hex hd cap screw 1/4-20 x 7/8	3
8	114 x 12	Soc hd cap screw	3
9	PT5504TT1	Nylon gear	1
10		Nut-part of item 13	1
11		Lock nut-part of item 13	1
12	PT9945DD1	Bracket	1
13	PT8715TT1	Potentiometer, 2 watt, Bourn cat no. 3507S	1
14	120 x 12	Hex cap screw 1/4-20 x 3/4	2
15	139 x 23	Hex nut	2
16	*PA8770DD1	Switch arm	1
17	138 x 24	nut	1
18	101 x 308	Soc button hd screw 10-32 x 1/2	2
19	PT5559-1	Terminal Block	1
20	196 x 5038	Tubing approx. 2" long, cut to fit	1
21	101 x 80	Soc button hd screw 6-32 x 1.25	4
22	160220	Switch (BZ2RDA2)	2
23	PT9984TT1	Mounting plate	1
24	180 x 317	Lock Washer	4
25	138 x 13	Hex nut	4
26	161 x 7	Flat washer	5
27	180 x 300	Lock washer	5
28	138 x 23	Hex nut	5
29	112 x 220	Hex hd cap screw 3/8-16 x 1.25	4
30	180 x 302	Washer	4
31	132 x 27	Hex nut	4

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621



PARTS ILLUSTRATED ON THIS PAGE ARE FOR TRANSMISSIONS PA9956TT1 and PA9956TT2

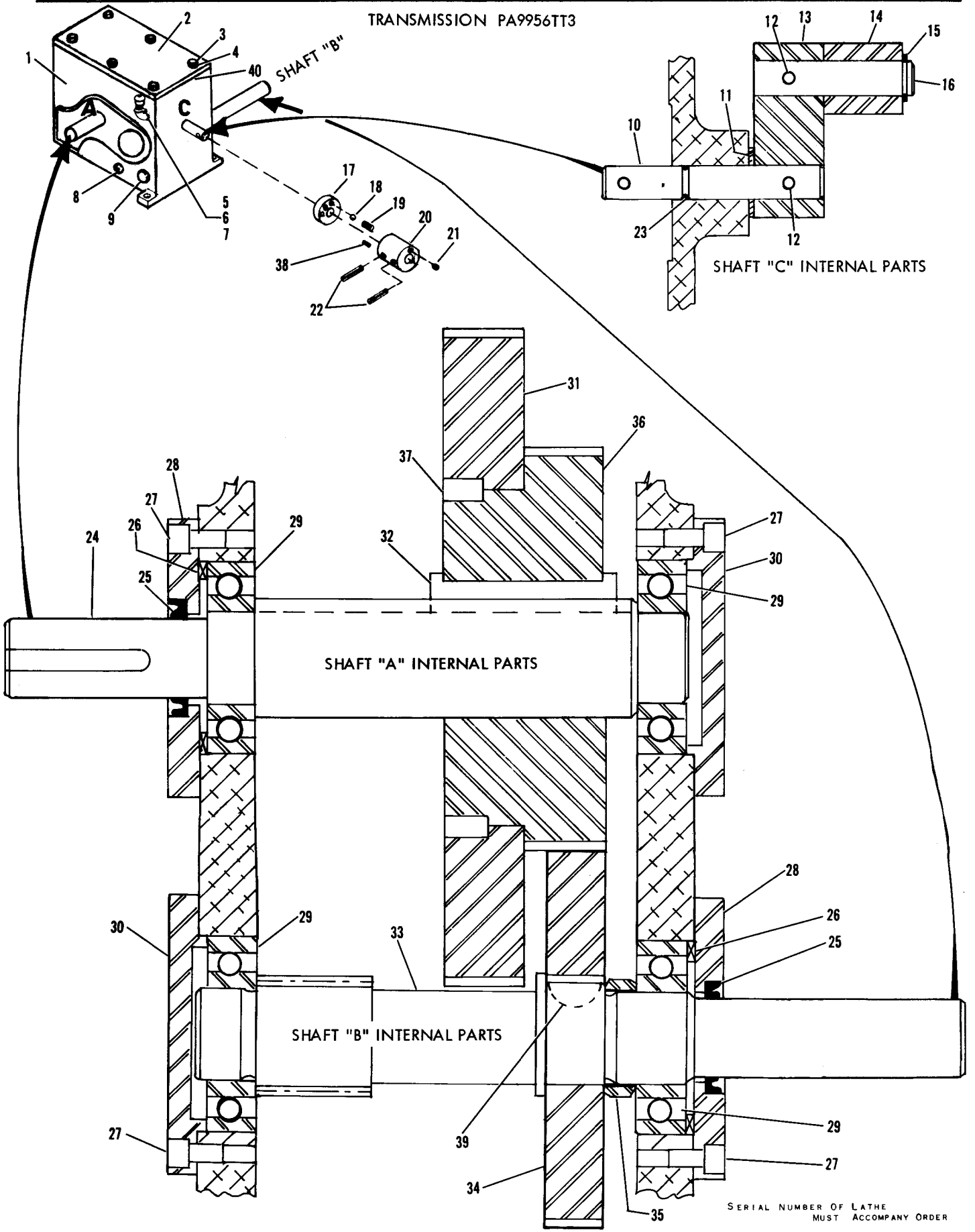
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

TRANSMISSION PA9956TT1 & PA9956TT2 used prior to nov. 1974
apprdx. ser. no. 74TT1260

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
1	PT9960TT1	Shaft	1
2	193 x 7	O-Ring	2
3	160137	Thrust Bearing	1
4	159 x 13	Roll Pin 1/8 x 1	2
5	PT9963TT1	Shifter Arm	1
6	PT9961TT1	Shifter Fork	1
7	PT9962TT1	Shaft	1
8	165 x 50	Retainer	1
9	PT9956TT1	Transmission Housing	1
10	PT9968TT1	Cover	1
11	114 x 608	Soc Hd Cap Screw 10-32 x 1/2	6
12	180 x 204	Lock Washer	6
13	PT9967TT1	Gasket	1
14	PT8970-1	Vent	1
15	152 x 308	Reducer Bushing 1/4 x 1/8	1
16	152 x 56	Street Elbow 1/4-18 NPT	1
17	PT9977TT3	Plate	1
18	172 x 20	Steel Ball 5/16	1
19	162 x 7	Spring	1
20	PT5690TT1	Coupling	1
21	120 x 210	Set Screw 3/8-16 x 5/8	1
22	159 x 38	Roll Pin	2
23	160 x 78	Straight Pin 1/4 x 3/4	2
24	PT7569-1	Vision Window	1
25	152 x 69	Drain Plug 1/4-18 NPT	1
26	161 x 26	Washer	1
27	114 x 436	Soc Hd Cap Screw 1/2-13 x 2 1/4	1
28	PT9976TT1	Connector Arm	1
29	PT9979TT1	Spacer	1
30	193 x 10	O-Ring	1
31	PT1072-5	Hex Jam Nut	1
32	PT9988TT2	Pin	1
33	170 x 306	Cotter Pin 1/8 x 3/4	1
34	PT9962TT1	Shaft	1
35	159 x 13	Roll Pin 1/8 x 1	3
36	PT9961TT1	Shifter Fork	1
37	165 x 50	Retainer	1
38	PT9963TT1	Shifter Arm Inside	1
39	160137	Thrust Washer	1
40	193 x 7	O-Ring	1
41	PT9977TT1	Plate	1
42	172 x 16	Steel Ball 1/4	1
43	162 x 3	Spring	1
44	PT9978TT1	Shifter arm Outside	1
45	PT9969TT1	Sliding Gear Shaft	1
46	PT9975TT1	Oil seal	4
47	PT9973TT1	Spring washer	2
48	114 x 8	Soc Hd Cap Screw 1/4-20 x 1/2	14
49	PT9958TT1	Cap	2
50	PT9959TT1	Ball Bearing	4
51	PT996TT1	Guide Ring	2
52	PT2072	Woodruff Key	1
53	PT9974TT1	Retainer	1
54	PT9972TT1	Bull Gear	1
55	*PA9971TT1	Drive Gear Assy (51)	1
56	PT9957TT1	Cap	2
57	165 x 108	Retainer	1
58	PT9970TT1	Pinion Shaft	1
59	PT2072	Woodruff Key	1
60	PT9965TT1	Driver Gear	1
61	165 x 106	Retainer	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

TRANSMISSION PA9956TT3



SERIAL NUMBER OF LATHE
MUST ACCOMPANY ORDER

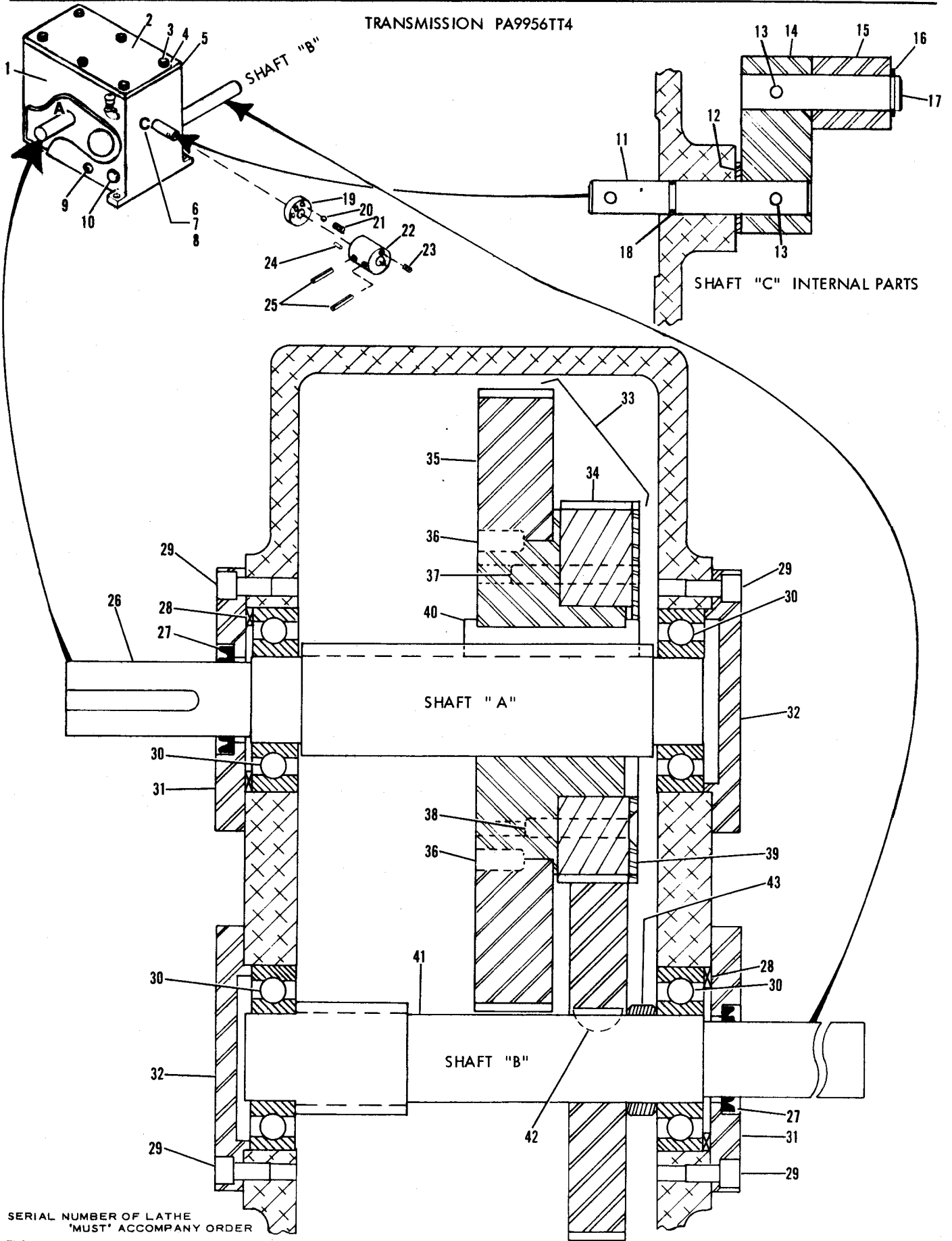
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

PA9956TT3 TRANSMISSION

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
		Used from Nov. 1974 (approx. serial no. 74TT1260) to July 1980 serial no. 00274TT	
1	PT9956TT1	Transmission housing	1
2	PT9968TT1	Cover	1
3	114 x 608	Soc hd cap screw 10-32 x .5	6
4	180 x 204	Lock washer	6
5	PT8970-1	Vent	1
6	152 x 308	Reducer bushing 1/4 x 1/8	1
7	152 x 56	Street elbow 1/4-18NPT	1
8	152 x 69	Drain plug 1/4-18NPT	1
9	PT7569-1	Vision window	1
10	PT9960TT1	Shaft	1
11	160137	Thrust bearing	1
12	159 x 185	Roll pin 3/16	2
13	PT9963TT1	Shifter arm	1
14	PT9961TT1	Shifter fork	1
15	165 x 50	Retainer	1
16	PT9962TT1	Shaft	1
17	PT9977TT3	Plate	1
18	172 x 20	Steel ball 5/16	1
19	162 x 7	Spring	1
20	PT5690TT1	Coupling	1
21	120 x 210	Set screw 3/8-16 x 5/8	1
22	159 x 199	Roll pin 3/16 x 2	2
23	193 x 7	O-Ring	1
24	PT1872TT1	Sliding gear shaft	1
25	PT9975TT1	Oil seal	2
26	PT9973TT1	Spring washer	2
27	114 x 8	Soc hd cap screw	12
28	PT9958TT1	Cap	2
29	PT9959TT2	Ball bearing	4
30	PT9957TT1	Cap	2
31	*PS1874TT1	Sliding gear assy (36, 37)	1
32	PT1870TT1	Key	1
33	PT1873TT1	Pinion shaft	1
34	PT71TT1	Gear	1
35	PT1875TT1	Spacer	1
36	PT1869TT1	Driven gear	1
37	120 x 108	Set screw 5/16-18 x 1/2	2
38	160 x 78	Straight pin 1/4 x 3/4	1
39	106 x 605	Woodruff key	1
40	PT9967TT1	Gasket	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

TRANSMISSION PA9956TT4



SERIAL NUMBER OF LATHE
'MUST' ACCOMPANY ORDER

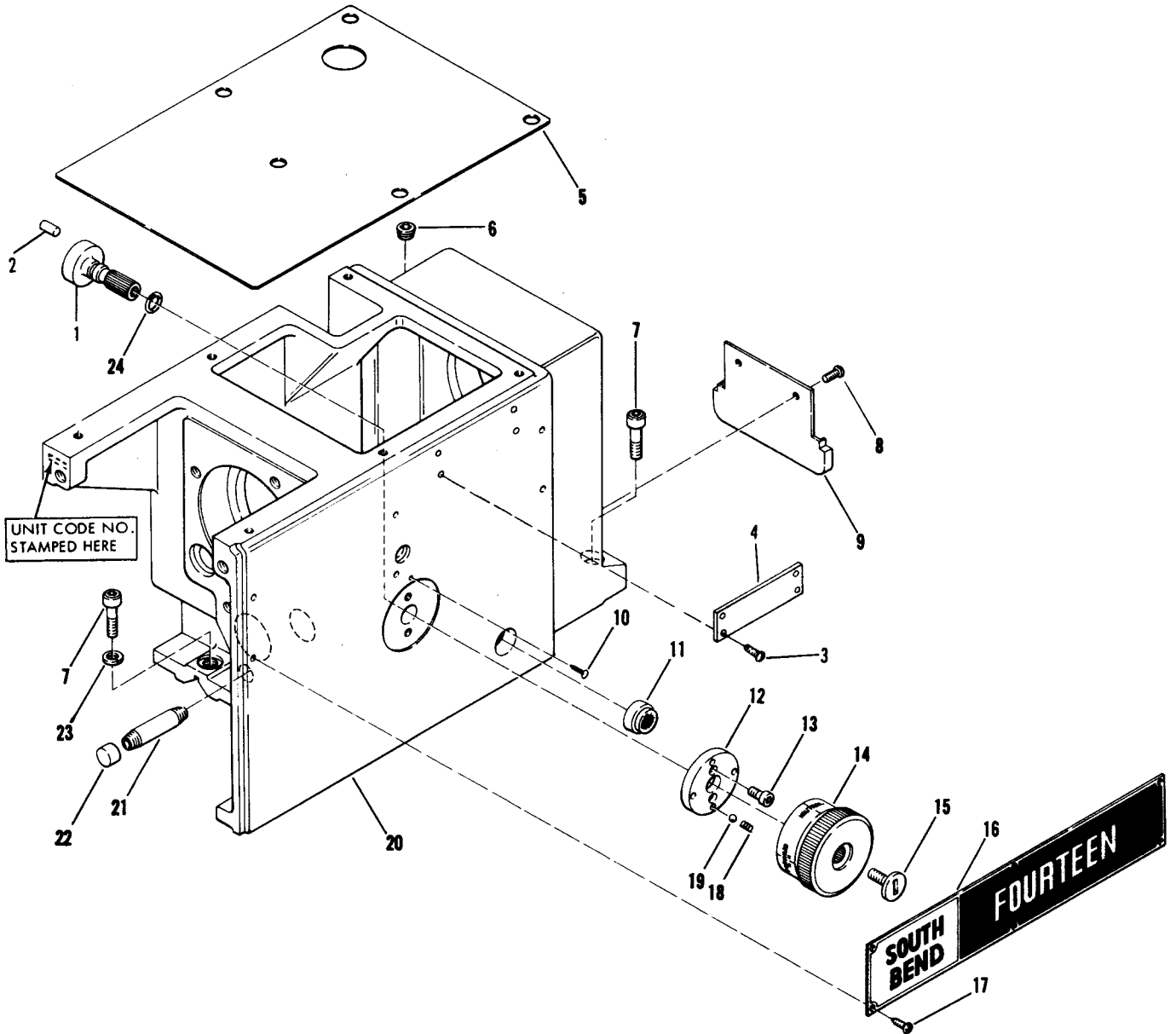
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

TRANSMISSION PA9956TT4 used from May 1980
Serial No. 00374TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
	PA9956TT4	Complete transmission assy. all parts shown	
1	PT9956TT2	Transmission housing	1
2	PT9968TT1	Cover	1
3	114 x 608	Soc hd cap screw 10-32 x 1/2	6
4	180 x 204	Lock washer	6
5	PT9967TT1	Gasket	1
6	PT8970-1	Vent	1
7	152 x 308	Reducer bushing 1/4 x 1/8	1
8	152 x 56	Street elbow 1/4-18 NPT	1
9	152 x 69	Drain plug 1/4-18 NPT	1
10	PT7569-1	Vision window	1
11	PT9960TT1	Shaft for shift lever	1
12	160137	Thrust bearing	1
13	159 x 185	Roll pin 3/16 x 1	2
14	PT9963TT1	Shifter arm	1
15	PT9961TT1	Shifter fork	1
16	165 x 50	Retainer	1
17	PT9962TT1	Shaft for shift fork	1
18	193 x 7	O-Ring	2
19	PT9977TT4	Plate	1
20	172 x 20	Steel ball 5/16	1
21	162 x 7	Spring	1
22	PT5690TT1	Coupling	1
23	120 x 210	Set screw 3/8-16 x 5/8	1
24	160 x 78	Straight pin 1/4 x 3/4	1
25	159 x 199	Roll pin 3/16 x 2	2
26	PT1872TT1	Sliding gear shaft	1
27	PT9975TT1	Oil seal	2
28	PT9973TT1	Spring washer	2
29	114 x 8	Soc hd cap screw 1/4-20 x 1/2	12
30	PT9959TT2	Ball bearing	4
31	PT9958TT1	cap	2
32	PT9957TT1	Cap	2
33	*PA11121TT1	Sliding gear assy. (34, 35, 36, 37, 38, 39)	1
34	PT11121TT1	Gear, order item 33	1
35	PS1874TT1	Gear and hub assy. order item 33	1
36	120 x 108	Set screw 5/16-18 x 1/2	2
37	153 x 25	Straight pin	2
38	103 x 624	Flat hd screw 1/4-20 x 1.5	2
39	PT11120TT1	Plate striker	1
40	PT1870TT1	Key	1
41	PT1873TT1	Pinion shaft	1
42	106 x 605	Woodruff key	1
43	PT1875TT1	Spacer	1

*AVAILABLE ONLY AS SUBASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.

HEADSTOCK



Serial no of lathe and unit code no. must accompany order.

PARTS ILLUSTRATED ON THIS PAGE ARE FOR HEADSTOCK UNIT CODES VSH100TT, VSH101TT, VSH102TT, VSH103TT

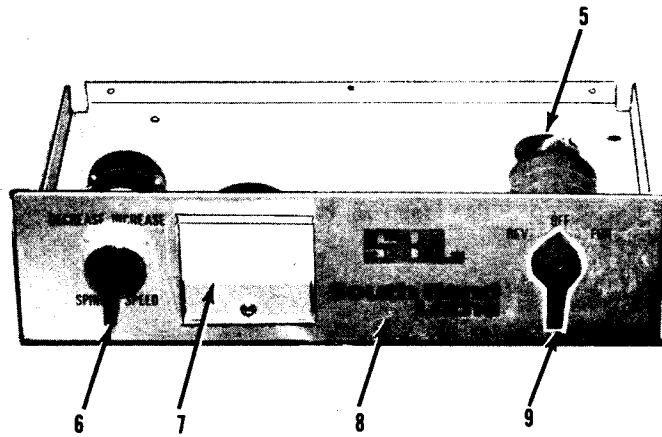
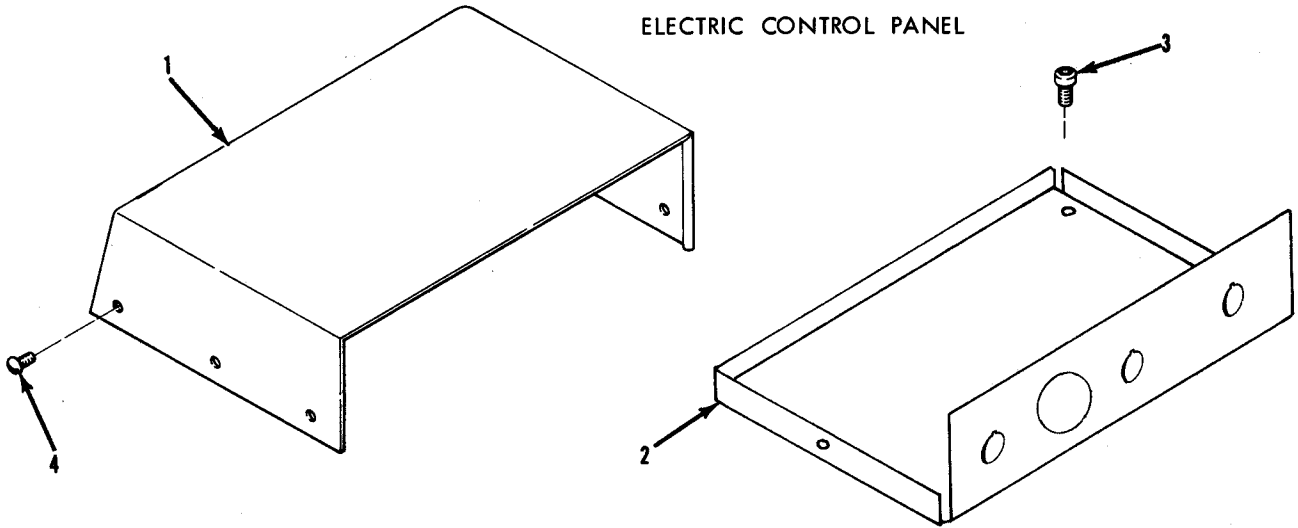
14" HEADSTOCK

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	PT8592TT1	Shifting shaft	1
2	153 x 10	Pin .3127 x 3/4	1
3	132 x 1100	Self tapping screw	4
4	*AS7916	Warning plate (3)	1
5	PT8839TT1	Gasket	1
6	152 x 69	Pipe plug	1
7	114 x 120	Soc hd cap screw 5/16-18 x 1.25	4
8	109 x 8	Soc button hd screw 10-32 x 1/2	2
9	PT8668TT1	Guard	1
10	130 x 103	Drive screw #4 x 3/16	1
11	PT7569-1	Vision window	1
12	PT8578TT1	Plate	1
13	114 x 608	Soc hd cap screw 10-32 x 3/8	2
14	*AS8581TT1	Dial (15)	1
15	130032	Screw	1
16	*AS8594TT2	Name plate (17)	1
17	132 x 1101	Self tapping screw #6-32	6
18	162 x 3	Spring	1
19	172 x 16	Steel ball 1/4	1
20	PT8577TT1	Headstock housing for VSH100TT	1
20	PT8577TT2	Headstock housing for VSH101TT, VSH102TT, VSH103TT	1
21	PT1335	Pipe 1/4 -18 x 2.5	1
22	152 x 75	Pipe cap	1
23	182 x 301	Washer	4
24	193 x 9	O-Ring	1

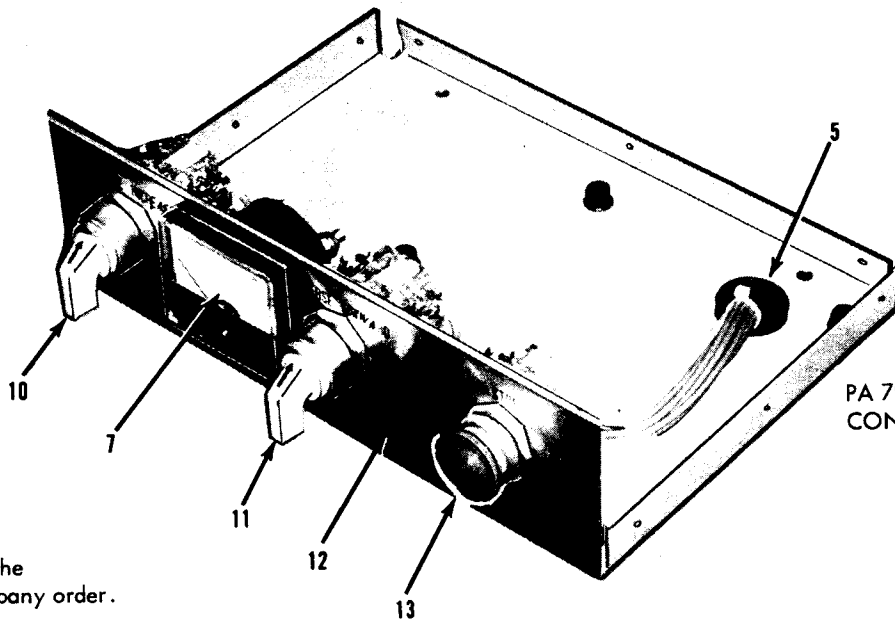
*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

ELECTRIC CONTROL PANEL



PA 8703TT6
CONTROL STATION ASSY.



PA 7947TT2
CONTROL STATION ASSY.

Serial no. of lathe
must accompany order.

ELECTRIC CONTROL PANEL

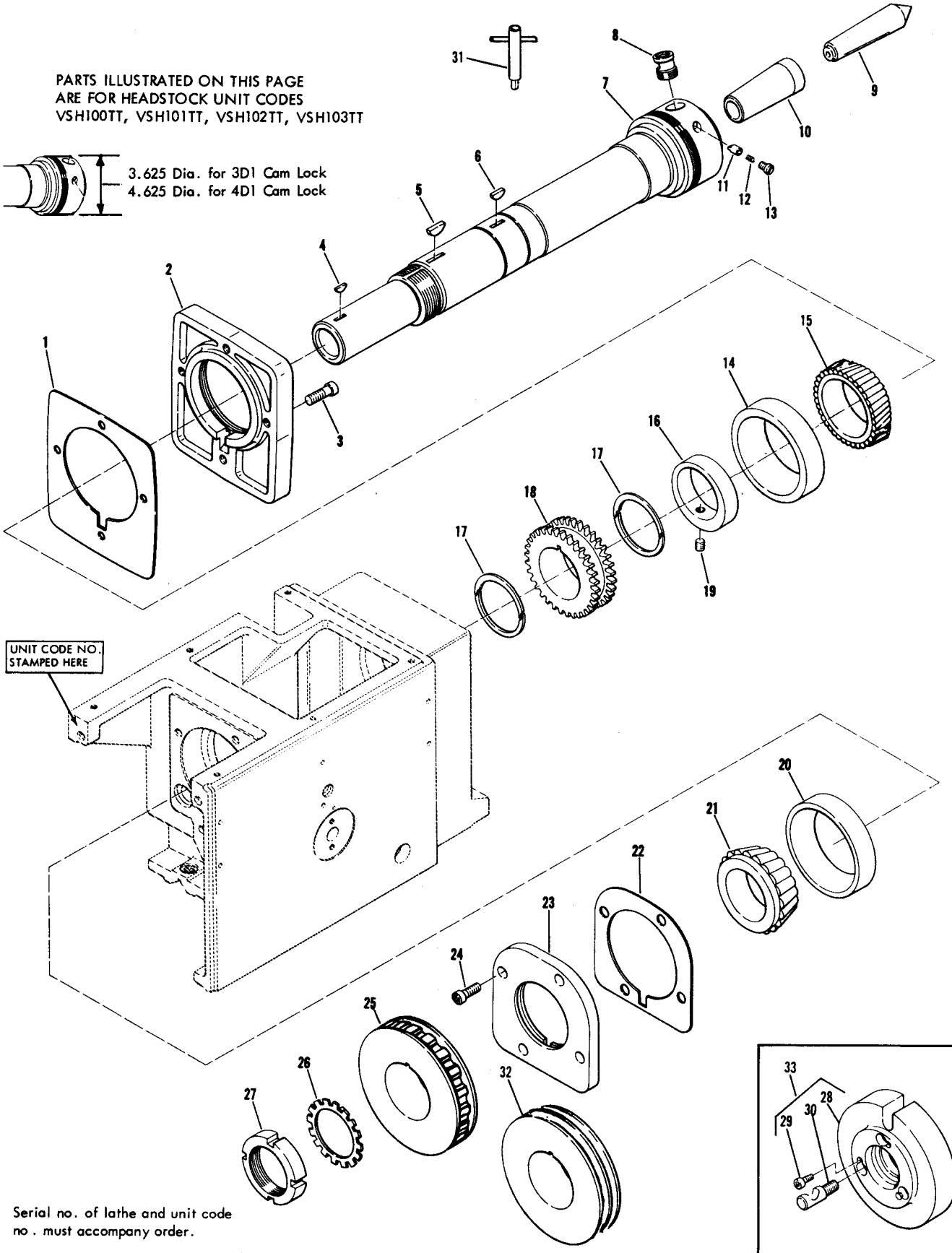
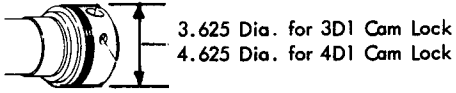
Control Station Assemblies
 on this page are for wire diagrams
 1328-15, 1333-15, 1335-15, 1336-15
 (B/M s 41, 42, 43, 44)

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	PT8702TT2	Cover	1
2	PT8703TT5	Control Station Plate	1
3	114 x 110	Soc Hd. Cap Screw 5/16 - 18 x 5/8	5
4	109 x 8	Button Soc Hd Cap Screw 10-32 x 1/2	6
5	160229	Bushing	1
	*PA8703TT6	Control Station Assy. (2,5,6,7,8,9) Also includes one Control Cable 72" Long With Leads and Case	1
6	PT9954DD1	Selector Switch. Decreases-Increase	1
7	PT8714TT3	Tachometer	1
8	PT8773TT4	Legend Plate (Used w/o Red Stop Button)	1
9	PT8712DD1	Drum Switch Control, Reverse-Off-Forward	1
	*PA7947TT2	Control Station Assy. (2,5,7,10,11,12,13) Also Includes one Control Cable 72" Long with Leads and Case	1
10	PT7929TT1	Selector Switch. Decrease-Increase	1
11	PT7931TT1	Selector Switch, Reverse-Forward	1
12	PT7947TT3	Legend Plate (Used With Red Stop Button)	1
13	PT7930TT1	Stop Push Button, Red Mushroom Head	1
*AVAILABLE ONLY AS ASSY. INCLUDED PARTS ARE IN PARANTHESIS AFTER PART NAME			

NOTE: Lathe serial no. is required when ordering electrical parts. Give voltage, phase, and wire diagram no. if known. This information is on the voltage and motor plate (on some models) or the inside of the control panel cover- both located on the back side of the lathe.

HEADSTOCK

PARTS ILLUSTRATED ON THIS PAGE
ARE FOR HEADSTOCK UNIT CODES
VSH100TT, VSH101TT, VSH102TT, VSH103TT



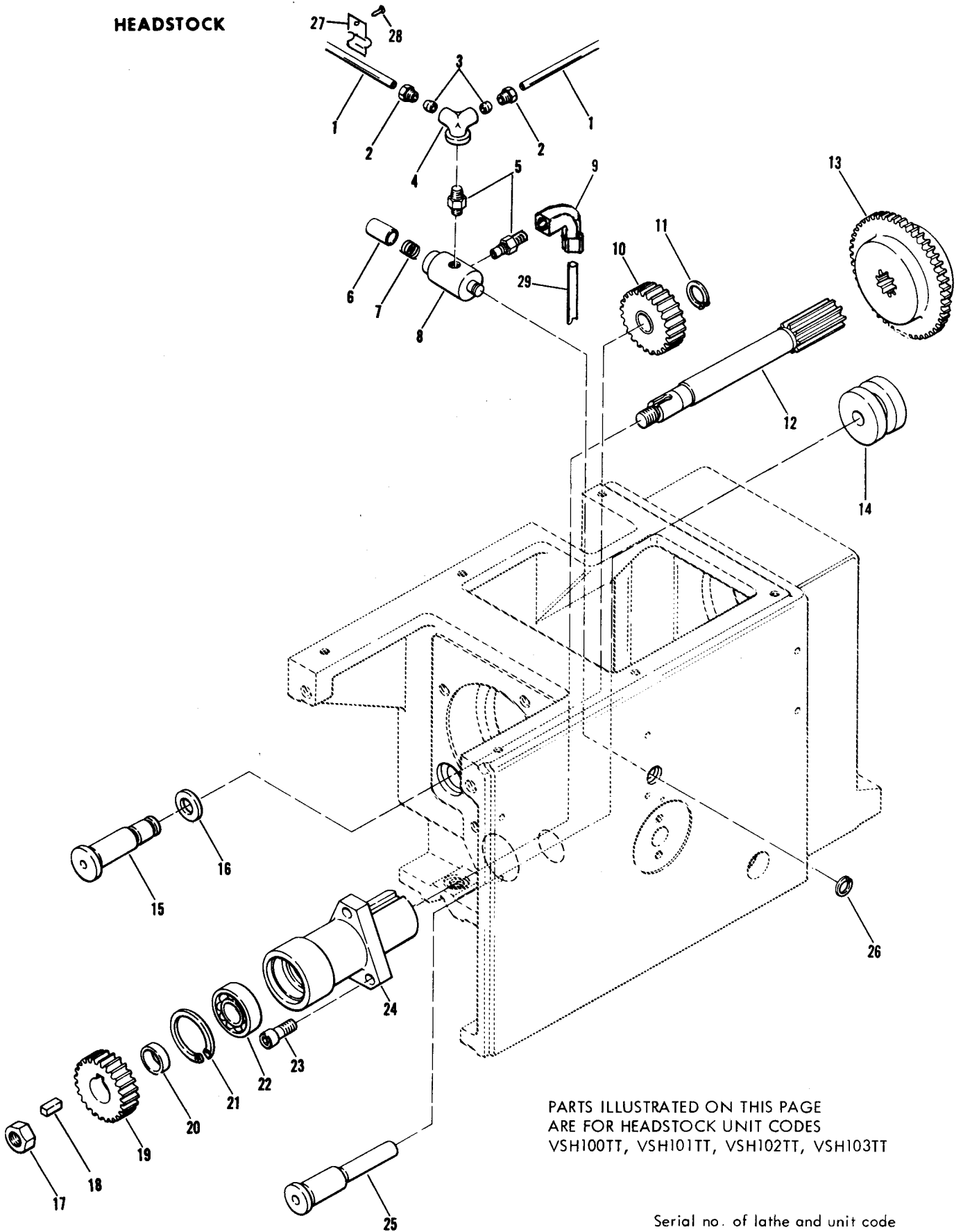
UNIT CODE NO.
STAMPED HERE

Serial no. of lathe and unit code
no. must accompany order.

ITEM NO.	PART NO.	DESCRIPTION	QUAN	
1	PT8840TT1	Gasket	1	VSH100TT
2	PT8568TT1	Nose Cap	1	VSH101TT
3	114 x 120	Soc Hd Cap Screw 5/16 - 18 x 1-1/4	4	VSH102TT
4	PT2070-1	Key Used With Collet Att.	1	VSH103TT
5	PT2086-1	Key	1	
6	PT2073	Key	1	
7	*AS8574TT1	Spindle Assy For 3D1 Cam Lock Used On VSH 100 TT, VSH 101TT (1,2,3,4,5,6,8,11, 12,13,14,15,16,17,18,19,20,21,26,27,32)	1	
7	*AS8524TT1	Spindle Assy For 4D1 Cam Lock, No. 5 Morse Taper, Used on VSH102TT, VSH103TT (1,2,3,4,5,6,8,11,12, 13,14,15,16,17,18,19,20,21,25,26,26)	1	
8	PT6718R1	Cam For 3D1 Cam Lock Spindle Used On VSH 100 TT, VSH 101 TT	1	
8	PT3629LH1	Cam For 4 D 1 Cam Lock Spindle Used On VSH102TT, VSH103TT	1	
9	PT6712R1	Center For 3 D 1 Cam Lock Spindle, #3 AM STD. Taper	1	
9	PT6524GJ1	Center For 4D1 Cam Lock Spindle, CE8006, #4 AM Std. Taper	1	
10	PT8567TT1	Sleeve For 3D1 Cam Lock Spindle #3 ASA Taper Inside, #4-1/2 ASA Taper Outside	1	
10	PT8521DD1	Sleeve For 4D1 Cam Lock Spindle #4 Morse Taper Inside, #5 AM Std Taper Outside Used on Lathe Mfg Up to 1977 Approx. Ser No. 76TT1655	1	
10	PT8521DD2	Sleeve For 4D1 Cam Lock Spindle #4 Morse Taper Inside, #5AM Std Taper Outside Used On Lathe Mfg. From 1977 Approx Ser. No. 76TT1656	1	
11	PT2827L1	Plunger For 3D1 Cam Lock Spindle Used on VSH100TT, VSH 101TT	1	
11	PT3638LH1	Plunger For 4D1 Cam Lock Spindle Used on VSH 102TT, VSH 103TT	1	
12	PT3639LH1	Spring Used on all Spindles	1	
13	PT2826L1	Screw For 3D1 cam lock (VSH100TT, VSH101TT)	1	
13	114 x 112	Screw For 4 D 1 Cam Lock Spindle Used on VSH102TT, VSH103TT 5/16-18 x 3/4	1	
14	PT8569-1	Bearing Cup	1	
15	PT8571-1	Bearing Cone	1	
16	PT8664TT1	Balance Ring	1	
17	165 x 603	Retain Ring	2	
18	PT8570TT1	Gear	1	
19	120 x 108	Cup Pt Set Screw 5/16 - 18 x 1/2	1	
20	PT8569-1	Bearing Cup	1	
21	PT8572-1	Bearing Cone	1	
22	PT8841TT1	Gasket	1	
23	PT8593TT2	End Cap	1	
24	114 x 114	Soc Hd Cap Screw 5/8-18 x 7/8	4	
25	PT4459TT2	Spindle Pulley For Timing Belt	1	
26	PT8575-1	Lock Washer	1	
27	PT8576-1	Lock Nut	1	
28		Face Plate-Order Item 33		
29	114 x 8	Soc Hd. Cap Screw 1/4-20 x 1/2	3	
30	PT2825L1	Lock Stud For 3D1 Cam Lock Spindle Used On VSH 100TT, VSH101TT	3	
30	PT3626LH1	Lock Stud For 4 D1 Cam Lock Spindle Used ON VSH102TT, VSH103TT	3	
31	PA3672-2	Wrench For 3D1 Cam Lock Spindle	1	
31	PA3686-1	Wrench For 4D1 Cam Lock Spindle	1	
32	PT8573TT2	Spindle Pulley For V-Belts	1	
33	CC2175TT1	Small Face Plate For 3 D1 Spindle	1	
33	CB2175LT1	Small Face Plate For 4D1 Spindle	1	

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

HEADSTOCK



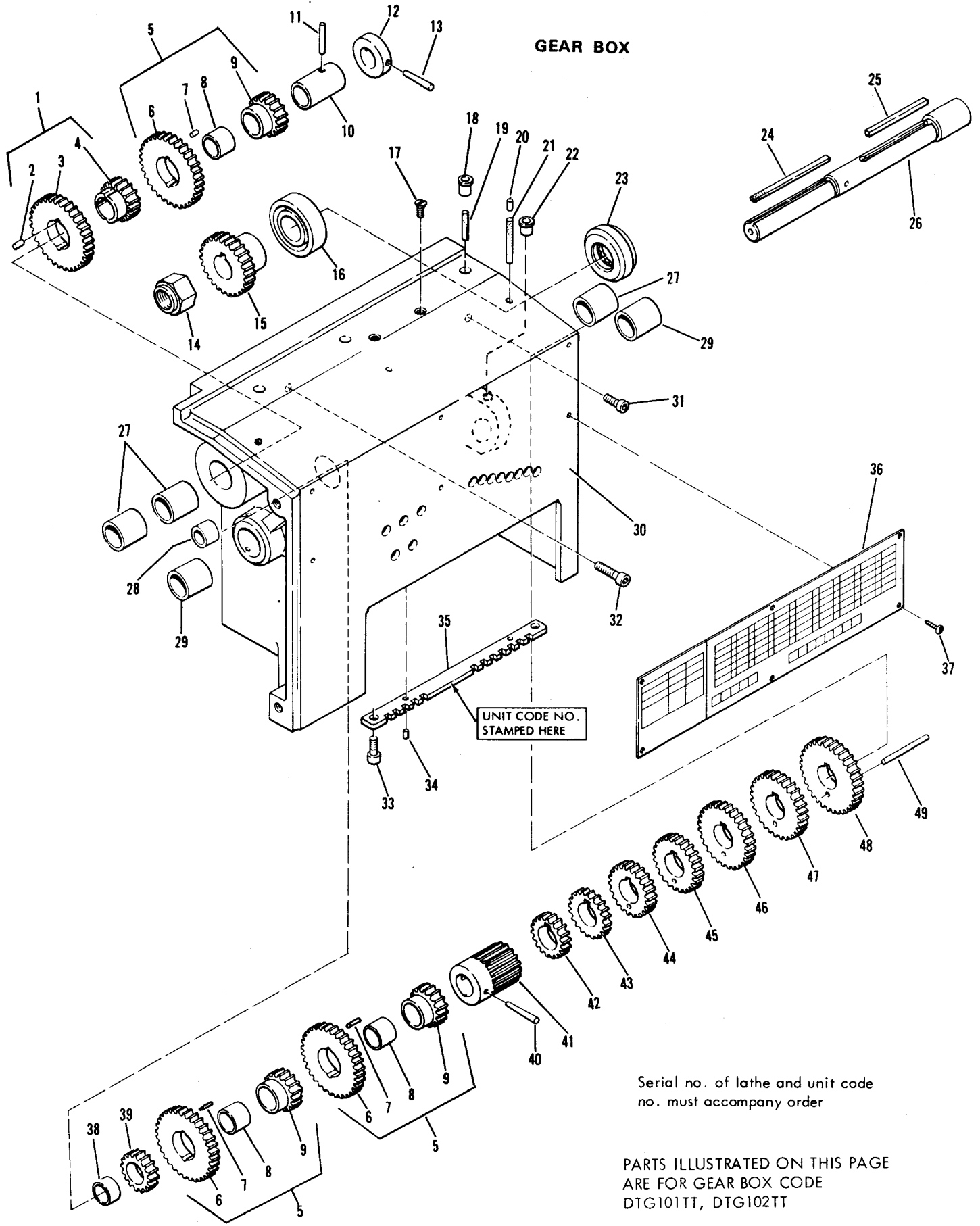
PARTS ILLUSTRATED ON THIS PAGE
 ARE FOR HEADSTOCK UNIT CODES
 VSH100TT, VSH101TT, VSH102TT, VSH103TT

Serial no. of lathe and unit code
 no. must accompany order.

14" HEADSTOCK

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	234 x 3	Tubing	1
2	PT8601-1	Bushing	2
3	PT8602-1	Sleeve	2
4	PT8603-1	Header	1
5	PT8599-2	Check valve	2
6	PT8598TT2	Plunger	1
7	162 x 66	Spring	1
8	*AS8597TT2	Pump assy. (4 thru 8)	1
9	PT8870TT1	Elbow	1
10	PA8587TT1	Gear (with PT8588-1 bearing)	1
11	165 x 802	Retaining ring	1
12	PT8584TT1	Shaft	1
13	PT8589TT1	Gear	1
14	PT8591TT1	Shifter	1
15	PT8585TT1	Shaft for VSH100TT	1
15	PT8585TT2	Shaft for VSH101TT, VSH102TT, VSH103TT	1
16	PT8586-6	Bearing	1
17	139 x 31	Hex nut 1/2-13	1
18	PT7518M1	Key	1
19	PT612T124	Gear for standard lathe	1
19	PT2291T1	Gear for Metric lathe only	1
20	PT8596TT1	Spacer	1
21	165 x 306	Retaining ring	1
22	653093	Bearing	1
23	114 x 114	Soc hd cap screw 5/16-18 x 7/8	3
24	*PA8582TT1	Housing (with PT8583-1 bearing)	1
25	PT8590TT1	Shaft	1
26	165 x 1100	Retaining ring	1
27	PX4891S1	Clamp	1
28	132 x 1103	Self tapping screw #6-32 x 3/8	1
29	134 x 4	Tubing	1

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ARE IN PARANTHESIS AFTER PART NAME



Serial no. of lathe and unit code no. must accompany order

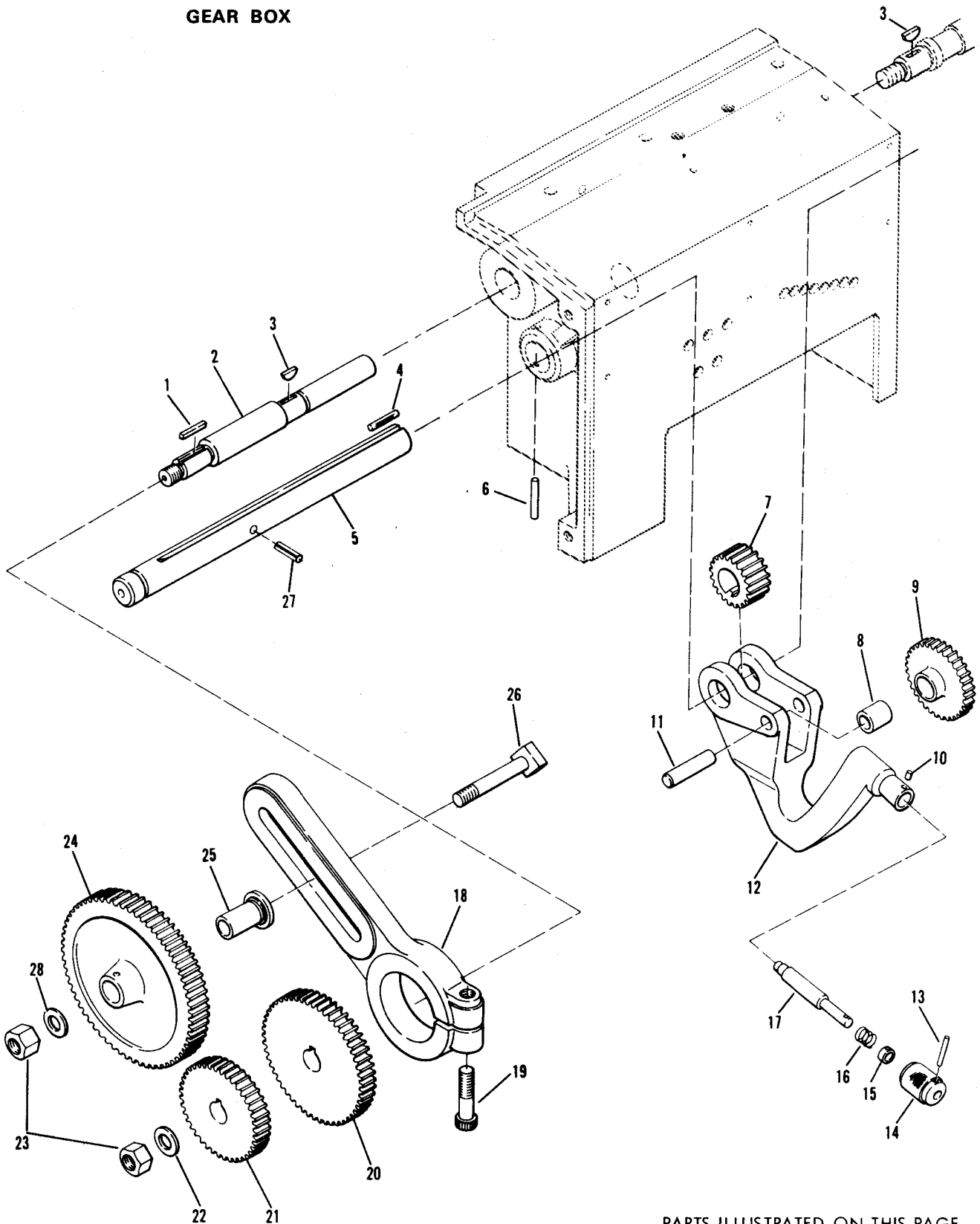
PARTS ILLUSTRATED ON THIS PAGE ARE FOR GEAR BOX CODE DTG101TT, DTG102TT

14" GEAR BOX DTG101TT, DTG102TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
	DTG102TT	Complete Gear Box Assy.	1
1	*AS625T1	Compound gear assy (2,3,4)	1
2	160 x 19	Straight Pin 1/8 x 3/8	2
3	PT626T1	Gear - Order Item 1	1
4	PT625T1	Gear Order Item 1	1
5	*AS619T2	Compound gear assy (6,7,8,9)	3
6	PT626T1	Gear - Order Item 5	3
7	160 x 19	Straight Pin 1/8 x 3/8	6
8	PT686T1	Bushing	3
9	PT619T2	Gear - Order Item 5	3
10	PT606T3	Bushing	1
11	160 x 33	Straight Pin 1/8 x 1 - 1/4	1
12	PT604T2	Collar	1
13	168 x 212	Taper Pin	1
14	PT1055T1	Nut	1
15	PT3235T1	Lead Screw Gear	1
16	PT3240TH1	Bearing	1
17	116 x 610	Screw	2
18	155 x 14	Oiler	3
19	256 x 8	Oil Wick	5
20	169 x 4	Straight Pin .2605 x 5/16	4
21	256 x 8	Oil Wick	5
22	155 x 18	Oiler	1
23	PT661T1	Bearing	1
24	256 x 1	Oil Wick	2
25	PT599T1	Key	1
26	*AS614T3	Shaft (24,25)	1
27	PX2380-1	Bushing	3
28	PX2381-1	Bushing	1
29	PX2379-1	Bushing	2
30	*PA8623TT2	Gear Box Housing, Not available Separately	1
31	114 x 116	Soc Hd Cap Screw 5/16 - 18 x 1	3
32	114 x 124	Soc Hd Cap Screw 5/16 - 18 x 1-1/2	1
33	114 x 110	Soc Hd Cap Screw 5/16-18 x 5/8	2
34	160 x 19	Straight Pin 1/8 x 3/8	2
35	PT8660TT3	Guide Bar	1
36	*AS8661TT3	Feed And Lube Plate (37)	1
37	132 x 1101	Self Tapping Screw	6
38	PT686T1	Bushing	1
39	*PA624T2	Gear (38)	1
40	168 x 312	Taper Pin	1
41	PT615T216	Cone Gear	1
42	PT615T218	Cone Gear	1
43	PT615 T220	Cone Gear	1
44	PT615T222	Cone Gear	1
45	PT615T223	Cone Gear	1
46	PT615T224	Cone Gear	1
47	PT615T226	Cone Gear	1
48	PT615T228	Cone Gear	1
49	160 x 257	Straight Pin 5/32 x 2-1/8	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

GEAR BOX



PARTS ILLUSTRATED ON THIS PAGE
ARE FOR GEAR BOX CODE
DTG101TT, DTG102TT

Serial no. of lathe and unit code
no. must accompany order

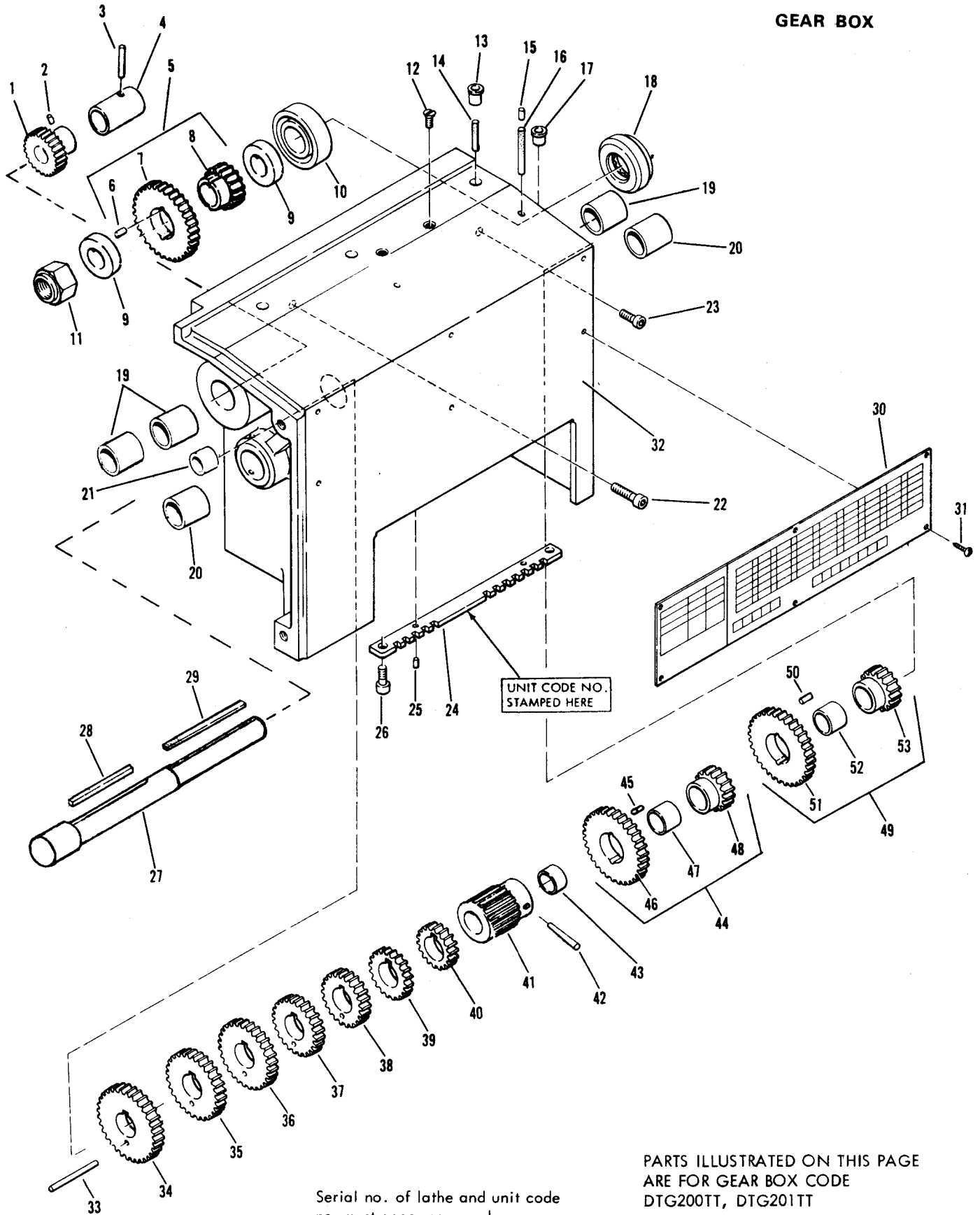
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" GEAR BOX DTG101TT and DTG102TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	161 x 21	Square key (used on DTG101TT) used on a *AS603T2 shaft	1
1	106 x 605	Woodruff key (used on DTG102TT) used on a *AS603T3 shaft	1
2	*AS603T2	Main drive shaft (used on DTG101TT) (1,3,22,23)	1
2	*AS603T3	Main drive shaft (used on DTG102TT) (1,3,22,23)	1
3	PT2077	Woodruff key (used on DTG101TT)	2
3	106 x 405	Woodruff key (used on DTG102TT)	2
4	256 x 3	Oil wick	2
5	PT620T1	Tumbler shaft	1
6	159 x 197	Straight pin 3/16 x 1.75	1
7	PT621T1	Main drive gear	2
8	PT384FH1	Needle bearing	2
9	*AS605T3	Tumbler Idler gear assy. (8)	2
10	160 x 42	Straight pin 1/8 x 5/32	2
11	160 x 253	Straight pin 1/2 x 15/16	2
12	*AS8665TT2	Tumbler assy. (8,9,10,13,14,15,16,17)	2
13	160 x 29	Straight pin 1/8 x 1	2
14	PT88F2	Knob	2
15	PT610TH2	Bushing	2
16	162 x 26	Spring	2
17	*AS608T3	Plunger assy. (13,16)	2
18	PT8636TT2	End gearing brkt	1
19	114 x 328	Screw 7/16-14 x 1.75	1
20	PT3237T1	Lead screw gear 64 teeth	1
21	PT612K48T1	Stud gear	1
22	161 x 30	Washer	1
23	PT1071-3	Hex nut	2
24	PT33T2	Idler gear 80 teeth	1
25	PT8635TT1	Bushing	1
26	*AS247T1	Bolt (23,28)	1
27	159 x 10	Roll pin 1/8 x 1.25	1
28	161 x 26	Washer	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

Metric
GEAR BOX



Serial no. of lathe and unit code
no. must accompany order.

PARTS ILLUSTRATED ON THIS PAGE
ARE FOR GEAR BOX CODE
DTG200TT, DTG201TT

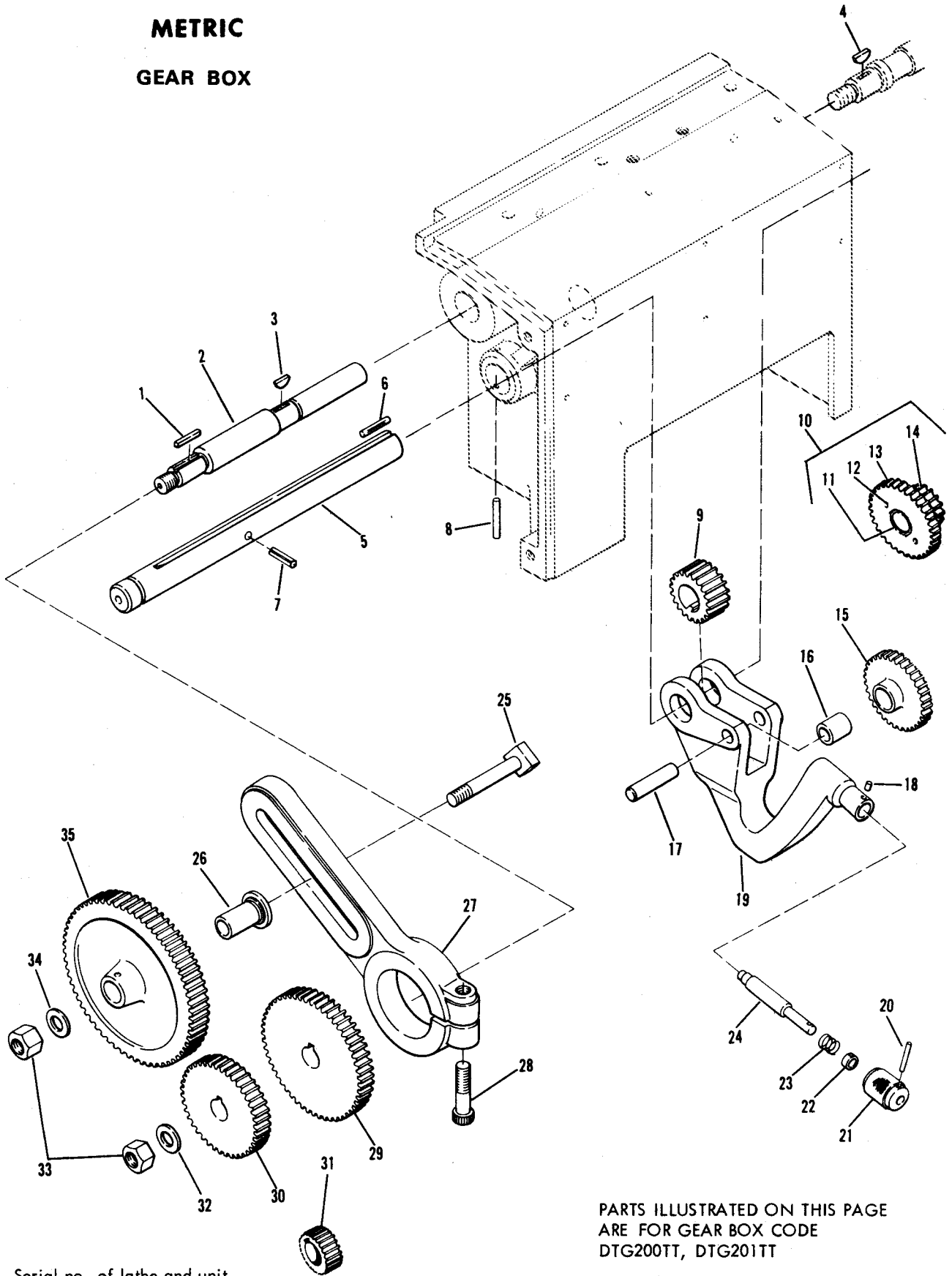
SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

METRIC GEAR BOX DTG200TT, DTG201TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	PT2257T1	Gear	1
2	159 x 4	Roll Pin 3/16 x 1 - 1/8	1
3	159 x 10	Roll Pin 1/8 x 1 - 1/4	1
4	PT606T3	Bushing	1
5	*PA2258T1	Lead Screw Gear Assy (6,7,8)	1
6	160 x 19	Straight Pin 1/8 x 3/4	2
7	PT2258T1	Gear - Order Item 5	1
8	PT2259T1	Gear - Order Item 5	1
9	PT2276T1	Spacer	2
10	PT3240TH1	Bearing	1
11	PT1055T1	Elastic Nut	1
12	116 x 610	Screw	2
13	155 x 14	Oiler	3
14	256 x 8	Oil Wick	5
15	169 x 4	Straight Pin .2605 x 5/16	4
16	256 x 8	Wick	5
17	155 x 18	Oiler	1
18	PT661T1	Bearing	1
19	PX2380-1	Bushing	3
20	PX2379-1	Bushing	2
21	PX2381-1	Bushing	1
22	114 x 124	Soc Hd Set Screw 5/16-18 x 1-1/2	1
23	114 x 116	Soc Hd Cap Screw 5/16-18 x 1	3
24	PT3538TT1	Guide Bar	1
25	160 x 19	Straight Pin 1/8 x 3/8	2
26	114 x 110	Soc Hd Cap Screw 5/16 - 18 x 5/8	2
27	*AS614T3	Shaft (28,29)	1
28	PT599T1	Key	1
29	256 x 1	Oil Wick	2
30	*AS3539TT1	Feed Selector and Lube Plate (31)	1
31	132 x 1101	Self Tapping Screw	6
32	*PA3536TT1	Gear Box Housing, Not Available Separately	1
33	160 x 257	Straight Pin 5/32 x 2 -1/8	1
34	PT2254T130	Cone Gear	1
35	PT615T228	Cone Gear	1
36	PT615T226	Cone Gear	1
37	PT615T224	Cone Gear	1
38	PT615T222	Cone Gear	1
39	PT615T220	Cone Gear	1
40	PT615T218	Cone Gear	1
41	PT615T216	Cone Gear	1
42	168 x 312	Taper Pin #2 x 1-1/2	1
43	PT2778TT1	Spacer	1
44	*PA2262T2	Gear Assy (45,46,47,48)	1
45	160 x 19	Straight Pin 1/8 x 3/8	2
46	PT626T1	Gear - Order Item 44	1
47	PT686T1	Bushing	1
48	PT2262T2	Gear - Order Item 44	1
49	*PA619T2	Gear Assy (50,51,52,53)	1
50	160 x 19	Straight Pin 1/8 x 3/8	2
51	PT626T1	Gear-Order Item 49	1
52	PT686T1	Bushing	1
53	PT619T1	Gear - Order Item 49	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

METRIC
GEAR BOX



PARTS ILLUSTRATED ON THIS PAGE
ARE FOR GEAR BOX CODE
DTG200TT, DTG201TT

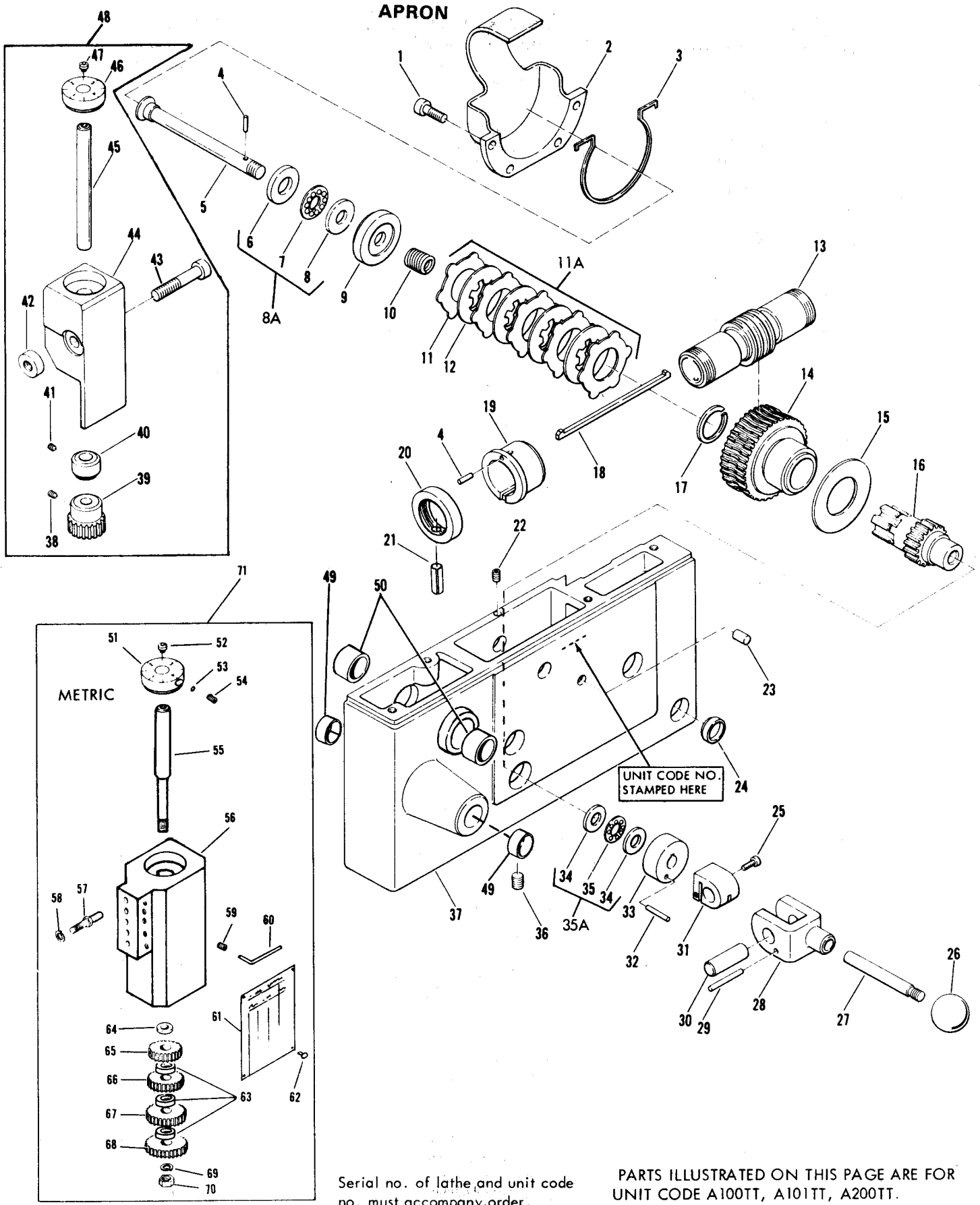
Serial no. of lathe and unit
code no. must accompany order.

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" METRIC GEAR BOX

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
1	164 x 12	Square key (used on DTG200TT)	1
1	106 x 605	Woodruff key (used on DTG201TT)	1
2	*AS603T2	Main drive shaft (1, 3, 32, 33) (used on DTG200TT)	1
2	*AS2266T2	Main drive shaft (1, 3, 32, 33) (used on DTG201TT)	1
3	PT2077	Woodruff key (used on DTG200TT)	2
3	106 x 405	Woodruff key (used on DTG201TT)	2
4	PT2077	Key	1
5	PT620T1	Tumbler shaft	1
6	256 x 3	Oil wick	2
7	159 x 10	Roll pin 1/8 x 1.25	1
8	159 x 197	Straight pin 3/16 x 1.75	1
9	PT621T1	Main drive gear	2
10	*PA2261T1	Compound tumbler gear assy. (11, 12, 13, 14) Right Hand	1
11	PT384FH1	Needle bearing	1
12	160 x 19	Straight pin 1/8 x 3/8	2
13	PT626T1	Gear- order item 10	1
14	PT2261T1	Gear- order item 10	1
15	PT605T3	Tumbler idler gear Left Hand	1
16	PT384FH1	Needle bearing	1
17	160 x 253	Straight pin 1/2 x 15/16	2
18	160 x 42	Straight pin 1/8 x 5/32	2
19	*AS8665T2	Tumbler assy. L.H. (15, 16, 18, 20, 21, 22, 23, 24)	2
19	*AS2261T1	Tumbler assy. R.H. (*10, 18, 20, 21, 22, 23, 24)	1
20	160 x 29	Straight pin 1/8 x 1	2
21	PT88TF2	Knob	2
22	PT610TH2	Bushing	2
23	162 x 26	Spring	2
24	PT608T3	Plunger	2
25	*AS247T1	Bolt (33, 34)	1
26	PT8635TT1	Bushing	1
27	PT8636TT2	Bracket	1
28	114 x 328	Soc hd cap screw 7/16-14 x 1.75	1
29	PT2279T1	Lead screw gear 60 teeth	1
30	PT2292T1	Stud gear 50 teeth	1
31	PT2291T1	Stud gear 20 teeth	1
32	161 x 30	Washer	1
33	PT1071-1	Hex nut	2
34	161 x 26	Washer	1
35	PT2277	Idler gear 100 teeth	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME



Serial no. of lathe and unit code no. must accompany order.

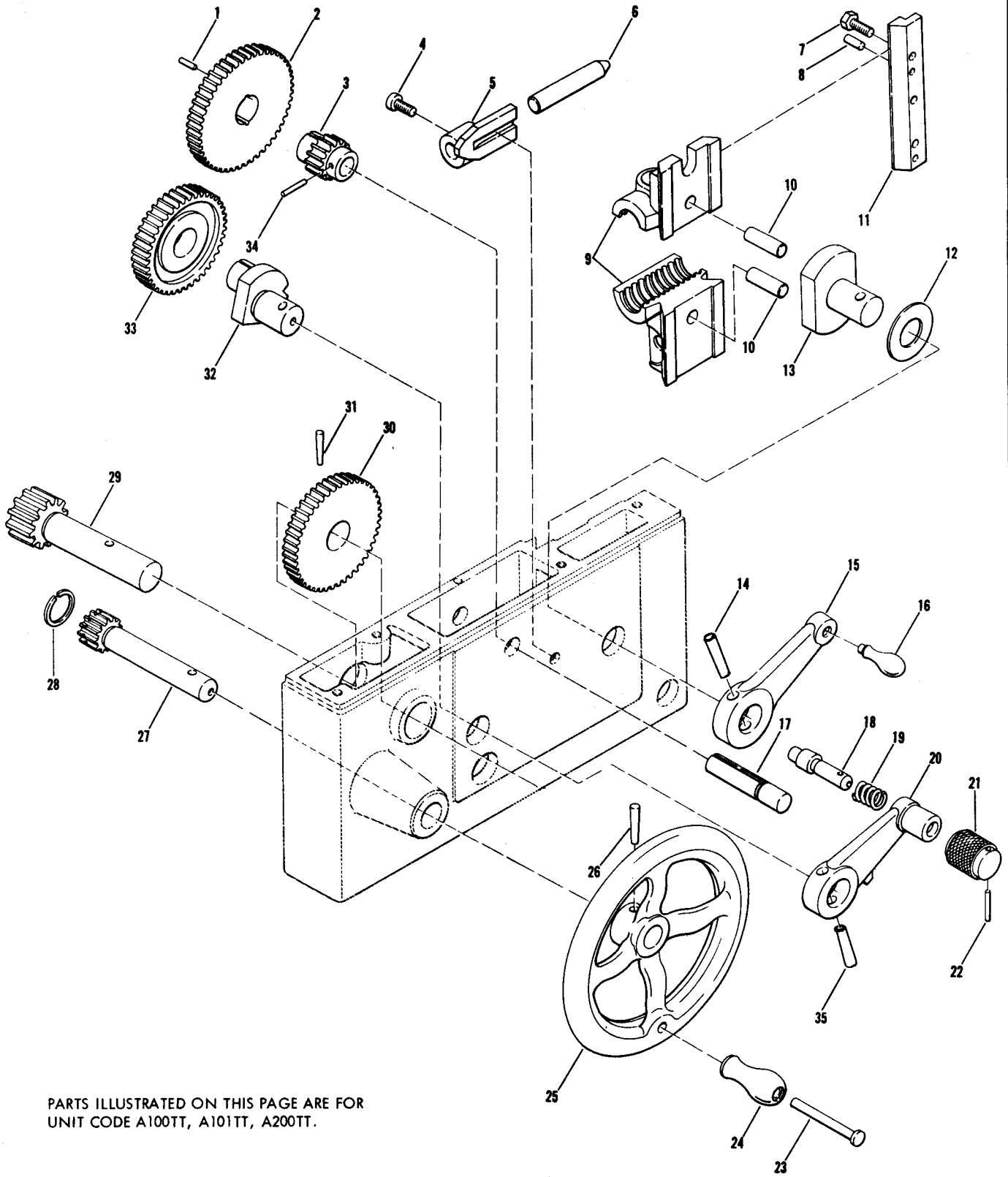
PARTS ILLUSTRATED ON THIS PAGE ARE FOR UNIT CODE A100TT, A101TT, A200TT.

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	114 x 110	Soc Hd. Cap Screw 5/16-18 x 5/8	4
2	PT8701TT1	Trough	1
3	256X1	Felt Oil Wick	1
4	160 x 21	Straight Pin 1/8 x 1/2	1
5	PT8707TT2	Clutch Draw Bar	1
6	PT4629RHI	Race	1
7	PS841H2	Bearing Assy.	1
8	PT840H2	Race	1
8A	*ASA4629RHI	Bearing Assy (6,7,8)	1
9	PT4628TF1	Plate	1
10	162 x 15	Coil Spring	1
11	PT411TF1	Outside Clutch Plate	5
11A	*AS410TF1	Clutch Plate Set	1
12	PT410TF1	Inside Clutch Plate	4
13	PT203T2	Worm	1
14	PT77T1	Worm Gear	1
15	161 x 60	Washer	1
16	PT4620T1	Clutch Sleeve	1
16A	*AXS4620TT1	Complete Clutch Assy. (4,5, 8A,9,10,11A,14,15,16,17,25,26,27,28,29,30,31,32,33,35A)	1
17	PT408TF1	Lock Ring	1
18	PT239T1	Worm Key	1
19	PT79T1	Worm Bushing	2
20	PT208T1	Worm Collar	2
21	159 x 21	Roll Pin	2
22	120 x 6	Set Screw 1/4-20 x 3/8	1
23	PT1811	Straight Pin	1
24	PT7569-1	Vision Window	1
25	114 x 708	Soc Hd Cap Screw 8-32 x 1/2	1
26	PT406KFH1	Knob	1
27	PT4624TH1	Handle	1
28	PT4622RH1	Cam	1
29	160 x 33	Straight Pin 1/8 x 1-1/4	1
30	160 x 252	Straight Pin 1/2 x 1-1/2	1
31	*AS4623TH1	Nut (25)	1
32	159 x 12	Roll Pin 1/8 x 5/8	1
33	PT8689TT2	Plate	1
34	PT840T2	Race	2
35	PS841T2	Bearing	1
35A	*AS841T2	Bearing Assy (34,35)	1
36	152 x 73	Plug 1/8-27 NPT	1
37	PA8670TT2	Apron	1
38	120 x 6	Hol Hd Cup Pt Set Screw 1/4-20 x 3/8	1
39	PT887TH1	Worm Wheel	1
40	PT7458M1	Collar	1
41	120 x 4	Hol Hd Cup Pt Set Screw 1/4-20 x 1/4	1
42	PT890TH1	Spacer	1
43	114 x 236	Soc Hd Cap Screw 3/8-16 x 2-1/4	1
44	PT886TH2	Frame	1
45	PT6617GJ3	Indicator Shaft	1
46	PT6618GJ1	Indicator Dial	1
47	155 x 16	Oiler	1
48	CL810TH	Thread Indicator, English, Complete, THD10TH	1
49	PT8731TT1	Oilite Bearing	2
50	PT8693TT1	Oilite Bearing	2
51	*AS2281TH1	Metric Indicator Dial (53,54)	1
52	155 x 16	Oiler	1
53	PT1078RH1	Shoe	1
54	120 x 6	Set Screw 1/4-20 x 3/8	1
55	*AS2282TH1	Indicator Shaft (52)	1
56	PT2280TH1	Frame	1
57	PT2284TH1	Mounting Stud	1
58	161 x 64	Lock Washer	1
59	120 x 108	Set Screw 5/16 - 18 x 1/2	5
60	173 x 7	Wrench	1
61	*AS2286TH1	Metric Thread Dial Chart (62)	1
62	130 x 103	Drive Screw	4
63	PT2283TH1	Spacer	3
64	PT2296TH1	Spacer	1
65	PT2285K39TH1	Worm Wheel 39 Teeth	1
66	PT2285K42TH	Worm Wheel 42 Teeth	1
67	PT2285K44TH1	Worm Wheel 44 Teeth	1
68	PT2285K45TH1	Worm Wheel 45 Teeth	1
69	180 x 302	Lock Washer	1
70	139 x 27	Hex Jam Nut 3/8-16	1
71	CL2265TH	Metric Thread Indicator Complete THD200TT	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

APRON



PARTS ILLUSTRATED ON THIS PAGE ARE FOR
UNIT CODE A100TT, A101TT, A200TT.

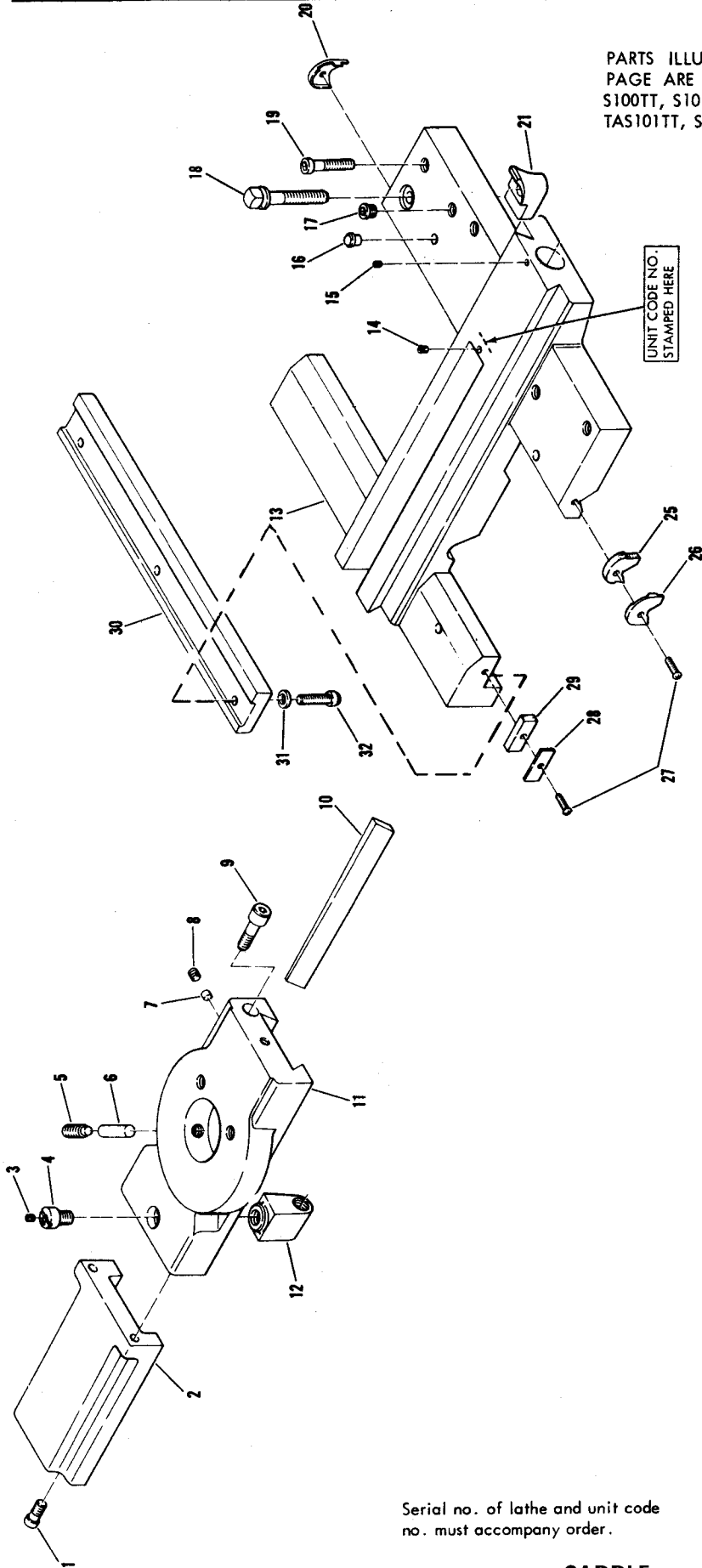
Serial no. of lathe and unit code
no. must accompany order.

APRON A100TT, A101TT, A200TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	160 x 21	Straight Pin 1/8 x 1/2	2
2	PT85T1	C. F. Compound Gear	1
3	*AS87T1	C. F. Compound Pinion Gear Assy. (1,2,3,4)	1
4	114 x 108	Soc. Hd. Cap Screw 5/16-18 x 1/2	1
5	PT98T1	Plunger Arm	1
6	PT97T1	Plunger	1
7	112 x 114	Hex Hd. Cap Screw 5/16-18 x 7/8	1
8	160 x 77	Straigh Pin 1/4 x 11/16	2
9	*AS72T1	Half Nut English (10) 1 x 6TPI Acme R. H.	1
9	*PA2236T1	Half Nut Metric (10) 4 MM Thread	1
10	PT172RT1	Pin	2
11	PT73T1	Gib	1
12	PT75TF1	Washer	1
13	PT74T1	Half Nut Cam	1
14	159 x 7	Roll Pin 5/16 x 1 3/4 (Used on Lathes Mfg in 1969 and 1970)	
14	168 x 516	Taper Pin (Used on Lathes Mfg from 1970)	1
15	*AS407TF1	Lever (14, 15)	1
16	PT1481	Handle	1
17	PT231T1	Shaft	1
18	PT89TF1	Plunger	1
19	162 x 28	Coil Spring	1
20	PT84TF1	Lever	1
21	*AS88TF2	Knob (18, 19, 22)	1
22	160 x 29	Straight Pin 1/8 x 1	1
23	PT1244	Stud	1
24	PT1494	Handle	1
25	*AS1263TF1	Handlewheel (23, 24)	1
26	168 x 412	Taper Pin	1
27	PT225T1	Handwheel Pinion	1
28	PT409T1	Spring	1
29	PT204T1	Rack Pinion	1
30	*AS76T1	Rack Pinion Gear (29, 31)	1
31	168 x 514	Taper Pin	1
32	PT83T1	Shifter	1
33	PT86T1	Idler Gear	1
34	160 x 25	Straight Pin 1/8 x 3/4	1
35	159 x 7	Roll Pin 5/16 x 1 3/4 (Used on Lathes Mfg in 1969 and 1970)	
35	168 x 414	Taper Pin (Used on Lathes Mfg From 1970)	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

PARTS ILLUSTRATED ON THIS PAGE ARE FOR SADDLE CODE S100TT, S101TT, TAS100TT, TAS101TT, S200TT.

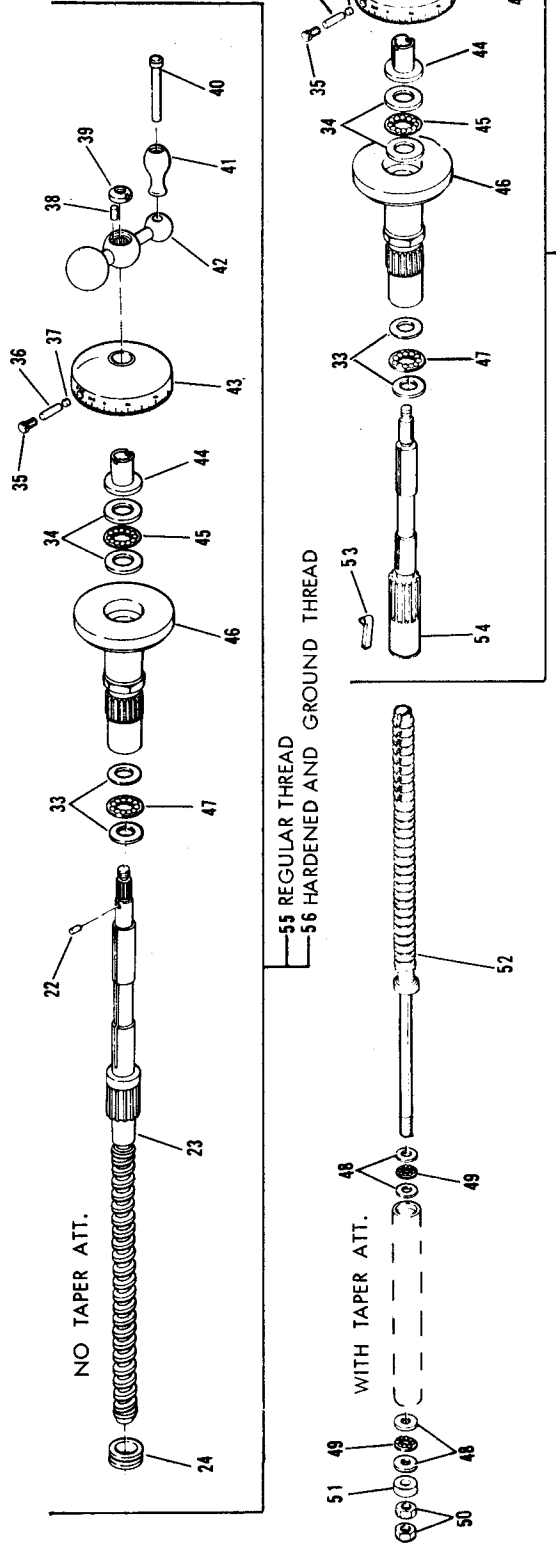


UNIT CODE NO. STAMPED HERE

Serial no. of lathe and unit code no. must accompany order.

SADDLE

SOUTH BEND LATHE



NO TAPER ATT.

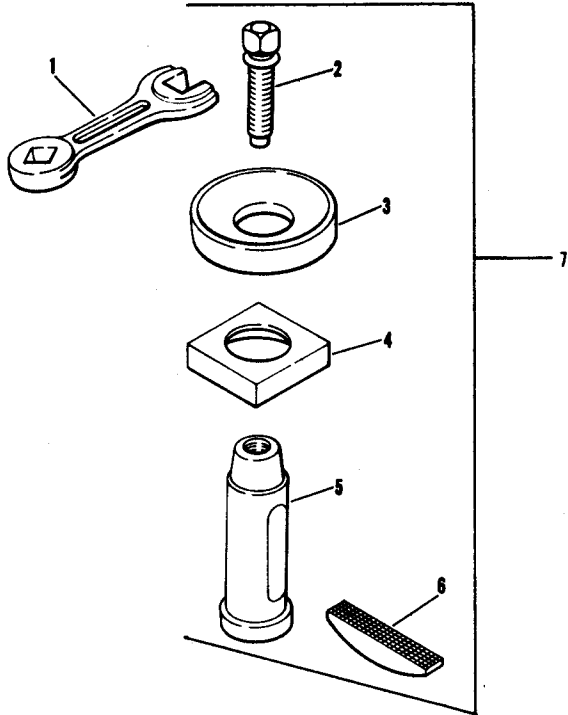
55 REGULAR THREAD
56 HARDENED AND GROUND THREAD

WITH TAPER ATT.

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	114 x 112	Soc Hd Cap Screw 5/16 - 18 x 3/8	2
2	PT8613T1	Chip Guard For Lathes w/o Taper Att.	1
3	120 x 4	Hol Hd Cup Pt Screw 1/4-20 x 1/4	1
4	*AS66T2	C. F. Nut Screw Assy (3)	1
5	121 x 412	Dog Pt Set Screw 1/2-13 x 3/4	2
6	PT211T1	Shoe	2
7	PT1077TH1	Shoe	1
8	120 x 5	Hol Hd Set Screw 1/4-20 x 5/16	1
9	PT219TH1	Gib Screw	1
10	PT221T1	Cross Slide Gib	1
11	*PA8617TT1	Compound Rest Base Assy (7,8,9,10)	1
12	PT8610TT1	Cross Feed Nut 5/8-8 Acme L. H.	1
12	PT3546TT1	Cross Feed Nut Metric 5/8-3 MM L. H.	1
13	PT8616TT1	Saddle	1
14	120 x 904	Hol Hd. Cup Pt Set Screw 10-32 x 1/4	1
15	120 x 903	Hol Hd Cup Pt Set Screw 10-32 x 3/16	1
16	155 x 14	Oiler	3
17	152 x 69	Pipe Plug 1/4-18 NPT	1
18	PT210T1	Saddle Lock Screw	1
19	114 x 124	Soc Hd Cap Screw 5/16-18 x 1 1/2	4
20	PT57T1	Retainer	1
21	PT8614TT2	Saddle Lock	1
22	160 x 268	Straight Pin .1250/.1245 x 5/16	1
23	PT224T4	Cross Feed Screw w/o taper Att. regular	1
23	PT6825T1	Cross Feed Screw w/o taper Att. Hardened and Ground	1
23	PT2230T3	Metric Cross Feed Screw w/o Taper Att.	1
23	PT6827T1	Metric Cross Feed Screw w/o Taper Att. Hardened and Grd.	1
24	PT419T1	Collar	1
25	PT59T1	Wiper	2
26	PT58T1	Retainer	1
27	132 x 1104	Screw 6-32 x 1/2	4
28	PT8611T2	Retainer	2
29	PT8612TT2	Wiper	2
30	PT61T1	Saddle Rear Gib	1
31	182 x 301	Washer	3
32	114 x 120	Soc Hd Cap Screw	3
33	PT840T2	Race	2
34	PT840H2	Race	2
35	PT1857	Thumb Screw	1
36	160 x 26	Straight Pin 1/8 x 13/16	1
37	PT1080NK1	Shoe	1
38	160 x 19	Straight Pin 1/8 x 3/8	1
39	PT295T1	Nut	1
40	PT1242	Stud	1
41	PT1492	Handle	1
42	*AS1264T1	Crank Assy. (40,41)	1
43	PT1266TH2	Inch Graduated Collar	1
43	PT2232TH4	Metric Graduated Collar Used Only with Metric Cross Feed	1
44	PT69TH1	Sleeve	1
45	*AS841H2	Bearing Assy (34)	1
46	PT63T3	Bushing	1
47	*AS841T2	Bearing Assy (33)	1
48	PT840T2	Bearing Race	4
49	*AS841R1	Bearing Assy (48)	2
50	139 x 27	Hex Jam Nut	2
51	PT866TF2	Collar	1
52	*AS6827TT2	Rear Taper Att. Cross Feed Screw Assy. (Hardened and Ground available only on Taper Att.) (*12, 48, 49, 50, 51) English Threads.	1
52	*AS2230T3	Metric Rear Taper Att. Cross Feed Screw Assy (Hardened and Ground available only on Taper Att. (*12, 48, 49, 50, 51)	1
53	PT484T1	Key	1
54	PT482T3	Front T. A. Cross Feed Screw	1
55	*ASD8604TT2	Complete Cross Feed Screw Assy with Regular Threads English Graduations, for Lathes without Taper Att. Includes All Parts Bracketed Plus Item 12	1
56	*ASD6825TT1	Complete Cross Feed Screw Assy. with Hardened and Ground Threads, English Graduations, For Lathes without Taper Att. Includes All Parts Bracketed Plus Item 12.	1
57	*ASD482TT3	Front Taper Att. Cross Feed Screw Assy. With Inch English Graduations, Includes All Parts Bracketed	1

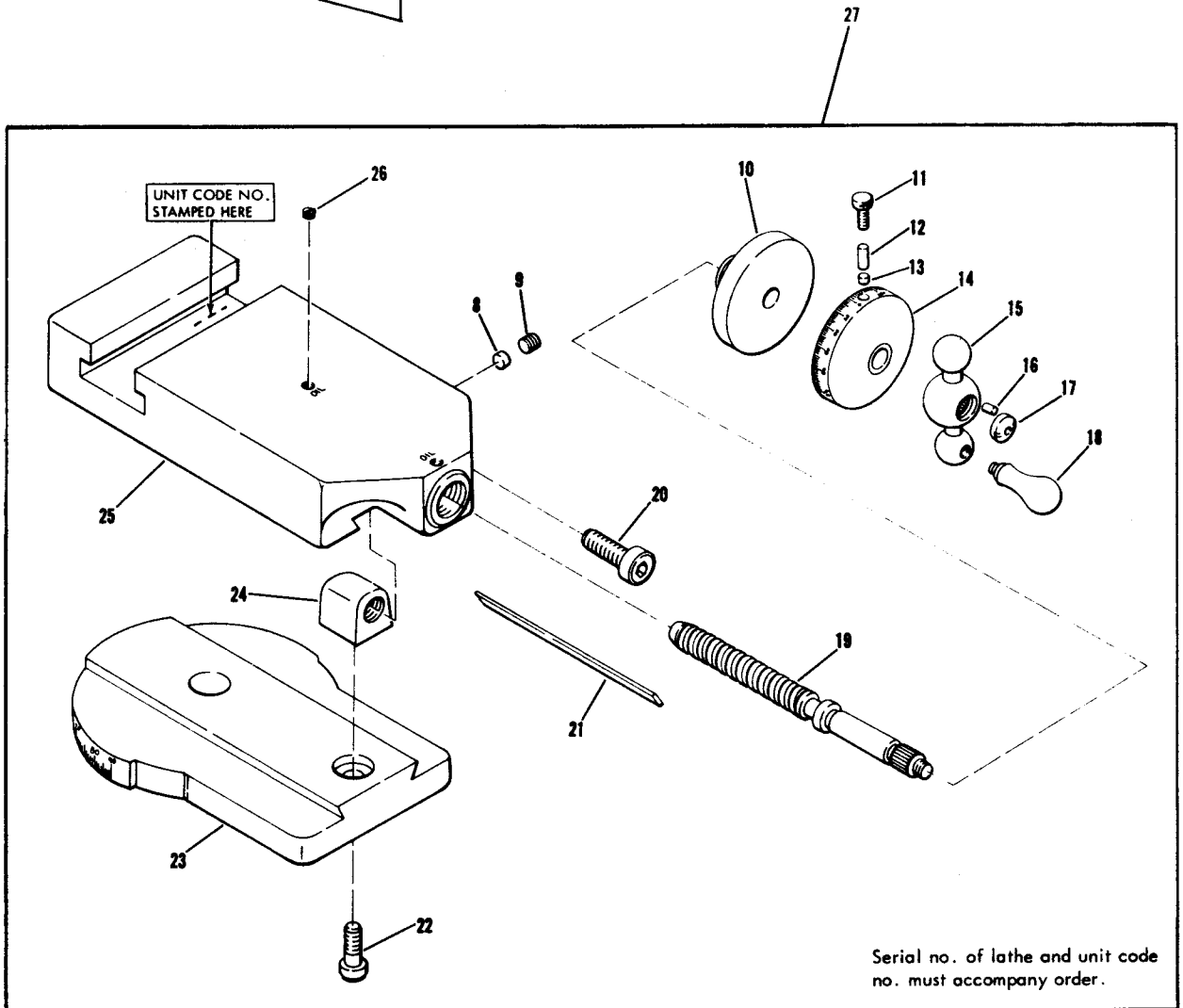
*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621



COMPOUND REST

PARTS ILLUSTRATED ON THIS PAGE
ARE FOR COMP. REST CODES:
C101TT, C101TTG, C200TT



Serial no. of lathe and unit code
no. must accompany order.

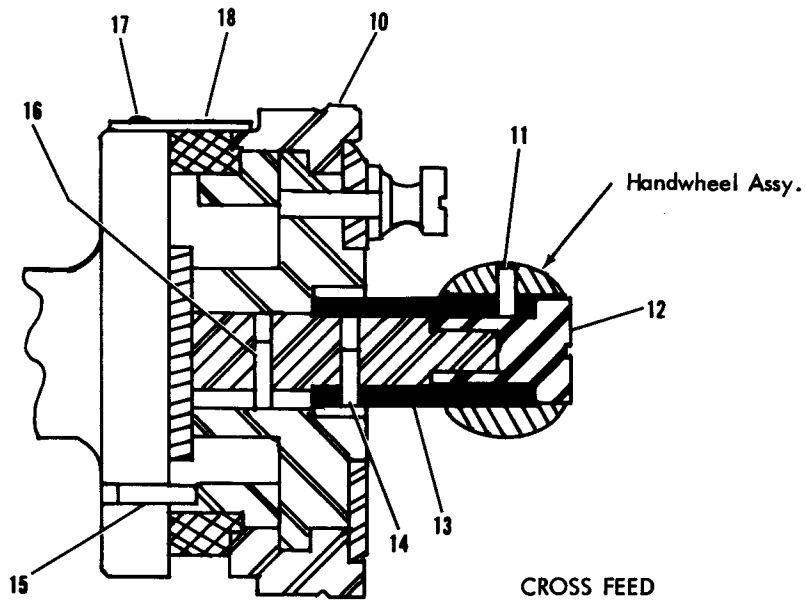
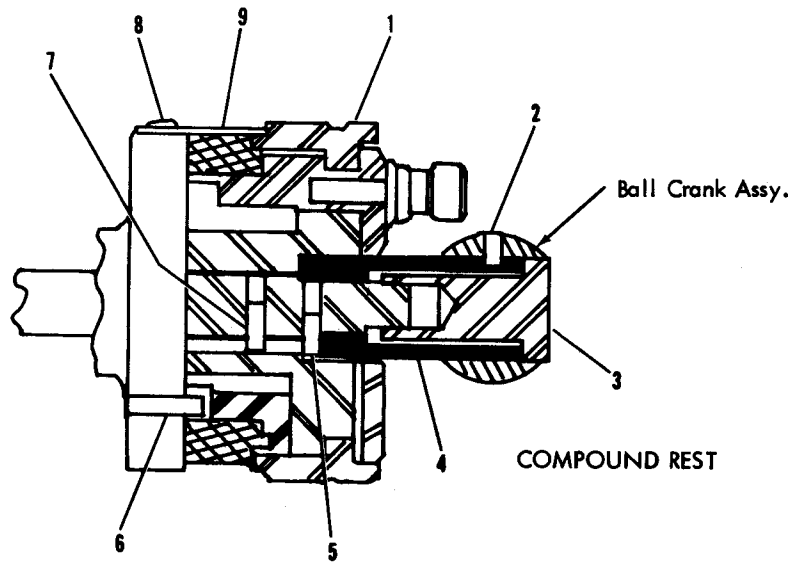
SOUTH BEND LATHE

14" COMPOUND REST C101TT C101TTG C200TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
1	PT253T1	Wrench	1
2	PT233T2	Tool post screw	1
3	PT251T1	Tool post ring	1
4	PT209T1	Tool post block	1
5	PT250T2	Tool post	1
6	PT252T2	Tool post wedge	1
7	CE2450T	Tool post assy. TPL100T, all parts bracketed	1
8	PT1077TH1	Shoe	1
9	120 x 5	Hol hd cup pt set screw 1/4-20x 5/16	1
10	PT94T2	Bushing	1
11	PT1857	Thumb screw	1
12	160 x 21	Straight pin 1/8 x 1/2	1
13	PT1080NK1	Shoe	1
14	PT1269TH1	Graduated collar, English	1
14	PT2235TH3	Graduated collar, Metric	1
15	*AS277TH1	Crank (18)	1
16	160 x 17	Straight pin 1/8 x 1/4	1
17	PT295T1	Nut	1
18	PT1481	Handle	1
19	*ASD230T3	Comp. rest screw assy. Regular (10 thru 19,22 and 24)	1
19	*ASD6824T1	Comp rest screw assy. H & G (10 thru 19,22 and 24)	1
19	*AS2233T2	Comp rest screw assy. Metric (10 thru 19, 22 and 24)	1
20	PT219TH1	Gib screw	1
21	PT257T1	Comp. rest gib	1
22	114 x 114	Soc hd cap screw 5/16-18 x 7/8	1
23	PT8619TT1	Comp rest swivel	1
24	PT95T1	Compound rest nut, English thread 1/2-10 ACME R. H.	1
24	PT2234T1	Compound rest nut, Metric thread 3MM, R. H.	1
25	*AS8618TT1	Comp. rest top (8,9,20,26)	1
26	120 x 903	Hol hd cup pt set screw 10-32 x 3/16	2
27	C101TT	Compound Rest assy. complete w/regular screw	1
27	C101TTG	Compound Rest assy. complete w/H & G screw	1
27	C200TT	Compound Rest assy. complete w/metric screw	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME

INCH - METRIC DIALS



Serial No. of Lathe Must accompany order.

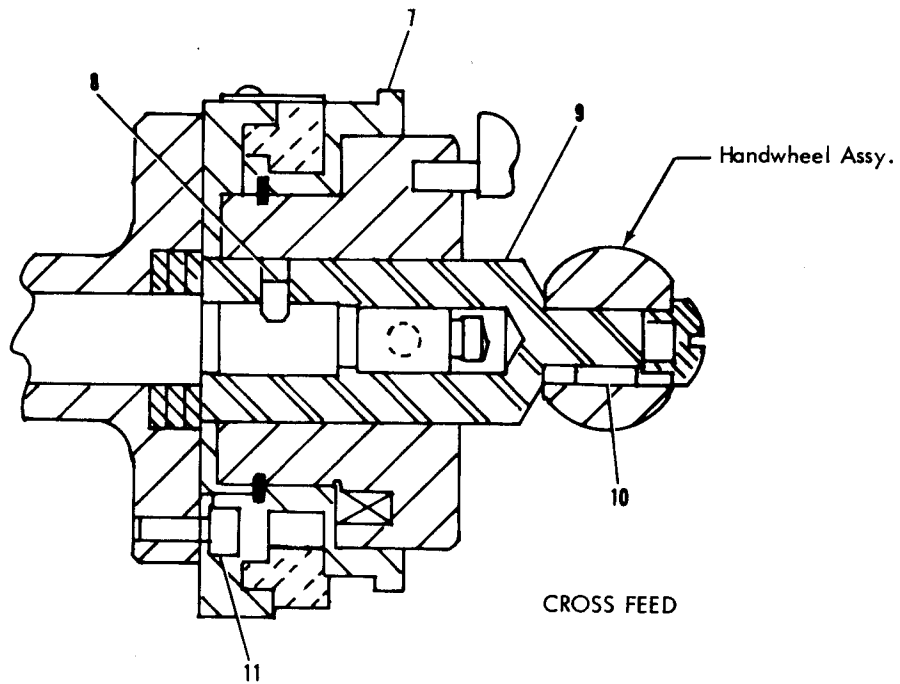
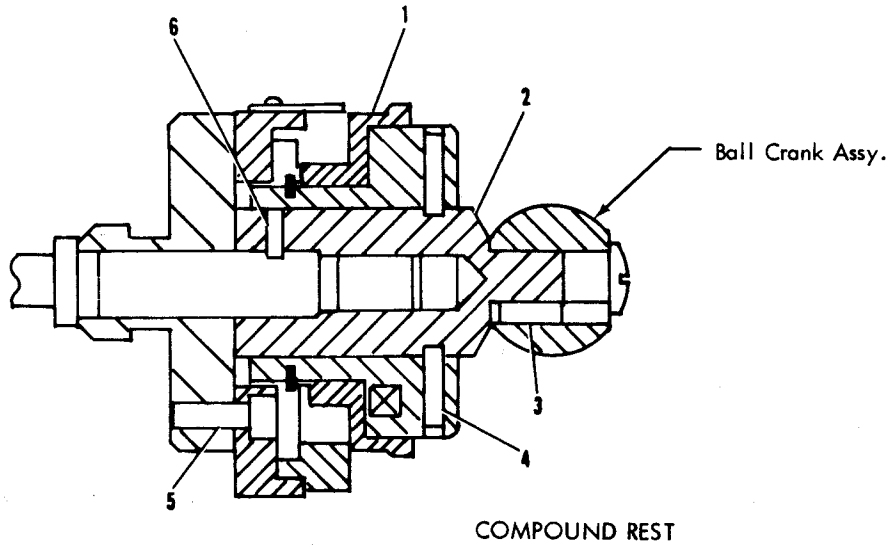
PARTS ILLUSTRATED ON THIS PAGE WERE USED FROM 1969 TO 1979

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

INCH-METRIC DIALS used prior to July 1979

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
1	CI2542T	COMPOUND Inch-Metric Dial Assy. PA4051T1	1
2	159 x 28	Roll pin 1/8 x 1/4	1
3	PT4052T1	Adapter nut	1
4	PT4051T1	Extension Sleeve	1
5	159 x 43	Roll Pin 3/32 x 5/16	1
6	160 x 21	Straight pin 1/8 x 1/2	1
7	159 x 37	Roll pin 1/8 x 5/16	1
8	130 x 103	Drive screw #4 x 3/16	2
9	PT4055T1	Dial plate	1
10	CL2541T	CROSS FEED Inch-Metric Dial Assy. PA4048T1	1
11	159 x 37	Roll pin 1/8 x 5/16	1
12	PT4048T1	Adapter nut	1
13	PT4049T1	Sleeve	1
14	159 x 43	Roll pin 3/32 x 5/16	1
15	160 x 21	Straight pin	1
16	159 x 37	Roll pin 1/8 x 5/16	1
17	130 x 103	Drive screw #4 x 3/16	2
18	PT4054T1	Dial plate	1

INCH - METRIC DIALS



Serial No. of Lathe Must accompany order.

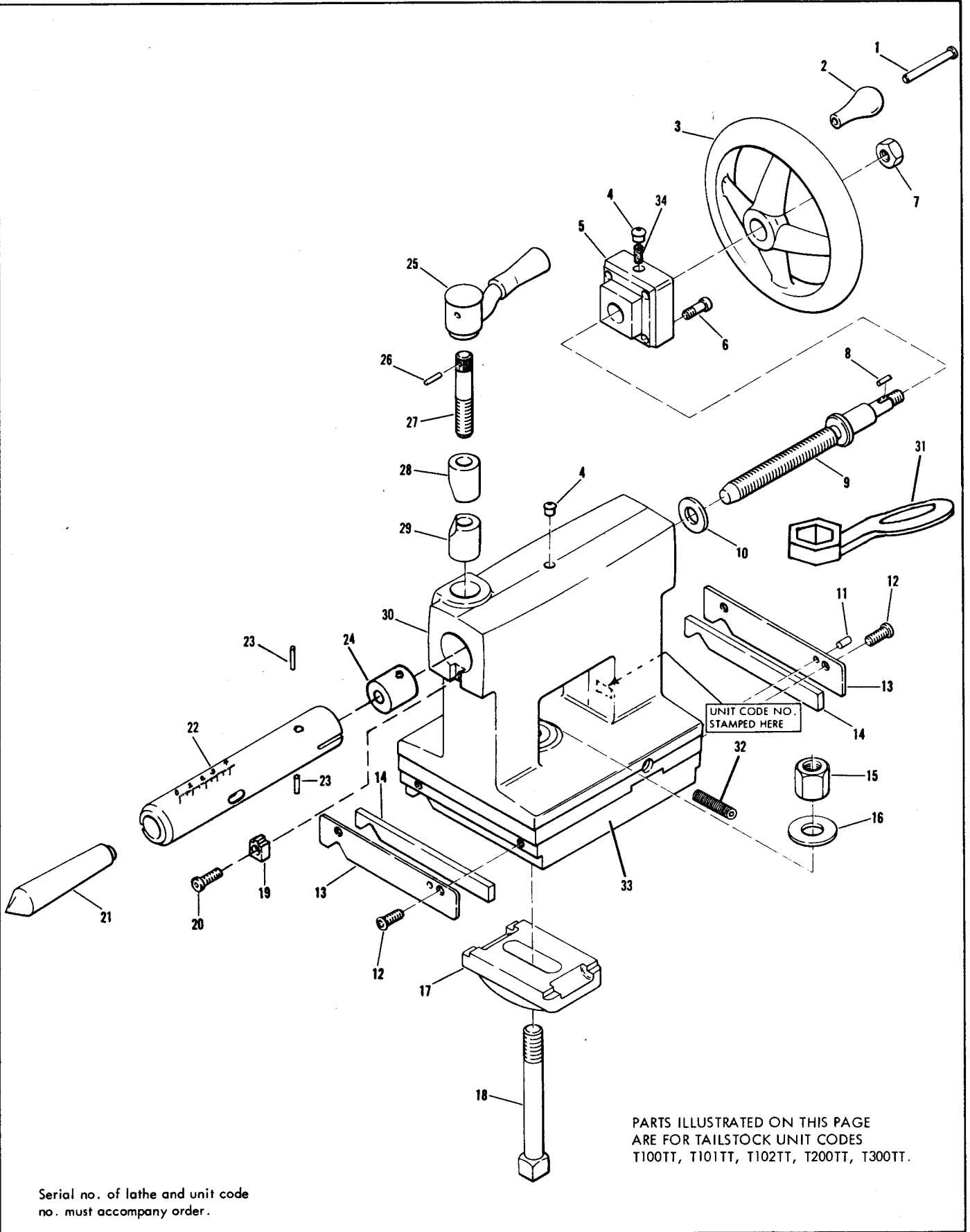
PARTS ILLUSTRATED ON THIS PAGE WERE USED FROM 1979.

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" Lathe Inch-Metric Dials

USED FROM 1979

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	CL2552TH	Compound Inch-Metric Dial Assy. (2,3,4,5,6) A-238	1
2		Extension, Part of dial assy.	1
3	160 x 17	Straight pin 1/8 x 1/4	1
4		Dog pt set screw	2
5	114 x 608	Soc hd cap screw 10-32 x 1/2	3
6		Set screw	2
7	CL2551T	Cross Feed Inch-Metric Dial Assy. (8,9,10,11) A-239	1
8		Set screw	2
9		Extension, part of assy.	1
10	160 x 19	Straight pin 1/8 x 3/8	1
11	114 x 608	Soc hd cap screw 10-32 x 1/2	3



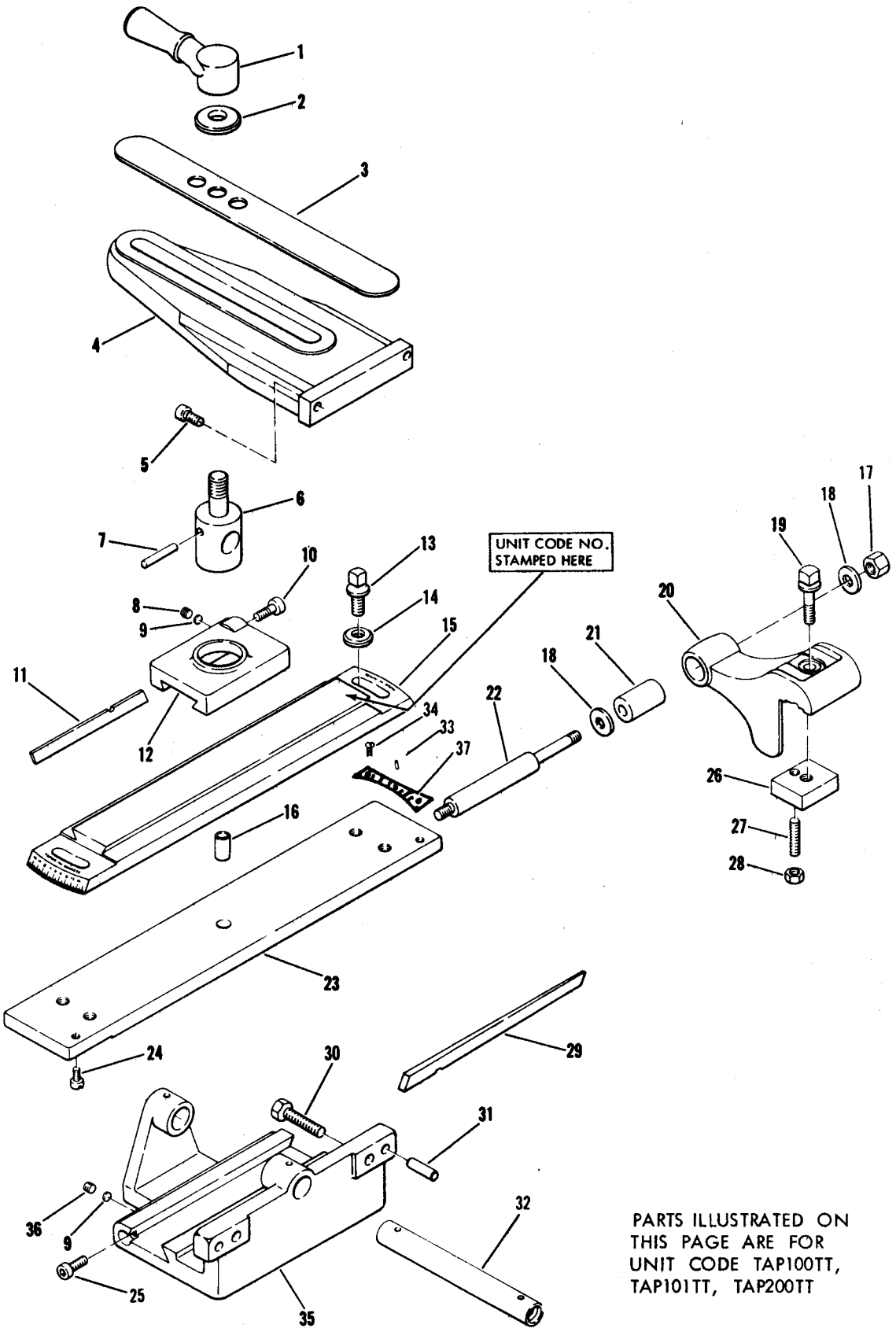
TAILSTOCK

SOUTH BEND LATHE

14" TAILSTOCK T100TT, T101TT, T102TT, T200TT, T300TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
	CL2036TT	Tailstock Assy Complete All Parts Shown	1
1	PT1243	Stud	1
2	PT1493	Handle	1
3	*AS1262TH1	Handwheel Assy (1,2)	1
4	155 x 14	Oiler	1
5	PT8556TT1	Cap, The Caps Alone For Codes T100TT And T101TT Are Not Available, Order Item 9 ASX8556TT2	1
5	*AS8556TT2	Cap (4,6,34)	1
6	114 x 616	Soc Hd Cap Screw 10-32X1	4
7	PT1071-2	Hex Nut 7/16 - 14 (WA5 132 x 39)	1
8	160 x 21	Straight Pin 1/8 x 1/2	1
9	*ASX8555TT4	Screw Assy. For Codes T100TT and T101TT (1,2,3,4,6,7,8,9,10)	1
9	*AS8555TT4	Screw For Codes T102TT, T102TT, T200TT, T300TT (10)	1
10	PT3554TH1	Neoprene Washer	1
11	160 x 18	Straight Pin 1/8 x 5/16	1
12	109 x 8	Button Hd Cap Screw 10-32 x 1/2	4
13	PT580T2	Retainer	2
14	PT582T1	Wiper	2
15	PT283T1	Hex Nut	1
16	161 x 37	Washer	1
17	PT56T1	Clamp	1
18	143 x 420	Clamp Bolt 5/8 - 11 x 5	1
19	PT8554TT1	Key	1
20	114 x 606	Soc Hd Cap Screw 10-32 x 3/8	1
21	PT6712R1	Tailstock Center #3 Morse Taper	1
22	PT20IT1	Spindle For Code T100TT #3 Morse Taper	1
22	*AS8902TT3	Spindle Assy Regular with Inch-Metric Graduations (19,20,23,24) For Code T101TT, T102TT, T200TT, T300TT	1
22	*AS6830TT3	Hardened Tailstock Spindle For Code T101TT, T102TT, T200TT, T300TT (19,20,23,24)	1
23	159 x 28	Roll Pin 1/8 x 1/4	2
24	PT6706T1	Spindle Nut for Code T101TT, T102TT, T200TT, T300TT	1
25	*PA54T1	Binder Lever Assy. (2,6,27)	1
26	160 x 251	Pin	1
27	PT206T2	Binder Stud - Order Item 25	1
28	PT248T2	Top Binder Plug	1
29	PT249T2	Bottom Binder Plug	1
30	*PA8558TT1	Top And Base Assy (32, *33)	1
31	PT55T1	Tailstock Wrench	1
32	126 x 788	Set Over Screw, Flat Point 1/2 - 13 x 3	2
33	*AS8559TT1	Base Assy (11,12,13,14)	1
34	256 X 8	Oil Wick	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS ARE IN PARANTHESIS AFTER PART NAME



PARTS ILLUSTRATED ON THIS PAGE ARE FOR UNIT CODE TAP100TT, TAP101TT, TAP200TT

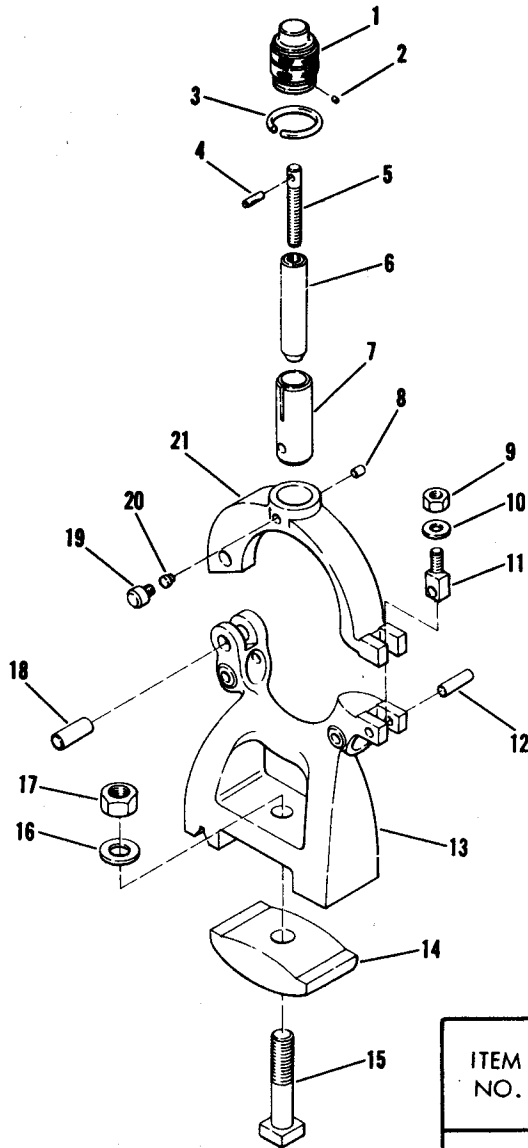
SERIAL NUMBER OF LATHE AND UNIT CODE NUMBER 'MUST' ACCOMPANY ORDER.

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" TAPER ATTACHMENT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
1	PT54TH1	Binding lever	1
2	PT857H2	Washer	1
3	PT6730T1	Chip guard	1
4	PT868T2	Connecting bar	1
5	114 x 112	Soc hd cap screw 5/16-18 x 3/4	2
6	PT8734TT1	Binder stud	1
7	168 x 412	Taper pin	1
8	122 x 505	Cup pr set screw 1/4-20 x 5/16	2
9	PT1077TH1	Shoe	2
10	PT219TH1	Gib screw	1
11	PT870TF1	Slide block gib	1
12	*AS861TF1	Slide block assy (8,9,10,11)	1
13	PT872T1	Collar screw	2
14	PT857TF2	Washer	2
15	PT869TF1	Swivel bar	1
16	160 x 197	Straight pin 1/4 x 1-9/16	1
17	PT1051NF1	Nut	1
18	PT875RT1	Washer	2
19	PT871T1	Clamp screw	1
20	*AS8735TT1	Tie rod bracket assy. (17,18,19,21,26,27,28)	1
21	506 x 6	Babbitt	1
22	PT865T2	Tie rod	1
23	PT860TT1	Taper att. bed	1
24	114 x 112	Soc hd cap screw 3/8-16 x 5/8	2
25	PT219TH1	Gib screw	1
26	PT863TF1	Bracket clamp	1
27	126 x 624	Soc hd set screw 5/16-18 x 1.5	1
28	PT1072-2	Nut	1
29	PT859TF1	Bed bracket gib	1
30	112 x 424	Hex hd cap screw 1/2-13 x 1.5	2
31	160 x 119	Straight pin 5/16 x 1.5	2
32	PT858TF2	Cross feed sleeve only	1
32	*AS858TF2	Cross feed sleeve assy. (6,7)	1
33	160 x 19	Straight pin (for metric 1/8 x 3/8)	1
34	103 x 8	Flat hd mach screw (for metric T.A 6-32 x 1/2	2
35	PT862TF1	Bracket	1
36	122 x 507	Cup pt set screw 1/4-20 x 7/16	2
37	*AS2239T1	Metric plate (33,34)	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME



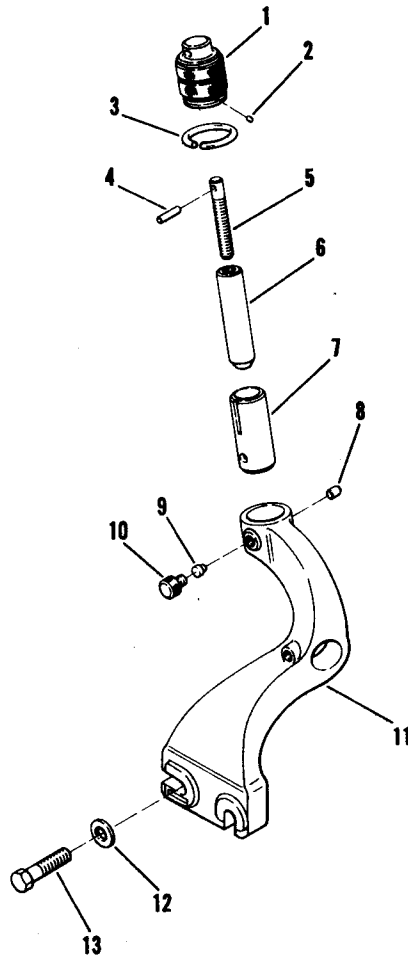
STEADY REST

ITEM NO.	PART NO.	DESCRIPTION	QUAN.
	CL2400T	Complete assy.	
1	PT132T1	Knob	3
2	PT1082NT1	Shoe	3
3	PT135T1	Ring, Snap	3
4	160x54	Pin, Straight	3
5	PT133T1	Screw, Adjusting	3
6	PT129T1	Jaw	3
7	PT131T1	Sleeve	3
8	160x47	Pin, Straight	3
9	138x27	Nut, Full	1
10	161x17	Washer	1
11	PT217T1	Bolt, Lock	1
12	160x60	Pin, Straight	1
13	*PA8726TT1	Base and top assy. (7, 8, 21)	1
14	PT127T1	Clamp	1
15	143x414	Bolt, Square Head	1
16	167x8	Washer	1
17	138x35	Nut, Full	1
18	PT1804	Pin, Straight	1
19	PT134TH1	Screw, Thumb	3
20	PT137TH1	Key	3
21	PT116T1	Top order item 13	1

* AVAILABLE ONLY AS SUB-ASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.

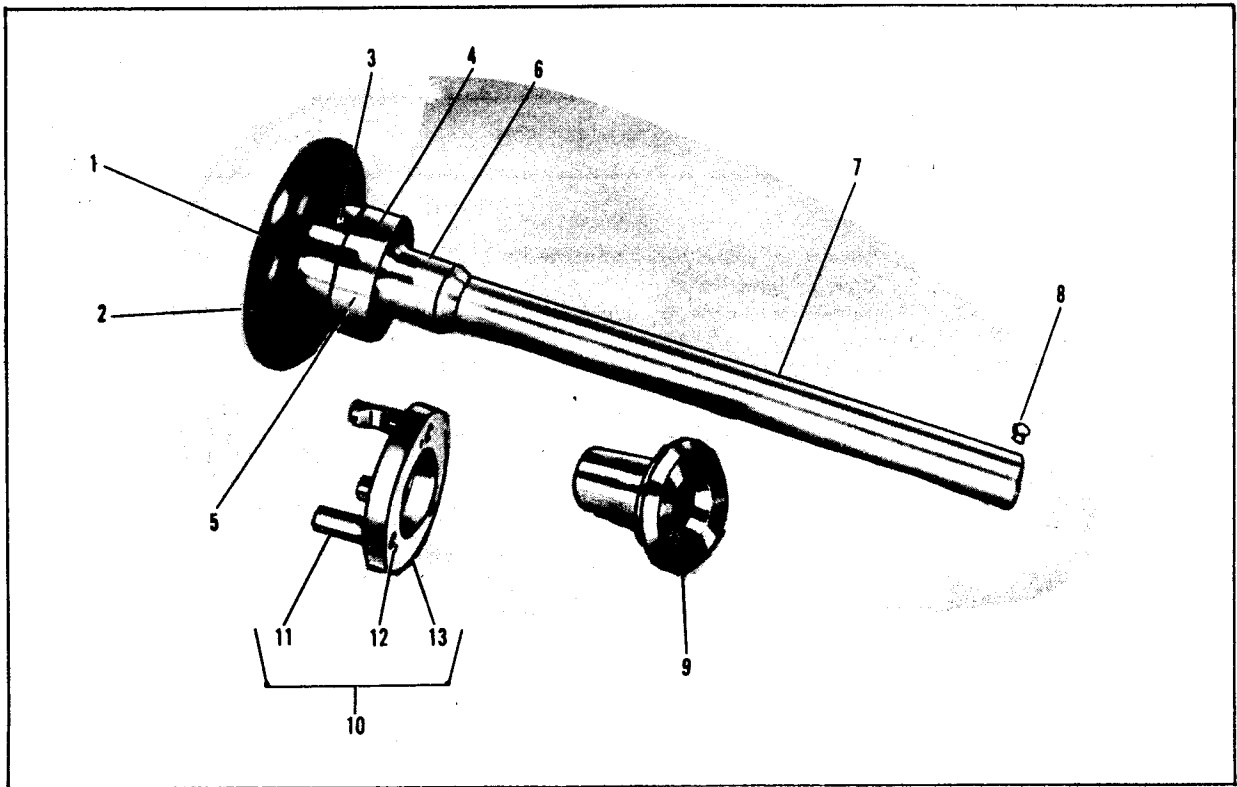
SOUTH BEND LATHE
 400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

FOLLOWER REST



ITEM NO.	PART NO.	DESCRIPTION	QUAN.
	CL2395TT	Complete assy.	
1	PT132T1	Knob	2
2	PT1082NT1	Shoe	2
3	PT135T1	Ring, Snap	2
4	160x54	Pin, Straight	2
5	PT133T1	Screw, Adjusting	2
6	PT129T1	Jaw	2
7	PT131T1	Sleeve	2
8	160x47	Pin, Straight	2
9	PT137TH1	Key	2
10	PT134TH1	Screw	2
11	*PA8728TT1	Follower Rest (7,8)	1
12	161x17	Washer	2
13	112x228	Screw	2

* AVAILABLE ONLY AS SUB-ASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.



HANDWHEEL COLLET ATTACHMENTS

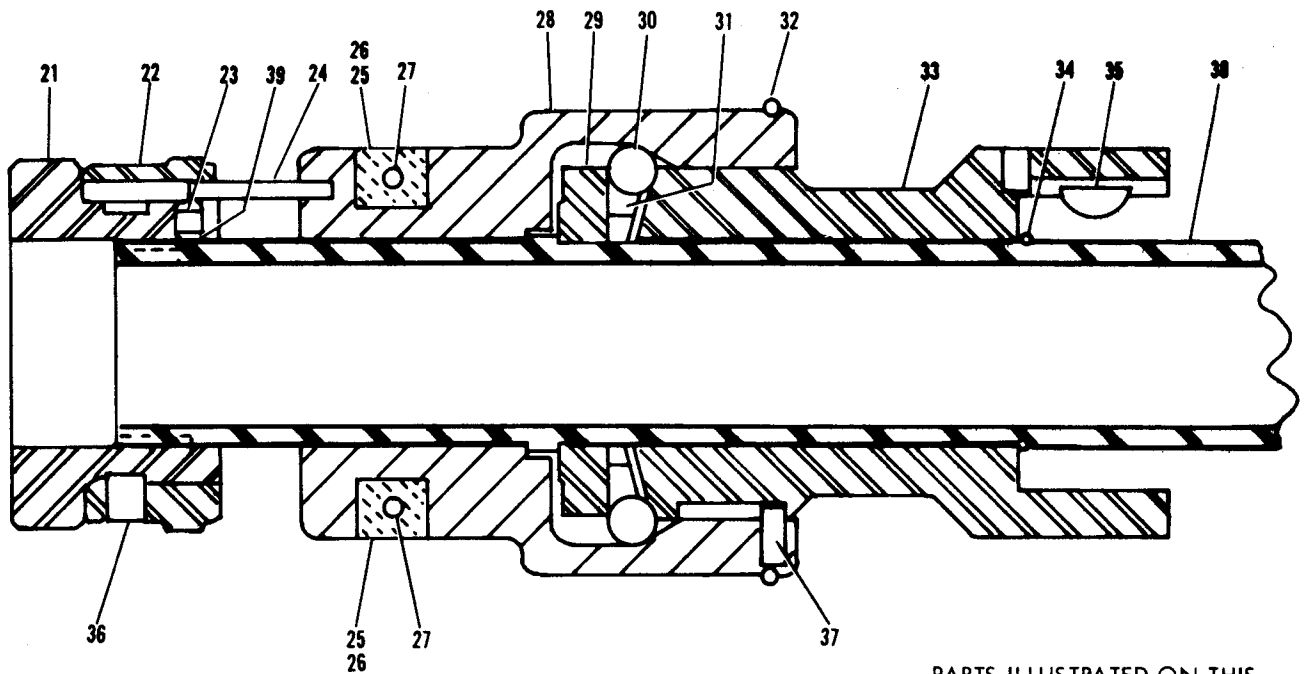
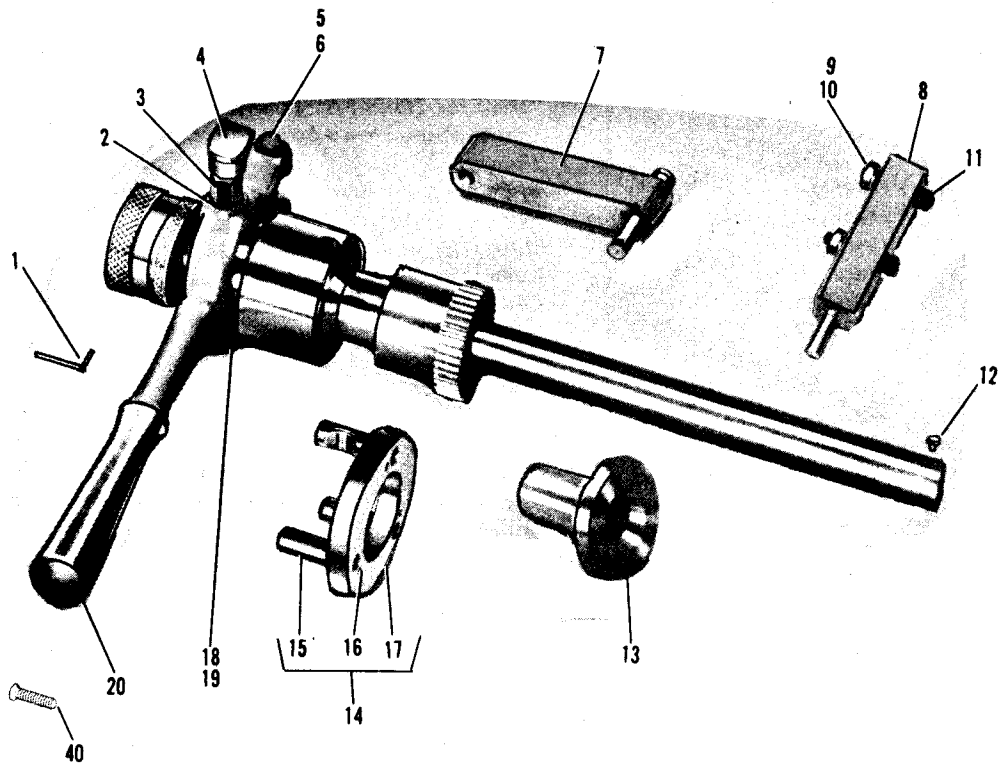
Serial no. of lathe
must accompany order.

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" HANDWHEEL COLLET ATT. HWD100TT, HWD101TT, HWD102TT, HWD103TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
	CC4306TT	Handwheel collet att. complete for 3" D1 cam lock spindle (used from 1969 to approx. June 1973)	
	CB4306TT	Handwheel collet att. complete for 4" D1 cam lock spindle (used from approx. June 1973)	
1	PT798RH2	Handwheel	1
2	103 x 208	Flt hd mach screw 10-32 x 1/2	3
3	160 x 49	Straight pin 3/16 x 9/16	2
4	PT797LH1	Handwheel sleeve	1
5	PT207NK1	Ball bearing	1
6	PT794LH1	Draw bar sleeve for 3 D 1 cam lock spindle	1
6	PT8528DD1	Draw bar sleeve for 4 D 1 cam lock spindle	1
7	PT8720TT1	Draw bar for 3 D 1 cam lock spindle	1
7	PT8720TT2	Draw bar for 4 D 1 cam lock spindle	1
8	160096	Key for 3 D 1 cam lock spindle	1
8	PT493NH1	Key for 4 D 1 cam lock spindle	1
9	160200	Collet sleeve for 3 cam lock spindle	1
9	PT8532DD1	Collet sleeve for 4 D 1 cam lock spindle	1
10	160228	Spindle protector assy. (11, 12, 13) for 3 D 1 cam lock spindle	1
10	*AS3641LH3	Spindle protector assy. (11, 12, 13) for 4 D 1 cam lock spindle	1
11	PT2814L1	Stud for 3 D 1 cam lock spindle	3
11	PT3626LH1	Stud for 4 D 1 cam lock spindle	3
12	103 x 206	Screw 10-32 x 3/8	3
13	160227	Protector for 3 D 1 cam lock spindle	1
13	PT3641LH3	Protector for 4 D 1 cam lock spindle	1
*AVAILABLE ONLY AS ASSY. INCLUDED PARTS ARE IN PARANTHESIS AFTER PART NAME			

HANDLEVER COLLET ATTACHMENTS



Serial no. of lathe and unit no. must accompany order.

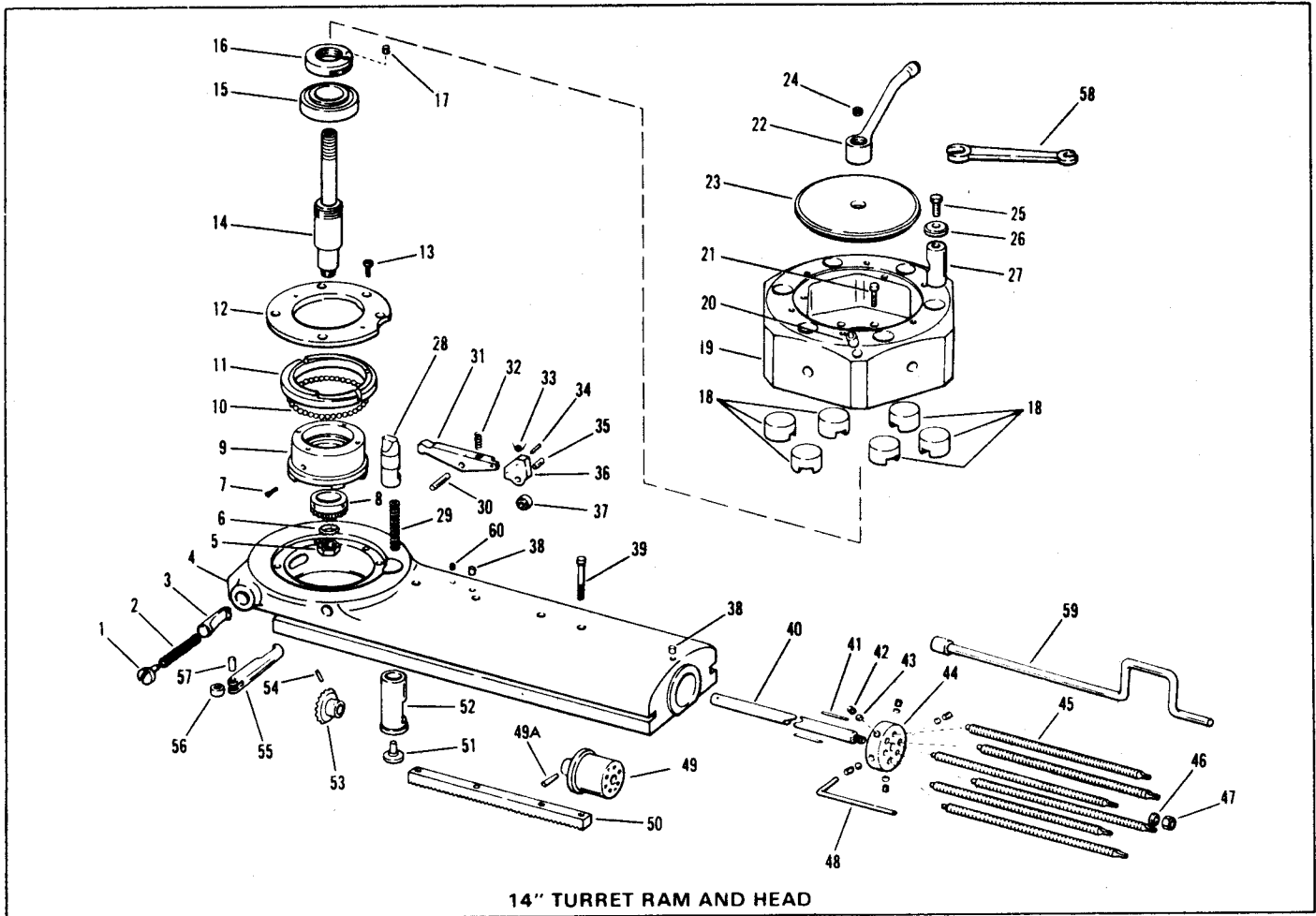
PARTS ILLUSTRATED ON THIS PAGE ARE FOR UNIT CODES DHL100TT, DHL101TT

SOUTH BEND LATHE
400 W. SAMPLE STREET SOUTH BEND, INDIANA 46621

14" HAND LEVER COLLET ATT. DHL100TT, DHL101TT

ITEM NO.	PART NO.	DESCRIPTION	QUAN
	CC5206TT	Handlever Collet Att Complete For 3 D1 Cam Lock Spindle (Used From 1969 To Approx June 1973)	
	CB5206TT	Handlever Collet Att. Complete For 4 D1 Cam Lock Spindle (Used From Approx. June 1973)	
1	173 x 6	Wrench	1
2	PT492LH1	Screw	1
3	PT494LH1	Nut	1
4	155 x 5	Oiler	1
5	174 x 6	Clevis Pin	1
6	170 x 306	Cotter Pin	1
7	PT8725TT1	Lever Bracket	1
8	PT8724TT1	Bracket Support	1
9	182 x 301	Lock Washer	2
10	139 x 25	Jam Nut	2
11	114 x 128	Soc Hd Cap Screw 5/16 - 18 x 1-3/4	2
12	160 096	Key for 3 D1 Cam Lock Spindle	1
12	PT493NH1	Key For 4 D1 Cam Lock Spindle	1
13	160 208	Collet Sleeve (12) For 3 D1 Cam Lock Spindle	1
13	*AS8532DD1	Collet Sleeve (12) For 4 D1 Cam Lock Spindle	1
14	160 228	Spindle Protector Assy For 3 D1 Cam Lock Spindle (15,16,17)	1
14	*AS3641LH3	Spindle Protector Assy for 4 D1 Cam Lock Spindle (15,16,17)	1
15	PT2814L1	Stud For 3 D1 Cam Lock Spindle	1
15	PT3626LH1	Stud For 4 D1 Cam Lock Spindle	3
16	103 x 206	Screw 10-32 x 3/8	3
17	160 227	Protector For 3 D1 Cam Lock Spindle	1
17	PT3641LH3	Protector For 4 D1 Cam Lock Spindle	1
18	PT994LT1	Screw	1
19	PT1062-1	Nut	1
20	PT990LT2	Lever	1
21	PT978LH3	Stop Nut	1
22	PT998LH1	Collar	2
23	120 x 903	Screw 10-32 x 3/16	2
24	160 x 29	Straight Pin 1/8 x 1	2
25	*AS988LH1	Segment Assy. (26,27)	1
26	256 x 11	Wick	2
27	160 x 18	Straight Pin 1/8 x 5/16	2
28	PT986LH3	Yoke Cone	1
29	PT981LH2	Collar	1
30	172 x 20	Steel Ball 5/16	10
31	PT488LH2	Retainer	1
32	PT983LH1	Snap Ring	1
33	PT8723TT1	Clutch Sleeve For 3 D1 Cam Lock Spindle	1
33	PT8723DD1	Clutch Sleeve For 4 D1 Cam Lock Spindle	1
34	PT976LH1	Snap Ring	1
35	PT2070-1	Key	1
36	120 x 5	Screw 1/4-20 x 5/16	1
37	PT1826-1	Straight Pin	1
38	PT8722TT1	Draw Bar For 3 D1 Cam Lock Spindle	1
38	PT8722TT2	Draw Bar For 4 D1 Cam Lock Spindle	1
39	PT4809RH1	Shoe	2
40	101 x 748	Rd Hd Screw To Support End Gear Guard 5/16 - 18 x 2-3/4	1

*AVAILABLE ONLY AS ASSY. INCLUDED PARTS
ARE IN PARANTHESIS AFTER PART NAME



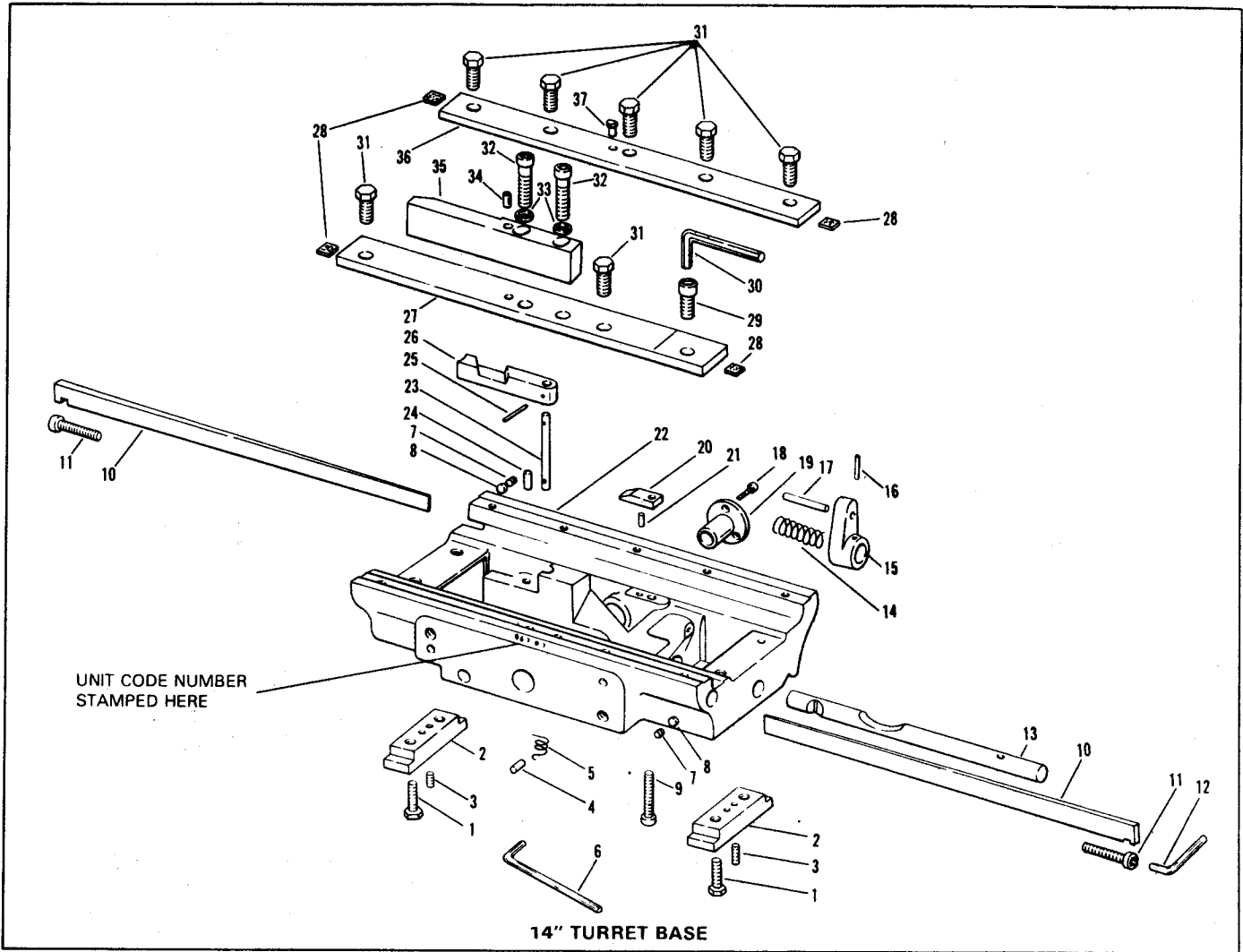
14" TURRET RAM AND HEAD

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
1	PT3458T1	CLAMP FINGER SPRING RETAINER	1
2	PT3014H1	CLAMP FINGER SPRING	1
3	PT3447T1	CLAMP FINGER	1
4	PT3001T1	TURRET RAM	1
5	PT215R1	HEX NUT	1
6	180 X 310	LOCK WASHER	1
7	114 X 710	CAP SCREW	1
8	PT3023T1	TURRET HEX GEAR	1
9	*AS3442T1	INDEX BUSHING (7-8)	1
10	172 X 12	BALL	57
11	PT3443T1	LOWER CAM	1
12	PT3444T1	UPPER CAM	1
13	103 X 610	SCREW	5
14	*AS8737TT1	PIVOT POST (5-6-24)	1
15	PT442PH1	BEARING	1
16	*AS3467T1	PIVOT POST NUT (17)	1
17	120 X 904	SET SCREW	1
18	PT3013H2	LOCK BOLT INDEXING BUSHING	6
19	*AS8737TT1	HEX TURRET (18-20-21-22-23-24-25-26-27-28)	1
20	155 X 14	BALL OILER	1
21	114 X 12	CAP SCREW	6
22	PT3006H2	CLAMPING LEVER	1
23	PT3456T1	LOCK COVER	1
24	155 X 16	BALL OILER	1
25	PT2902T1	CAP SCREW	6
26	PT3037T1	BINDER BOLT WASHER	6
27	PT3010T1	TURRET BINDER	6
28	PT3011T1	LOCK BOLT	1
29	PT3014H1	LOCK BOLT SPRING	1
30	PT3459T1	STRAIGHT PIN	1

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
31	*AS3016T1	LOCK BOLT LEVER (30-32)	1
32	162 X 58	SPRING	1
33	PT3452T1	LOCK BOLT LEVER SPRING	1
34	171 X 270	PIN	1
35	PT1838-1	STRAIGHT PIN	1
36	*AS3451T1	ROLLER BRACKET (34-35-33)	1
37	PT3017T1	LOCK BOLT ROLLER	1
38	155 X 17	BALL OILER	2
39	114 X 34	CAP SCREW	4
40	*AS3030T1	STOP SCREW INDEX SHAFT (47-48-*54)	1
41	150 X 29	STRAIGHT PIN	2
42	120 X 105	SET SCREW	6
43	PT1084H1	SHOE	6
44	PT 30 05T 1	ORDER ITEM * 49	1
45	PT3029T1	STOP SCREW	6
46	151 X 66	WASHER	1
47	PT1071-1	HEX NUT	1
48	173 X 7	WRENCH	1
49	*AS3004T1	STOP SCREW INDEX (41 42 43 44 49A)	1
49A	168 X 206	TAPER PIN	1
50	PT3041T1	RACK	1
51	PT3015H1	LOCK BOLT SPRING RETAINER	1
52	PT3012T1	LOCK BOLT BUSHING	1
53	*AS3024T1	STOP SCREW GEAR (55)	1
54	168 X 307	TAPER PIN	1
55	PT3448T1	RELEASE FINGER	1
56	PT3446T1	RELEASE FINGER ROLLER	1
57	PT3450T1	PIN	1
58	PT2461-1	WRENCH	1
59	AS3073T1	WRENCH	1
60	120 X 916	SET SCREW	1

*AVAILABLE ONLY AS SUBASSEMBLY PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME

SOUTH BEND LATHE

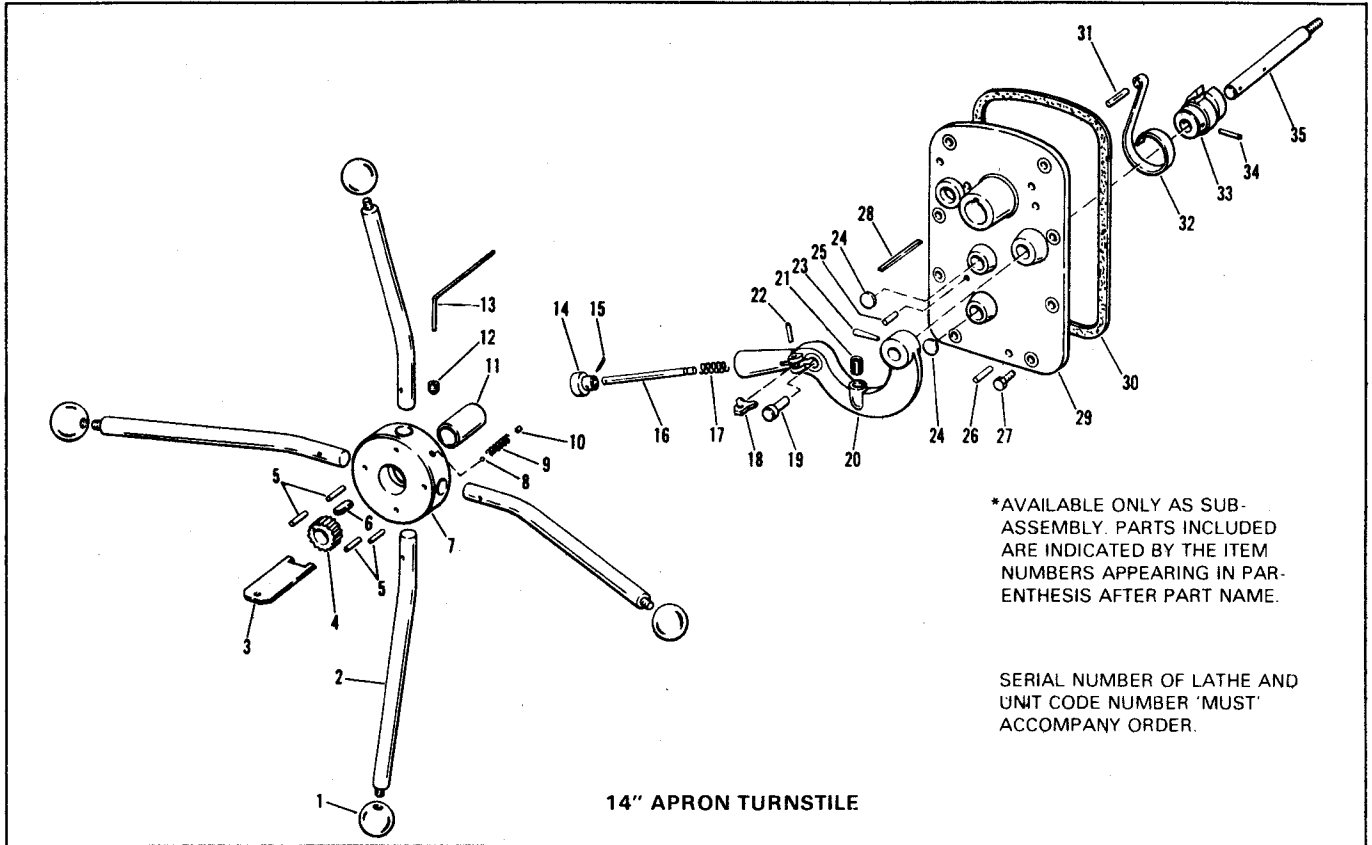


INDEX NO.	PART NO.	DESCRIPTION	QUAN.
1	112 X 436	CAP SCREW	4
2	PT3003T1	CLAMP	2
3	121 X 320	SET SCREW	4
4	PT1815	PIN	1
5	PT3028T1	INDEX LEVER SPRING	1
6	173 x 6	HEX WRENCH	1
7	120 X 4	SET SCREW	2
8	PT1078RH1	SHOE	2
9	114 X 34	CAP SCREW	1
10	PT3036T1	SIDE GIB	2
11	PT219TH1	GIB SCREW	2
12	173 x 9	HEX WRENCH	1
13	*AS3031T1	FEED STOP SHAFT (16)	1
14	162 X 59	SPRING	1
15	*AS3007T1	STOP SCREW STOP (16-17)	1
16	168 X 410	TAPER PIN	1
17	160 X 39	STRAIGHT PIN	1
18	114 X 712	CAP SCREW	4
19	*AS3453T1	TURNSTILE SHAFT BUSHING (18)	1

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
20	PT3020T1	LOCK BOLT CAM	1
21	160 X 74	STRAIGHT PIN	1
22	PT3000T1	TURRET BASE	
23	*PA3027T1	INDEX LEVER PIN (4,5)	1
24	169 x 236	STRAIGHT PIN	1
25	168 X 208	TAPER PIN	1
26	*AS3026T1	TURRET INDEXING LEVER (4-5-23-25)	1
27	*AS3441T1	HORIZONTAL GIB, FRONT (28)	1
28	PT3454T1	FELT	4
29	114 X 216	SOC. HD. CAP SCREW	1
30	173 x 12	HEX WRENCH	1
31	PT3136T1	CAP SCREW	7
32	114 X 228	CAP SCREW	2
33	PT1684-1	WASHER	2
34	155 X 14	BALL OILER	1
35	*AS3445T1	RELEASE CAM (34)	1
36	*AS3440T1	HORIZONTAL GIB, REAR (28-37)	1
37	155 X 21	OILER	1

* AVAILABLE ONLY AS SUB-ASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.

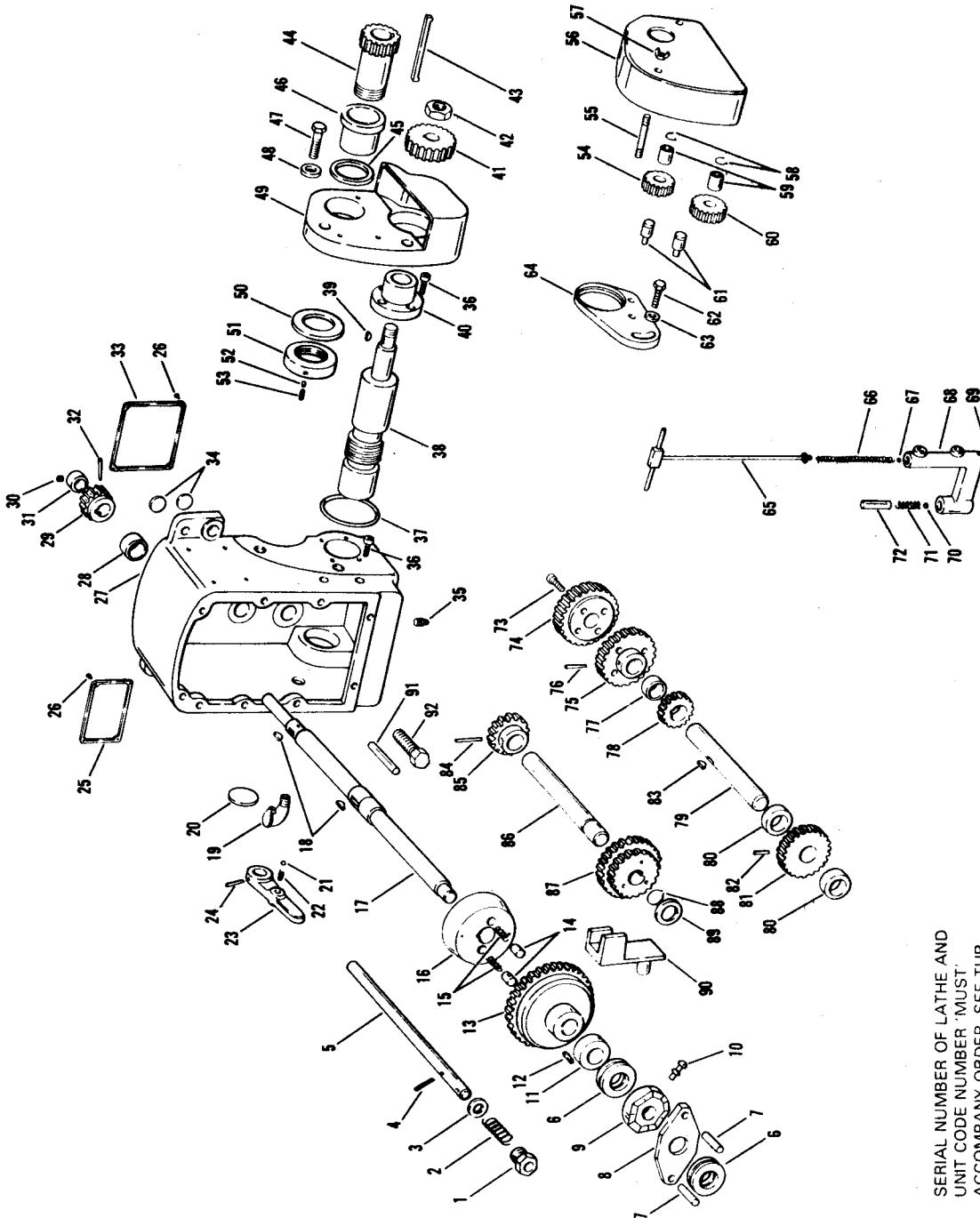
SERIAL NUMBER OF LATHE AND UNIT CODE NUMBER 'MUST' ACCOMPANY ORDER.



INDEX NO.	PART NO.	DESCRIPTION	QUAN.
1	PT406K & FH1	BAKELITE BALL	4
2	*AS3044T1	TURNSTILE HANDLE (1-5)	4
3	PT3099H2	CLUTCH ADJUSTING WRENCH	1
4	PT3057H1	CLUTCH ADJUSTING NUT	1
5	168 X 409	TAPER PIN	4
6	164 X 11	KEY	1
7	*AS3043T1	TURNSTILE HUB (5-8-9-10-12)	1
8	172 X 14	BALL	1
9	162 X 34	SPRING	1
10	122 X 605	SET SCREW	1
11	PT4746T1	SLEEVE	1
12	120 X 206	SET SCREW	1
13	173 x 8	HEX WRENCH	1
14	PT3065T1	RELEASE PUSH ROD HEAD	1
15	160 X 22	STRAIGHT PIN	1
16	PT3066T1	RELEASE PUSH ROD	1
17	162 X 26	COIL SPRING	1
18	PT3078H1	CLUTCH RELEASE CAM	1

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
19	PT3064H1	CLUTCH RELEASE PLUNGER	1
20	*AS3063T1	CLUTCH LEVER (14-15-16-17-18-19-21-22-23)	1
21	PT4747T1	BUMPER	1
22	160 X 52	STRAIGHT PIN	1
23	168 X 410	TAPER PIN	1
24	PT4946-2	PLUG	4
25	160 X 119	STRAIGHT PIN	1
26	160 X 236	STRAIGHT PIN	2
27	112 X 12	HEX HD CAF SCREW	8
28	256 X 3	FELT WICK	1
29	*AS4730T1	APRON COVER (28)	1
30	PT4775T1	GASKET	1
31	160 X 82	STRAIGHT PIN	1
32	PT3071H1	CLUTCH LEVER SPRING	1
33	*AS4738T1	CLUTCH OPERATING CAM (34)	1
34	168 X 411	TAPER PIN	1
35	PT4757T1	CLUTCH LEVER SHAFT	1

SOUTH BEND LATHE



14" TURRET APRON

SERIAL NUMBER OF LATHE AND UNIT CODE NUMBER MUST ACCOMPANY ORDER. SEE TURRET BASE SHEET FOR LOCATION OF UNIT CODE NUMBER.

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
1	PT3072H1	KNOCK OUT SHAFT BUSHING	1
2	162 X 20	SPRING	1
3	161 X 25	FINISHED WASHER	1
4	170 X 206	COTTER PIN	1
5	PT3032T1	KNOCK OUT SHAFT	1
6	PT3042T1	BEARING	2
7	160 X 117	STRAIGHT PIN	2
8	*AS3068H1	STATIONARY CAM (7)	1
9	*AS4756T1	REVOLVING CAM (10)	1
10	PT4739T1	CLUTCH OPERATING PIN	1
11	PT4768T1	SPACER COLLAR	1
12	256 X 3	FELT WICK	1
13	*AS3058T1	CLUTCH GEAR (12)	1
14	PT3060H1	CLUTCH RELEASE	2
15	162 X 34	SPRING	2
16	*AS3062T1	CLUTCH CONE (14-15)	1
17	*AS3033T1	TURNSTILE SHAFT (18)	1
18	PT2072	WOODRUFF KEY #9	2
19	155 X 4	OILER	1
20	PT4770T1	PLUG	1
21	172 X 20	BALL	1
22	162 X 3	SPRING	1
23	*AS4735T1	GEAR SHIFTER LEVER (21-22-24)	1
24	168 X 410	TAPER PIN	1
25	*AS3462T1	POWER TURRET FEED PLATE (26)	1
26	120 x 4	DRIVE SCREW	8
27	PT3046T1	TURRET APRON	1
28	PT3085T1	BUSHING	1
29	*AS3034T1	RACK PINION (32)	1
30	120 X 4	SET SCREW	1
31	*AS3454T1	TURNSTILE SHAFT COLLAR (30)	1
32	168 X 212	TAPER PIN	1
33	*AS3463T1	DIRECTION FEED PLATE (26)	1
34	PT4945-2	PLUG	2
35	PT1511	PIPE PLUG	1
36	114 X 608	CAP SCREW	6
37	PT4733T1	"O" RING	1
38	*AS3049T1	WORM (39-42)	1
39	PT2070-1	WOODRUFF KEY	1
40	*AS4761T1	THRUST BEARING (36)	1
41	PT4743T1	WORM SHAFT GEAR	1
42	139 x 35	JAM NUT (PT1072-6)	1
43	PT4754T1	LEAD SCREW KEY	1
44	*AS4758T1	LEAD SCREW GEAR (43)	1
45	PT4765T1	THRUST WASHER	1
46	PT4753T1	GEAR BUSHING	1

INDEX NO.	PART NO.	DESCRIPTION	QUAN.
47	112 X 224	CAP SCREW	2
48	161 X 64	WASHER	2
49	*AS4731T1	END BRACKET (47-48)	1
50	PT4765T1	THRUST WASHER	1
51	*AS4755T1	LEAD SCREW GEAR NUT (52-53)	1
52	PT1077TH1	BINDER SHOE	1
53	120 X 4	HOLL HD CUP PT SET SCREW	1
54	*AS4762T1	IDLER GEAR (58-59)	1
55	*PA4745T1	BRACKET COVER STUD (57)	1
56	PT4732T1	END BRACKET COVER	1
57	141 X 19	WING NUT	1
58	165 X 50	TRU-ARC RETAINING RING	2
59	PT4764T1	IDLER GEAR BUSHING	2
60	*AS4763T1	IDLER GEAR (58-59)	1
61	PT4748T1	GEAR STUD	2
62	112 X 116	HEX HD CAP SCREW	1
63	161 X 66	FINISHED WASHER	1
64	*AS4752T2	IDLER GEAR BRACKET (58-61)	1
65	AS4772T1	OIL PUMP TUBE ASSEMBLY	1
66	162 X 56	SPRING	1
67	172 X 12	BALL	1
68	*AS3089T1	OIL PUMP (65-66-67-69-70-71-72)	1
69	169 x 241	STRAIGHT PIN	1
70	172 X 14	BALL	1
71	162 X 29	SPRING	1
72	PT3090T1	OIL PUMP PLUNGER	1
73	114 X 16	SOC HD CAP SCREW	4
74	PT3052T1	WORM GEAR	1
75	*AS4750T1	DRIVE GEAR (73-76)	1
76	168 X 410	TAPER PIN	1
77	PT4767T1	SPACER	1
78	PT4737T1	DRIVE GEAR	1
79	*AS3069T1	WORM GEAR SHAFT (83)	1
80	PT4769T1	SPACER	2
81	*AS4749T1	CAM GEAR (82)	1
82	168 x 409	TAPER PIN	1
83	PT2070-1	WOODRUFF KEY	1
84	168 X 410	TAPER PIN	1
85	*AS4751T1	GEAR PINION (84)	1
86	*AS4744T1	SLIDING GEAR SHAFT (84-88)	1
87	AS4740T1	SLIDING GEAR ASSEMBLY	1
88	155 X 75	TRU-ARC RING	1
89	161 X 43	FINISHED WASHER	1
90	AS4735T1	GEAR SHIFTER ARM	1
91	112 X 420	HEX HD CAP SCREW	2
92	153 X 5	PIN	2

*AVAILABLE ONLY AS SUBASSEMBLY PARTS
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