

## HOW TO USE YOUR 10-IN-1 TOOL BLOCK

The South Bend Ten-in-One Tool Block will replace practically all of the tool holders and boring bar holders ordinarily required, combining them into one practical easy-to-use unit. It may be used for heavy duty operations or, because of its compactness, for smaller classes of work. An outstanding advantage is the screw adjustments for tool height which are easily made and need never be changed until a change in the height of the cutting edge of the tool becomes necessary. Cutter bits may be removed, ground and replaced without the usual height adjustments. The tool block may be revolved to permit mounting the tools from either the right or the left hand side. Instructions for using and a few of the many applications are shown in the diagrams below.

### TURNING AND CUTTING OFF

To mount the 10 in 1 Tool Holder on the compound rest, first remove the nut "A" and block from stud "S". Then slide stud assembly into T-slot and tighten flat head screws "F". Replace block and nut, but do not tighten nut until adjustment for tool height is made.

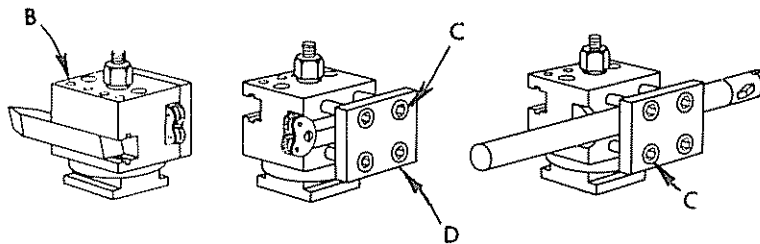
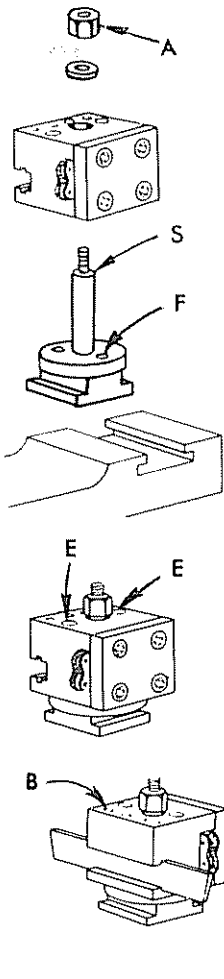
Vertical adjusting screws "E" are used to position the cutting tool. First make sure nut "A" is loose enough to permit complete adjustment, then unscrew the back adjusting screw (one farthest from work) and adjust front screw until cutting edge is at the desired height. Swivel the tool block to the correct position for taking the cut, and tighten nut "A" with fingers only. Now tighten back vertical adjusting screw, and you are ready to take the cut.

Cut-off blades and cutter bits are held in the tool slots by the 4 set screws labeled "B" in the diagram. Loosen these screws sufficiently to allow entry of the tool and then tighten them to lock the tool in place.

### BORING AND KNURLING

Your Tool Block comes equipped with a self-aligning knurling head having No. 3151 medium diamond knurls. To change knurls or for using a boring bar, loosen the 4 cap screws labeled "C" and move plate "D" away from the main body to allow sufficient clearance for removal of the knurling head. When replacing, always tighten these screws enough to bring the plate solidly against the main body of tool block.

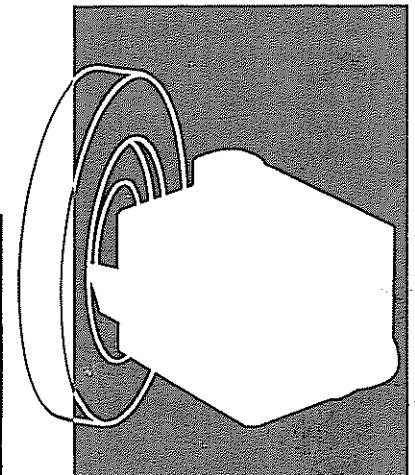
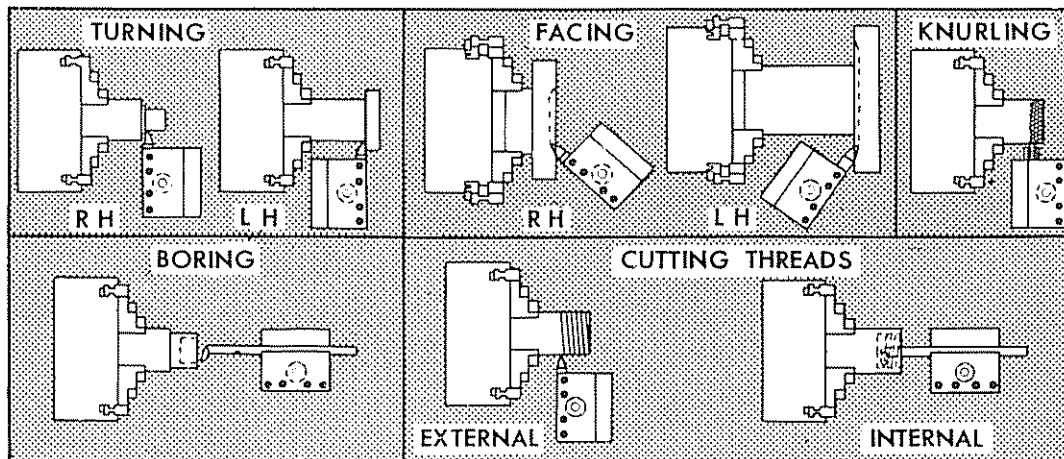
For all boring and knurling operations, invert the entire tool block. This places the boring or knurling tool at the correct height, without disturbing the height adjustment for the turning tool.

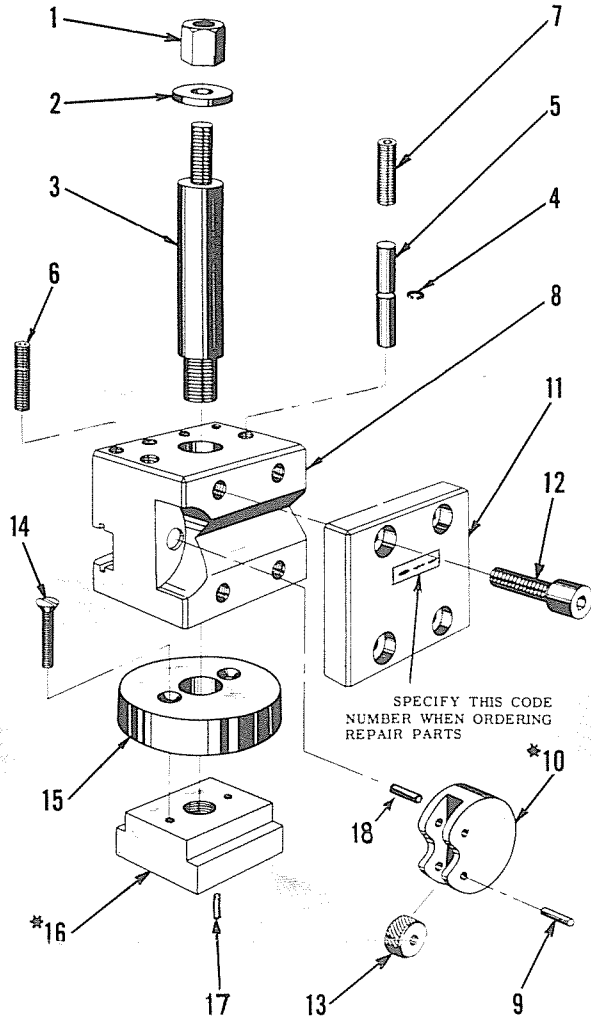


**SOUTH  
BEND**

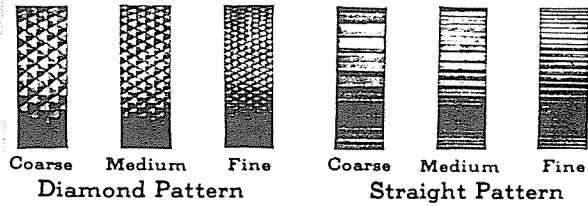
**10  
IN ONE**

**TOOL  
BLOCK**





**Extra Knurls for Knurling Tool**



THE TEN IN ONE TOOL BLOCK COMES EQUIPPED WITH A SELF-ALIGNING KNURLING HEAD HAVING NO. CE3151 MEDIUM DIAMOND KNURLS. OTHER KNURLS ARE AVAILABLE AT EXTRA COST. ILLUSTRATIONS ABOVE SHOW ACTUAL SIZES OF KNURLING PRODUCED. SUPPLIED IN PAIRS.

CAT. NO.	PATTERN	SIZE	PRICE PER PAIR
CE3150	FINE DIAMOND	5/8" x 5/16"	\$2.11
CE3151	MED. DIAMOND	5/8" x 5/16"	2.11
CE3152	COARSE DIAMOND	5/8" x 5/16"	2.11
CE3153	FINE STRAIGHT	5/8" x 5/16"	2.11
CE3154	MED. STRAIGHT	5/8" x 5/16"	2.11
CE3155	COARSE STRAIGHT	5/8" x 5/16"	2.11

**10 in 1 Tool Block**  
 For 9", Lt. 10, 10", 13",  
 14 1/2", 16", & 16 1/4"

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

ITEM NO.	PART NAME	9" & LT. 10 (A.B. & C)		10" ( 1" COL. )		13"		14 1/2"		16" & 16 1/4"	
		PART NO.	PRICE EACH	PART NO.	PRICE EACH	PART NO.	PRICE EACH	PART NO.	PRICE EACH	PART NO.	PRICE EACH
1	NUT	PT283NK1	\$ .30	PT283NK1	\$ .30	PT283R1	\$ .60	PT283R1	\$ .60	PT283R1	\$ .60
2	WASHER	PT1673NR1	.05	PT1673NR1	.05	PT1674T1	.05	PT1675FH1	.05	PT1675FH1	.05
3	STUD	PT1464NR1	.90	PT1464NR1	.90	PT1464T1	2.90	PT1464F1	3.10	PT1464H1	3.35
4	SNAP RING	NOT USED	-	NOT USED	-	PT1474T1	.05	PT1474FH1	.10	PT1474FH1	.10
5	ADJ. PIN	NOT USED	-	NOT USED	-	PT1473T1	.45	PT1473FH1	.50	PT1473FH1	.50
6	DOG PT. SCR.	121x16	.25	121x16	.25	121x124	.35	121x224	.40	121x224	.40
7	ADJ. DOG PT. SCR.	121x228	.40	121x228	.40	121x312	.30	121x412	.40	121x412	.40
8	BLOCK				PRICE		ON		REQUEST		
9	KNURL STUD	PT1476NH1	.40	PT1476NH1	.40	PT1476NH1	.40	PT1476NH1	.40	PT1476NH1	.40
10	KNURL HD. (18)	*AS1475NH1	1.90	*AS1475NH1	1.90	*AS1475NH1	1.90	*AS1475NH1	1.90	*AS1475NH1	1.90
11	CLAMP	PT1461NK1	3.75	PT1461R1	3.85	PT1461T1	4.50	PT1461F1	5.25	PT1461H1	5.55
12	CAP SCREW	114x16	.30	114x16	.30	114x124	.35	114x224	.45	114x224	.45
13	KNURLS		SEE		SEE	TABULATION		ABOVE			
14	FLAT HD. SCR.	103x212	.05	103x212	.05	103x212	.05	103x614	.05	103x618	.05
15	BASE	PT1462NR1	1.80	PT1462NF1	1.80	PT1462T1	2.15	PT1462F1	2.55	PT1462H1	2.85
16	CLAMP (1-2-3-17)	*AS1463NK1	4.35	*AS1463R1	5.00	*AS1463T1	9.00	*AS1463F1	9.95	*AS1463H1	12.35
17	PIN OR SCREW	160x18	.05	160x18	.05	120x906	.20	120x906	.20	120x906	.20
18	PIN	160x45	.05	160x45	.05	160x45	.05	160x45	.05	160x45	.05

PRICES NET F.O.B., SOUTH BEND, INDIANA. (SUBJECT TO CHANGE WITHOUT NOTICE)