

## ATTACHMENTS, CHUCKS, TOOLS and ACCESSORIES

For

### SOUTH BEND LATHES

South Bend Lathes are noted for the number of practical attachments with which they can be equipped for taking care of milling, keyway cutting, grinding, turning tapers and etc., in the Tool Room, Manufacturing Plant and General Machine Shop. Most of these attachments may be purchased with the lathe or ordered later when needed. These attachments are illustrated, described and priced in this bulletin for each size South Bend Lathe. Many of the attachments listed are designed for use only on South Bend Lathes and cannot be used on other makes.

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## South Bend Lathe Works

425 East Madison St., South Bend, Indiana, U. S. A.

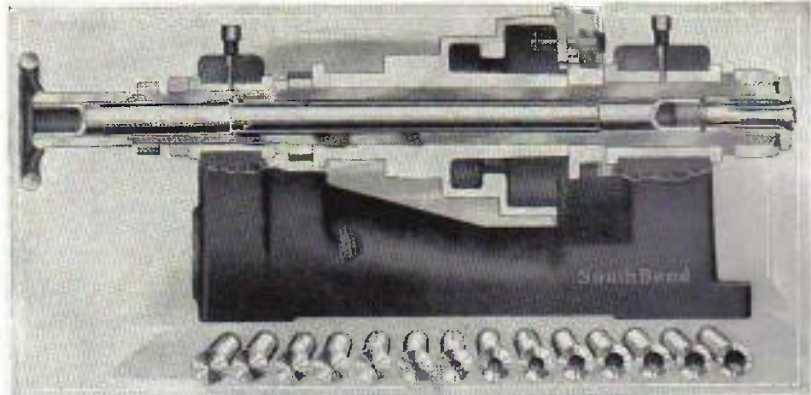
# Draw-in Collet Chuck Attachments for South Bend Lathes

## For Accurately Chucking Small Diameter Work

The Draw-in Collet Chuck is used on the lathe in the tool room for making small accurate tools and in the manufacturing plant for making small parts for watches, typewriters, sewing machines, radios, etc. It is the most accurate type of chuck made and will center any small work instantly. The hollow draw bar permits bars and rods to be passed through the lathe spindle and held in the collet for machining.

### How The Collet Chuck Operates

The hollow draw bar extending through the lathe spindle is threaded on the right end to fit the collet. When the hand wheel on the left end of the draw bar is turned, the spring collet is drawn into the taper closing sleeve, causing it to tighten on the work.



A Cross Section of the Lathe Headstock Showing Hand Wheel Draw-in Collet Chuck

## Hand Wheel Type Draw-in Collet Chuck Attachment



Hand Wheel Type Draw-in Collet Chuck Attachment and Equipment.

Prices of Hand Wheel Draw-in Collet Chuck with One Round Split Collet

Size of Lathe	Catalog No.	Hole in Lathe Spindle	Collet Capacity in Sixty-Fourths (for Round Work)	Code Word	Price Each
"Workshop"	4308W	3/4 in.	1/8 in. up to 1/2 in.	Aerut	\$25.00
9 in.	4309	3/4 in.	1/8 in. up to 1/2 in.	Aaron	32.00
11 in.	4311	1 in.	1/8 in. up to 3/4 in.	Abode	35.00
13 in.	4313	1 1/8 in.	1/8 in. up to 3/4 in.	Abort	40.00
15 in.	4315	1 1/2 in.	1/8 in. up to 3/4 in.	Above	45.00
16 in.	4316	1 3/4 in.	1/8 in. up to 3/4 in.	Adore	50.00

The Hand Wheel Type Draw-in Collet Chuck attachment is used to great advantage in the tool room in making small tools and parts where accuracy is essential. It is also suitable for small lot production work in the manufacturing plant. The work is held in the collet chuck by turning the hand wheel to the right and released by turning it to the left. It is necessary to stop the lathe spindle in order to open or close the chuck.

The capacity of the draw-in collet chuck is limited by the size of the hole in the spindle of the lathe on which it is used.

### Equipment Included In Price

The price of the Hand Wheel Draw-in Collet Chuck Attachment includes hand wheel and hollow draw bar, spindle nose cap, spanner wrench for nose cap, tapered steel closing sleeve, and one round, split collet of any size desired up to the maximum capacity of lathe. The tapered closing sleeve is made of tool steel, hardened and ground, to minimize wear and to insure accuracy.



Split Collets in Standard Hole Sizes for Round Work

Size of Lathe	Catalog No.	Hole in Spindle	Collet Sizes in Sixty-Fourths	Code Word	Price Each
Workshop	609-W	3/4 in.	1/8 in. up to 1/2 in.	Castra	\$4.00*
9 in.	609	3/4 in.	1/8 in. up to 1/2 in.	Cabot	4.00*
11 in.	611	1 in.	1/8 in. up to 3/4 in.	Cello	4.25*
13 in.	613	1 1/8 in.	1/8 in. up to 3/4 in.	Chose	4.75*
15 in.	615	1 1/2 in.	1/8 in. up to 3/4 in.	Civit	5.00*
16 in.	616	1 3/4 in.	1/8 in. up to 3/4 in.	Clear	5.50*

\*Price of Split Collets 3/8", 1/2", and 5/8" capacity, \$1.00 extra.  
 No. 609W—Special Collet for 9-inch lathes, has 1/8-inch hole in front end for holding Jewelers' Plunger Blanks.....\$4.50  
 No. 611—Special Collet for 11-inch lathes, 5/8" capacity... 4.75  
 No. 613—Special Collet for 13-inch lathes, 1 1/8" capacity... 5.25

## Split Collets for Round Work

### Used in Draw-in Collet Chuck Attachments

Split Collets for round work, as illustrated at left, are widely used for manufacturing and in the tool room. Collets for Draw-in Collet Chuck Attachments used on all South Bend Lathes are made of tool steel, hardened and tempered. They are ground both outside and inside to insure accuracy. The left end is threaded for the hollow draw bar of the draw-in chuck and has a keyway to prevent the collet from turning while holding the work. The other end is tapered to conform to the tapered closing sleeve of the attachment. Three slots divide the tapered end of the collet into segments. This permits the collet to grip or release the work as it is drawn into or released from the tapered closing sleeve in the lathe spindle.



Cross Section View of Split Collet showing its accurate construction

### Special Collets

Collets for odd diameter round work measured in thousandths of an inch or in millimeters, also collets for odd diameter drills and wire gauges, can be supplied for each size South Bend Lathe at an additional charge of \$1.00 each.

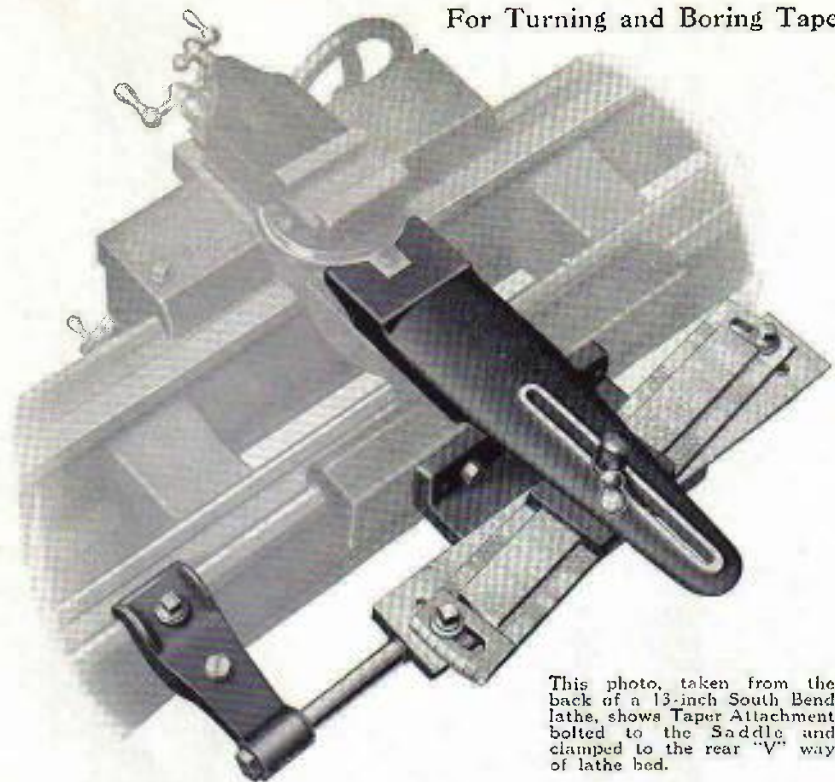
Prices of special split collets for holding round, square, and hexagonal stock quoted on request.



Round Split Collets with Hole Sizes Ranging from 1/8" up by Steps of 64ths of an Inch.

## Graduated Taper Attachment for South Bend Lathes

For Turning and Boring Taper Work



This photo, taken from the back of a 13-inch South Bend lathe, shows Taper Attachment bolted to the Saddle and clamped to the rear "V" way of lathe bed.



Close-up of Graduation On End of Swivel Bar

The Swivel Bar, which controls the Taper, is graduated—one end in inches per foot of taper and the other end in degrees. The attachment can be set for any Taper up to 3 inches per foot.

The Taper Attachment is used for tool room, manufacturing and production work for turning and boring all classes of tapers. It is especially practical on production work where a large number of duplicate parts are to be taper machined by turning or boring. The attachment may be left on the lathe at all times when doing either taper or straight work. It requires only a couple of minutes to change the taper attachment from straight to taper machining or vice versa.

### Fitting Taper Attachment to Lathe

The Taper Attachment should be ordered with the lathe so that it can be properly fitted and aligned at the factory. No extra charge is made for fitting this attachment to the lathe carriage and aligning with the V-ways of the bed. Fitting the Taper Attachment to lathe outside of our factory is not recommended as special tools and equipment are necessary.

### Attachment Operates Entire Length of Bed

The Taper Attachment is bolted to the Lathe carriage and can be set for taper turning or boring at any position along the entire length of the lathe bed. The Attachment does not interfere with straight turning as it does not operate unless the clamp on the back "V" of the bed is locked.

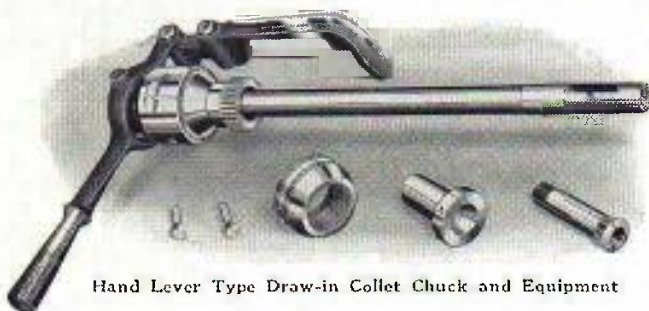
Net Factory Prices of Graduated Taper Attachment

Size of Lathe	Catalog No.	Maximum Taper			Approx. Shipping Weight	Code Word	Price Attachment
		At One Setting	Per Foot	In Degrees			
*Workshop	428-W	7 in.	3 in.	14	35 lbs.	Hapwo	\$55.00
9 in.	209	9 in.	3 in.	14	40 lbs.	Dashe	65.00
11 in.	211	9 in.	3 in.	14	50 lbs.	Devor	75.00
13 in.	213	10 in.	3 in.	14	65 lbs.	Digit	85.00
15 in.	215	10 in.	3 in.	14	80 lbs.	Doted	95.00
16 in.	216	12 in.	3 in.	14	100 lbs.	Dress	105.00

\*Must be fitted to lathe in our factory.

## Hand Lever Type Draw-in Collet Chuck Attachment

For Rapid Production Work



Hand Lever Type Draw-in Collet Chuck and Equipment

The Hand Lever Type Draw-in Collet Chuck permits releasing and feeding bar stock through the collet, without stopping the lathe. The gripping action of the collet can be adjusted to any desired tension by regulating the cylinder of the adjustable chuck closer.

The rapid production and accuracy of the Hand Lever Draw-in Collet Chuck attachment makes it a very economical tool for use in manufacturing small interchangeable parts where accuracy and precision are required.

### Equipment Included in Price

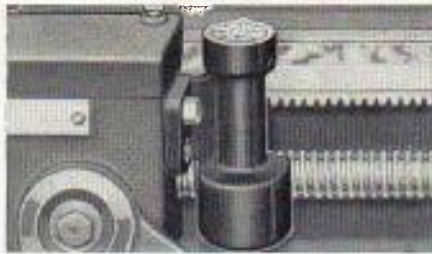
The price of the Hand Lever Draw-in Collet Chuck Attachment includes adjustable chuck closing mechanism and hollow draw bar, spindle nose cap, spanner wrench for nose cap, tapered steel closing sleeve, and one round split collet of any size desired up to the maximum capacity of the lathe. The tapered closing sleeve is made of tool steel, hardened and ground to minimize wear and to insure accuracy.

Net Factory Prices of Hand Lever Draw-in Collet Chuck Attachment with One Round Split Collet\*

Size of Lathe	Catalog No.	Hole in Lathe Spindle	Collet Capacity in 6ths (for Round Work)	Code Word	Price Each
*Workshop	5206W	3/8 in.	1/8 in. up to 3/8 in.	Abpat	\$85.00
9 in.	5209	3/8 in.	1/8 in. up to 7/8 in.	Allen	95.00
11 in.	5211	7/8 in.	1/8 in. up to 1 1/8 in.	Among	105.00
13 in.	5213	1 in.	1/8 in. up to 5/8 in.	Andes	120.00
15 in.	5215	1 1/8 in.	1/8 in. up to 3/4 in.	Askew	140.00
16 in.	5216	1 3/8 in.	1/8 in. up to 7/8 in.	Aster	150.00

\*Should be fitted at factory. For prices of extra collets see page 2.

# Tools, Attachments and Accessories for South Bend Lathes



## Thread Dial Indicator

This attachment eliminates the necessity of reversing the lathe to return the carriage to the starting point to catch the thread at the beginning of each successive cut that is taken. The dial is numbered and graduated to show when to clamp the half-nuts on the lead screw for the next cut.

### Prices of Thread Dial Indicator

Size Lathe	Cat. No.	Code	Price	Size Lathe	Cat. No.	Code	Price
"Workshop"	810-W	Adnok	\$ 6.00	13 in.	813	Advds	\$11.00
9 in.	809	Abait	9.00	15 in.	815	Aesop	12.00
11 in.	811	Acres	10.00	16 in.	816	Aflot	13.00



## Micrometer Carriage Stop

This attachment is useful in accurate facing, turning, boring, etc. It is used for stopping the carriage at any point along lathe bed. Can be used on either side of carriage. Has a micrometer adjustment. The stop is hardened on both ends and may be locked for doing duplicate work.

### Prices of Micrometer Carriage Stop

Size Lathe	Cat. No.	Code	Price	Size Lathe	Cat. No.	Code	Price
"Workshop"	968-W	Cupys	\$10.00	13 in.	973	Chain	\$13.00
9 in.	971	Calef	11.00	15 in.	974	Cigar	14.00
11 in.	972	Celed	12.00	16 in.	975	Climb	15.00

## Oil Pans and Chip Pans for Lathes

Pans are heavy one-piece welded steel. Oil pans and chip pans are used on regular floor leg lathes, countershaft drive, pedestal motor drive, and underneath motor drive lathes.

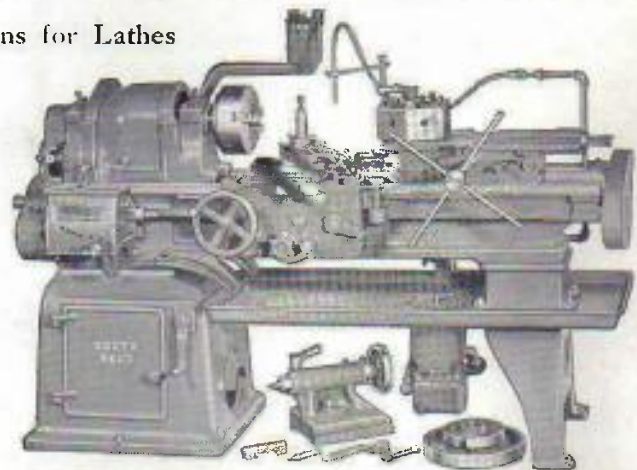
### Prices of Oil Pans for Countershaft Drive and Pedestal Adjustable Motor Drive Floor Leg Lathes †

Size Lathe	Cat. No.	LENGTH OF BED									
		3'	3 1/2'	4'	4 1/2'	5'	5 1/2'	6'	7'	8'	10'
9" W.S.	274-W	\$21	\$22	\$23	\$24	...	...	...	...	...	...
9 in.	282	23	24	25	26	...	...	...	...	...	...
11 in.	281	25	26	27	...	\$29	\$30	...	...	...	...
13 in.	286	...	...	35	...	38	...	\$41	\$44	...	...
15 in.	288	...	...	...	...	45	...	49	53	\$57	\$65
16 in.	292	...	...	...	...	...	...	50	55	60	70

### Prices of Chip Pans for Underneath Belt Motor Drive Floor Leg Lathes †

9 in.	134	\$17	\$18	\$19	\$20	...	...	...	...	...	...
11 in.	135	19	20	21	...	\$23	\$24	...	...	...	...
13 in.	136	...	...	28	...	31	...	\$34	\$37	...	...
15 in.	137	...	...	...	...	32	...	36	40	\$44	\$52
16 in.	138	...	...	...	...	...	...	38	43	48	58

† Prices include special legs instead of regular legs.  
NOTE: Pans should be fitted to lathe at factory.



16" x 6" Underneath Belt Motor Driven Quick Change Gear Lathe with Power Feed Turret, Oil Pan, Oil Pump, Reservoir, and Piping

## Oil Pump, Reservoir and Piping for Countershaft Drive and Motor Drive Lathes

Countershaft Drive Lathe Equipment includes geared oil pump, piping, reservoir, and a flat pulley for the countershaft to drive the oil pump. See prices of equipment at right. Leather belt is extra.

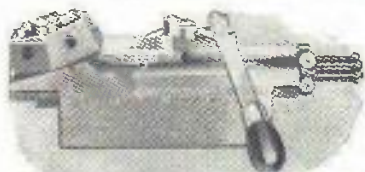
Pedestal Adjustable Motor Drive Lathe Equipment includes geared oil pump, V-belt driven by 1/2 H.P. Split Phase Motor (1 Ph., 60-Cy., A.C. 110-V. or 220-V.); switch, wired to motor; and reservoir. See prices at right.

Underneath Belt Motor Drive Lathe Equipment includes geared oil pump, V-belt driven by 3/4 H.P. Split Phase Motor (1-Ph., 60-Cy., 110-V. or 220-V.); switch, wired to motor; splash pans; and reservoir. Headstock and gear box have special fittings for returning oil to pan. See prices at right.

### Prices of Oil Pump, Reservoir and Piping (Fitted to Lathe at Factory)

Size of Lathe	For Countershaft Drive Lathes			For Pedestal Adjustable Motor Drive Lathes			For Underneath Belt Motor Drive Lathes		
	Cat. No.	Code	Price	Cat. No.	Code	Price	Cat. No.	Code	Price
Workshop	1404-W	Busak	\$45.00	1923-W	Cinr	\$ 90.00	Not	Supplied	
9"	1465	Basis	45.00	1924	Ciniv	90.00	1726	Pazel	\$110.00
11"	1466	Basay	45.00	1926	Cinoo	90.00	1727	Pebit	110.00
13"	1467	Batax	50.00	1927	Cisad	100.00	1728	Perox	125.00
15"	1468	Bateb	55.00	1928	Cisoh	100.00	1729	Povar	125.00
16"	1469	Batal	60.00	1929	Cisil	100.00	1730	Pobst	125.00

## Hand Lever Bed Turret



### Prices of Semi-Automatic Bed Turret

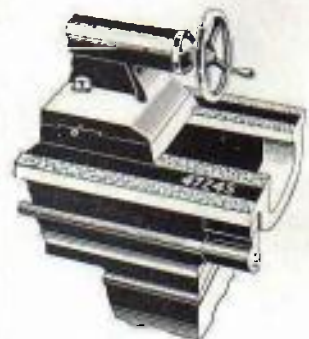
Size of Lathe	Cat. No.	Std. Turret Hole	Length Base	Max. Feed	Code	Price Not Fitted*	Price Fitted*
9 in.	1509	5/8 in.	9 1/2 in.	1/4 in.	Jaber	\$297.00	\$307.00
11 in.	1511	5/8 in.	9 1/2 in.	1/4 in.	Jenbs	302.00	312.00
13 in.	1512	5/8 in.	9 1/2 in.	1/4 in.	Jatns	307.00	317.00

\* Price includes fitting turret to lathe bed only. Finish boring of the six turret holes is \$10.00 extra.

This Turret automatically indexes one-sixth of a turn by the backward movement of the hand lever. Adjustable stops are provided for each of the six faces of the turret for regulating the depth of each tool. The feed of the turret slide is controlled by the hand lever. Power feed cannot be supplied. Price includes special turret base.

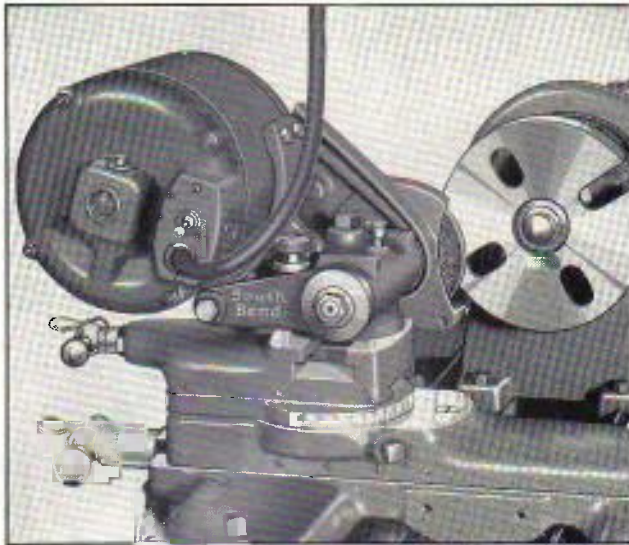
## Specify Serial Number of Lathe When Ordering Parts

The serial number is stamped on top of the lathe bed between the V-way and the flat-way at the tailstock end. (See illustration at right.) This number is an index to the size, type and model of the lathe and should always be specified when attachments, tools, chucks, accessories or parts are ordered separate from lathe.



# No. 85 Electric Grinder for South Bend Lathes

For Grinding Hardened or Tempered Tools and Parts



No. 85 Electric Grinder Mounted on Compound Rest of Lathe

The No. 85 Electric Grinder makes a valuable addition to the screw cutting lathe in any shop that is not equipped with a modern tool room cutter and reamer grinder. It is practical for grinding straight, taper or spiral reamers, lathe centers, milling cutters, taps, dies, valves, pistons, bushings, hardened and tempered tools, parts, etc., but is not intended for grinding lathe tool bits, drills, etc. This grinder operates from electric light socket.

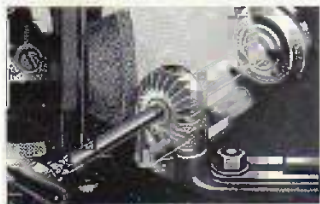
## Equipment for Grinder

Price of grinder includes 1/3 H.P. motor, 1-phase, 60-cycle, 110-volt, A.C.; V-belt; belt guard; one Alundum grinding wheel (Grain 46-N, Grade 5-B); extension cord; switch; and clamp for mounting to compound rest. If D.C. motor is wanted add \$15.25 to prices shown. When ordering specify voltage and current required.

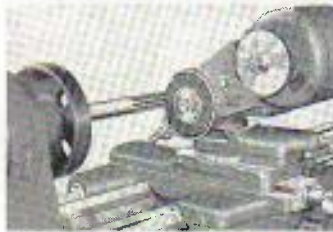
### Net Factory Prices of No. 85 Electric Grinder

Size of Lathe	Cat. No.	Size Grind. Wheel	Diam. Will Grind	Motor Speed R.P.M.	Spindle Speed R.P.M.	Code Word	Price, Each
Workshop	85-W	4"x1/2"	4 3/4 in.	1725	4000	Raben	\$45.00
9 in.	85-I4	4"x1/2"	5 1/2 in.	1725	4000	Raeck	50.00
11 in.	85-C	4"x1/2"	7 1/2 in.	1725	4000	Radem	55.00
13 in.	85-D	4"x1/2"	9 in.	1725	4000	Rafel	55.00
15 in.	85-F	4"x1/2"	10 1/2 in.	1725	4000	Rafel	55.00
16 in.	85-G	4"x1/2"	11 in.	1725	4000	Rahom	60.00

Extra Grinding Wheels, Price Each \$1.50. State class of work.



No. 3236, Special Cup Wheel for cutter grinding. Shipping weight, 14 oz. Code "Lapom" \$2.00



Sharpening a Straight Reamer

## Sharpening Cutters and Reamers

Cutters and reamers, of all angles, valve seat counterboring cutters, valve guide reamers, straight and taper reamers, and adjustable reamers can be sharpened quickly and accurately in the lathe equipped with the No. 85 Electric Grinder.

### Adjustable Spring Cutter Stop

The Adjustable Spring Cutter stop shown at right attaches directly to the grinding attachment and travels with the wheel so that either straight, spiral, or fluted cutters may be ground. Cannot be used to hold diamond dresser.



Spring Cutter Stop

No. 1362, Code "Macoc", Ship. wt., 14 oz. \$2.00

## Fixture for Diamond Dresser and Reamer Grinding Stop



Truing a Grinding Wheel with a Dresser Mounted in Holding Fixture

The No. 19 Adjustable Holding Fixture, as illustrated at left, will hold the industrial diamond dresser for truing grinding wheels and will also hold the reamer and cutter stop which is supplied with the fixture.

The fixture clamps directly to the bed of the lathe so that the carriage has free movement both when truing grinding wheels and sharpening reamers and cutters.

### Net Factory Prices of Adjustable Holding Fixture

Size of Lathe	Workshop	9 in.	11 in.	13 in.	15 in.	16 in.
Catalog No.	19-W	19	19-B	19-C	19-D	19-E
Code Word	Almag	Quetic	Quarz	Quast	Quick	Quitr
Price, Each	\$8.00	\$8.00	\$9.00	\$10.00	\$12.00	\$13.00



### Diamond Holding Fixture

Clamps to tail-spindle. Holds No. 406 diamond dresser for truing grinding wheel for valve or general work.

Size Lathe	Cat. No.	Code Word	Price Each	Size Lathe	Cat. No.	Code Word	Price Each
W.S.	41-W	Kiba	\$3.00	1 1/2"	41-D	Kirac	\$3.75
6"	41-15	Kipol	3.25	1 1/2"	41-E	Kirix	4.25
11"	41-C	Kipte	3.25	1 1/2"	41-F	Kiroz	4.50

No. 406, Diamond, Code "Kirac" \$6.00.  
19-inch Workshop Lathe.

### Industrial Diamond Dresser



Industrial Diamond Dresser

No. 18, Industrial Diamond, special metal mount, 1/2 carat. Code word "Quaft." Price each \$6.00

## High Speed Electric Grinder

This light weight grinder for the lathe does internal and external grinding to the finest limits. It is attached to tool post of lathe by means of a special shank which is adjustable for different centers. Motor is of the universal type. Maximum speed 20,000 R.P.M. Full load speed 10,000 R.P.M. A specially designed collet chuck attached direct to armature shaft takes round shank 3/8" to 5/8" in size. Chuck will accommodate drills from No. 42 to No. 22 inclusive. Equipment: 6 mounted pencil wheels, for finish work: No. 60 Grit, No. 0 Grade, 1x1/8"; 3/4x1/8"; 1/2x1/4"; 1/4x1/4"; 3/8x1/4"; 1/8x1/4". Shank 1 1/8x1/8" diameter; two wrenches, 8-ft. rubber covered cord, molded rubber plug and switch. Net weight 2 lbs.

No. 166, Light Duty Electric Grinder for "Workshop", 9-inch and 11-inch Lathes. Code word "Obpol." Price \$30.00



Light Duty Electric Grinder Fitted to Tool Post of Lathe

# Milling and Keyway Cutting Attachment

For All Sizes and Types of South Bend Lathes

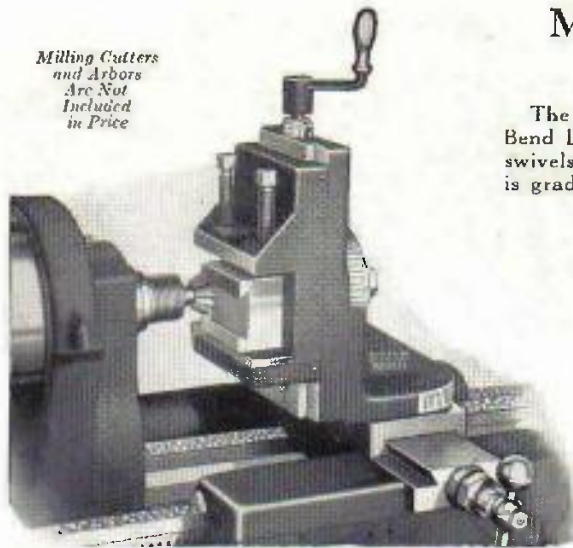
The Milling and Keyway Cutting Attachment is made for all sizes of South Bend Lathes from 9-inch to 16-inch swing. It fits on compound rest base, swivels all the way around in a horizontal plane like the compound rest and is graduated 180 degrees. In addition, the upright Angle Plate to which the vise is attached swivels in a vertical plane, and is graduated 180 degrees. The vertical adjusting screw at the top of the attachment is equipped with a micrometer graduated collar. The automatic cross and longitudinal feeds of carriage can be used as well as the hand feeds.

A lathe fitted with a milling and keyway cutting attachment makes an excellent equipment for small shops not having enough work to invest in an expensive milling machine.

## Equipment Included in Price

The equipment consists of milling and keyway cutting attachment, two standard V-blocks for holding round work, one crank handle for feed screw, one double end wrench and necessary bolts and nuts for installing attachments to lathe.

Milling Cutters and Arbors Are Not Included in Price



Milling Attachment for 13" and Larger South Bend Lathes.



Squaring the End of a Shaft.

## Net Factory Prices of Milling and Keyway Cutting Attachment

Size of Lathe	Cat. No.	Vertical Feed	Cross Feed	Vise Will Hold	Depth of Jaws	Width of Jaws	Weight Each	Code Word	Price Each
Workshop	9-W	2 1/2 in.	5 1/2 in.	1 3/4 in.	1 1/2 in.	3 in.	13 lbs.	Vabif	\$35.00
9 in.	1	3 in.	7 in.	1 3/4 in.	1 1/2 in.	3 1/2 in.	25 lbs.	Vagon	45.00
11 in.	2	4 in.	8 in.	1 3/4 in.	1 1/2 in.	3 1/2 in.	30 lbs.	Valet	50.00
13 in.	3	4 1/2 in.	9 in.	2 1/4 in.	1 1/2 in.	4 1/2 in.	40 lbs.	Victo	55.00
15 in.	4	6 in.	9 1/2 in.	4 in.	2 in.	5 1/2 in.	50 lbs.	Visit	65.00
16 in.	5	6 in.	9 1/2 in.	4 in.	2 in.	5 1/2 in.	65 lbs.	Varen	75.00



Milling a Standard Keyway.



Milling Keyway in Center of Shaft.



Milling an Angular Piece.



Milling a Woodruff Keyway.

## Milling Cutters and Arbors for Milling Attachment

### Plain Milling Cutters

Made of High Speed Steel, hardened and ground. Cut on face only. Have standard keyway.

#### Net Factory Prices of Plain Milling Cutters

Cat. No.	Face Width	Cutter Diam.	Hole Diam.	Price Each
810-A	1/2 in.	3 1/2 in.	1 in.	\$3.10
810-B	3/4 in.	3 1/2 in.	1 in.	4.10
810-C	1 in.	3 1/2 in.	1 in.	4.30
810-J	1 1/2 in.	3 1/2 in.	1 in.	4.60
810-N	2 in.	3 1/2 in.	1 in.	4.90
810-P	2 1/2 in.	3 1/2 in.	1 in.	5.10
810-S	3 in.	3 1/2 in.	1 in.	5.60
810-T	3 1/2 in.	3 1/2 in.	1 in.	6.00

### Side Milling Cutters

Made of High Speed Steel, hardened and ground. Cut on face and both sides. Have standard keyway.

#### Net Factory Prices of Side Milling Cutters

Cat. No.	Face Width	Cutter Diam.	Hole Diam.	Price Each
850-A	1/2 in.	3 in.	1 in.	\$ 8.50
850-B	3/4 in.	3 in.	1 in.	5.90
850-C	1 in.	3 in.	1 in.	7.20
850-F	1 1/2 in.	3 in.	1 in.	7.63
850-J	2 in.	3 in.	1 in.	8.00
850-N	2 1/2 in.	3 in.	1 in.	13.30
850-P	3 in.	3 in.	1 in.	14.30

### Collet Chuck for Woodruff Cutters



#### Prices of Chuck for Woodruff Cutters (without cutter)

Size Lathe	9" W.S.	9"	11"	13"	15"	16"
Cat. No.	101-W	101-A	102-A	103-A	104-A	105-A
Morse Taper	2	3	3	3	3	3
Price	\$4.00	\$4.00	\$4.03	\$5.00	\$5.00	\$5.00

\*9-inch Workshop Lathe.

### Arbor for Side and Plain Milling Cutters



For holding cutters with standard 1-inch hole. Capacity between nut and shoulder is 1 1/2 inches. Three locking collars and hardened nut are furnished with each arbor. The Taper Shank is ground to fit the head spindle of the lathe.

#### Net Factory Prices of Arbors for Milling Cutters

Size of Lathe	Cat. No.	Morse Taper	Price Each	Size of Lathe	Cat. No.	Morse Taper	Price Each
Workshop	100-W	No. 3	\$6.00	15 in.	115-M	No. 3	\$8.00
9 in.	109-M	No. 3	6.00	16 in.	110-M	No. 3	6.00
11 in.	111-M	Special	6.00				
13 in.	113-M	No. 3	6.00				

### Woodruff System Keyway Cutters



Made of High Speed Steel, hardened and ground. Have straight shanks 1/2-inch in diameter. Right-hand cutters only are carried in stock. Prices of left-hand cutters quoted on request.

#### Net Factory Prices Woodruff System Milling Cutters

Cat. No.	Diam.	Width	Price Each	Cat. No.	Diam.	Width	Price Each
887-A	1/2 in.	1/2 in.	\$2.80	897-I	1 in.	1/2 in.	\$3.80
887-B	3/4 in.	1/2 in.	2.80	897-J	1 in.	3/4 in.	4.20
887-C	1 in.	1/2 in.	2.80	897-K	1 1/4 in.	1/2 in.	4.20
887-D	1 1/4 in.	1/2 in.	3.10	897-L	1 1/4 in.	3/4 in.	4.40
887-E	1 1/2 in.	1/2 in.	3.10	897-M	1 1/2 in.	1/2 in.	4.40
897-F	1 1/2 in.	3/4 in.	3.40	897-N	1 1/2 in.	3/4 in.	4.60
897-G	1 3/4 in.	1/2 in.	3.40	897-O	1 3/4 in.	1/2 in.	4.60
897-H	1 in.	3/4 in.	3.80	897-P	1 1/2 in.	3/4 in.	4.90

### Spiral End Mills



High Speed Steel, hardened and ground. Furnished in right-hand cut, right-hand spiral only.

#### Net Factory Prices of Spiral End Mills

Cat. No.	Diam. of Mill	Morse Taper	Price Each	Cat. No.	Diam. of Mill	Morse Taper	Price Each
868-B	1/2 in.	No. 2	\$4.80	870-A	3/8 in.	No. 3	\$7.00
868-J	3/8 in.	No. 2	4.90	870-B	7/8 in.	No. 3	7.00
868-K	1/2 in.	No. 2	4.90	870-C	1 in.	No. 3	7.30
868-L	3/4 in.	No. 2	5.70	870-D	1 1/4 in.	No. 3	8.40
868-N	1 in.	No. 2	6.60	870-E	1 1/2 in.	No. 3	8.60

### Angular Cutters with Threaded Holes

Furnished R.H. or L.H. angle and with either R.H. or L.H. threaded hole. Have 60° included angle. When ordering specify whether style No. 1, 2, 3 or 4 is wanted.

Cat. No.	Diam.	Thick-ness	Hole	Thread	Price per In. Each
667	1 1/4"	3/8"	3/8"	24 NF	\$5.80



### Screw Arbors for Angular Cutters

When ordering arbor only give catalog number and style number of cutter the arbor is to be used with.

No. 829-A, Arbor for Workshop and 9" lathes... \$2.50  
 No. 829-B, Arbor for 11" lathes... 2.50  
 No. 829-F, Arbor for 13", 15", 16" lathes... 2.50

# Tools, Attachments and Accessories for South Bend Lathes



Using center rest to support long slender shaft while being machined



Cutting a screw thread on a long shaft with the aid of a follower rest.

## Center Rest

The center rest clamps onto the inside ways of the lathe bed and is used for supporting long shafts, boring spindles, etc. The three jaws are adjustable to accommodate various sizes of work, and the top of the center rest is hinged to facilitate inserting and removing shafts.



The jaws are made of cast iron, and if properly lubricated, will wear very little. The jaws are machined all over and have adjusting screws and lock screws for setting them in the desired position.

Net Factory Prices of Center Rests

Size of Lathe	Catalog Number	Maximum Capacity	Minimum Capacity	Code Word	Price Each
"Workshop"	125-W	3 in.	1/4 in.	Cegke	\$ 6.00
9 in.	125	3 in.	1/4 in.	Nygia	8.00
11 in.	303	3 1/4 in.	1/4 in.	Nygod	9.00
13 in.	341	3 3/4 in.	1/4 in.	Nygas	11.00
15 in.	512	4 1/4 in.	1/4 in.	Nygew	14.00
16 in.	720	4 3/4 in.	1/4 in.	Nyjon	15.00

## Follower Rest

The follower rest is attached to the lathe carriage and travels with the carriage, as shown above. The follower rest is used to support long, slender shafts while being machined between the lathe centers. Adjusting screws and lock screws are provided for setting the jaws in position.



Slots in bottom of follower rest are used for attaching follower rest to carriage, and permit attaching or removing quickly, as it is not necessary to remove the screws from the saddle.

Net Factory Prices of Follower Rests

Size of Lathe	Catalog Number	Maximum Capacity	Minimum Capacity	Code Word	Price Each
"Workshop"	34-W	2 in.	3/16 in.	Cegmo	\$ 4.00
9 in.	130	2 1/2 in.	3/16 in.	Culve	4.00
11 in.	322	3 in.	3/16 in.	Farof	6.00
13 in.	376	3 1/4 in.	3/16 in.	Fanta	7.00
15 in.	513	4 1/4 in.	3/16 in.	Furfa	8.00
16 in.	730	4 3/4 in.	3/16 in.	Fanuf	9.00

## Large Face Plate

The large face plate is threaded to fit the spindle nose of the lathe, has slots for clamping work or special face plate fixtures. It is heavily constructed and is ribbed on the back. May be used for general tool work and machine shop work.



Cat. No. 40-W. Face Plate for 9" Workshop Lathe. Outside diameter 7 3/4". Code Word, "Cebak".....\$5.00

Cat. No. 40. Face plate for 9" Junior Lathe. Outside diameter 7 3/4". Code Word, "Cryed".....\$6.00

## Adjustable Thread Cutting Stop

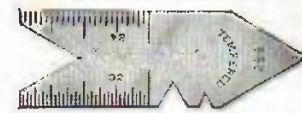
The adjustable thread cutting stop is used for regulating the depth of each chip when cutting screw threads. This attachment may also be used for regulating the depth of the cut for regular turning operations. The attachment clamps on the cross slide dovetail of the lathe and can be locked in any position.



Cat. No. 67-W. Thread Cutting Stop for 9" Workshop Lathe. Code Word, "Cegpy".....\$2.50

Cat. No. 67. Thread Cutting Stop for 9" Junior Lathe. Code Word, "Cobra".....\$2.50

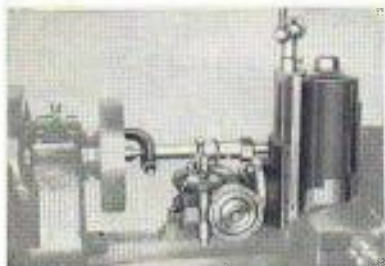
## Center Gauge



The center gauge is a useful tool for the lathe operator. The 60° included angle is used for checking the angle of the lathe center point. The two small 60° notches in the side of the tool are used for grinding and setting the point of the lathe tool for cutting screw threads. Made of good quality tool steel, hardened and tempered.

Cat. No. 650. Center Gauge. Code Word, "Xutje".....\$0.50

## Gear Cutting Attachment



This attachment is equipped with a dividing head for cutting spur and bevel gears, also for graduating and milling, external key-seating, slotting and light milling. Holds work in any position. An index plate shows gears for divisions from 2 to 360.

Equipment included in price of the Gear Cutting Attachment illustrated consists of: wrenches, arbor for cutter, straight clamp, dog center, out-board support and 24 change gears.

Prices of the Gear Cutting Attachment together with further information will be furnished on application.

SOUTH BEND, INDIANA, U.S.A.

## Double Tool Slides

Screw Feed Type and Hand Lever Type



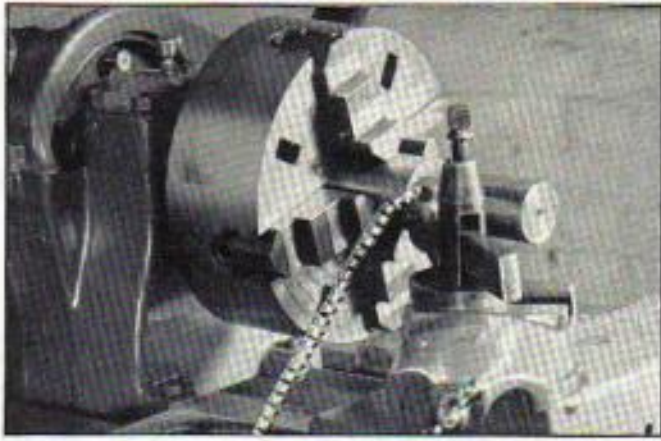
Tool Slide illustrated is controlled by the lathe cross feed screw. An adjustable stop regulates both front and back tools. The Hand Lever Tool Slide is similar but is operated by a hand lever.

Equipment includes front and back tool rests, adjustable stop, and one tool post—the other tool post is furnished with lathe.

Prices of Double Tool Slides.

Size of Lathe	Screw Feed Type			Hand Lever Type		
	Cat. No.	Code Word	Price	Cat. No.	Code Word	Price
9"W.S.	968	Hemor	\$40.00	733	Abble	\$60.00

Prices of Double Tool Rests for Larger Sizes of Lathes quoted on request.



A chuck mounted on the spindle of the lathe

## Chucks for South Bend Lathes

### Selecting the Chuck for the Lathe

A 4-jaw Independent chuck is recommended if the lathe is to have but one chuck, as this type of chuck will hold square, round and irregular shapes in either a concentric or eccentric position. The jaws of the Independent chuck may be reversed so that work may be chucked either on the inside or the outside.

The 3-jaw Universal chuck is used for chucking round and hexagonal work quickly, as the jaws move simultaneously and automatically center the work. Two sets of jaws are supplied with each 3-jaw Universal chuck, one set for external chucking and one set for internal chucking.

### 4-Jaw Independent Lathe Chucks with Reversible Jaws



4-jaw Independent lathe chuck with reversible jaws, fitted to lathe spindle nose ready for use

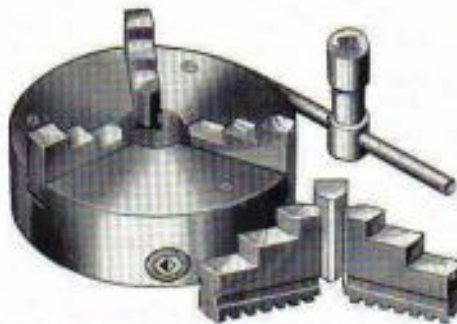
These chucks have four independent solid jaws with individual screw adjustment. The jaws may be reversed for chucking work either inside or outside. Chuck body is ground and chuck jaws are hardened and ground.

Chucks listed below are ready for use as the prices include chuck-back properly fitted to the chuck and threaded for the lathe spindle. Chuck wrench is also included in price of chuck. Made in U. S. A.

#### Prices of 4-Jaw Independent Lathe Chucks with Reversible Jaws

Cat. No.	Size of Chuck	Approx. Ship. Weight	Price of Chuck Fitted to South Bend Lathe Spindle					
			9" Workshop	9" Lathe	11" Lathe	13" Lathe	15" Lathe	18" Lathe
4006	6"	13 lbs.	\$23.00	\$26.00				
4206	6"	18 lbs.		38.00	\$39.00	\$40.00		
4207	7½"	37 lbs.			46.00	47.00	\$48.00	
4209	9"	50 lbs.				52.00	53.00	\$54.00
4210	10"	60 lbs.					58.00	59.00
4212	12"	95 lbs.					88.00	89.00

### 3-Jaw Universal Lathe Chucks with Two Sets of Jaws



3-jaw Universal lathe chuck with two sets of jaws, fitted to lathe spindle nose ready for use

Chuck jaws are moved simultaneously by a scroll, and work is automatically centered. Two sets of jaws furnished, one set for chucking internally and the other for chucking externally. Chuck body is ground and jaws are hardened. Prices include two sets of jaws, wrench and chuck-back fitted to chuck and threaded for lathe spindle. Manufactured in the United States.

#### Prices of 3-Jaw Universal Lathe Chucks with Two Sets of Jaws

Cat. No.	Size of Chuck	Approx. Ship. Weight	Price of Chuck Fitted to South Bend Lathe Spindle					
			9" Workshop	9" Lathe	11" Lathe	13" Lathe	15" Lathe	18" Lathe
3005	5"	12½ lbs.	\$25.00	\$28.00				
3505	5"	16 lbs.		40.00	\$41.00	\$42.00		
3506	6"	22 lbs.			50.00	51.00	\$52.00	
3507	7½"	37 lbs.				58.00	59.00	\$60.00
3509	9"	54 lbs.					68.00	69.00
3510	10½"	35 lbs.					105.00	106.00

### Chucks Fitted to Lathe at Factory

The illustration at the right shows a chuck that has been fitted with a threaded chuck plate to fit the spindle nose of the lathe. This chuck plate is carefully fitted to the back of the chuck so that the chuck will run true when mounted on the lathe spindle.



Chuck with Chuck-Back Attached

### Threaded Chuck Plates

Threaded chuck plates fitted to spindle nose of lathe are supplied for those who wish to fit their own chucks. When ordering threaded chuck plates specify size and serial number of lathe and diameter of recess in back of chuck.



#### Additional Threaded Chuck Plates for South Bend Lathes

Size of Lathe	9" Workshop	9 inch	11 inch	13 inch	15 inch	16 inch
Catalog No.	126-W	1935	1936	1937	1938	1939
Price Each	\$3.00	\$5.00	\$6.00	\$7.00	\$8.00	\$9.00



# Drill Chucks for Manufacturing and General Machine Work

For All Sizes and Types of South Bend Lathes

## Jacobs Three-Jaw Drill Chuck



This Chuck is practical for general drilling work in the lathe. The jaws are of tempered steel and are operated by a heavy screw. The geared sleeve and key assure a powerful grip. Price and weight include pinion key, but not arbors, which are listed below.

Prices of Three-Jaw Drill Chuck

Cat. No.	Capacity	Diam.	Length	Net Wt.	Ship. Wt.	Code	Price
1200	0 to 5/8 in.	1 1/4 in.	2 1/2 in.	1 1/2 lbs.	1 7/8 lbs.	Cleve	\$ 4.50
1201	0 to 3/4 in.	2 1/2 in.	2 1/2 in.	1 3/4 lbs.	2 3/8 lbs.	Wauko	6.50
1202	1/2 to 1 in.	2 3/4 in.	3 1/2 in.	3 1/4 lbs.	3 1/2 lbs.	Falco	9.50
1203	3/4 to 1 1/4 in.	3 1/2 in.	5 1/2 in.	7 1/2 lbs.	8 lbs.	Frank	12.50

## Almond Three-Jaw Drill Chuck



This chuck is practical, powerful, well-balanced and accurate for all drilling work in the lathe. The jaws are of tempered steel and are operated by a heavy screw. Price and weight include pinion key, but not arbors which are listed below.

Prices of Three-Jaw Drill Chuck

Cat. No.	Capacity	Diam.	Length	Net Wt.	Ship. Wt.	Code	Price
219	0 to 5/8 in.	1 1/4 in.	2 1/2 in.	1 3/8 lbs.	1 7/8 lbs.	Aepen	\$ 3.85
220	0 to 3/4 in.	2 1/2 in.	2 1/2 in.	1 3/4 lbs.	2 3/8 lbs.	Aepip	5.25
327	1/2 to 1 in.	2 3/4 in.	3 1/2 in.	3 1/4 lbs.	3 1/2 lbs.	Rulid	7.50
328	3/4 to 1 1/4 in.	3 in.	4 1/2 in.	5 1/2 lbs.	6 1/2 lbs.	Rulof	10.00

## Solid Arbors for Fitting Drill Chucks to South Bend Lathes



Solid Arbor for Fitting Drill Chuck to Lathe

Solid Arbors are used for fitting drill chucks to lathes. When ordering drill chuck arbor only, state size and make of drill chuck, diameter and depth of arbor socket and size of lathe on which the chuck is to be used so that we can supply the correct size arbor.

Size Lathe	Morse Taper	Cat. No.	Net Wt.	Ship. Wt.	Code	Price
"Workshop"	No. 2	700-W	1/2 lb.	3/4 lb.	Achuk	\$1.00
9-in.	No. 2	700	1/2 lb.	3/4 lb.	Abner	1.00
11-in.	No. 2	707	1/2 lb.	3/4 lb.	Aerom	1.00
13-15 in.	No. 3	713	3/4 lb.	1 lb.	Adams	1.50
14-in.	No. 3	716	3/4 lb.	1 lb.	Agate	1.50

## Hollow Arbor Chuck



This is an ideal chuck for holding small rods and bar work for machining in the lathe. It is also practical for holding all kinds of engine valves, centered and centerless, for refacing in the lathe. Price and weight include pinion key and hollow steel arbor.

Prices of Hollow Spindle Chuck

Cat. No.	Size Lathe	Capacity	Net Wt.	Ship. Wt.	Code	Price
354-A	13", 15", 16"	1/2" to 3/4"	2 1/2 lbs.	3 1/4 lbs.	Tavif	\$10.50
354-B	13", 15", 16"	3/4" to 1"	4 1/2 lbs.	5 1/2 lbs.	Taved	14.25

## Hollow Chuck Threaded for Spindle



Screws on spindle nose of lathe. Has hollow body for holding small rods, bars and automobile engine valves for refacing. 3/4" chuck can also be used in tailstock of lathe, as chuck has taper hole in body which can be fitted with solid arbors listed above. Price includes pinion key but does not include arbor.

Prices of Headstock Spindle Chuck

Cat. No.	Size Lathe	Capacity	Net Wt.	Ship. Wt.	Code	Price
907-W	"Workshop"	1/2" to 3/4"	3 1/2 lbs.	3 3/4 lbs.	Robal	\$10.00
907-L	9-in.	1/2" to 3/4"	3 1/2 lbs.	3 3/4 lbs.	Robet	10.00
925-A	9-in.	3/4" to 1"	8 1/2 lbs.	4 1/2 lbs.	Rodna	11.25
925-B	11-in.	3/4" to 1"	3 1/2 lbs.	4 1/4 lbs.	Rodpe	11.25

## Chuck and Tool Assortments

For South Bend Lathes

The chuck and tools shown in the assortment at left and listed below are recommended for use in the various sizes of South Bend Lathes. This is the basic equipment required for the average shop for handling general machine work, such as turning, boring, drilling, cutting-off, chucking, etc.

The 4-jaw Independent lathe chuck is listed in each assortment because this chuck will handle round, square and irregular shaped work. However, if a 3-jaw Universal chuck is wanted instead it can be furnished at additional cost. See page 8.



Practical Chuck and Tool Assortment for General Machine Work

Assortment for Each Size Lathe	9" "Workshop"	9-inch	11-inch	13-inch	15-inch	16-inch
4-Jaw Independent Lathe Chuck fitted to lathe ready for use	\$23.00	\$26.00	\$39.00	\$47.00	\$53.00	\$59.00
Size of Above Lathe Chuck	6 in.	6 in.	6 in.	7 1/2 in.	9 in.	10 in.
3-Jaw Drill Chuck	5.25	5.25	5.25	7.50	7.50	10.00
Capacity of Drill Chuck	1/2 in.	1/2 in.	1/2 in.	3/4 in.	3/4 in.	1 in.
Arbor Fitted to Above Drill Chuck	1.00	1.00	1.00	1.50	1.50	1.50
Straight Shank Tool Holder	1.25	2.35	2.50	2.85	2.85	3.50
Six Ground Cutters for Tool Holder	1.65	1.65	1.65	2.50	2.50	3.75
Boring Tool Holder, Style "D"	3.00	3.00	3.00	3.00	3.00	3.00
Boring Tool Holder, Style "B"	3.00	3.00	3.00	3.00	3.00	3.00
Cutting-Off Tool Holder	1.50	2.55	2.75	3.20	3.20	4.00
Four Malleable Lathe Dogs	2.60	2.60	2.60	3.15	3.15	3.15
Size of Above Lathe Dogs	1. 1. 1 1/2"	1. 1. 1 1/2"	1. 1. 1 1/2"	1. 1. 1 1/2"	1. 1. 1 1/2"	1. 1. 1 1/2"
<b>Assortments, Complete</b>	<b>\$39.25</b>	<b>\$45.70</b>	<b>\$59.05</b>	<b>\$72.85</b>	<b>\$78.85</b>	<b>\$91.65</b>
Catalog No., Assortment Complete	105-WT	109-T	111-T	113-T	115-T	116-T
Code Word, Assortment Complete	Dakem	Ducak	Dufec	Dufus	Dugum	Dukob

# Tool Holders and Boring Tools for South Bend Lathes

## Lathe Tool Holders



### Tool Holder—Straight Shank

Prices below include one drop forged, heat treated and hardened steel tool holder (choice of straight, right-hand or left-hand shank) with hardened steel set screw, a hardened drop forged steel wrench and one unground high speed steel cutter bit, complete for the lathe.

Size of Lathe, Inches	Size of Shank, Inches	Size of Cutter, Inches	Catalog Numbers			Price Tool Complete
			Straight	Right Hand	Left Hand	
9" W.S.	3/4 x 3/4	1 1/2	847-S	847-R	847-L	\$1.25
9	3/4 x 3/4	1 1/2	848-S	848-R	848-L	2.35
11	3/4 x 3/4	1 1/2	851-S	851-R	851-L	2.50
13, 15	1 1/4 x 1 1/4	2 1/2	852-S	852-R	852-L	2.85
16	1 1/2 x 1 1/2	3 1/2	853-S	853-R	853-L	3.50

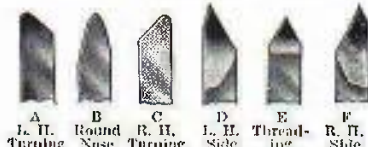
### High Speed Steel Cutter Bits Ground to Shape—Ready to Use



These cutter bits are for use with the tool holders listed above. They are made of best quality high speed steel (Bex AA, or Red Cut Superior) and are heat treated and hardened. We use the same quality of cutter bits in our own shops and recommend them very highly.

The illustration below shows six cutter bits ground to the shapes that are most practical for general work. When ordering, be sure to specify the catalog numbers and the letters designating shape of cutter bits wanted.

### Ground High Speed Steel Cutter Bits



Prices of Ground High Speed Steel Cutter Bits

Size of Lathe, Inches	Size Square, Inches	Length Cutter, Inches	Single Bit		Set of 6 Bits	
			Cat. No.	Price Each	Cat. No.	Price of Set
9" W.S.	1/2	2	1355	\$0.30	291	\$1.65
9	1/2	2	1361	.30	1775	1.65
11	1/2	2 1/2	1311	.30	1776	1.65
13, 15	3/4	3	1373	.45	1777	2.50
16	1/2	3 1/2	1314	.65	1778	3.75

### Unground Cutter Bits



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

### Prices of Unground High Speed Steel Cutter Bits

Size of Lathe, Inches	Size Square, Inches	Length Cutter, Inches	Single Bit		Set of 6 Bits	
			Cat. No.	Price Each	Cat. No.	Price of Set
9" W.S.	1/2	2	1460	\$0.17	1629	\$0.90
9	3/4	2	1419	.17	1630	.90
11	3/4	2 1/2	1421	.17	1631	.90
13, 15	1 1/4	2 1/2	1423	.30	1632	1.60
16	1 1/2	3	1425	.45	1633	2.50

## Tool Holder and Cutter Bit Set

Set consists of tool holder (choice of straight, right-hand or left-hand) with one unground H.S. Steel Cutter Bit and a set of 6 H.S. Steel Cutter Bits ground to forms A to F shown at right.



### Prices of Tool Holder and Cutter Bit Set

Size Lathe	Workshop	9"	11"	13" 15"	16"
Cat. No.	828-A	808-R	808-L	803-D	803-E
Price	\$2.90	\$4.00	\$4.15	\$5.35	\$7.25

## Cutting-Off Tool Holders



Cutters are beveled on both sides and are held at an angle giving the side clearance and top rake required. Prices below include forged steel cutting-off tool holder wrench and one high speed cutter bit a ground.

Size of Lathe, Inches	Size Shank, Inches	Size Cutter, Inches	Catalog Numbers			Tool Complete	Extra Cutter
			Straight	Right	Left		
9" W.S.	3/4 x 3/4	1 1/2	833-S	833-R	833-L	\$1.50	\$0.50
9	3/4 x 3/4	1 1/2	831-S	831-R	831-L	2.55	.55
11	3/4 x 3/4	1 1/2	832-S	832-R	832-L	2.75	.60
13, 15	1 1/4 x 1 1/4	2 1/2	838-S	838-R	838-L	3.25	.75
16	1 1/2 x 1 1/2	3 1/2	834-S	834-R	834-L	4.00	1.25

## Heavy Duty Boring and Turning Tool

This is a very rigid combination tool for boring, turning, facing, turning, and turning. Holder takes bar from 3/8" up to size listed in tabulation.



A Practical Tool for Many Jobs

Tool may be swiveled to any angle and holder may be reversed for turning extra large diameters. Bar may be turned in holder to adjust angle of cutter bit and height of cutting edge.

Provides rigid support for the cutter bit and is a practical tool as it may be used for many unusual jobs.

### Net Factory Prices of Boring and Turning Tool

Size of Lathe, Inches	Tool Complete			Holder Only		Bar Only	
	Cat. No.	Size of Bar, Inches	Price Each	Cat. No.	Price Each	Cat. No.	Price Each
9" W.S.	469-W	3/8x14	\$10.00	3677-W	\$4.50	4110	\$ 5.50
9	469	3/8x14	10.00	3677	4.50	2119	5.50
11	470	1/2x15	12.50	3678	6.00	2120	6.50
13	471	1/2x18	14.25	3679	7.00	2121	8.25
15	472	1 1/4x20	18.50	3680	8.00	2122	10.50
16	473	1 1/2x20	19.50	3681	8.00	2123	10.50

## Combination Center Drill & Countersink



For drilling center hole and countersinking 90° angle for lathe center. Made of carbon tool steel, hardened and ground.

### Net Factory Prices of Center Drill and Countersink

Diam. of Work	Diam. of Drill	Diam. of Body	Single Drill	
			Cat. No.	Price
3/8" to 5/8"	3/8 in.	3/8"	898-A	\$0.30
5/8" to 1"	5/8 in.	5/8"	898-B	.35
1" to 2"	1 in.	1 in.	898-C	.46
2 1/4" to 4"	2 1/4 in.	2 1/4"	898-D	.45

## Threading Tool Holder



Cutter requires grinding on top edge only to sharpen. Prices below include threading tool, wrench and a high speed steel single point cutter (choice of V, U.S.S. or Whitworth Standard). Sharp V Cutter is furnished unless otherwise ordered. Specify pitch or number threads per inch required.

Size of Lathe, Inches	Threading Tool Complete			Extra Cutters (H. S. Steel)	
	Cat. No.	Size of Shank, Inches	Price, Each	Cat. No.	Price, Each
9" W.S.	845	3/4 x 3/4	\$2.50	814	\$1.50
9	855	3/4 x 3/4	3.60	880	2.25
11	866	3/4 x 3/4	3.60	861	2.25
13, 15	867	1 1/4 x 1 1/4	4.25	862	2.70
16	868	1 1/2 x 1 1/2	5.50	863	3.55

## Knurling Tool Holder



Prices include spurting tool holder and one set of medium knurls made of tool steel, tempered.

Size of Lathe, Inches	Tool Complete			Coarse, Medium or Fine Straight or Diamond Shape			
	Cat. No.	Size of Shank, Inches	Price, Each	Cat. No.	Dimensions, In.	Face Hole	Price, Pair
9" W.S.	829	3/4 x 3/4	\$3.00	817	3/8	3/8	\$1.00
9	830	3/4 x 3/4	4.80	850	3/8	3/8	1.00
11	832	3/4 x 3/4	5.10	837	3/8	3/8	1.00
13, 15	833	1 1/4 x 1 1/4	5.75	838	3/8	3/8	1.25
16	834	1 1/2 x 1 1/2	6.95	839	3/8	3/8	1.25

## Style "D" Boring Tool Holder



For boring work of small internal diameter, and for threading, turning, etc. Prices include boring tool holder, one boring bar and wrench. Will take the following sizes of boring bars: 9" Lathes 1/8" to 3/8"; 11" Lathes 3/8" to 1/2"; 13" and 15" Lathes 1/2" to 3/4"; 16" and 18" Lathes 3/4" to 1".

Size of Lathe, Inches	Tool Complete				Extra Boring Bars		
	Cat. No.	Size of Shank, Inches	Size of Bar, Inches	Price Each	Cat. No.	Size of Bar, Inches	Price Each
9" W.S.	505-B	3/4 x 3/4	3/8 x 8	\$3.00	498-A	3/8 x 8	\$0.50
9	505-A	3/4 x 3/4	3/8 x 8	3.00	498-A	3/8 x 8	.50
11	505-B	3/4 x 3/4	3/8 x 8	3.50	498-B	3/8 x 8	.60
13, 15	505-C	1 1/4 x 1 1/4	3/8 x 7	4.87	498-C	3/8 x 7	.80
16	505-D	1 1/2 x 1 1/2	3/8 x 8	4.50	498-D	3/8 x 8	1.16

## Style "B" Boring Tool Holder



Provides rigid support for the cutter bit and is a practical tool as it may be used for many unusual jobs.

Size of Lathe, Inches	Tool Complete			Extra Cutter Bits		
	Cat. No.	Size of Shank, Inches	Size of Bar, Inches	Price, Each	Cat. No.	Size of Cutter, Inches
9" W.S.	422	3/4 x 3/4	3/8 x 8	\$3.30	451-W	3/8
9	429	3/4 x 3/4	3/8 x 8	4.30	451	.15
11	430	3/4 x 3/4	3/8 x 10	4.30	455	.15
13, 15	431	1 1/4 x 1 1/4	3/8 x 12	5.15	456	.17
16	432	1 1/2 x 1 1/2	3/8 x 14	6.75	457	.30

## Style "C" Boring Tool Holder



Size of Lathe, Inches	Tool Complete			Extra Cutter Bits		
	Cat. No.	Size of Shank, Inches	Size of Bar, Inches	Price, Each	Cat. No.	Size of Cutter, Inches
9" W.S.	486	3/4 x 3/4	3/8 x 8	\$3.00	440	3/8
9, 11	484	3/4 x 3/4	3/8 x 8	3.60	459	3/8
13, 15	485	1 1/4 x 1 1/4	3/8 x 8	4.35	469	3/8
16	486	1 1/2 x 1 1/2	3/8 x 8	5.75	461	3/8

\* NOTE: "9" W.S." listed in the tabulations above is an abbreviation for the name 9-inch "Workshop."

# Lathe Dogs, Centers and Accessories for South Bend Lathes

## 60° Head Spindle Lathe Center

## 60° Tail Spindle Lathe Center



Above—Standard Lathe Dog

Right—Safety Lathe Dog

### Standard and Safety Lathe Dogs

Made of heavy malleable iron and are properly designed for strength and service. The Standard Dog has square head alloy steel set screw. The Safety Dog has a headless alloy steel set screw and wrench.

### Prices of Heavy Type Lathe Dogs For 11-inch to 16-inch Swing Lathes

Capacity of Lathe Dog	Standard Lathe Dogs		Safety Lathe Dogs	
	Cat. No.	Price, Each	Cat. No.	Price, Each
3/8 in.	1-M	\$0.50	1-MH	\$0.60
1/2 in.	2-M	.60	2-MH	.70
5/8 in.	4-M	.70	4-MH	.80
1 in.	6-M	.80	6-MH	.90
1 1/4 in.	8-M	.90	8-MH	1.00
1 1/2 in.	10-M	1.05	10-MH	1.15
1 3/4 in.	11-M	1.20	11-MH	1.30
2 in.	12-M	1.35	12-MH	1.45
2 1/2 in.	14-M	1.60	14-MH	1.70
3 in.	15-M	1.75	15-MH	1.90
3 1/2 in.	16-M	1.95	16-MH	2.10
4 in.	17-M	2.25	17-MH	2.40

### Light Pattern Lathe Dogs

For 9-inch and 11-inch Swing Lathes Only

Capacity Between Screws	Clamp Dog	
	Cat. No.	Price, Each
1 1/4 in.	160	\$2.25
2 1/4 in.	161	3.00
2 3/4 in.	162	3.75
3 1/2 in.	163	5.00



### Clamp Lathe Dogs

Made of heavy drop forged steel, carefully machined and hardened. Practical for holding round, hexagonal or rectangular work. Each lathe dog is boxed separately.

### Prices of Clamp Lathe Dogs

Capacity Between Screws	Clamp Dog	
	Cat. No.	Price, Each
1 1/4 in.	160	\$2.25
2 1/4 in.	161	3.00
2 3/4 in.	162	3.75
3 1/2 in.	163	5.00

### Metric Transposing Gear Attachment

Metric Transposing Gear Attachments can be supplied for both Standard Change Gear and Quick Change Gear South Bend Lathes to permit cutting right and left hand metric screw threads equal in accuracy and precision to threads cut on lathes equipped with metric lead screws.

The prices listed below include all special equipment required for cutting the following right and left hand metric threads: 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7, and 7.5, mm. pitch.

### Net Factory Prices Metric Transposing Gear Attachment

Size of Lathe	When Ordered With Lathe				When Ordered Extra			
	Quick Ch. L. Code Word	Price	Std. Jr. Code Word	W.S.L. Price	Quick Ch. L. Code Word	Price	Std. Jr. Code Word	W.S.L. Price
9" W.S.	Behau	\$30.00	Bydof	\$15.00	Tanota	\$33.00	Tyrol	\$18.00
9"	Belar	35.00	Barol	25.00	Tasid	40.00	Tigen	35.00
11"	Banch	40.00	Bazap	30.00	Tadus	45.00	Tolis	40.00
13"	Bemil	45.00	Belar	40.00	Tesol	52.00	Tuper	47.00
15"	Berow	50.00	Bedik	45.00	Texis	58.00	Tolcas	53.00

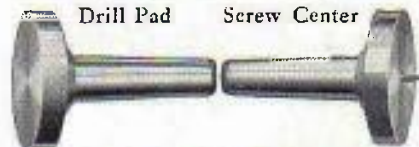
NOTE: The double arm gear bracket is common on both the Metric Transposing Gear Attachment and the Fine Thread Cutting Attachment. Therefore a lower price will be quoted if both attachments are wanted. Prices on request.

SOUTH BEND, INDIANA, U. S. A.



### Prices of Head Spindle Lathe Center

Size Lathe	9" W.S.	9 in.	11 in.	13 in.	15 in.	16 in.
Cat. No.	725-W	725-A	725-B	725-C	725-D	725-E
Price, each	\$2.00	\$2.00	\$2.00	\$2.75	\$2.75	\$2.75



Size of Lathe	Cat. No.	Net Price
9" W.S.	727-W	\$2.00
9 in.	727-A	2.00
11 in.	727-B	2.00
13 in.	727-C	2.75
15 in.	727-D	2.75
16 in.	727-E	2.75

Size of Lathe	Cat. No.	Net Price
9" W.S.	731-W	\$2.50
9 in.	731-A	2.50
11 in.	731-B	2.50
13 in.	731-C	3.25
15 in.	731-D	3.25
16 in.	731-E	3.25

### Crotch Center



Size of Lathe	Cat. No.	Net Price
9" W.S.	728-W	\$2.50
9 in.	728-A	2.50
11 in.	728-B	2.50
13 in.	728-C	3.25
15 in.	728-D	3.25
16 in.	728-E	3.25

### Spur Center



Size of Lathe	Cat. No.	Net Price
9" W.S.	732-W	\$2.75
9 in.	732-A	2.75
11 in.	732-B	2.75
13 in.	732-C	3.25
15 in.	732-D	3.25
16 in.	732-E	3.25

### Cup Center



Size of Lathe	Cat. No.	Net Price
9" W.S.	733-W	\$2.00
9 in.	733-A	2.00
11 in.	733-B	2.00
13 in.	733-C	2.75
15 in.	733-D	2.75
16 in.	733-E	2.75



### Prices of Tail Spindle Lathe Center

Size Lathe	9" W.S.	9 in.	11 in.	13 in.	15 in.	16 in.
Cat. No.	726-W	726-A	726-B	726-C	726-D	726-E
Price, each	\$2.25	\$2.25	\$2.25	\$3.00	\$3.00	\$3.00

### Morse Taper Sleeve

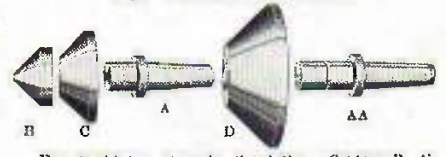
Made of steel and machined to Morse Standard Taper Gauges. Used in fitting small tapers to large sockets.



### Prices of Morse Taper Sleeve

Cat. No.	Size Morse Taper	Taper of Bore	Outside Taper	Price, Each
118-A	No. 1 to 2	No. 1 Morse	No. 2 Morse	\$0.75
118-B	No. 1 to 3	No. 1 Morse	No. 3 Morse	.90
118-C	No. 1 to 4	No. 1 Morse	No. 4 Morse	1.10
118-D	No. 2 to 3	No. 2 Morse	No. 3 Morse	.90
118-E	No. 2 to 4	No. 2 Morse	No. 4 Morse	1.10
118-F	No. 3 to 4	No. 3 Morse	No. 4 Morse	1.10

### Pipe Centers for Lathes



For machining pipes in the lathe, centers B, C, and D revolve on the short end of taper shanks A and AA, which fit within the head and tail spindle of the lathe. Shank A is used with centers B and C; Shank AA with center D. Prices of centers larger than those listed will be furnished on request.

### Prices of Taper Shanks and Pipe Centers

Size of Lathe	Taper Shank A and Center B for Pipe 3/2" to 3"		Taper Shank AA and Center D for Pipe 3/2" to 3"	
	Cat. No.	Price	Cat. No.	Price
9" W.S.	661-W	\$7.00	Not Made	Not Made
9", 11"	663-A	7.00	Not Made	Not Made
12", 15"	663-B	8.00	929-A	\$18.50
16"	663-C	8.50	929-B	17.00

Extra for No. 912-C Center C, for pipe 3" to 5", \$6.00.

### Hand Rest for Wood Turning

The hand rest for wood turning is a necessary attachment for the pattern shop and is also used in general shops where wood working, as well as metal working is done. This attachment is also used for turning fiber, bakelite, catalin and other cast resin plastics. Clamps direct to lathe bed. The prices listed below include the base, two T-rests, clamp and bolt.

Size Lathe	Cat. No.	"T" Rest Length		Price
		Small	Large	
9" W.S.	107-W	4 in.	12 in.	\$7.50
9 in.	1071	4 in.	12 in.	9.00
11 in.	1072	4 in.	12 in.	9.00
13 in.	1073	6 in.	12 in.	10.00
15 in.	1074	7 in.	15 in.	13.00
16 in.	1075	7 in.	15 in.	13.00



### Hand Rest for Wood Turning

For 9" "Workshop" Only

Attachment clamps on lathe carriage in place of the compound rest. Price includes base and "T" rests 4", and 12" long. No. 896-W, Code "Adaws", Ship. wt. 6 lbs. \$5.00

### Fine Thread Cutting Attachment For Standard Change Gear South Bend Lathes



Fine Screw Thread and Fine Automatic Feed Attachment

This attachment permits compounding the gears furnished with lathe for cutting additional screw threads of fine pitch as follows: 44, 46, 48, 52, 54, 56, 60, 64, 72 and 80 per inch. The same attachment can be fitted with additional gears at extra cost for extra fine screw threads and fine feeds.

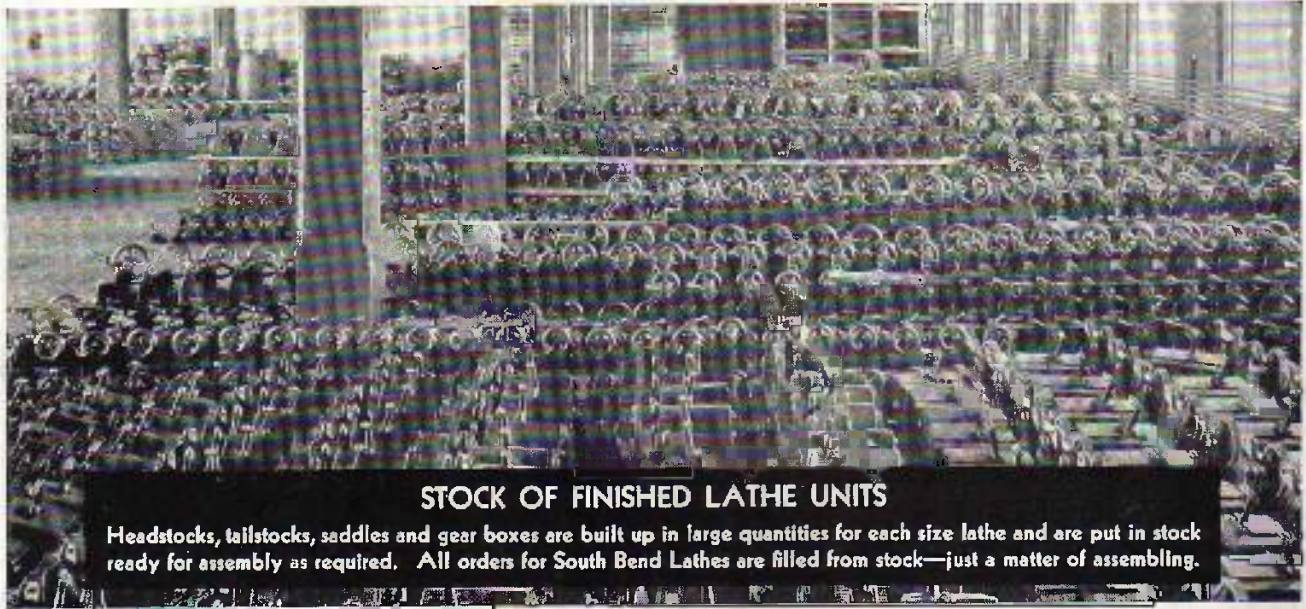
The Attachment can be ordered with the lathe and fitted at factory, or it can be purchased later as extra equipment. When ordered with the lathe the gear bracket regularly supplied with the lathe is omitted.

Equipment includes a double arm bracket, one 1 to 2 compound gear, intermediate gear, thread chart, bushings, bolts and nuts.

### Prices Fine Thread Cutting Attachment

Size of Lathe	Price When Ordered With Lathe		Price When Ordered Extra	
	Cat. No.	Price	Cat. No.	Price
9" W.S.	1365-W	\$ 8.00	1365-W	\$10.00
9 in.	300	10.00	1000	20.00
11 in.	310	13.00	1001	22.00
13 in.	311	14.00	1002	27.50
15 in.	315	17.00	1003	27.50
16 in.	317	17.00		

South Bend Lathes are Produced on Quantity Basis  
Each Size Lathe is Built in Large Lots



**STOCK OF FINISHED LATHE UNITS**

Headstocks, tailstocks, saddles and gear boxes are built up in large quantities for each size lathe and are put in stock ready for assembly as required. All orders for South Bend Lathes are filled from stock—just a matter of assembling.



**FACTORY DISPLAY AND DEMONSTRATION ROOM OF THE SOUTH BEND LATHE WORKS**

Showing a few of the various sizes and types of South Bend Lathes which we manufacture.



**FACTORY OF THE SOUTH BEND LATHE WORKS, SOUTH BEND, INDIANA, U. S. A.**

Established 1906. Lathe Builders for 30 Years. Ground area 4½ acres. Floor space 180,000 sq. ft.

**SOUTH BEND LATHE WORKS**

425 EAST MADISON ST.  
SOUTH BEND INDIANA, U. S. A.