

Parts List No. P-344

Lathe Serial No. 167824

Parts List No. P-344

for

**South Bend 9-inch Model A
Underneath Motor Driven
Quick Change Gear Lathes**



SOUTH BEND LATHE WORKS

South Bend 22, Indiana, U.S.A.

How to Order Replacement Parts for South Bend Lathes

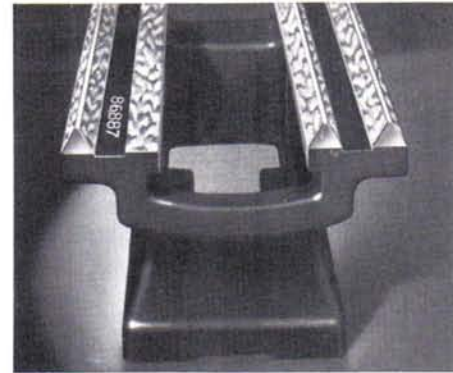
This parts list has been prepared especially for the lathe bearing the serial number which appears on the front cover. It should be considered as a part of the lathe equipment and be kept permanently where it will be readily accessible so the correct part numbers can be given when replacement parts are ordered.

The best way to order replacement parts is to send the old part to the factory with the order. This will avoid delay or possible error.

If it is inconvenient to return the old part, be sure to give the following information:

- (1) Serial number of lathe.
- (2) Correct number and name of part.
- (3) Quantity.
- (4) Specify length of wire, cable, conduit, wicking, or hose as the part number does not indicate length.
- (5) Specify dimensions of gasket material as the part number indicates type of material and thickness only.

If the part needed can not be located in this parts list, send a sketch of the part showing all principal dimensions.



Specify Serial Number of Lathe When Ordering Parts

The serial number of each lathe is stamped on top of the lathe bed between the V-way and flat way at the tailstock end. This number is an index to the size, type, and model of the lathe. Always specify the serial number on each order for replacement parts or attachments.

Terms and Prices

All orders for replacement parts will be shipped C.O.D. unless remittance in full is sent with the order.

All prices are F.O.B. South Bend, Indiana, and will be quoted on request.

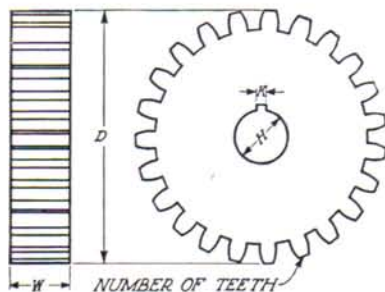
Special Instructions

How to Order Gears

When ordering replacement gears, be sure to give all of the information required as listed and illustrated below.

When Ordering Gears Specify—

Serial Number of Lathe	Diameter "D" in Inches
Number and Name of Part	Width "W" in Inches
Quantity	Keyway "K" in Inches
Number of Teeth	Hole "H" in Inches



The illustration above shows two views of a gear with parts lettered for use when indicating specifications on your order.

How to Order Threaded Parts

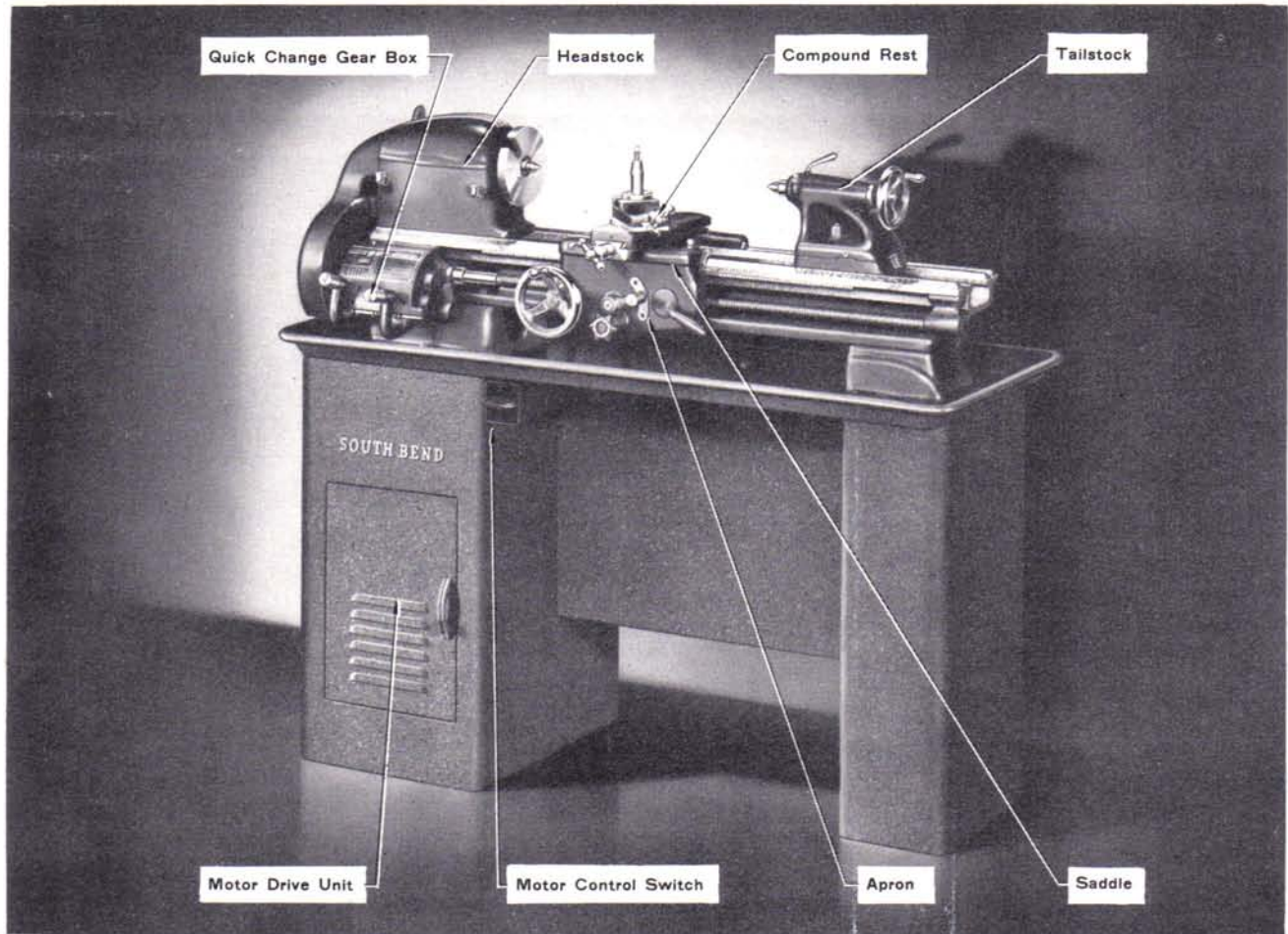
When ordering threaded parts, other than commercial parts such as standard screws, bolts, and nuts, be sure to give all of the information required as listed below.

When Ordering Threaded Parts Specify—

Serial Number of Lathe	Number of Threads per Inch
Number and Name	Kind of Thread:
of Part	Acme Thread
Quantity	U. S. Standard Thread
Outside Diameter of	Sharp "V" Thread
Threads in Inches	Right-or Left-hand Thread

Repair Parts Supplied for South Bend Lathes Only

The lathe parts listed in this parts list can be supplied only for use on South Bend Lathes. We are not in a position to supply parts for other makes of lathes or for use on jigs, fixtures, special machines or equipment.



PARTS LIST NO. P-344

for

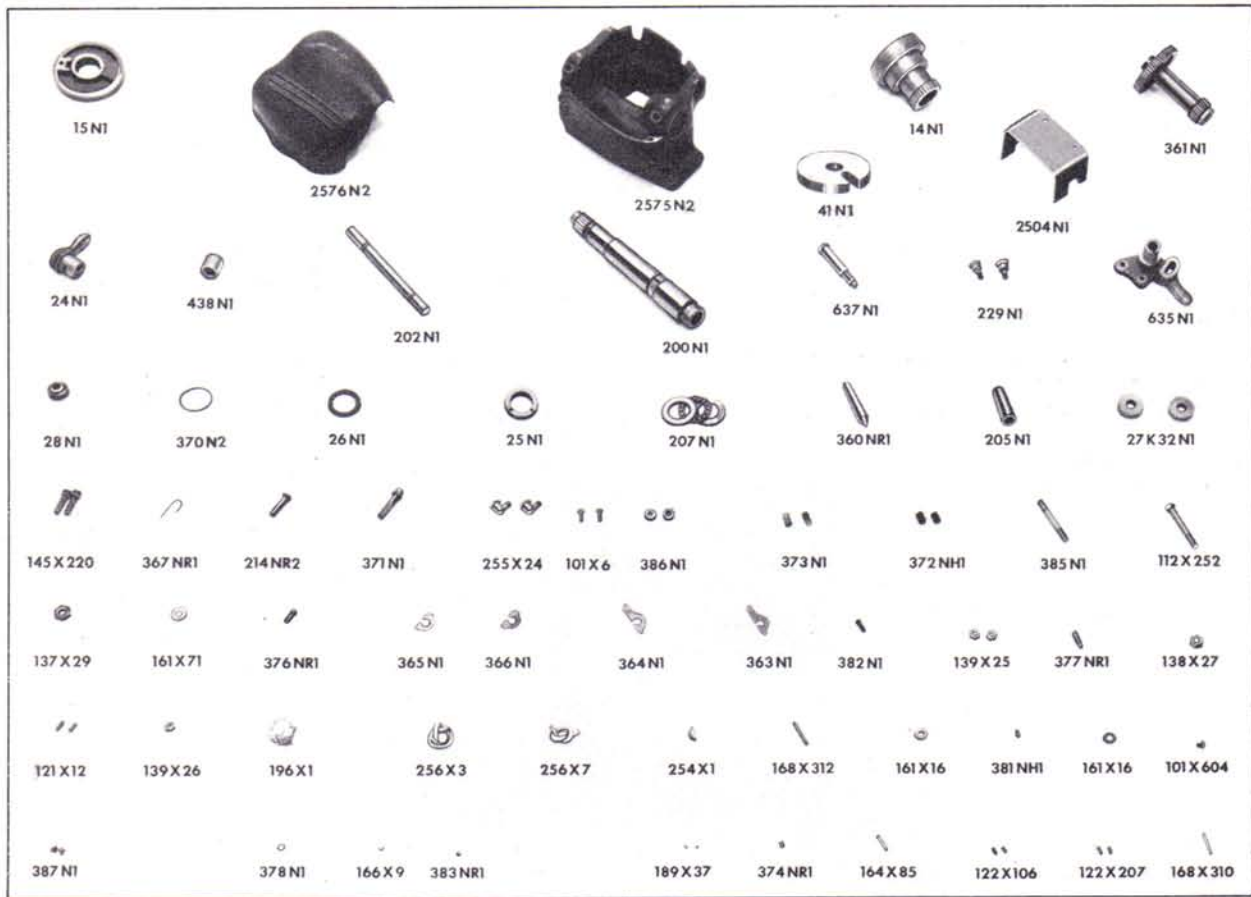
**South Bend 9-inch Model A
Underneath Motor Driven
Quick Change Gear Lathes**

Unit	Page
Headstock	2-A and 2-B
Quick Change Gear Box	3-A and 3-B
Saddle and Compound Rest	4
Apron	5

Unit	Page
Motor Drive Unit	6-A and 6-B
Tailstock	7
Legs	8
Motor Control Switch	9

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Headstock Parts

Part No.	Name of Part	Part No.	Name of Part
14N1	Spindle Cone.....	161X16	Washer, Left Headstock Stud.....
15N1	Bull Gear.....	161X71	Washer, Right Headstock Stud.....
24N1	Back Gear Lever.....	164X85	Key, Reverse Bracket Shaft.....
25N1	Nut, Spindle Take-up.....	166X9	Shoe, Back Gear.....
26N1	Washer, Spindle Take-up Nut.....	168X310	Pin, Eccentric Shaft Bushing.....
27K32N1	Twin Gears.....	168X312	Pin, Back Gear Lever.....
28N1	Reverse Gear.....	189X37	Shoes, Cone Cover Hinge Screw Set Screw.....
41N1	Face Plate.....	196X1	Spindle Bearing Capillary Oiler Wool.....
101X6	Screws, Bed Belt Pocket Cover.....	200N1	Spindle.....
101X604	Screw, Back Gear Oil Hole.....	202N1	Eccentric Shaft.....
112X252	Clamping Screw, Right Headstock.....	205N1	Spindle Sleeve.....
121X12	Screws, Cone Cover Hinge.....	207N1	Ball Thrust Bearing.....
122X106	Set Screws, Cone Cover Hinge Screw.....	214NR2	Bull Gear Plunger.....
122X207	Set Screws, Reverse Bracket.....	229N1	Twin Gear Studs.....
137X29	Nut, Reverse Shaft.....	254X1	Bull Gear Key.....
138X27	Nut, Left Headstock Clamping Screw.....	255X24	Spindle Bearing Oilers.....
139X25	Nuts, Twin Gear Stud.....	256X3	Reverse Bracket Wick.....
139X26	Nut, Back Gear Lever Stop Screw.....	256X7	Twin Gear Stud Wick.....
145X220	Cap Screws, Headstock.....	360NR1	Headstock Spindle Center (Catalog No. 726-W)
161X16	Washer, Reverse Bracket Lock Screw.....	361N1	Back Gear.....

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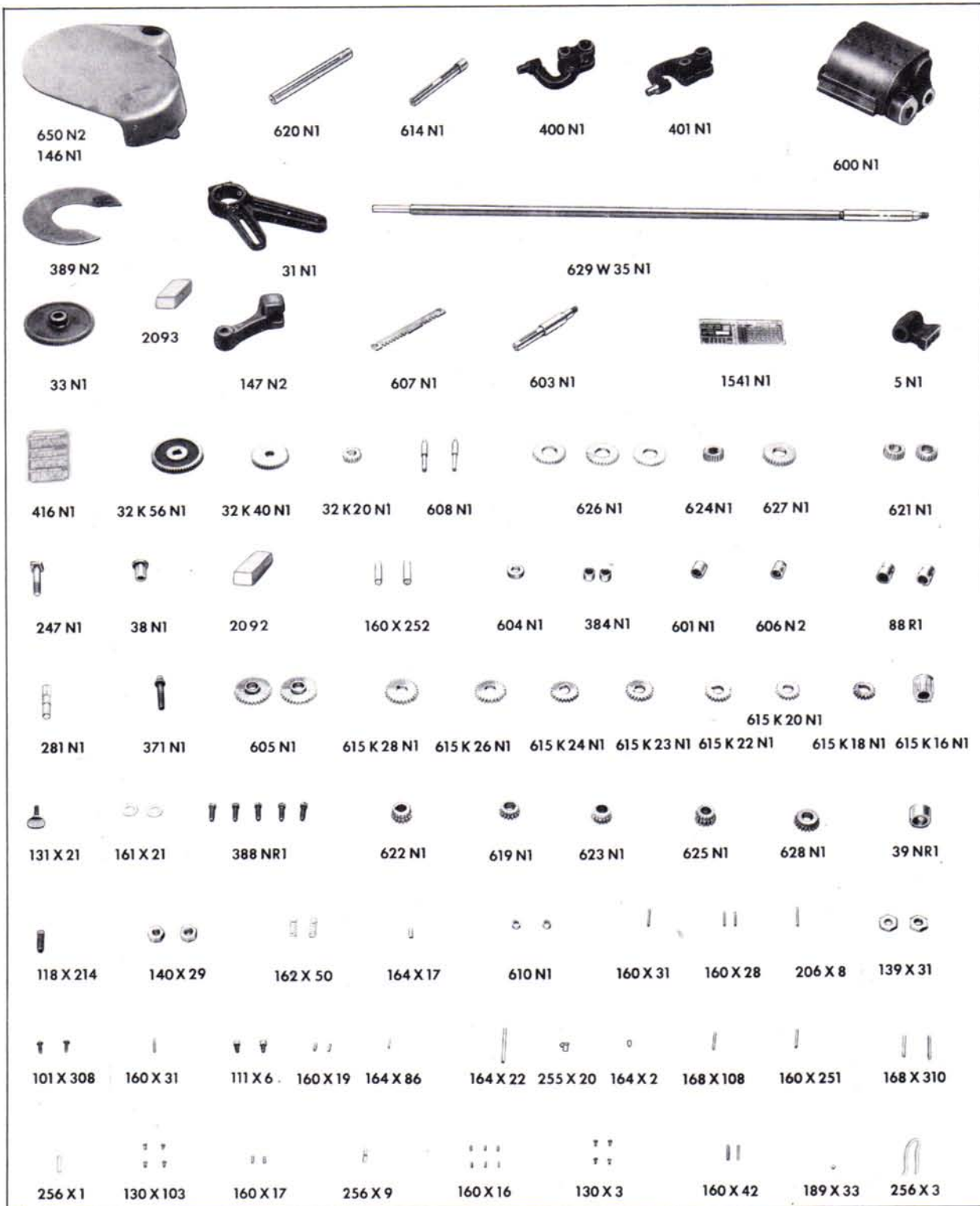
Headstock Parts

(Continued from Other Side of This Sheet)

Part No.	Name of Part	Part No.	Name of Part
363N1	Headstock Shim, Large Laminated	381NH1	Screw, Spindle Cone Oil Hole Plug
364N1	Headstock Shim, Large Solid	382N1	Screw, Spindle Take-up Nut
365N1	Headstock Shim, Small Laminated	383NR1	Pin, Spindle Take-up Nut Washer
366N1	Headstock Shim, Small Solid	385N1	Left Headstock Clamping Stud
367NR1	Bull Gear Plunger Spring	386N1	Headstock Oiler Plugs
370N2	Spindle Protecting Ring	387N1	Spindle Cone Cover Bumpers
371N1	Lock Screw, Reverse Bracket	438N1	Eccentric Shaft Bushing, Front
372NH1	Spindle Bearing Capillary Oiler Felts	635N1	Reverse Bracket
373N1	Spindle Bearing Capillary Oiler Springs	637N1	Reverse Bracket Shaft
374NR1	Back Gear Spring	2504N1	Bed Belt Pocket Cover (rear)
376NR1	Set Screw, Back Gear	2575N2	Headstock
377NR1	Screw, Back Gear Stop	2576N2	Spindle Cone Cover
378N1	Washer, Quill Sleeve Oil Hole		

Quick Change Gear Box Parts

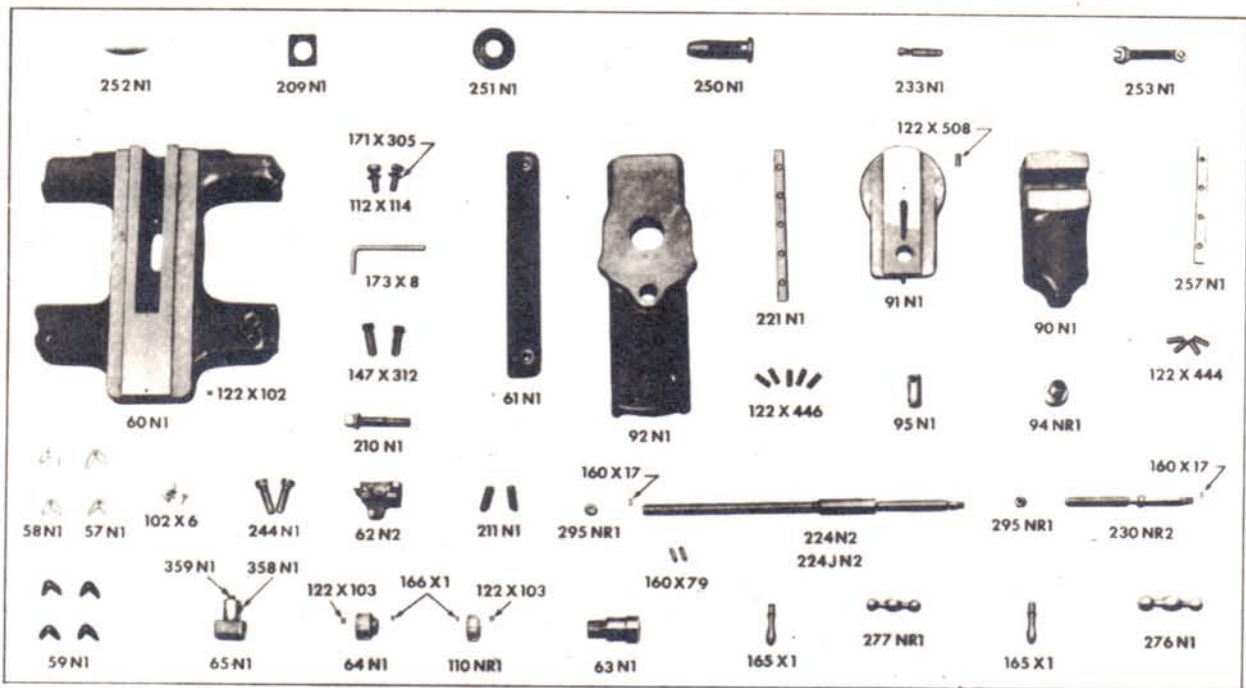
(See List of Parts on Other Side of This Sheet)



Quick Change Gear Box Parts

(See Illustration of Parts on Other Side of This Sheet)

Part No.	Name of Part	Part No.	Name of Part
5N1	Rear Lead Screw Bracket	256X3	Gear Box Felt Wick, Flat
31N1	Change Gear Bracket	256X3	Main Drive Shaft Wicking
32K20N1	Change Gear—20 Teeth	256X9	Wired Cotton Wicking for Gear Box
32K40N1	Change Gear—40 Teeth	281N1	Stud, Change Gear Guard
32K56N1	Change Gear—56 Teeth	371N1	Collar Screw, Change Gear Bracket
33N1	Idler Gear	384N1	Tumbler Idler Gear Bearings
38N1	Idler Gear Bushing	388NR1	Screws, Gear Box
39NR1	Lead Screw Thrust Collar	388NR1	Screws, Lead Screw Bracket
88R2	Tumbler Plunger Knobs	389N2	Change Gear Safety Guard
101X308	Screws, Change Gear Safety Guard	400N1	Gear Box Tumbler (Right)
111X6	Screws, Tumbler Guide Bar	401N1	Gear Box Tumbler (Left)
118X214	Set Screw, Gear Guard Bracket	416N1	Lubrication Chart
130X3	Escutcheon Pins, Lubrication Chart	600N1	Gear Box
130X103	Escutcheon Pins, Index Plate	601N1	Cone Gear Shaft Bushing
131X21	Thumb Screw, Gear Guard Bracket	603N1	Main Drive Shaft
139X31	Nuts, Lead Screw	604N1	Main Drive Shaft Collar
140X29	Nut, Idler Gear Bolt	605N1	Tumbler Idler Gears
140X29	Nut, Main Drive Shaft	606N2	Main Drive Shaft Bushing
146N1	Change Gear Guard for Horizontal Motor Driven Lathes	607N1	Tumbler Guide Bar
147N2	Change Gear Guard Bracket	608N1	Tumbler Plungers
160X16	Pins, Small Compound Gear (Cone Gear Shaft)	610N1	Plunger Bushings
160X16	Pins, Small Compound Gear (Main Drive Shaft)	614N1	Cone Gear Shaft
160X16	Pins, Tumbler Comp. Gear (Cone Gear Shaft)	615K16N1	Cone Gear—16 Teeth
160X17	Pin, Large Compound Gear (Main Drive Shaft)	615K18N1	Cone Gear—18 Teeth
160X17	Pin, Small Compound Gear (Main Drive Shaft)	615K20N1	Cone Gear—20 Teeth
160X19	Pins, Tumbler Guide Bar	615K22N1	Cone Gear—22 Teeth
160X28	Pins, Tumbler Plunger	615K23N1	Cone Gear—23 Teeth
160X31	Pin, Main Drive Shaft Bushing	615K24N1	Cone Gear—24 Teeth
160X42	Pins, Tumbler	615K26N1	Cone Gear—26 Teeth
160X251	Pin, Cone Gear	615K28N1	Cone Gear—28 Teeth
160X252	Tumbler Idler Gear Shafts	619N1	Small Compound Gear (Main Drive Shaft)
160X252	Pin, Cone Gear	620N1	Main Pinion Shaft
161X21	Washer, Idler Gear Bolt	621N1	Tumbler Gears
161X21	Washer, Main Drive Shaft	622N1	Tumbler Compound Gear (Cone Gear Shaft)
162X50	Springs, Tumbler Plunger Knob	623N1	Small Compound Gear (Cone Gear Shaft)
164X2	Key, Lead Screw	624N1	Cone Shaft Gear
164X17	Key, Main Drive Shaft (Large)	625N1	Small Compound Gear (Main Drive Shaft)
164X22	Key, Cone Gear Shaft	626N1	Large Compound Gears (Cone Gear Shaft)
164X86	Key, Main Drive Shaft (Small)	627N1	Large Compound Gear (Main Drive Shaft)
168X108	Pin, Main Drive Shaft Collar	628N1	Lead Screw Gear
168X310	Pin, Cone Gear	629W3N1	Lead Screw for 3-foot Bed
168X310	Pin, Lead Screw Thrust Collar	629W35N1	Lead Screw for 3½-foot Bed
189X33	Gear Box Expansion Plug	629W4N1	Lead Screw for 4-foot Bed
206X8	Tumbler Pinion Shaft	629W45N1	Lead Screw for 4½-foot Bed
247N1	Bolt, Idler Gear	650N2	Change Gear Guard for Underneath Motor Driven Lathes
255X20	Gear Box Oiler	1541N1	Index Plate
256X1	Cone Gear Shaft Wicking	2092	Babbitt for Rear Lead Screw Bracket
256X1	Tumbler Pinion Shaft Wicking	2093	Babbitt for Change Gear Guard Bracket



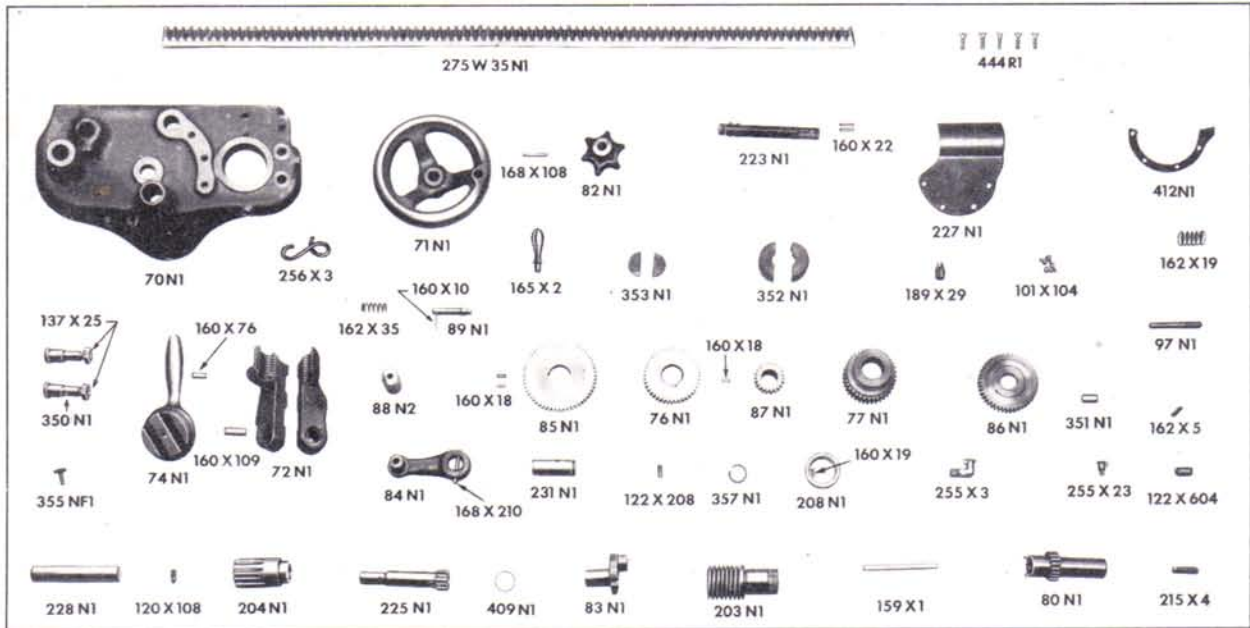
Saddle and Compound Rest Parts

Part No.	Name of Part	Part No.	Name of Part
57N1	Wiper Retainers, Left Front and Right Rear	165X1	Compound Rest Handle
58N1	Wiper Retainers, Right Front and Left Rear	165X1	Cross-Feed Handle
59N1	Felt Wipers	166X1	Compound Rest Graduated Collar Screw Shoe
60N1	Saddle	166X1	Cross-Feed Graduated Collar Screw Shoe
61N1	Saddle Gib	171X305	Lock Washers, Saddle Gib Screw
62N2	Saddle Lock	173X8	Compound Rest Wrench
63N1	Cross-Feed Bushing	209N1	Tool Post Block
64N1	Cross-Feed Graduated Collar	210N1	Collar Screw, Carriage Lock
65N1*	Nut, Cross-Feed	211N1	Compound Rest Clamping Shoes
90N1	Compound Rest Top	221N1*	Compound Rest Base Gib
91N1	Compound Rest Swivel	224JN2	Cross-Feed Screw for Model C Lathes
92N1*	Compound Rest Base	224N2	Cross-Feed Screw for Model A and B Lathes
94NR1	Compound Rest Bushing	230NR2	Screw, Compound Rest
95N1	Nut, Compound Rest	233N1	Screw, Tool Post
102X6	Screws, Felt Retainer	244N1	Screws, Apron to Saddle
110NR1	Compound Rest Graduated Collar	250N1	Tool Post
112X114	Screws, Saddle Gib	251N1	Tool Post Ring
122X102	Screw, Saddle Oil Hole	252N1	Tool Post Wedge
122X103	Screw, Compound Rest Graduated Collar	253N1	Tool Post Wrench
122X103	Screw, Cross-Feed Graduated Collar	257N1	Compound Rest Top Gib
122X444	Screws, Compound Rest Top Gib	276N1	Cross-Feed Ball Crank
122X446	Screws, Compound Rest Base Gib	277NR1	Compound Rest Ball Crank
122X508	Screw, Compound Rest Swivel	295NR1	Nut, Compound Rest Ball Crank
147X312	Lock Screws, Compound Rest	295NR1	Nut, Cross-Feed Ball Crank
160X17	Pin, Compound Rest Screw	358N1	Pin, Cross-Feed Nut Lock
160X17	Pin, Cross-Feed Screw	359N1	Screw, Cross-Feed Nut Lock Pin
160X79	Pins, Saddle Lock		

* Not used with Taper Attachment, see Taper Attachment page.

SOUTH BEND LATHE WORKS

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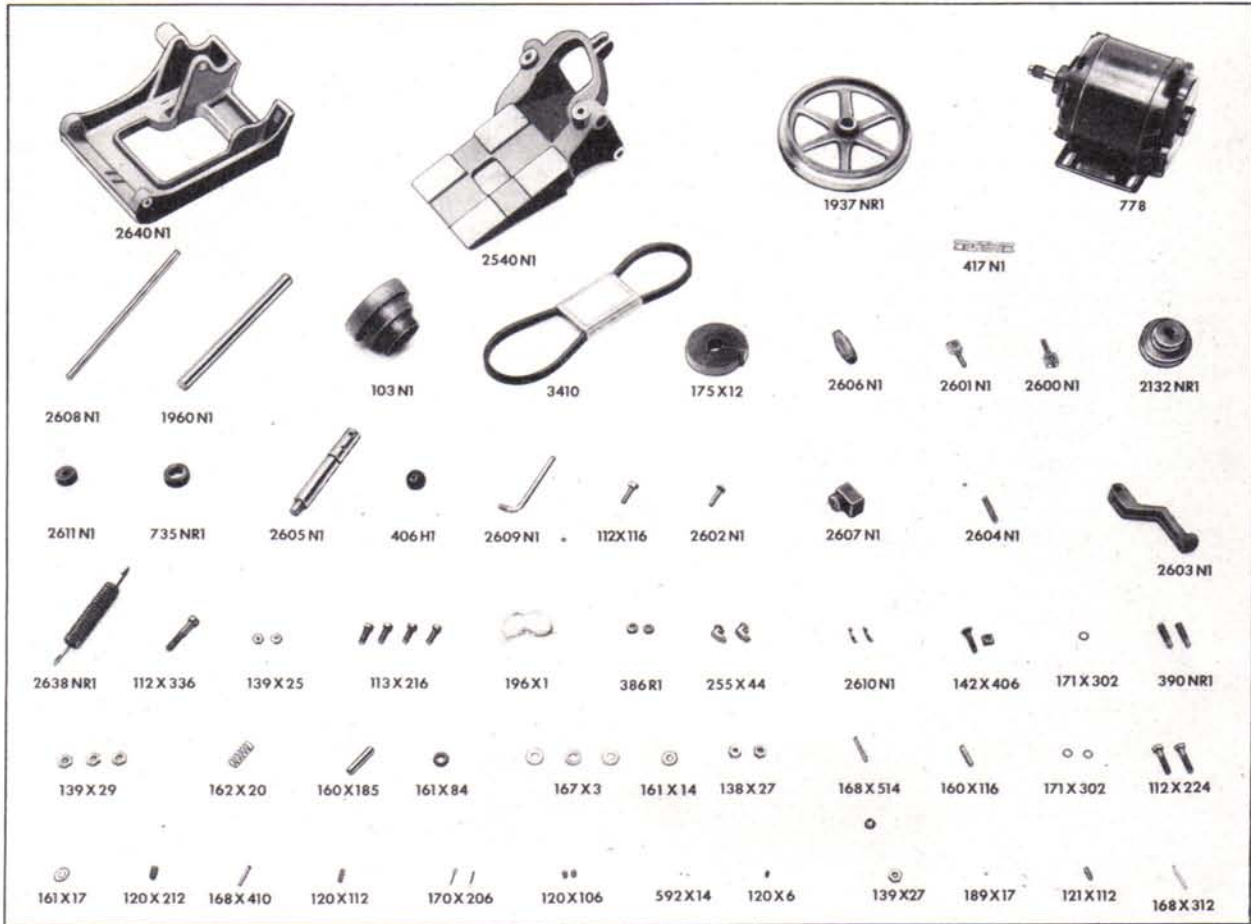
Apron Parts

Part No.	Name of Part
70N1	Apron.....
71N1	Handwheel.....
72N1	Half-Nuts.....
74N1	Half-Nut Cam.....
76N1	Rack Pinion Gear.....
77N1	Worm Gear.....
80N1	Clutch Sleeve.....
82N1	Clutch Knob.....
83N1	Idler Gear Shifter.....
84N1	Idler Gear Shifter Lever.....
85N1	Cross-Feed Compound Gear.....
86N1	Idler Gear.....
87N1	Cross-Feed Compound Pinion.....
88N2	Idler Gear Shifter Knob.....
89N1	Idler Gear Shifter Plunger.....
97N1	Feed Interlock Plunger.....
101X104	Screws, Oil Trough.....
120X108	Set Screw, Rack Pinion Stud.....
122X208	Set Screw, Cross-Feed Compound Gear Shaft.....
122X604	Set Screw, Cam Retainer Pin.....
137X25	Nuts, Half-Nut Stud.....
159X1	Key, Worm.....
160X10	Pin, Idler Gear Shifter Plunger.....
160X18	Pins, Cross-Feed Compound Pinion.....
160X18	Pin, Rack Pinion Gear.....
160X19	Pin, Worm Collar.....
160X22	Pins, Clutch Screw.....
160X76	Stop Pin, Half-Nut Cam.....
160X109	Pins, Half-Nut.....
162X5	Spring, Cam Retainer.....
162X19	Spring, Clutch Sleeve.....

Part No.	Name of Part
162X35	Spring, Shifter Plunger.....
165X2	Handwheel Handle.....
168X108	Pin, Handwheel.....
168X210	Pin, Idler Gear Shifter Lever.....
189X29	Plug, Reservoir.....
203N1	Apron Worm.....
204N1	Rack Pinion.....
208N1	Worm Collar.....
215X4	Half-Nut Oil Tube.....
223N1	Screw, Clutch.....
225N1	Handwheel Pinion.....
227N1	Oil Trough.....
228N1	Stud, Rack Pinion.....
231N1	Cross-Feed Compound Gear Shaft.....
255X3	Oiler, Reservoir.....
255X23	Oiler, Handwheel.....
256X3	Oil Wick, Apron Worm.....
275W3N1	Rack (for 3' bed).....
275W35N1	Rack (for 3½' bed).....
275W4N1	Rack (for 4' bed).....
275W45N1	Rack (for 4½' bed).....
350N1	Shoulder Screws, Half-Nut.....
351N1	Retainer Pin, Half-Nut Cam.....
352N1	Clutch Shoe.....
353N1	Clutch Shoe Expanders.....
355NF1	Screw, Clutch Knob.....
357N1	Spring, Cross-Feed Compound Gear Shaft.....
409N1	Spring, Handwheel Pinion.....
412N1	Oil Trough Gasket.....
444R1	Screws, Rack.....

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Motor Drive Unit Parts

Part No.	Name of Part
103NI	Countershaft Cone
112X116	Belt Tension Spring Screw
112X224	Cone Cradle Support Screws
112X336	Cone Cover Lock Pin Bracket Screw
113X216	Motor Screws
120X6	Belt Tension Turnbuckle Set Screw
120X106	Belt Tension Crankshaft Set Screw
120X106	Countershaft Cone Shaft Collar Set Screw
120X112	Combination Motor Pulley Set Screw
120X212	Countershaft Cone Set Screw
121X112	Belt Tension Crankshaft Set Screw
138X27	Cone Cradle Support Screw Nuts
139X25	Belt Tension Crankshaft Set Screw Nut
139X25	Belt Tension Spring Screw Nut
139X27	Countershaft Cone Set Screw Nut
139X29	Cone Cradle Support Pivot Screw Nuts
142X406	Cone Cradle Support Screw (Short) and Nut
160X116	Belt Tension Crankshaft Pin
160X185	Lock Pin

Part No.	Name of Part
161X14	Belt Tension Spring Screw Washer
161X17	Belt Tension Crank Pin Washer
161X84	Cone Cover Lock Pin Fibre Washer
162X20	Cone Cover Lock Pin Spring
167X3	Cone Cradle Support Screw Washers
168X312	Cone Cover Lock Pin Collar Pin
168X410	Belt Tension Crank Pin
168X514	Countershaft Drive Pulley Pin
170X206	Belt Tension Spring Pin Cotter Pin
170X206	Belt Tension Spring Crank Pin Cotter Pin
171X302	Cone Cradle Screw Lock Washers
175X12	Countershaft to Headstock Leather Belt
189X17	Belt Tension Crankshaft Turnbuckle Set Screw Shoe
196X1	Cone Cradle Oiler Wool
255X44	Cone Cradle Oilers
386R1	Cone Cradle Oiler Plugs
390NR1	Cone Cradle Support Pivot Screws
406H1	Belt Tension Crankshaft Lever Handle Knob

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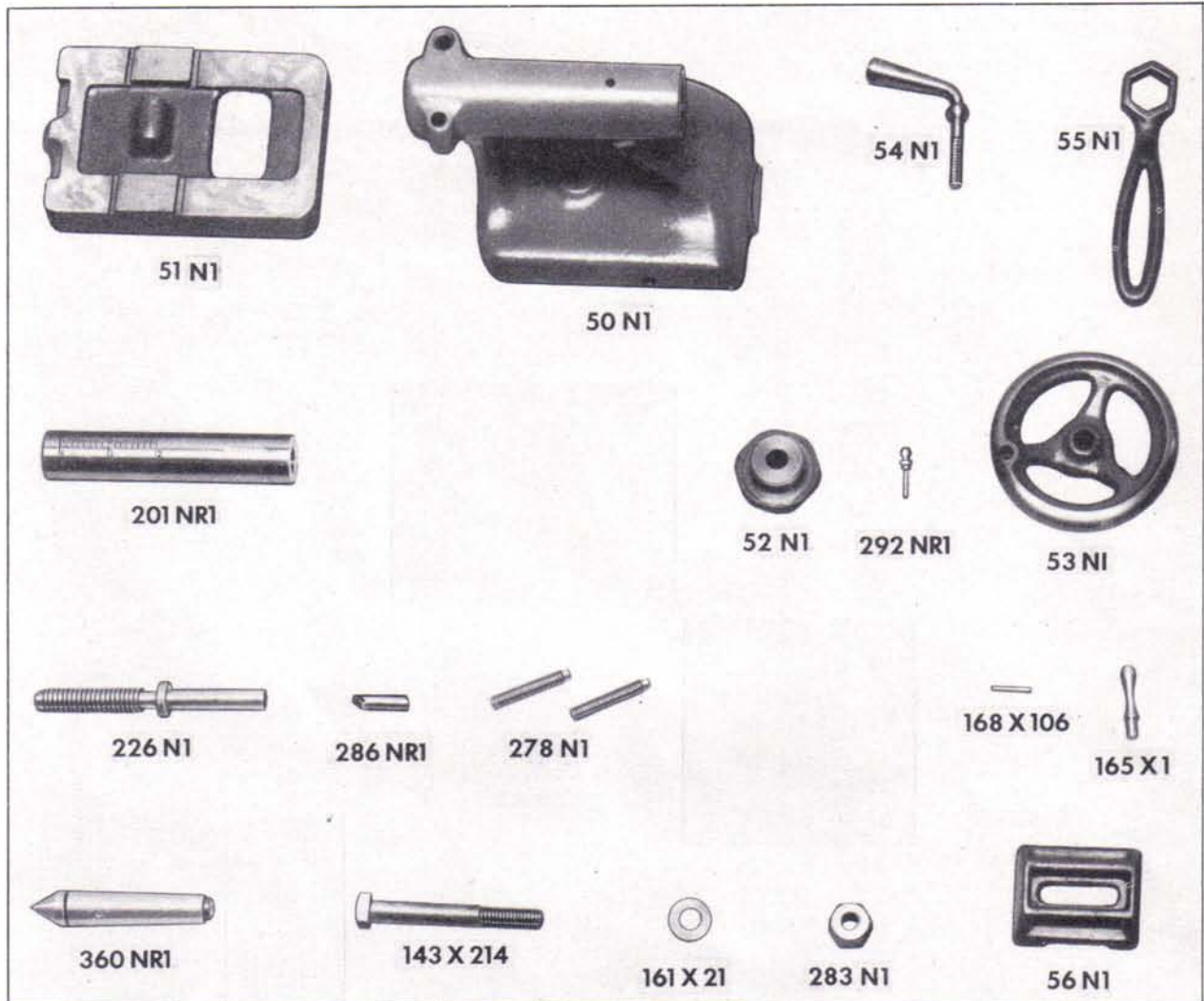
Motor Drive Unit Parts

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Part No.	Name of Part	Part No.	Name of Part
417N1	Belt Tension Release Plate	2601N1	Left Belt Tension Rod
592X14	Belt Release Plate Escutcheon Pins	2602N1	Belt Tension Spring Pin
735NR1	Countershaft Cone Shaft Collar	2603N1	Belt Tension Crank
778	Motor (state make, h.p., cycle, r.p.m., voltage, phase, and A.C. or D.C.)	2604N1	Belt Tension Spring Crank Pin
1937NR1	Countershaft Drive Pulley	2605N1	Belt Tension Crankshaft
1960N1	Countershaft Cone Shaft	2606N1	Belt Tension Turnbuckle
2130NR1	Combination Motor Pulley (for $\frac{1}{2}$ " motor shaft)	2607N1	Cone Cover Lock Pin Bracket
2131NR1	Combination Motor Pulley (for $\frac{5}{8}$ " motor shaft)	2608N1	Cone Cover Lock Pin
2132NR1	Combination Motor Pulley (for $\frac{3}{4}$ " motor shaft)	2609N1	Belt Tension Crankshaft Lever Handle
2540N1	Cone Cradle	2610N1	Cone Cradle Oiler Springs
2600N1	Right Belt Tension Rod	2611N1	Cone Cover Lock Pin Collar
		2638NR1	Belt Tension Spring
		2640N1	Cone Cradle Support
		3410	V-Belt, Motor Pulley to Countershaft

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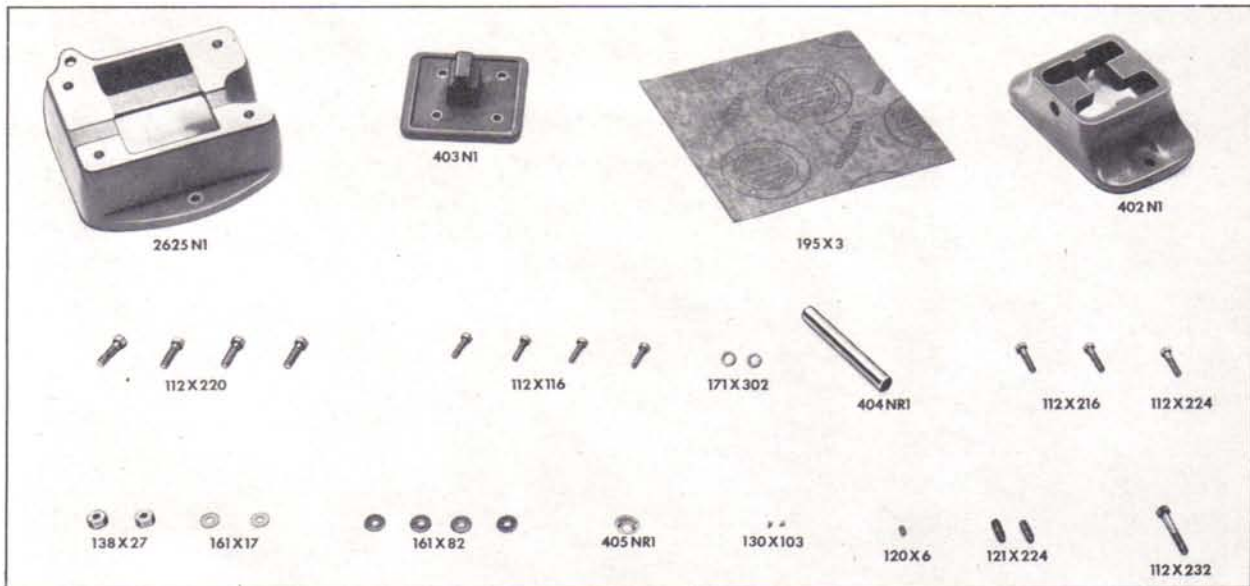


Tailstock Parts

Part No.	Name of Part	Part No.	Name of Part
50N1	Top	165X1	Handwheel Handle
51N1	Base	168X106	Pin, Handwheel
52N1	Nut, Spindle Screw	201NR1	Spindle
53N1	Handwheel	226N1	Screw
54N1	Binding Lever	278N1	Set Screws, Set-Over
55N1	Wrench	283N1	Nut, Clamp Bolt
56N1	Clamp	286NR1	Key, Spindle
143X214	Clamp Bolt	292NR1	Plug, Oil Reservoir
161X21	Washer, Clamp Bolt	360NR1	Center (Catalog No. 726-W)

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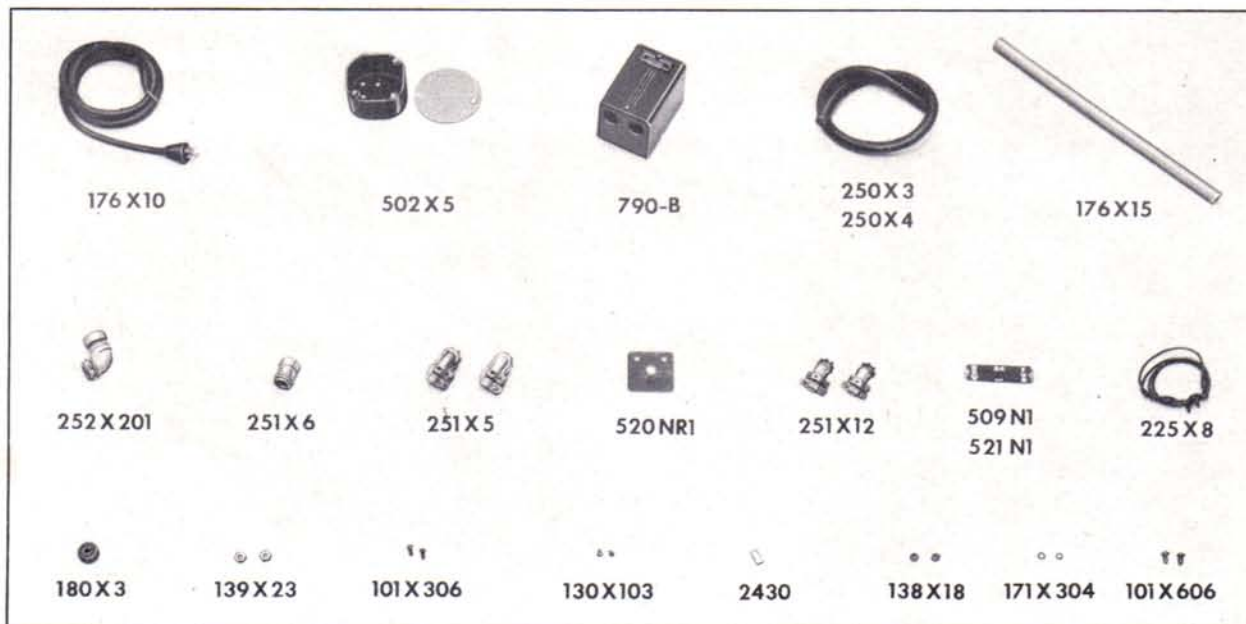
Bench Leg Parts

Part No.	Name of Part
112X116	Screw, Bench Leg Top.....
112X216	Screws, Bench Leg Base.....
112X220	Screws, Headstock Bench Leg.....
112X224	Screw, Headstock Bench Leg.....
112X232	Screw, Headstock Bench Leg.....
120X6	Set Screw, Tailstock Bench Leg Shaft.....
121X224	Set Screws, Bench Leg Base.....
121X232	Screws, Tailstock Bench Leg Leveling.....
130X103	Escutcheon Pins, Leveling Plate.....
138X27	Nuts, Headstock Bench Leg Screw.....

Part No.	Name of Part
161X17	Washers, Headstock Bench Leg Screw.....
161X82	Lead Washers, Leg Screw.....
171X302	Lock Washers, Headstock Bench Leg Screw..
195X3	Gasket, Headstock Bench Leg.....
402N1	Tailstock Bench Leg Base.....
403N1	Tailstock Bench Leg Top.....
404NR1	Tailstock Bench Leg Shaft.....
405NR1	Leveling Screw Plate.....
2625N1	Headstock Bench Leg.....

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Motor Control Switch Parts (A. C. and D. C.)

Part No.	Name of Part	Part No.	Name of Part
101X306	Screws, Switch.....	251X5*	Conduit Connectors, 90°.....
101X606	Screws, Outlet Box.....	251X6	Conduit Connector, Straight.....
130X103	Escutcheon Pins, Switch Plate.....	251X12**	Conduit Connectors, 90°.....
138X18	Nuts, Switch Screw.....	252X201	Conduit Elbow.....
139X23	Nuts, Outlet Box Screw.....	502X5	Outlet Box.....
171X304	Lock Washers, Switch Screw.....	509N1*	Switch Plate.....
176X10*	Rubber Cord Set.....	520NR1	Switch Spacer.....
176X15	Thinwall Conduit.....	521N1**	Switch Plate.....
180X3*	Grommet, Rubber Switch.....	790B	Switch.....
225X8	Wire, Stranded Insulated.....	2430	Switch Knob Spacer.....
250X3*	Wire, 4—Conductor.....		* omit for D. C.
250X4**	Wire, 5—Conductor.....		** omit for A. C.