

LATHE BULLETIN 10L-6  
Replaces Bulletin 10L-5

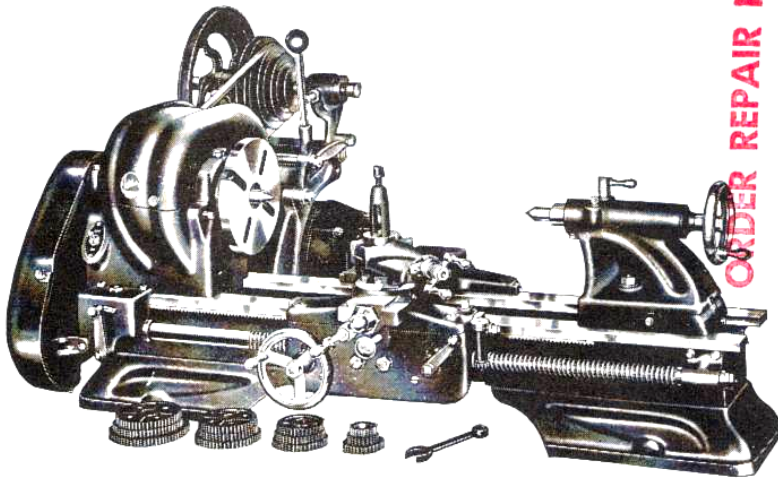
# Atlas

## PARTS LIST FOR SERIES ATLAS LATHES

FOR ATLAS TIMKEN BEARING LATHES:  
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: TH36, TH42, TH48, TH54  
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: TV36, TV42, TV48, TV54

FOR ATLAS BABBITT BEARING LATHES:  
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: H36, H42, H48, H54  
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: V36, V42, V48, V54

FOR ATLAS QUICK-CHANGE LATHES:  
Cat. Nos.: QC42 and QC54



ORDER REPAIR PARTS  
FROM

CLAUSING SERVICE CENTER  
2306 EISENHOWER DRIVE  
GOSHEN, INDIANA 46526

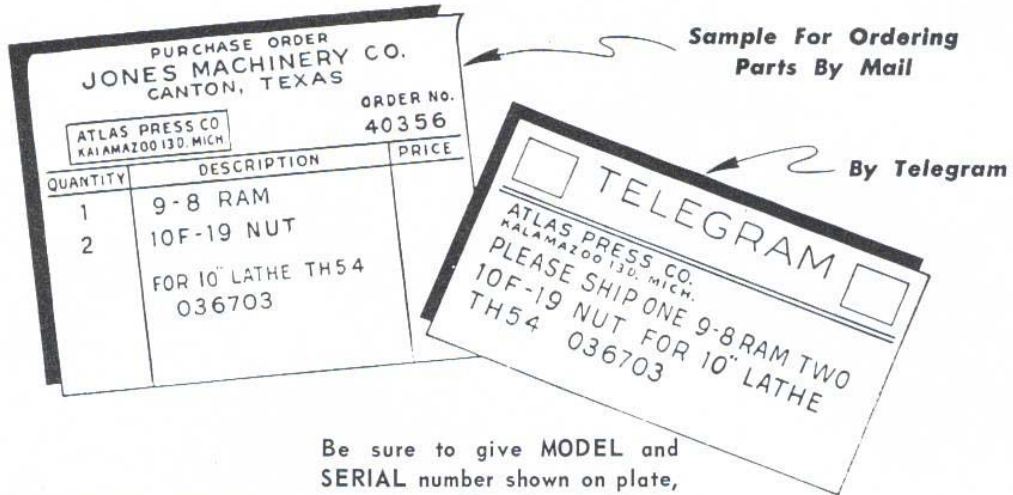
**GRESS CO. • Kalamazoo, Mich., U.S.A. 49001**

*SINCE 1911, MANUFACTURERS OF PRECISION MACHINE TOOLS*

PRINTED IN U.S.A.

**IMPORTANT:** The following information must be furnished on all repair part orders.

1. Quantity Required
2. PART NUMBER and Name of Part
3. Model and Serial Number of Lathe



Be sure to give MODEL and SERIAL number shown on plate, located at tailstock end of lathe bed.

NOTE: On Lathes without this plate, MODEL and SERIAL Number is found on top of FRONT BED-WAY.

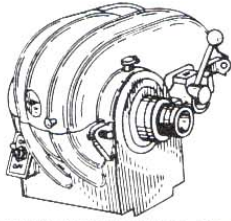


Parts shown without part numbers are standard parts and should be purchased locally.  
We reserve the right to make changes in design and specifications without notice.

## INDEX FOR LATHE PARTS AND PRICES

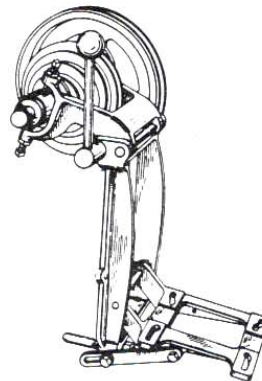
	Page
Unit Assemblies . . . . .	3
Babbitt Bearing Headstock . . . . .	4
Timken Bearing Headstock . . . . .	5
Carriage and Compound . . . . .	6
Lead Screw and Feed Gears . . . . .	7
Countershaft . . . . .	8
Tailstock, Bed and Rack . . . . .	9
Quick Changes . . . . .	10 & 11

# Atlas 10" F-SERIES LATHE UNIT ASSEMBLIES

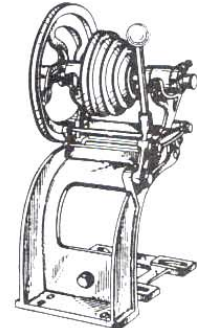


10A-2BXH TIMKEN BEARING HEADSTOCK ASSEMBLY  
For Horizontal Countershaft Lathes

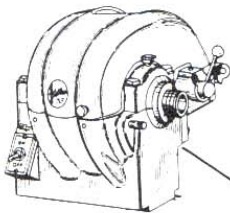
10A-2BXV TIMKEN BEARING HEADSTOCK ASSEMBLY  
For Vertical Countershaft Lathes



9-20X VERTICAL COUNTERSHAFT ASSEMBLY

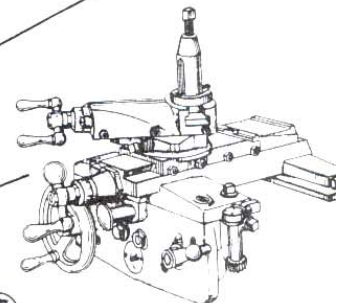


10-20X HORIZONTAL COUNTERSHAFT ASSEMBLY

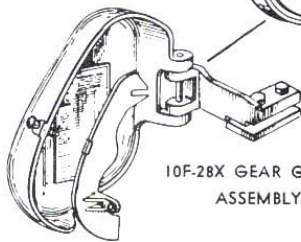


10A-2BXH TIMKEN BEARING HEADSTOCK ASSEMBLY  
For Horizontal Countershaft Lathes  
Replaces 10D-2BXH Babbitt Bearing Headstock Assembly

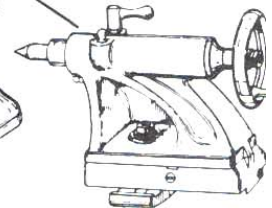
10A-2BXV TIMKEN BEARING HEADSTOCK ASSEMBLY  
For Vertical Countershaft Lathes  
Replaces 10D-2BXV Babbitt Bearing Headstock Assembly



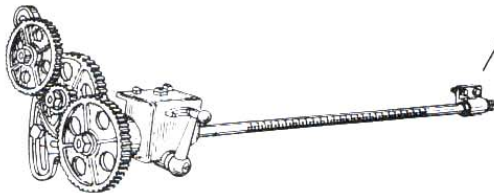
10F-9XY CARRIAGE ASSEMBLY



10F-28X GEAR GUARD ASSEMBLY



10D-5X TAILSTOCK ASSEMBLY



LEAD SCREW AND FEED GEAR ASSEMBLY



BED, LEGS AND RACK ASSEMBLY

10L - 6

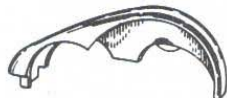
10F-35-36X 36" MODEL LATHE  
10F-35-42X 42" MODEL LATHE  
10F-35-48X 48" MODEL LATHE  
10F-35-54X 54" MODEL LATHE

3

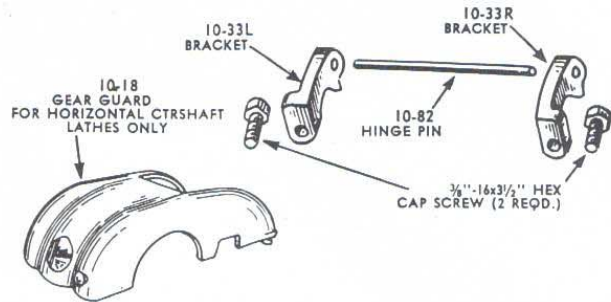
9-1 BX 36" MODEL LATHE Not Available  
942BX 42" MODEL LATHE  
948BX 48" MODEL LATHE Not Available  
954BX 54" MODEL LATHE



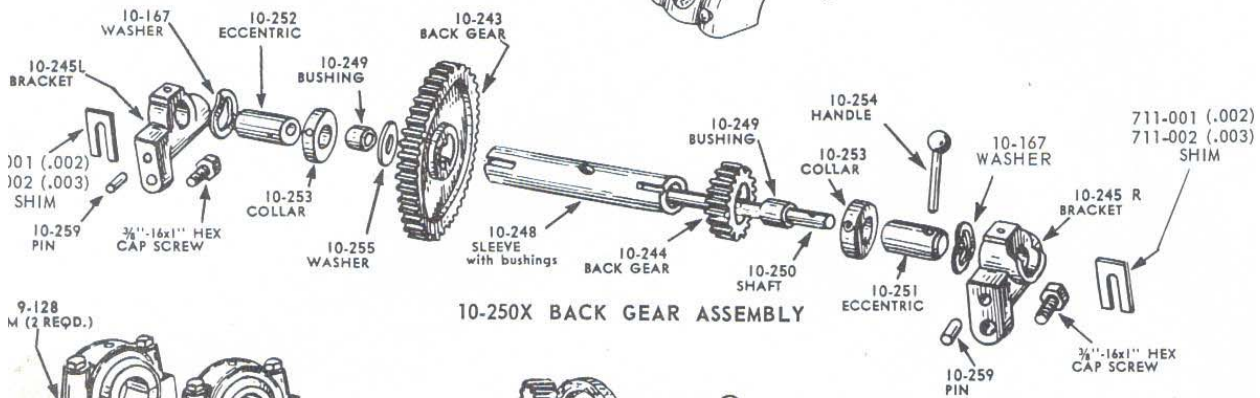
Not Available  
10D-246  
GEAR GUARD (RIGHT)  
FOR VERTICAL CTRSHAFT  
LATHES ONLY



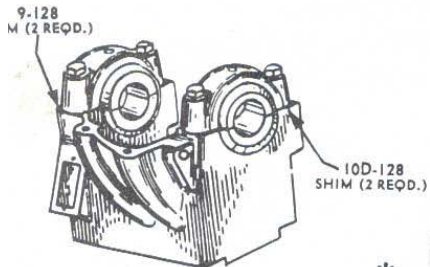
Not Available  
10D-247  
GEAR GUARD (LEFT)  
FOR VERTICAL CTRSHAFT  
LATHES ONLY



10-18  
GEAR GUARD  
FOR HORIZONTAL CTRSHAFT  
LATHES ONLY

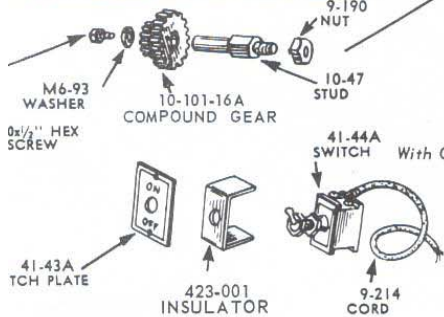


10-250X BACK GEAR ASSEMBLY



10D-128  
SHIM (2 REQ'D.)

10D-2BA TIMKEN BEARING HEADSTOCK  
Replaces 10D-2BA Babbitt Bearing Headstock



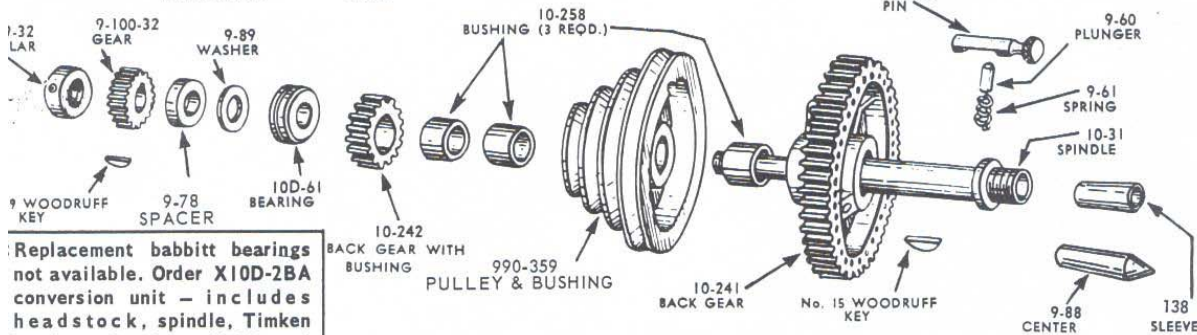
10A-2BXH HEADSTOCK ASSEMBLY

With Gear Guard - for Horizontal Countershaft Lathe

10A-2BXY HEADSTOCK ASSEMBLY

for Vertical Countershaft Lathe

Replaces 10D-2B XV



10-31X SPINDLE ASSEMBLY

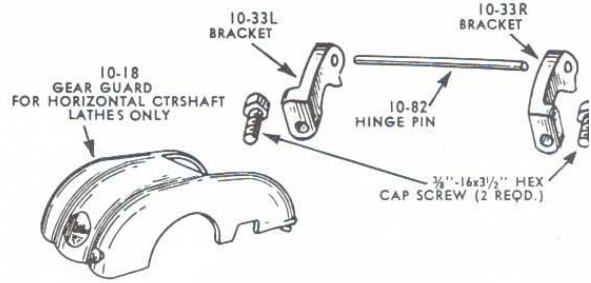
Replacement babbitt bearings not available. Order X10D-2BA conversion unit - includes headstock, spindle, Timken bearings, bearing shields and thrust collar.



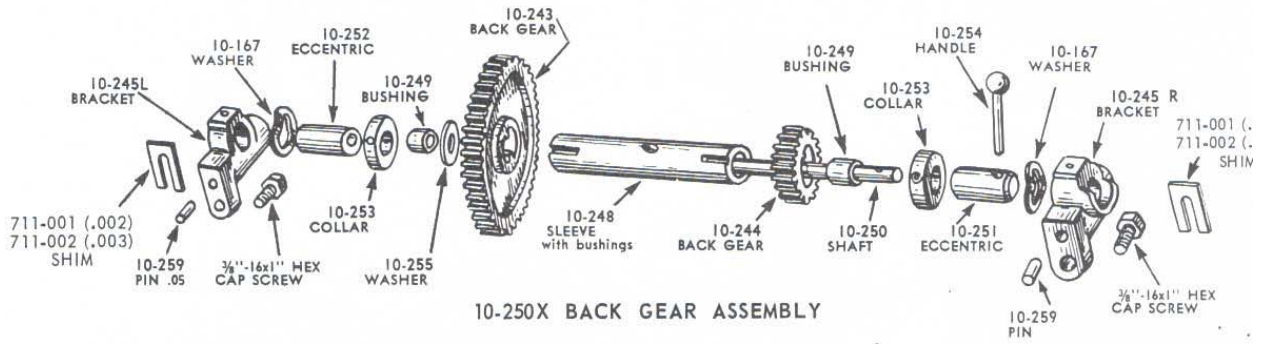
NOT AVAILABLE  
10D-246  
GEAR GUARD (RIGHT)  
FOR VERTICAL CTRSHAFT  
LATHES ONLY



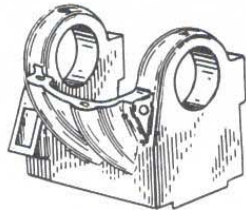
NOT AVAILABLE  
10D-247  
GEAR GUARD (LEFT)  
FOR VERTICAL CTRSHAFT  
LATHES ONLY



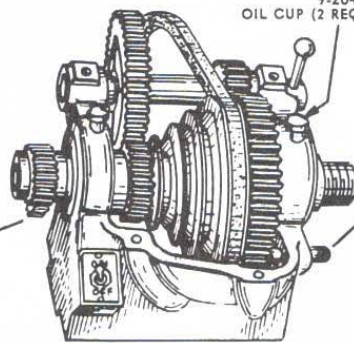
10-18  
GEAR GUARD  
FOR HORIZONTAL CTRSHAFT  
LATHES ONLY



10-250X BACK GEAR ASSEMBLY

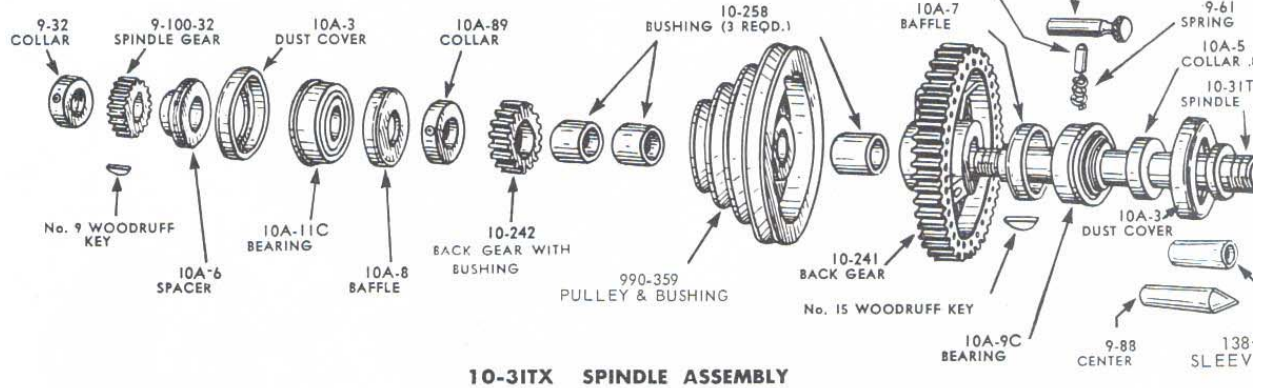
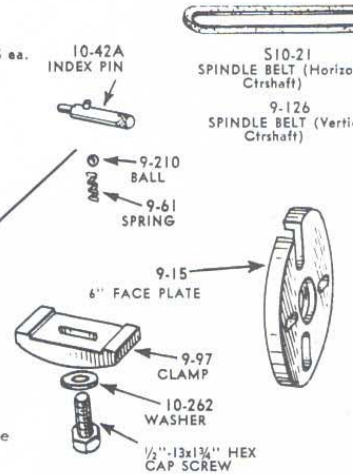
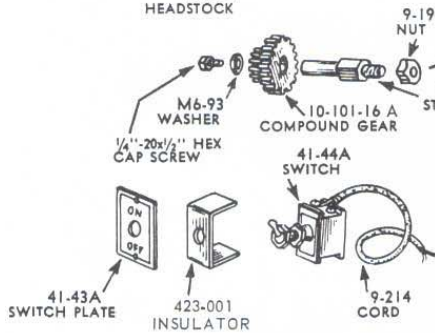


10A-2B  
HEADSTOCK

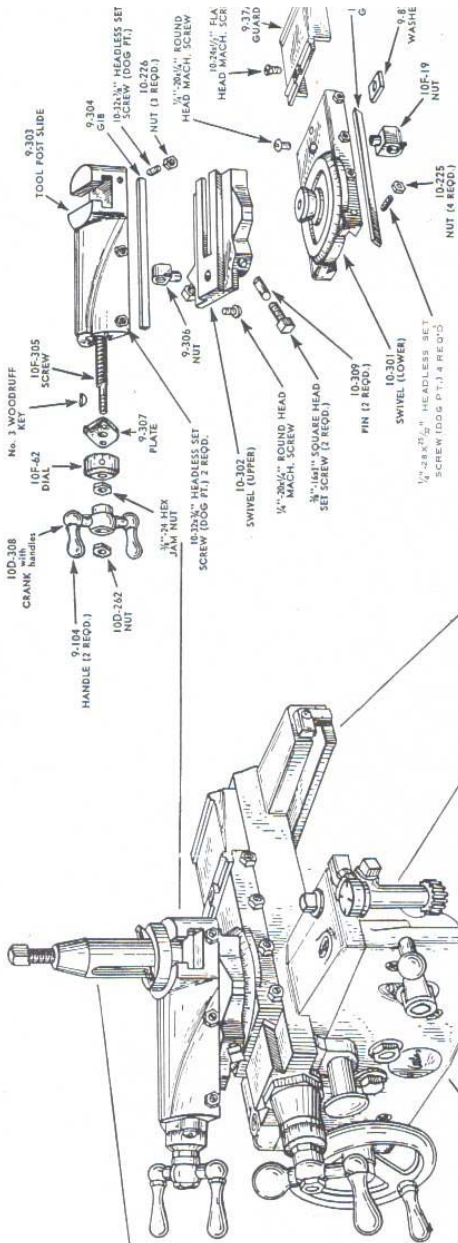


10A-2BXH HEADSTOCK ASSEMBLY  
With Gear Guard - for Horizontal Countershaft Lathe

10A-2BXV HEADSTOCK ASSEMBLY  
for Vertical Countershaft Lathe



10-31TX SPINDLE ASSEMBLY



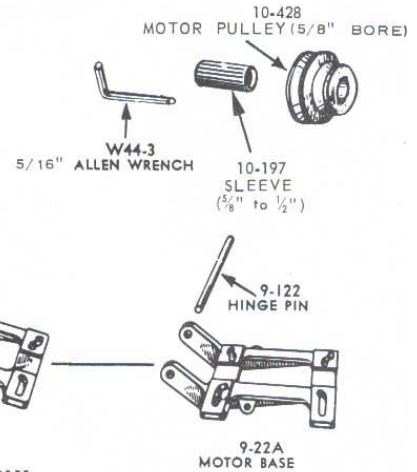
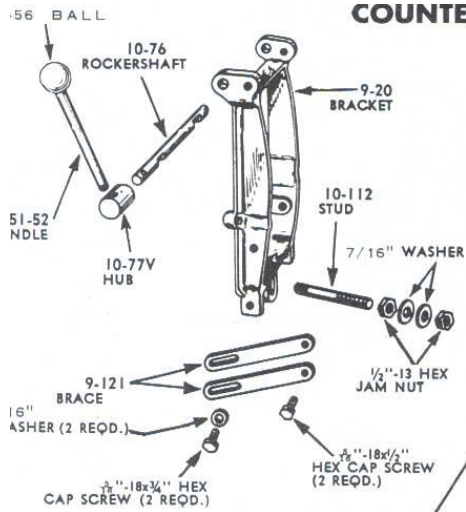
**10-301X COMPOUND REST ASSEMBLY**

**9-62X THREADING DIAL ASSEMBLY**

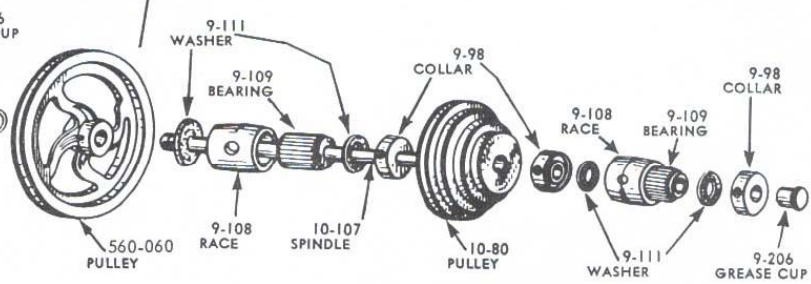
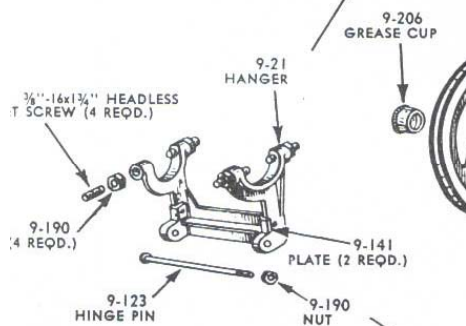
**10F-9XY CARRIAGE ASSEMBLY**



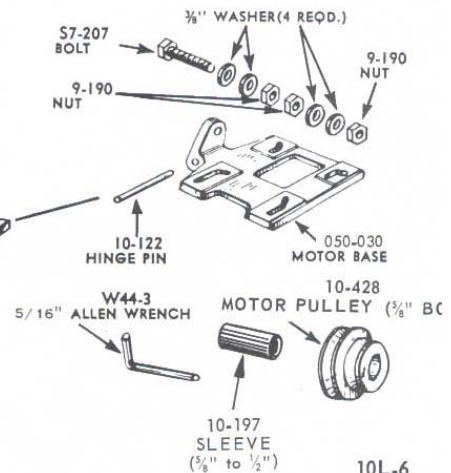
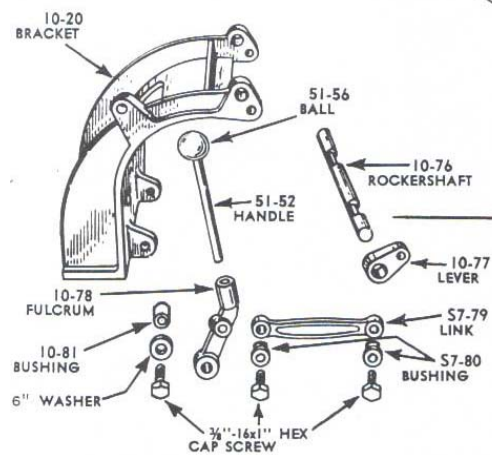
## COUNTERSHAFT PARTS



**9-20X VERTICAL COUNTERSHAFT ASSEMBLY WITH MOTOR BELT AND PULLEY**

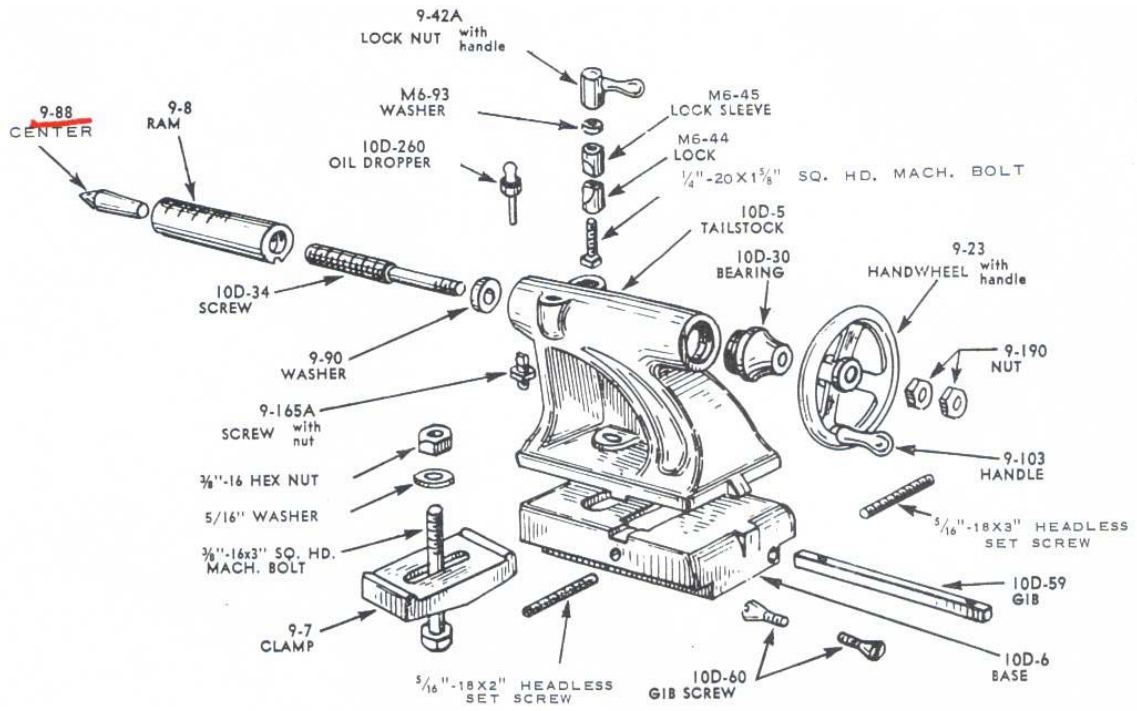


**10-107X COUNTERSHAFT SPINDLE ASSEMBLY**



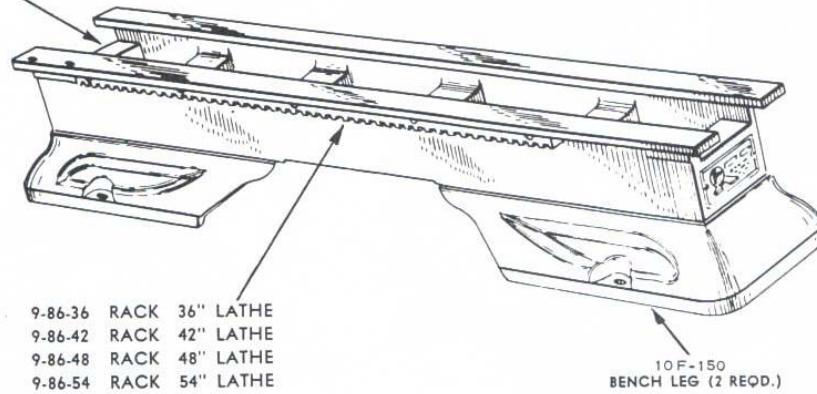
**10-20X HORIZONTAL COUNTERSHAFT ASSEMBLY WITH MOTOR BELT AND PULLEY**





**10D-5X TAILSTOCK ASSEMBLY**

942 B 42" LATHE BED ONLY  
 954 B 54" LATHE BED ONLY



**BED, LEGS, AND RACK ASSEMBLY**

942BX 42" MODEL LATHE  
 954BX 54" MODEL LATHE





INSTRUCTIONS and PARTS



ATLAS PRESS COMPANY  
KALAMAZOO, MICHIGAN 49001

# THREADING CHART

for  
10F-series 10" ATLAS LATHES  
with 3/4" diameter lead screw

DECEMBER, 1966 FILE NO. 10-99A

FIG. 1  
SPINDLE  
SCREW  
SET UP FOR 1/2" THREADS

FIG. 2  
SPINDLE  
SCREW  
SET UP FOR 3/8" THREADS

FIG. 3  
SPINDLE  
SCREW  
SET UP FOR 1/4" THREADS

FIG. 4  
SPINDLE  
SCREW  
SET UP FOR 5/16" THREADS

FIG. 5  
SPINDLE  
SCREW  
SET UP FOR 3/16" THREADS

FIG. 6  
SPINDLE  
SCREW  
SET UP FOR 1/8" THREADS

FIG. 7  
SPINDLE  
SCREW  
SET UP FOR 3/32" THREADS

FIG. 8  
SPINDLE  
SCREW  
SET UP FOR 1/16" FEED

FIG. 9  
SPINDLE  
SCREW  
SET UP FOR 1/32" FEED

## THREADING CHART

A-B-C-D ARE GEAR STUD POSITIONS  
B = BACK POSITION (TOWARD HEADSTOCK)  
F = FRONT POSITION (AWAY FROM HEADSTOCK)  
I = IDLER GEAR S = SPACER — = BLANK  
X = 24 TOOTH GEAR IN BACK POSITION (SS) = DOUBLE KEYWAY SPACER

THREADS PER INCH	SCREW	POSITION D		POSITION C		POSITION B		POSITION A		SPINDLE STUD GEAR	FIG.
		B	F	B	F	B	F	B	F		
4	32F					24	48	64I	20S	32	1
4.5	36F					32	64	64I	20S	32	1
5	40F					32	64	64I	20S	32	1
5.5	44F					32	64	64I	20S	32	1
6	48F					32	64	64I	20S	32	1
6.5	52F					32	64	64I	20S	32	1
7	56F					32	64	64I	20S	32	1
8	32B					48I	20S	46I	24S	32	2
9	36B					32I	20S	64I	24S	32	2
10	40B					32I	20S	64I	24S	32	2
11	44B					32I	20S	64I	24S	32	2
11.5	46B					32I	20S	64I	24S	32	2
12	48B					32I	20S	64I	24S	32	2
13	52B					32I	20S	64I	24S	32	2
14	56B					32I	20S	64I	24S	32	2
16	64B					32I	20S	64I	24S	32	2
18	36F					20S	64I	64	32	32	3
20	40F					20S	64I	64	32	32	3
22	44F					20S	64I	64	32	32	3
23	46F					20S	64I	64	32	32	3
24	48F					20S	64I	64	32	32	3
26	52F					20S	64I	64	32	32	3
27	54F					20S	64I	64	32	32	3
28	56F					20S	64I	64	32	32	3
32	64F					20S	56I	48	24	32	3
36	36B					64I	20S	24	48	16	4
40	40B					64I	20S	32	64	16	4
44	44B					64I	20S	32	64	16	4
48	48B					64I	20S	32	64	16	4
56	56B					64I	20S	32	64	16	4
64	64B					64I	20S	24	48	16	4
72	36F	20S	64I			64	32	24	48	16	5
80	40F	20S	64I			64	32	24	48	16	5
96	48F	40	20			64I	24S	32	64I	16	6

FEED PER REVOLUTION OF SPINDLE

FEED	SCREW	POSITION D	POSITION C	POSITION B	POSITION A	STUD	FIG.				
.001877	64B		20	64	52	20	24	48	16	—	
.0035	64F				64	20	20	56	16	7	
.005	64F X	52	20			54I	(SS)	20	48	16	—
.006	64F	52	20			54I	(SS)	24	48	16	—
.007	64B					20	64	56	20	32	—
.0087	64F	56	20			36	46	20S	64I	16	—

### METRIC THREADING CHART

PITCH IN MILLIMETERS	GEAR ON SCREW	POSITION D	POSITION C	POSITION B	POSITION A	SPINDLE STUD GEAR	FIG.				
.5	48F	40	44			52I (SS)	24	56	16	8	
.75	64F	40	32			52	44	20S	56I	16	—
1.00	44F	40	32			52	48	20S	64I	16	—
1.25	44B					52	48	20S	64I	16	—
1.50	44B					52	40	20S	64I	16	—
1.75	44F	48	52			56	40	20S	64I	16	—
2.00	40F	44	48			52	36	20S	64I	16	—
2.5	44B					52	24	20S	64I	16	—
3.0	44B					52	20	24S	64I	16	—
3.5	44F	48	56			52	20	24S	64I	16	—
4.0	20F	44	48			52	36	24S	64I	16	9
4.5	20F	44	54			52	36	20S	64I	16	—
5.0	24F	44	52			40	20	20S	64I	16	—
5.5	20F					48	52	64I	24S	32	—
6.0	20F	44	52			48	24	32S	64I	16	—
7.0	48B	52	44			20	56	64I	24S	32	—