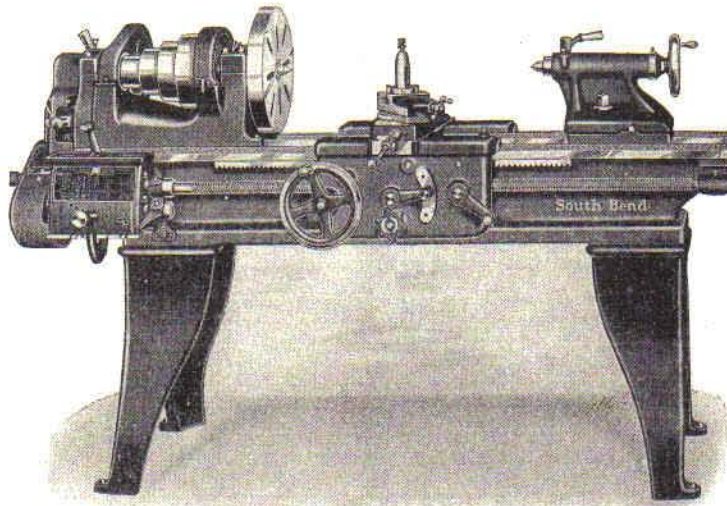


PARTS LIST No. 17-C

# REPLACEMENT PARTS

FOR

## SOUTH BEND LATHES



APPLYING TO THE FOLLOWING SIZES, TYPES, AND SERIES  
OF SOUTH BEND LATHES

SIZES: 9-inch; 11-inch; 13-inch; 14½-inch; 15-inch; 16-inch; and 16-24-inch swing lathes.

TYPES: Quick Change Gear; Standard Change Gear; and Junior.

SERIES: Series "O" Lathes; Series "N" Lathes; Series "R" Lathes; and Series "T" Lathes.



# SOUTH BEND LATHE WORKS

535 Niles Avenue

South Bend, Indiana, U. S. A.



# REPLACEMENT PARTS FOR SOUTH BEND LATHES

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SIZES: 9-inch; 11-inch; 13-inch; 14½-inch; 15-inch; 16-inch; and 16-24-inch swing lathes.

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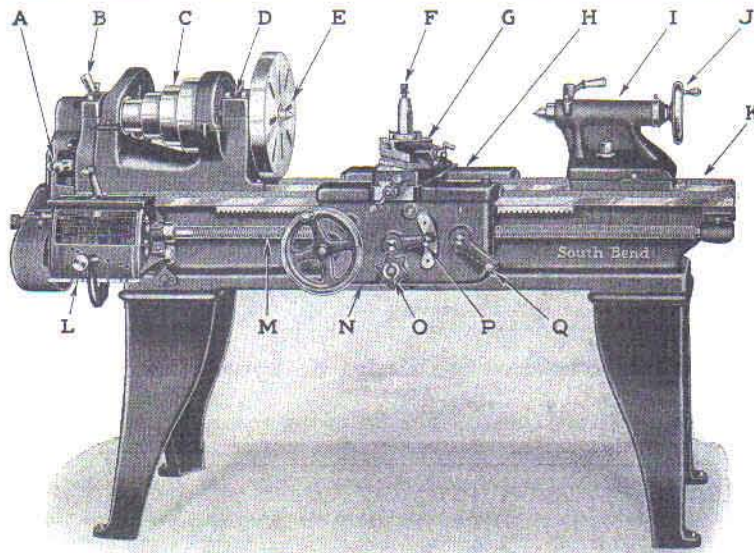


Fig. 1.

## Principal Parts of Lathe

The above illustration shows the principal parts and units of a modern, back-gearred, screw cutting precision lathe.

- |                                 |                         |
|---------------------------------|-------------------------|
| A—Reverse for Threads and Feeds | I—Tailstock             |
| B—Back Gear Lever               | J—Tailstock Hand Wheel  |
| C—Spindle Cone                  | K—Lathe Bed             |
| D—Headstock                     | L—Quick Change Gear Box |
| E—Face Plate                    | M—Lead Screw            |
| F—Tool Post                     | N—Apron                 |
| G—Compound Rest                 | O—Apron Clutch          |
| H—Saddle                        | P—Power Feed Lever      |
| Q—Lever for Thread Cutting      |                         |



**SOUTH BEND LATHE WORKS**

535 Niles Avenue

South Bend, Indiana, U. S. A.



# How to Order Replacement Parts For South Bend Lathes

Part numbers and names of the various parts for all sizes and types of South Bend Lathes (excepting 9-inch "Workshop" Lathes which are shown in 19-R Bulletin) are listed and illustrated in this bulletin. Prices for replacement parts will be quoted on request.

The best way to order replacement parts for your South Bend Lathe is to send the old part to the factory with the order. This will eliminate all possibility of error in filling your order and will assure prompt shipment of the part wanted.

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

- (1) Serial number of the lathe. (See Fig. 2.)
- (2) The correct name and number of the part wanted.
- (3) If the part wanted cannot be located in this parts list, send a sketch of the part, showing the principal dimensions.

When gears or threaded parts are wanted be sure to give information as listed on reverse side of the enclosed order blank.

All orders for replacement parts will be shipped parcel post or express C.O.D. unless remittance in full is inclosed with the order.

### How to Determine the Series or Type of Your Lathe

South Bend Lathes are built in the following series: Series "O;" Series "N;" Series "R;" Series "T;" and "Junior" Lathes. You can determine the series of your lathe by comparing the units of your lathe with those illustrated in this bulletin. When ordering replacement parts be sure the units on your lathe and those shown for the type or series selected are exactly alike.

### Specify Serial Number of Lathe When Ordering Parts

The serial number of your South Bend Lathe is stamped on the top of the lathe bed between the V-way and flat-way at the tailstock end, as shown in the illustration at right.

The serial number is an index to the size, type and model of your lathe and should always be specified when ordering replacement parts or attachments.

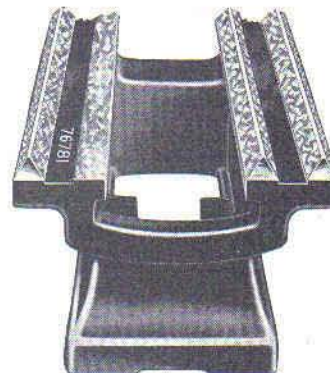


Fig. 2. Serial Number of Lathe.

## South Bend Lathe Works

535 Niles Avenue - - South Bend, Indiana, U.S.A.

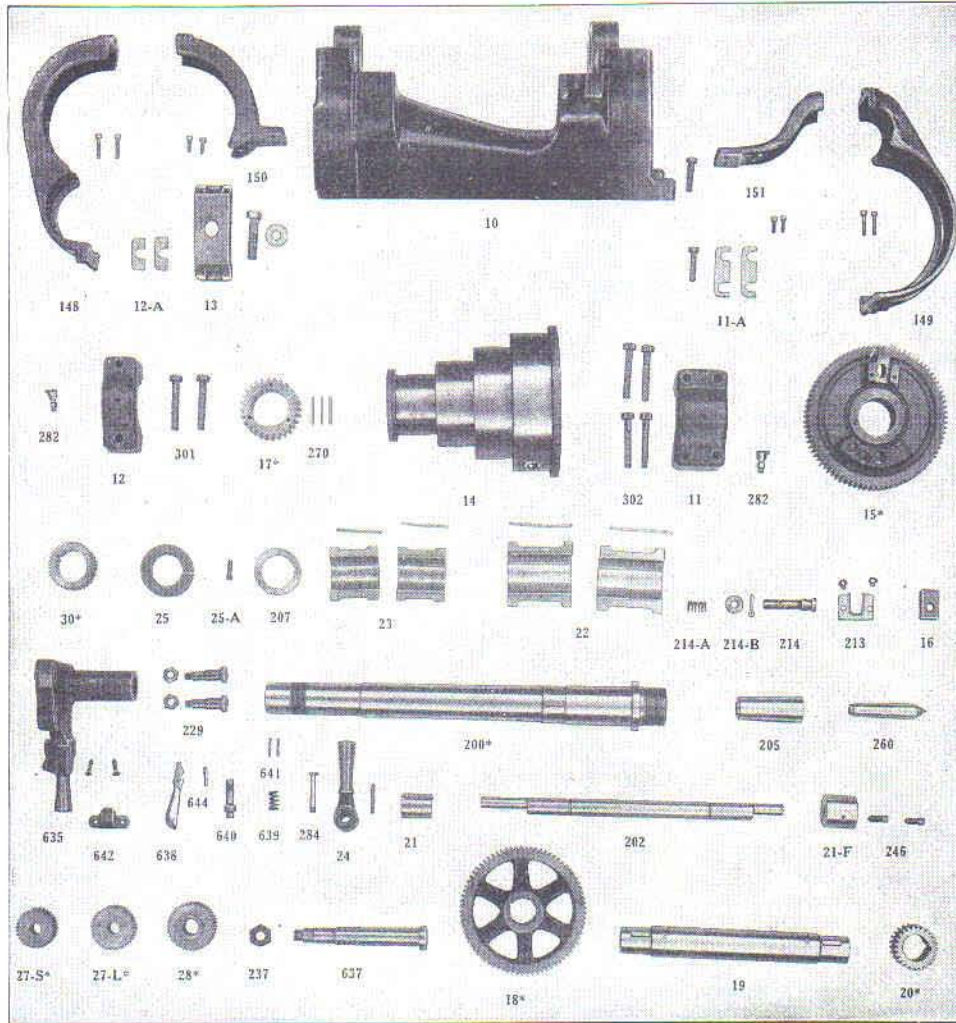


Fig. 3. Headstock Parts for South Bend Lathes.

## Headstock Parts—Overhead Drive

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

Part No.	Name of Part	Part No.	Name of Part	Part No.	Name of Part
10	Headstock and Two Screws.....	24	Back Gear Lever and Taper Pin.....	214B	Bull Gear Clamp Washer & C. Pin...
11	Headstock Cap, Large.....	25	Spindle Take-up Nut.....	229	Reverse Twin Gear Studs.....
11A	Headstock Shims, Large.....	25A	Spindle Take-up Nut Screw.....	237	Reverse Shaft Hexagonal Nut.....
12	Headstock Cap, Small.....	27L	Reverse Twin Gear, Large.....	246	Back Gear Lug Screws.....
12A	Headstock Shims, Small.....	27S	Reverse Twin Gear, Small.....	260	Center.....
13	Headstock Clamps, Screws and Washers for Front and Rear.....	28	Reverse Gear.....	270	Cone Pinion Pins.....
14	Spindle Cone.....	30	Spindle Reverse Gear.....	282	Headstock Oiler.....
15	Bull Gear, with Parts 16, 213, 214, 214A and 214B.....	148	Quill Gear Guard (Top) & 2 Screws..	284	Reverse Bracket Oiler.....
16	Bull Gear Clamp.....	149	Bull Gear Guard (Top) & 2 Screws..	301	Small Headstock Cap Screws.....
17	Cone Pinion.....	150	Quill Gear Guard (Lower) & 2 Screws..	302	Large Headstock Cap Screws.....
18	Quill Gear.....	151	Quill Pinion Guard (Lower), 2 Screws	635	Reverse Bracket with Parts 638, 639, 640, and 644.....
19	Quill Sleeve.....	200	Headstock Spindle (Not Hardened)..	637	Reverse Shaft with Key.....
20	Quill Sleeve Pinion.....	200	Headstock Spindle (Hardened Steel).	638	Reverse Latch.....
21	Eccentric Shaft Bushing, Rear.....	202	Eccentric Shaft.....	639	Reverse Shaft Spring.....
21F	Eccentric Shaft Bushing, Front.....	205	Spindle Sleeve.....	640	Reverse Bracket Plunger.....
22	Bronze Box, Large, Pair.....	207	Spindle Thrust Collar.....	641	Reverse Stop Pins.....
23	Bronze Box, Small, Pair.....	213	Bull Gear Clamp Gib and Screws....	642	Reverse Bracket Lock with Screws...
		214	Bull Gear Plunger.....	644	Reverse Latch Pin.....
		214A	Bull Gear Clamp Spring.....		

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

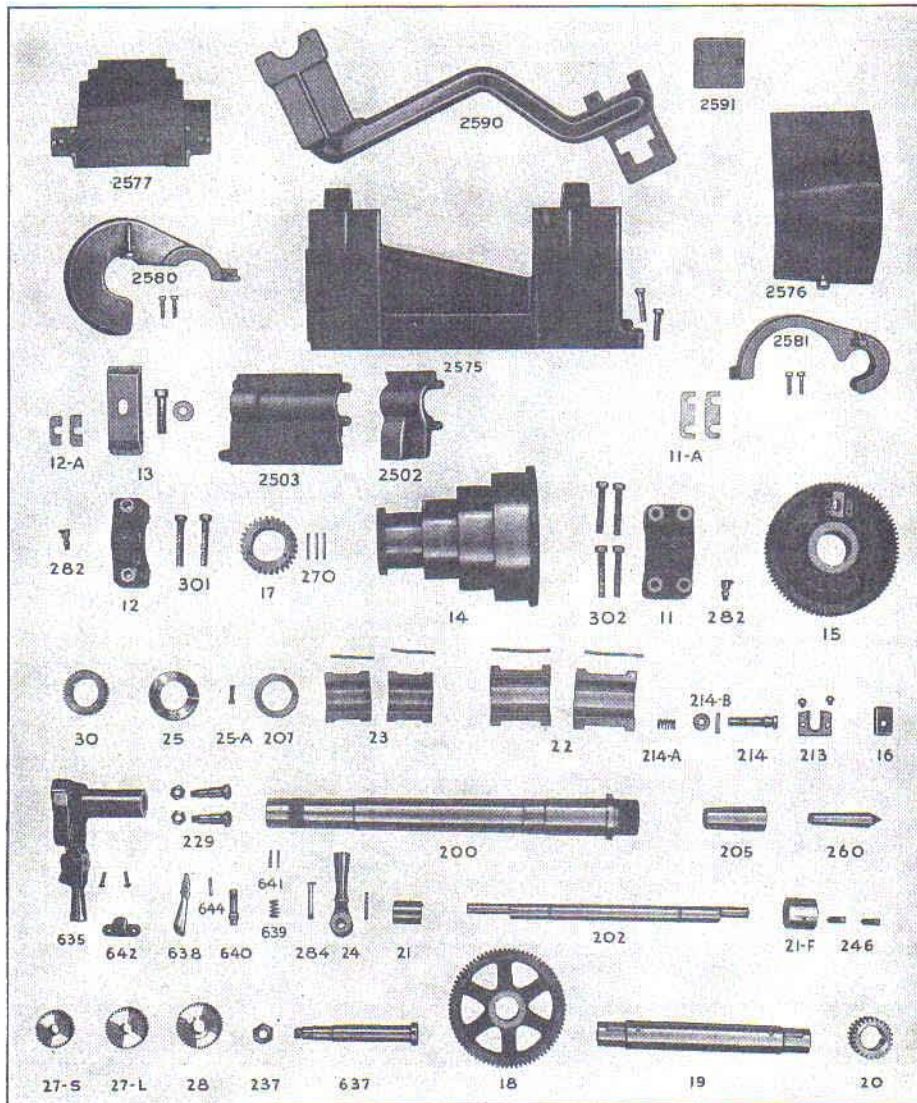


Fig. 4. Headstock Parts for South Bend Lathes.

### Headstock Parts—Underneath Drive

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

Part No.	Name of Part	Part No.	Name of Part	Part No.	Name of Part
11	Headstock Cap, Large	27S	Reverse Twin Gear, Small	301	Large Headstock Cap (Cap Screws)
11A	Headstock Shims, Large	28	Reverse Gear	302	Small Headstock Cap (Cap Screws)
12	Headstock Cap, Small	30	Spindle Reverse Gear	635	Reverse Bracket with Parts 638, 639, 640, and 644
12A	Headstock Shims, Small	148	Quill Gear Guard and 2 Screws	637	Reverse Shaft with Key
13	Headstock Clamps (Front and Rear)	149	Bull Gear Guard and 2 Screws	638	Reverse Shaft Lever
14	Spindle Cone	200	Headstock Spindle (Not Hardened)	639	Reverse Shaft Spring
15	Bull Gear, with Parts 16, 213, 214, 214A, and 214B	200	Headstock Spindle (Hardened Steel)	640	Reverse Bracket Plunger
16	Bull Gear Clamp	202	Eccentric Shaft	641	Reverse Stop Pins
17	Cone Pinion	205	Spindle Sleeve	642	Reverse Bracket Lock with Screws
18	Quill Gear	207	Spindle Thrust Bearing	644	Reverse Latch Pin
19	Quill Sleeve	213	Bull Gear Clamp Gib and Screws	2502	Belt Cover for Bed (Quick Chg. L.)
20	Quill Sleeve Pinion	214	Bull Gear Plunger	2503	Belt Cover for Bed (Std. Chg. L.)
21	Eccentric Shaft Bushing, Rear	214A	Bull Gear Clamp Washer	2575	Headstock
21F	Eccentric Shaft Bushing, Front	214B	Bull Gear Clamp Spring	2576	Spindle Cone Cover
22	Bronze Box, Large, Pair	229	Reverse Twin Gear Studs	2577	Cone Cover Bracket
23	Bronze Box, Small, Pair	237	Reverse Shaft Hexagonal Nut	2580	Quill Gear Guard
24	Back Gear Lever	246	Center	2581	Bull Gear Guard
25	Spindle Take-up Nut	260	Back Gear Lug Screws	2590	Switch Arm
25A	Spindle Take-up Nut Screw	270	Center	2590	Switch Arm Cover and Screws
27L	Reverse Twin Gear, Large	282	Cone Pinion Pins		
		284	Headstock Oiler		
			Reverse Bracket Oiler		

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

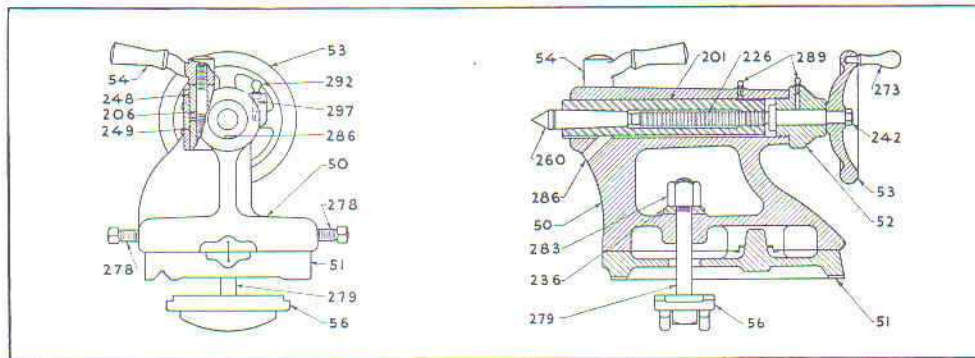


Fig. 5. Line Drawing of Tailstock Unit Showing Position of Parts in Assembly.

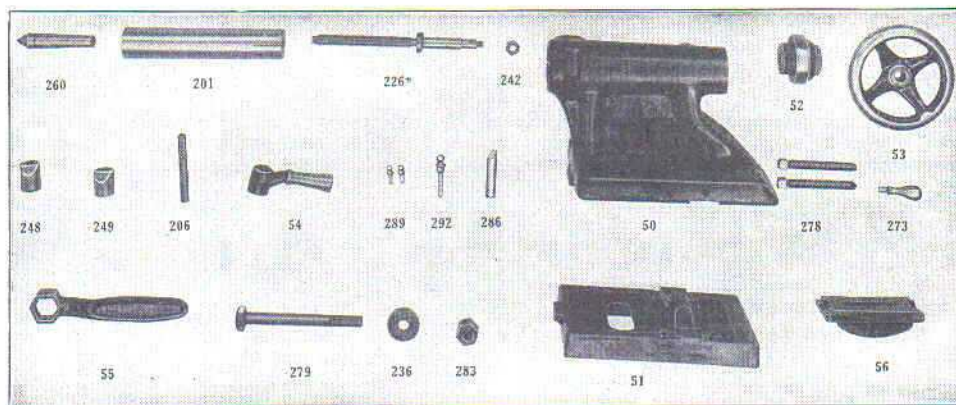


Fig. 6. Tailstock Parts for South Bend Lathes.

## Tailstock Parts

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

Part No.	Name of Part
50	Tailstock Top.....
51	Tailstock Base.....
52	Tailstock Nut.....
53	Tailstock Hand Wheel with Part 273
54	Tailstock Binding Lever.....
55	Tailstock Wrench.....
56	Tailstock Clamp.....
201	Tailstock Spindle.....
206	Tailstock Binding Lever Screw.....
226	Tailstock Screw.....
236	Tailstock Bolt Washer.....

Part No.	Name of Part
242	Tailstock Screw Hex. Nut.....
248	Tailstock Binding Lever Plug.....
249	Tailstock Bd. Lever Plug, Lower.....
260	Tailstock Center.....
273	Tailstock Hand Wheel Handle.....
278	Tailstock Set-over Screw.....
279	Tailstock Clamp Bolt.....
283	Tailstock Clamping Nut.....
286	Tailstock Spindle Key.....
289	Oil Hole Covers.....
292	Tailstock Oil Reservoir Quill.....

Prices quoted on request.

### Be Sure to Specify Serial Number of Lathe

The serial number of your 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 your lathe and should always be specified when repair parts or attachments are ordered.



Fig. 6-A. Serial Number.

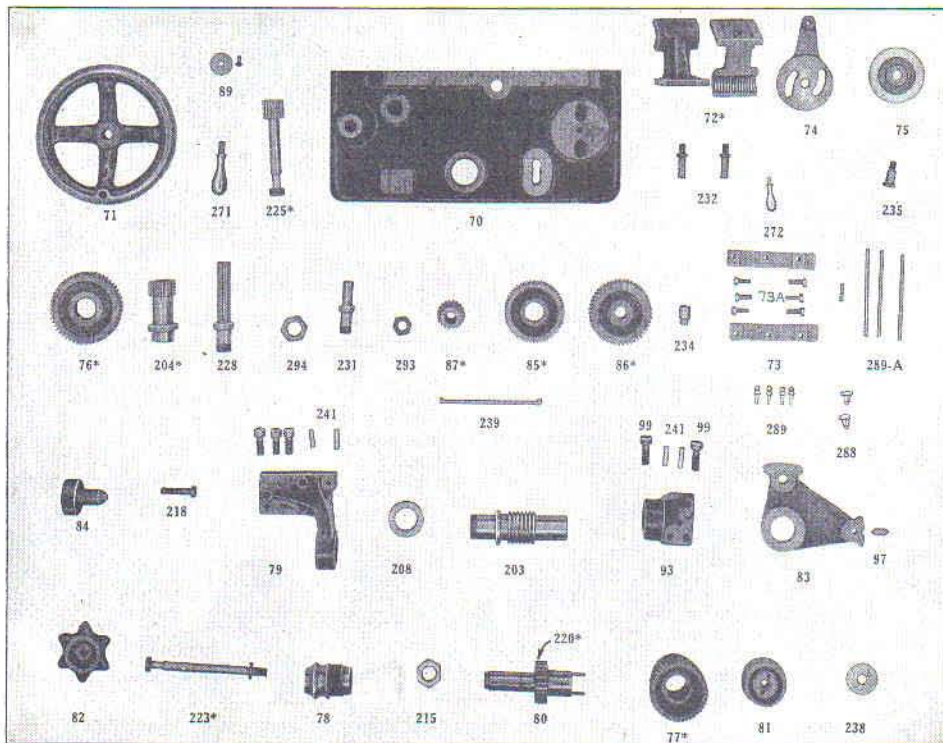


Fig. 7. Apron Parts for Series "O" Quick Change Gear and Standard Change Gear Lathes.

### Apron Parts Series "O" South Bend Lathes

Part No.	Name of Part	Part No.	Name of Part
70	Apron	203	Apron Worm with 208 and 239
71	Apron Hand Wheel with Part 271	204	Rack Pinion
72	Apron Half Nuts with Parts 232	208	Apron Worm Collar
73	Half Nut Gibs	215	Clutch Sleeve Hexagonal Nut
73A	Half Nut Gib Screw	218	Cross Feed Lever Stud
74	Apron Half Nut Cam with Part 272	220	Clutch Sleeve Pinion (Less Sleeve)
75	Apron Half Nut Cam Washer	223	Apron Clutch Screw
76	Rack Pinion Gear	225	Apron Hand Wheel Pinion & Nut
77	Apron Worm Wheel	228	Rack Pinion Stud
78	Clutch Sleeve Bushing	231	Cross Feed Stud
79	Worm Bracket	232	Apron Half Nut Studs
80	Clutch Sleeve with Gear No. 220	234	Cross Feed Idler Gear Stud
81	Cone Clutch	235	Cam Cap Screw
82	Clutch Knob	238	Apron Worm Wheel Washer
83	Cross Feed Lever with 218 and 234	239	Apron Worm Key
84	Cross Feed Lever Knob	241	Worm Bracket Pin
85	Cross Feed Gear	271	Apron Hand Wheel Handle
86	Cross Feed Idler Gear	272	Cam Lever Handle
87	Cross Feed Pinion	288	Hinge Top Oilers
89	Hand Wheel Pinion Washer & Screw	289	Oil Hole Plugs
93	Worm Support Bracket	289A	Apron Oil Tubes
97	Apron Feed Lock Plunger	293	Cross Feed Stud Nut
99	Worm Support Bracket Screw	294	Rack Pinion Stud Nut

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

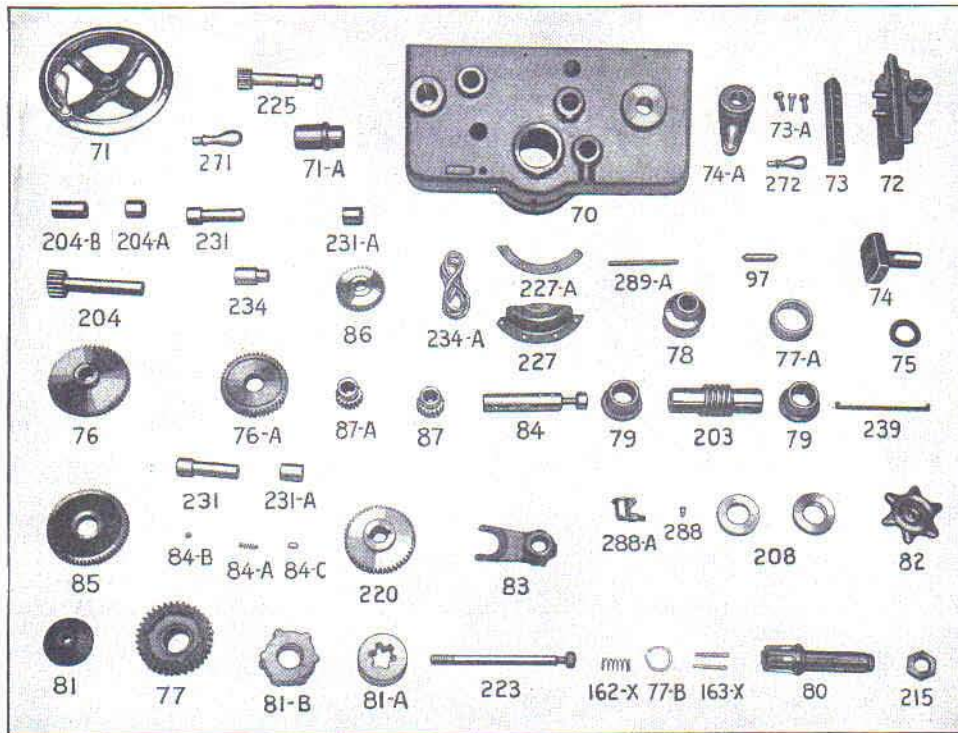


Fig. 8. Apron Parts for Series "N" Quick Change Gear and Standard Change Gear Lathes.

### Apron Parts Series "N" South Bend Lathes

Part No.	Name of Part
70	Apron
71	Apron Hand Wheel with Part 271
71A	Apron Hand Wheel Bushing
72	Half-Nuts with Studs
73	Half-Nut Gib
73A	Half-Nut Gib Screws
74	Half-Nut Cam
74A	Half-Nut Cam Lever with Part 272
75	Half-Nut Friction Washer
76	Rack Pinion Gear
76A	Longitudinal Feed Compound Gear
77	Worm Gear
77A	Worm Gear Bushing
77B	Worm Gear Lock Ring
78	Clutch Sleeve Front Bushing
79	Worm Bushings
80	Clutch Sleeve
81	Clutch Plate Nut
81A	Clutch Plates (Inside)
81B	Clutch Plates (Outside)
82	Clutch Knob
83	Sliding Gear Fork
84	Sliding Gear Shaft
84A	Sliding Gear Shaft Spring
84B	Sliding Gear Shaft Ball
84C	Sliding Gear Shaft Screw
85	Cross Feed Compound Gear

Part No.	Name of Part
86	Cross Feed Idler Gear
87	Cross Feed Compound Pinion
87A	Longitudinal Feed Compound Pinion
97	Feed Lock Safety Plunger
162X	Clutch Sleeve Coil Spring
163X	Clutch Sleeve Keys
203	Apron Feed Worm
204	Rack Pinion
204A	Rack Pinion Bushing (Front)
204B	Rack Pinion Bushing (Rear)
208	Worm Collars
215	Clutch Sleeve Hexagon Nut
220	Clutch Sleeve Sliding Gear
223	Clutch Sleeve
225	Hand Wheel Pinion
227	Worm Gear Oil Trough
227A	Oil Trough Gasket
231	Compound Idler Gear Shaft
231A	Compound Gear Shaft Bushing
234	Cross Feed Idler Stud
234A	Oil Wick
239	Worm Key
271	Apron Hand Wheel Handle
272	Half-Nut Cam Lever Handle
288	Hinge Top Oilers
288A	Oil Reservoir Filler
289A	Apron Oil Tubes

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.



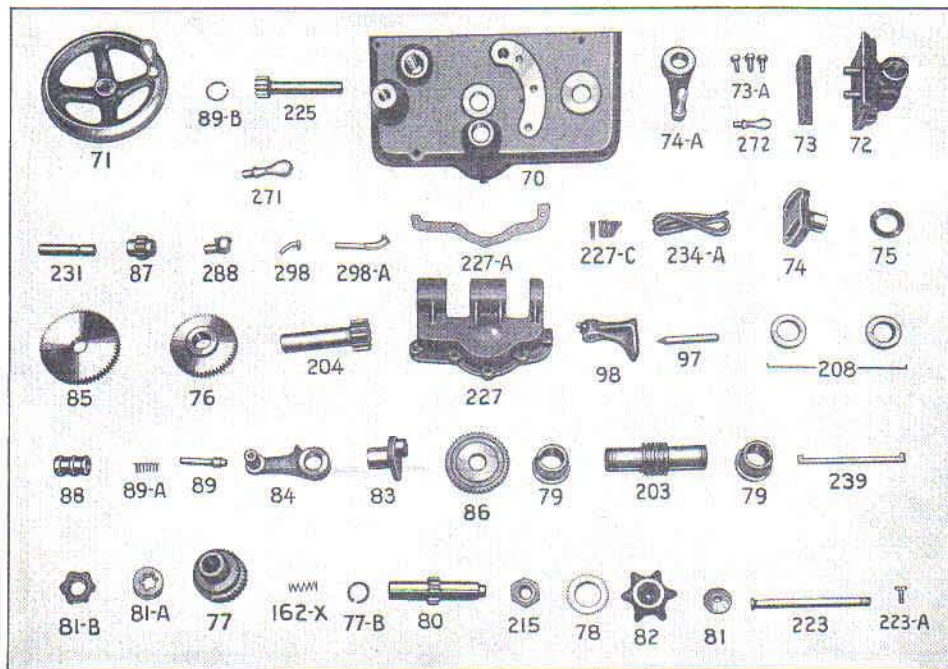


Fig. 9. Apron Parts for Series "R", and "T" Lathes.

## Apron Parts

### Series "R" and "T" South Bend Lathes

Part No.	Name of Part
70	Apron
71	Apron Hand Wheel with Part 271
72	Half-Nuts with Studs
73	Half-Nut Gib
73A	Half-Nut Gib Screws
74	Half-Nut Cam
74A	Half-Nut Cam Lever with Part 272
75	Half-Nut Friction Washer
76	Rack Pinion Gear
77	Worm Gear
77B	Worm Gear Lock Ring
78	Oil Distributing Washer
79	Worm Bushings
80	Clutch Sleeve
81	Clutch Plate Nut
81A	Clutch Plates (Inner)
81B	Clutch Plates (Outer)
82	Clutch Knob
83	Feed Gear Shift Eccentric
84	Feed Gear Shift Lever
85	Cross Feed Compound Gear
86	Apron Feed Idler Gear
87	Cross Feed Compound Pinion
88	Feed Gear Shift Knob

Part No.	Name of Part
89	Feed Gear Shift Plunger
89A	Feed Gear Shift Spring
89B	Hand Wheel Pinion Thrust Spring
97	Feed Lock Plunger
98	Feed Lock Plunger Arm
162X	Clutch Screw Spring
203	Apron Feed Worm
204	Rack Pinion
208	Worm Collars
215	Clutch Sleeve Hexagon Nut
223	Clutch Screw
223A	Clutch Knob Stop Screw
225	Hand Wheel Pinion
227	Oil Trough
227A	Oil Trough Gasket
227C	Oil Trough Screws
231	Cross Feed Compound Gear Shaft
234A	Oil Wick
239	Worm Key
271	Apron Hand Wheel Handle
272	Half-Nut Cam Lever Handle
288	Oil Reservoir Filler
298	Clutch Shaft Oiler
298A	Half-Nut Oiler

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.



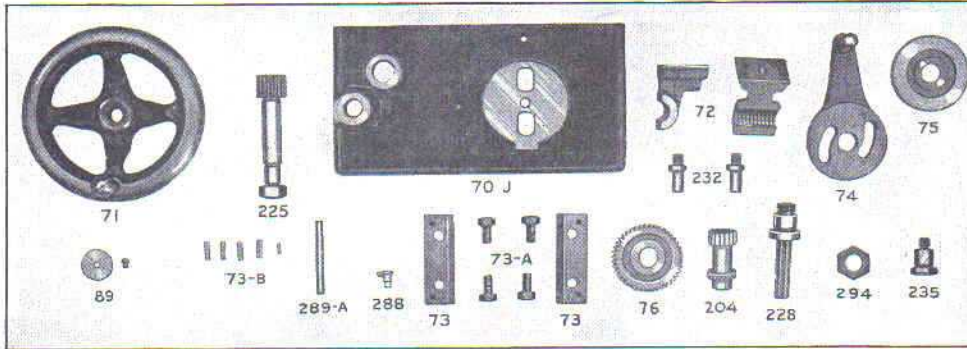


Fig. 10. Apron Parts for 9-inch Junior and 11-inch Junior South Bend Lathes.

### Apron Parts—9-in. Junior and 11-in. Junior South Bend Lathes

Part No.	Name of Part
70J	Apron
71	Apron Hand Wheel with Handle
72	Apron Half-Nuts
73	Half-Nut Gibs
73A	Half-Nut Gib Screws
73B	Half-Nut Gib Dowel Pins
74	Apron Half-Nut Cam with Handle
75	Apron Half-Nut Cam Washer
76	Rack Pinion Gear

Part No.	Name of Part
89	Hand Wheel Pinion Washer and Screw
204	Rack Pinion
225	Apron Hand Wheel Pinion
228	Rack Pinion Stud
232	Apron Half-Nut Studs
235	Cam Cap Screw
288	Hinge Top Oilers
289A	Half-Nut Oil Tube
294	Rack Pinion Stud Nut

Prices quoted on request.

### Apron Parts—8-in. Junior and 9-in. Toolmaker South Bend Lathes

Part No.	Name of Part
70J	Apron
70A	Half-Nut Oil Tube
71	Apron Hand Wheel with Handle
71A	Apron Hand Wheel Pin
72	Apron Half-Nuts with Studs
73	Half-Nut Gib
73A	Half-Nut Gib Screws
73B	Half-Nut Gib Dowel Pins
74	Apron Half-Nut Cam with Handle
76	Rack Pinion Gear
89	Hand Wheel Pinion Washer
204	Rack Pinion
225	Apron Hand Wheel Pinion
228	Rack Pinion Stud
228A	Rack Pinion Lock Washer (Toolmaker only)
235	Cam Cap Screw
238A	Rack Pinion Adjusting Block (Toolmaker only)
294	Rack Pinion Stud Nut

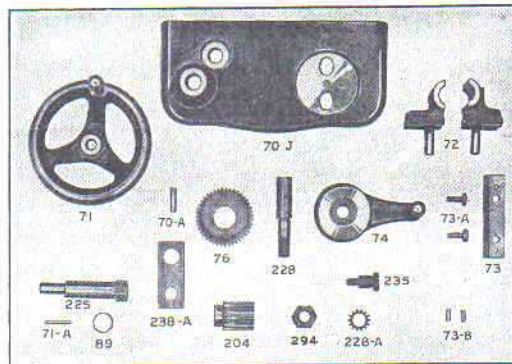


Fig. 11. Apron Parts for 8-inch Junior and 9-inch Toolmaker South Bend Lathes.

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

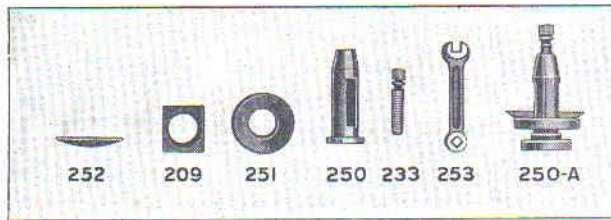


Fig. 12. Tool Post Parts for South Bend Lathes.

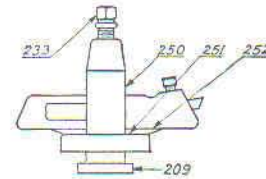


Fig. 13. Position of Parts in Assembly.

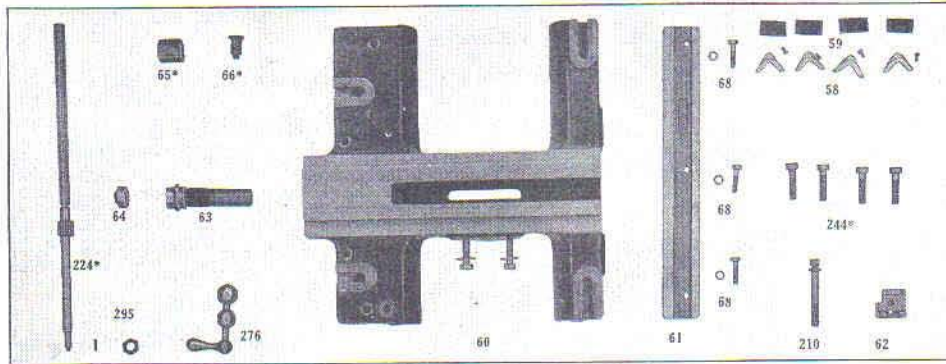


Fig. 14. Compound Rest Parts for South Bend Lathes.

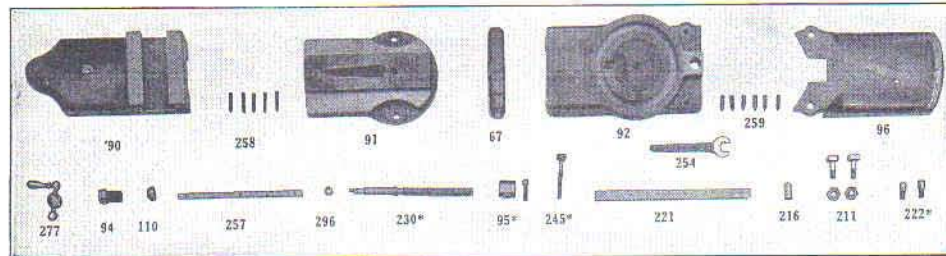


Fig. 15. Saddle Parts for South Bend Lathes.

## Tool Post, Saddle, and Compound Rest Parts Series "O", and "Junior" South Bend Lathes

Saddle Parts	
Part No.	Name of Part
58	Saddle Felt Retainer with Screw
59	Saddle Felt
60	Saddle
61	Saddle Gib
62	Saddle Lock
63	Cross Feed Bushing
64	Cross Feed Graduated Collar
65	Cross Feed Nut
66	Cross Feed Shoulder Screw
68	Gib Screw and Spring Washer
210	Carriage Lock Collar Screw
224	Cross Feed Screw
244	Apron to Saddle Screw
276	Cross Feed Ball Crank with Handle
295	Cross Feed Screw Hex. Nut and Pin

Compound Rest Parts	
Part No.	Name of Part
67	Thread Cutting Stop Complete
90	Compound Rest Top with Part 257
91	Compound Rest Swivel
92	Compound Rest Base with Part 221
94	Compound Rest Bushing
95	Compound Rest Nut and Screw
96	Chip Guard
110	Comp. Rest Graduated Collar
211	Comp. Rest Swivel Stud Bolts and Nuts
216	Comp. Rest Swivel Stud
221	Comp. Rest Base Gib
222	Chip Guard Studs
230	Comp. Rest Screw
245	Thread Cutting Stop Screw

Compound Rest Parts	
Part No.	Name of Part
254	Comp. Rest Wrench
257	Comp. Rest Top Gib
258	Comp. Rest Top Gib Screws
259	Comp. Rest Base, Gib Screws
277	Comp. Rest Crank with Handle
296	Comp. Rest Screw Hex. Nut
Tool Post Parts	
209	Tool Post Block
233	Tool Post Screw
250	Tool Post
251	Tool Post Ring
252	Tool Post Wedge
253	Tool Post Wrench
250A	Tool Post Unit Complete

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

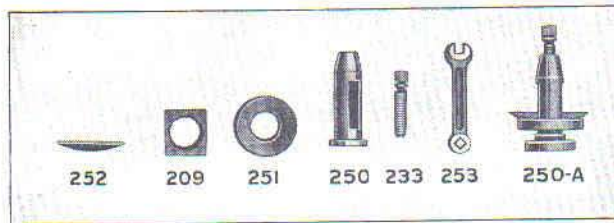


Fig. 16. Tool Post Parts for South Bend Lathes.

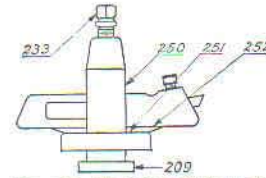


Fig. 17. Position of Parts in Assembly.

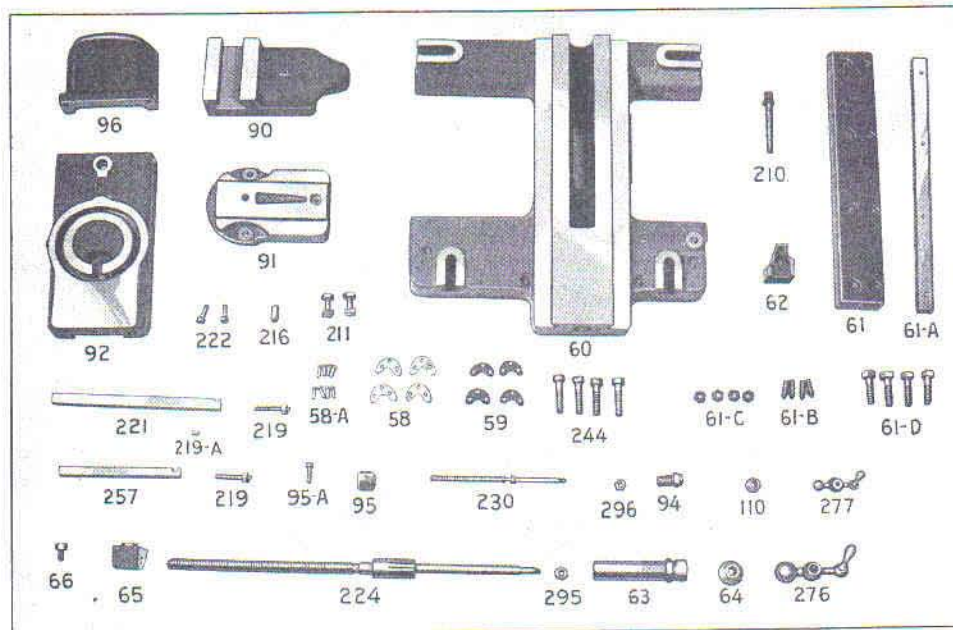


Fig. 18. Saddle and Compound Rest Parts for Series "N" Lathes.

## Tool Post, Saddle, and Compound Rest Parts Series "N" South Bend Lathes

Part No.	Name of Part
58	Saddle Felt Retainers
58A	Saddle Felt Retainer Screws
59	Saddle Felts
60	Saddle
61	Saddle Gib Support
61A	Saddle Gib
61B	Saddle Gib Screws
61C	Saddle Gib Screw Jam Nuts
61D	Saddle Gib Support Screws
62	Saddle Lock
63	Cross Feed Bushing
64	Cross Feed Graduated Collar
65	Cross Feed Screw Nut
66	Cross Feed Nut Shoulder Screw
90	Compound Rest Top
91	Compound Rest Swivel

Part No.	Name of Part
92	Compound Rest Base
94	Compound Rest Bushing
95	Compound Rest Nut
95A	Compound Rest Nut Screw
96	Compound Rest Chip Guard
110	Compound Rest Graduated Collar
210	Saddle Lock Collar Screw
211	Compound Rest Swivel Bolts
216	Compound Rest Swivel Stud
219	Gib Adjusting Screws
219A	Gib Screw Binder Plug
221	Compound Rest Base Gib
222	Chip Guard Screws
224	Cross Feed Screw
230	Compound Rest Screw
244	Apron to Saddle Screws

Part No.	Name of Part
257	Compound Rest Top Gib
276	Cross Feed Ball Crank and Handle
277	Compound Rest Ball Crank and Handle
295	Cross Feed Screw Nut
296	Compound Rest Screw Nut

Tool Post Parts	
209	Tool Post Block
233	Tool Post Screw
250	Tool Post
251	Tool Post Ring
252	Tool Post Wedge
253	Tool Post Wrench
250A	Tool Post Unit Complete

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, or attachments for South Bend Lathes.



Fig. 19. Tool Post Parts for South Bend Lathes.

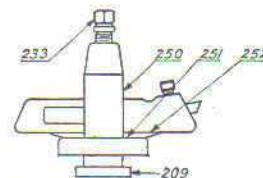


Fig. 20. Position of Parts in Assembly.

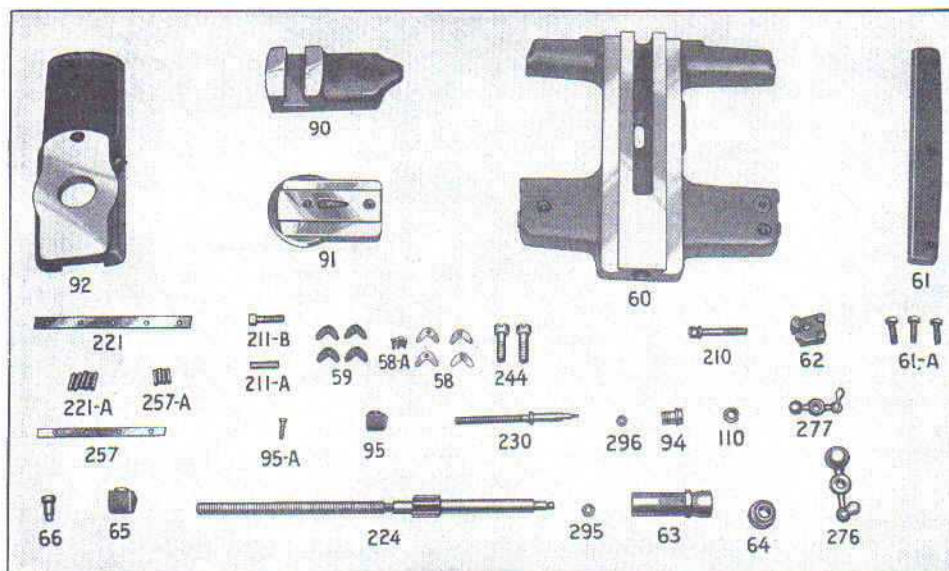


Fig. 21. Saddle and Compound Rest Parts for Series "R" and "T" Lathes.

## Tool Post, Saddle, and Compound Rest Parts Series "R" and "T" South Bend Lathes

Part No.	Name of Part	Part No.	Name of Part	Part No.	Name of Part
58	Saddle Felt Retainers	94	Compound Rest Bushing	276	Cross Feed Ball Crank and Handle
58A	Saddle Felt Retainer Screws	95	Compound Rest Nut	277	Compound Rest Ball Crank and Handle
59	Saddle Felts	95A	Compound Rest Nut Screw	295	Cross Feed Screw Nut
60	Saddle	110	Compound Rest Graduated Collar	296	Compound Rest Screw Nut
61	Saddle Gib	210	Saddle Lock Collar Screw	<b>Tool Post Parts</b>	
61A	Saddle Gib Screws	211A	Compound Rest Lock Pin	209	Tool Post Block
62	Saddle Lock	211B	Compound Rest Lock Screw	233	Tool Post Screw
63	Cross Feed Bushing	221	Compound Rest Base Gib	250	Tool Post
64	Cross Feed Graduated Collar	221A*	Compound Rest Base Gib Screws	251	Tool Post Wedge
65	Cross Feed Nut	224	Cross Feed Screw	252	Tool Post Wrench
66	Cross Feed Nut Shoulder Screw	230	Compound Rest Screw	253	Tool Post Wrench
90	Compound Rest Top	244	Apron to Saddle Screws	250A	Tool Post Unit Complete
91	Compound Rest Swivel	245	Compound Rest Top Gib		
92	Compound Rest Base	257A*	Compound Rest Top Gib Screws		

\*Not required on Series "T" Lathe. Use part No. 219, Gib Adjusting Screw and Part No. 219B, Lock Screw instead.

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, or attachments for South Bend Lathes.

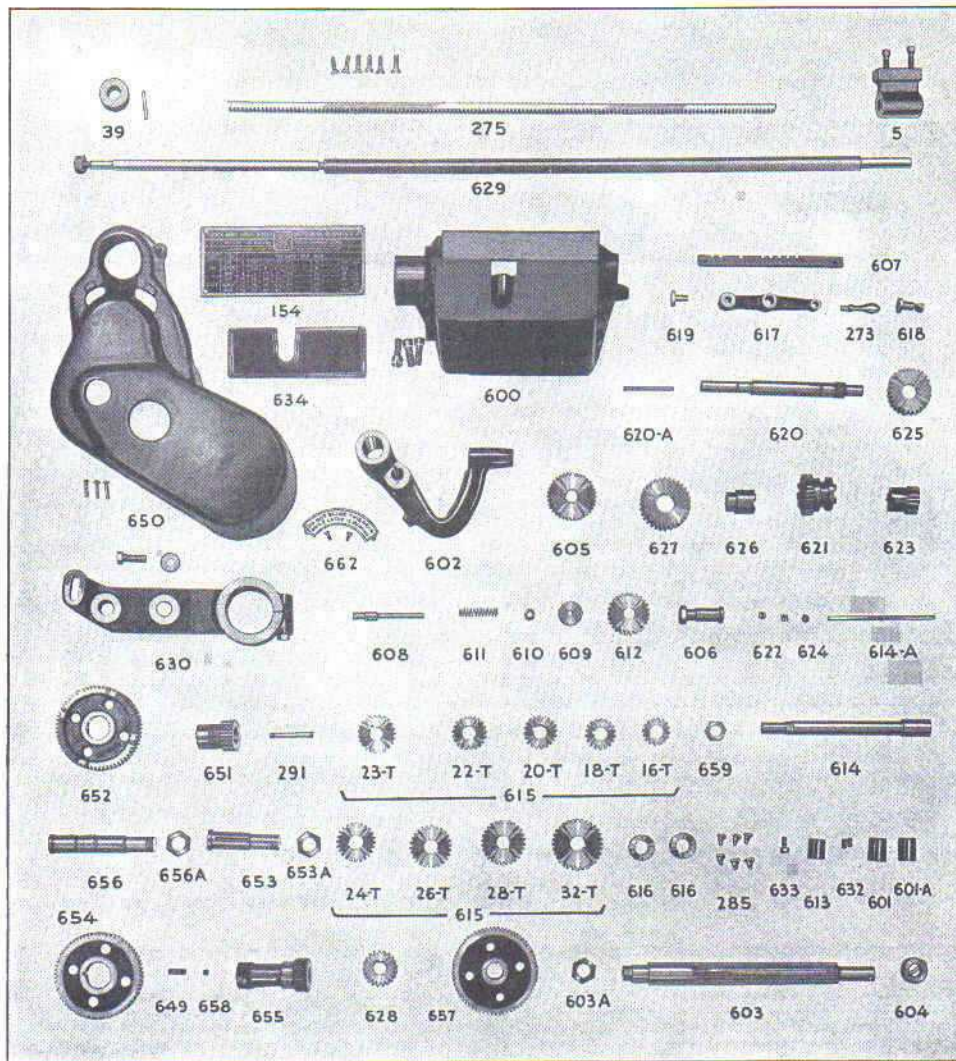


Fig. 22. Quick Change Gear Box Parts for South Bend Quick Change Gear Lathes.

## Quick Change Gear Box Parts Lead Screw—Rack

Series "O", "N", "R", and "T" South Bend Lathes

Part No.	Name of Part	Part No.	Name of Part	Part No.	Name of Part
5	Lead Screw Bracket (Tailstock End)	614	Cone Gear Shaft	626	Clutch
39	Lead Screw Thrust Collar and Pin	614A	Cone Gear Shaft Key	627	Clutch Shaft Gear
154	Index Plate	615	Gear Box Cone Gears—16 Teeth	628	Lead Screw Gear
273	Top Lever Handle	615	Gear Box Cone Gears—18 Teeth	629	Lead Screw
275	Rack	615	Gear Box Cone Gears—20 Teeth	630	Primary Gear Bracket
285	Gear Box Oilers	615	Gear Box Cone Gears—22 Teeth	632	Bushing Lock Screws
291	Gear Box Hub Oiler	615	Gear Box Cone Gears—23 Teeth	633	Bushing Adjusting Screw
600	Gear Box	615	Gear Box Cone Gears—24 Teeth	634	Tool Tray
601	Gear Box Bushing	615	Gear Box Cone Gears—26 Teeth	647	Primary Bracket Support
601A	Gear Box Bushing	615	Gear Box Cone Gears—28 Teeth	649	Primary Knob Spring
602	Gear Box Tumbler	615	Gear Box Cone Gears—32 Teeth	650	Primary Gear Stud
603	Main Drive Pinion	616	Cone Gear Spacing Collars	651	Primary Guard
603A	Hex. Nut for Main Drive Pinion	617	Top Lever with Part No. 273	652	Primary Pinion
604	Main Drive Pinion Collar	618	Top Lever Shoulder Screw	653	Primary Gear
605	Tumbler Idler Gear	619	Top Lever Shifting Plug	653A	Hex. Nut for Primary Gear Stud
606	Tumbler Gear Stud and Nut	620	Compound Gear Shaft	654	Primary Sliding Gear
607	Guide Bar	620A	Compound Gear Shaft Key	655	Primary Sliding Pinion
608	Knob Plunger	621	Clutch Sliding Gear	656	Sliding Gear Stud
609	Plunger Knob	622	Clutch Sliding Gear Spring	656A	Hex. Nut for Sliding Gear Stud
610	Plunger Spring Bushing	623	Clutch Pinion	657	Primary Drive Gear
611	Plunger Spring	624	Ball Bearing for Clutch Sliding Gear	658	Primary Knob Ball Bearing
612	Reverse Stud Gear	625	Clutch Gear	659	Hex. Nut for Cone Gear Shaft
613	Clutch Shaft Bushing			662	Instruction Plate

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

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\*For Series "T" Lathes only. Not illustrated.

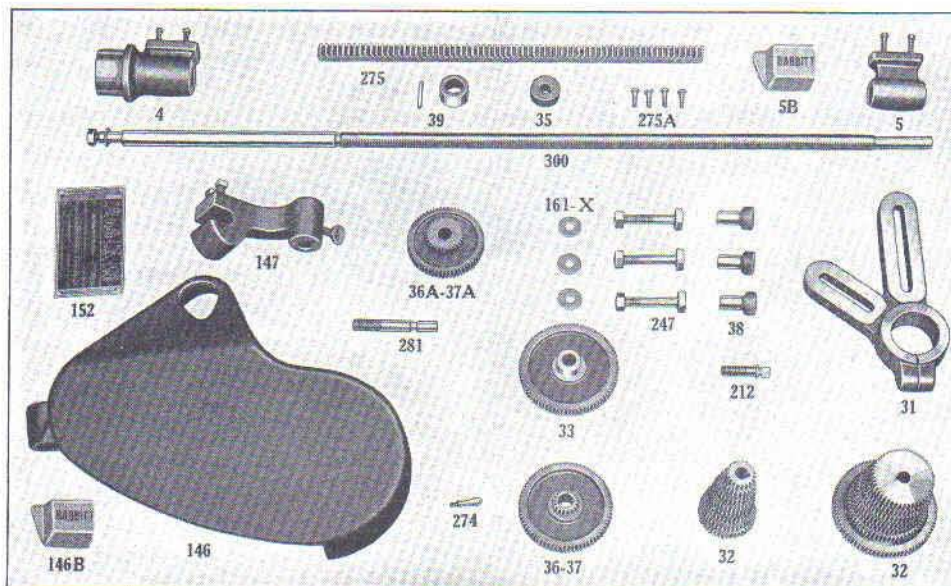


Fig. 23. Standard Change Gear Parts for South Bend Standard Change Gear Lathes.

## Change Gears—Lead Screw—Rack

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

Part No.	Name of Part
4	Front Lead Screw Bracket
5	Rear Lead Screw Bracket
5B	Babbitt for Lead Screw Bracket
31	Standard Change Gear Bracket
32	Change Gear (State No. of teeth)
32N	Complete Set of Std. Change Gears
33	Standard Change Idler Gear
35	Std. Change Gear Collar
36-37	Compound Gears (1 to 4)
36A-37A	Comp. Gears (1 to 3 or 1 to 2)
38	Compound Idler Gear Bushing
39	Lead Screw Thrust Collar and Pin

Part No.	Name of Part
146	Change Gear Guard with Part 274
146B	Babbitt for Gear Guard
147	Change Gear Guard Bracket
152	Index Plate
161X	Compound Idler Bolt Washers
212	Change Gear Bracket Collar Screw
247	Compound Idler Gear Bolts
274	Change Gear Guard Handle
275	Rack
275A	Rack Screws
281	Change Gear Guard Hinge Pin
300	Lead Screw

Prices quoted on request.

### Be Sure to Specify Serial Number of Lathe

The serial number of your 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 your lathe and should always be specified when repair parts or attachments are ordered.

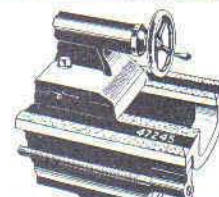


Fig. 23-A. Serial Number.

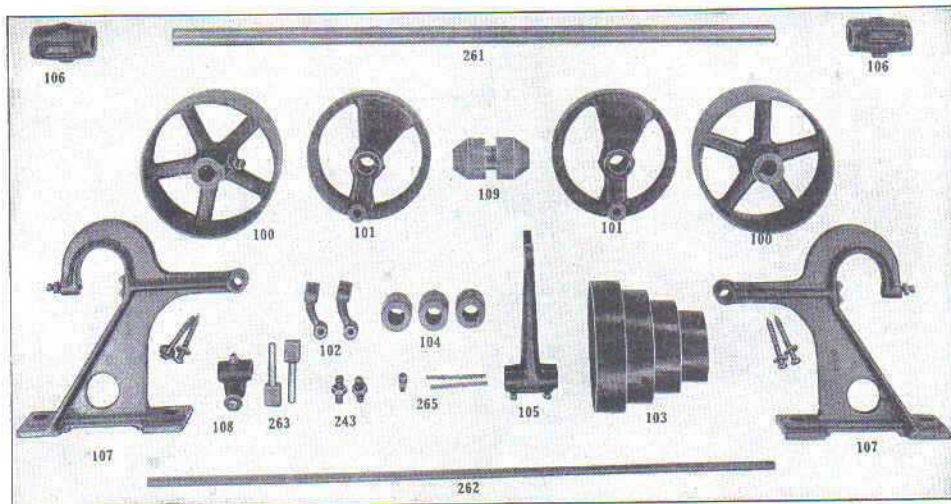


Fig. 24. Various Parts of Double Friction Countershaft.

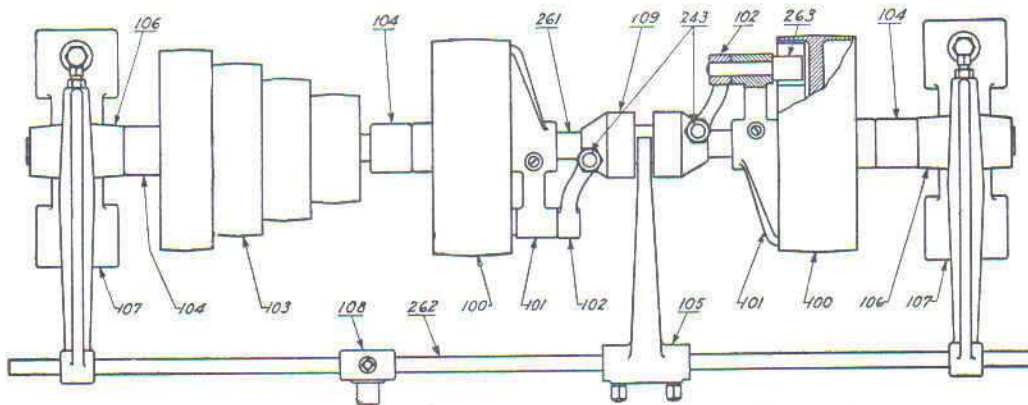


Fig. 25. Illustration Showing Parts of Double Friction Countershaft.

### Countershaft Parts

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

Part No.	Name of Part
100	Countershaft Pulley
101	Countershaft Spider and Set Screws
102	Countershaft Friction Finger
103	Countershaft Cone
104	Countershaft Collar
105	Countershaft Yoke Lever and Set Screws
106	Countershaft Box
107	Countershaft Hanger

Part No.	Name of Part
108	Countershaft Shifter Nut
109	Countershaft Yoke Cone
243	Countershaft Ball Point Set Screw with Lock Nut
261	Countershaft Shaft
262	Countershaft Shifter Rod
263	Countershaft Expansion Wedge
264	Countershaft Shifter Nut Washer
265	Countershaft Oil Hole Springs

Prices quoted on request.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.



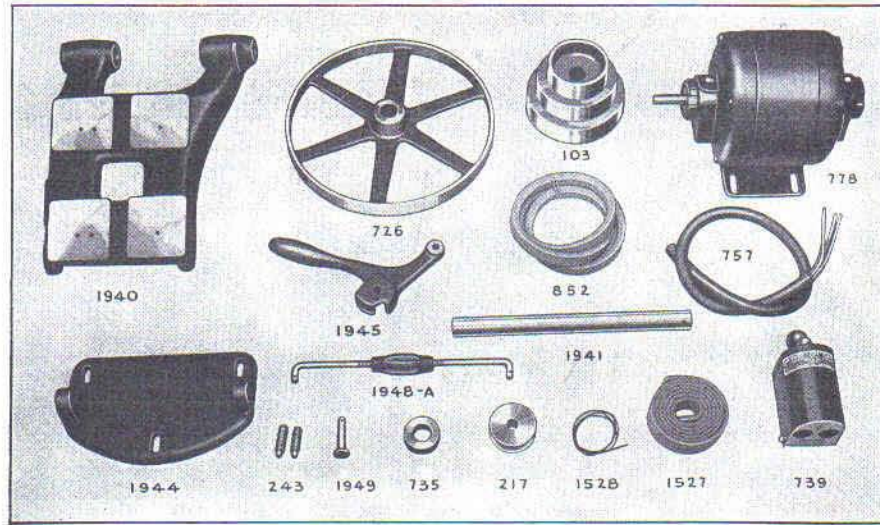


Fig. 26. Parts of Adjustable Horizontal Motor Drive for Lathes.

### Adjustable Horizontal Motor Drive Parts

Part No.	Name of Part	Part No.	Name of Part
103	Cone Pulley (Flat Belt type).....	852	V-Belt, Motor to Countershaft.....
103V	Cone Pulley (V-Belt type).....	1527	Leather Belt.....
217	Motor Pulley.....	1528	Belt Lacing.....
243	Ball Point Set Screw and Lock Nut.....	1940	Drive Standard.....
726	Drive Pulley.....	1941	Shaft.....
735	Shaft Collar.....	1944	Base.....
739	Switch (Specify size lathe, type drive, and motor specifications).....	1945	Belt Release Crank.....
757	Wiring.....	1948A	Turnbuckle Assembly.....
778	Motor (Specify horsepower, phase, cycle, voltage, and D.C. or A.C.).....	1949	Belt Release Crank Pin.....

Prices quoted on request.

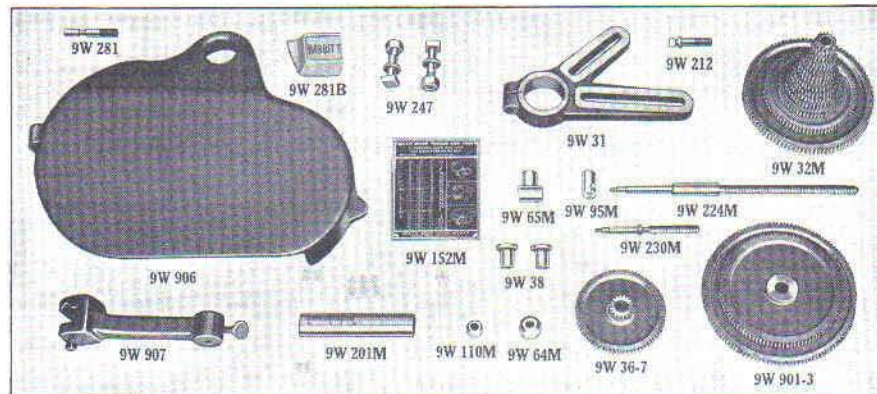


Fig. 27. Metric Parts for 9-inch "Workshop" South Bend Lathes.

### Metric Lathe Parts

9W31	Change Gear Bracket.....	9W201M	Metric Graduated Tailstock Spindle.....
9W32M	Metric Change Gears (Specify No. Teeth).....	9W212	Collar Screw for Change Gear Bracket.....
9W36-7	Compound Idler Gear Assembly.....	9W224M	Metric Cross Feed Screw.....
9W38	Compound Idler Gear Bushings.....	9W230M	Metric Compound Rest Screw.....
9W64M	Metric Cross Feed Graduated Collar.....	9W247	Compound Idler Gear Bolts.....
9W65M	Metric Cross Feed Nut, Lock Screw and Pin.....	9W281	Gear Guard Stud.....
9W95M	Metric Compound Rest Nut.....	9W281B	Babbitt for Gear Guard.....
9W110M	Metric Compound Rest Graduated Collar.....	9W901-3	Metric Transposing Gear Assembly.....
9W152M	Metric Index Plate.....	9W906	Metric Transposing Change Gear Guard.....
		9W907	Metric Transposing Gear Guard Bracket.....

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

## Underneath Belt Motor Drive Parts

Series "O", "N", "R", "T", and "Junior" South Bend Lathes

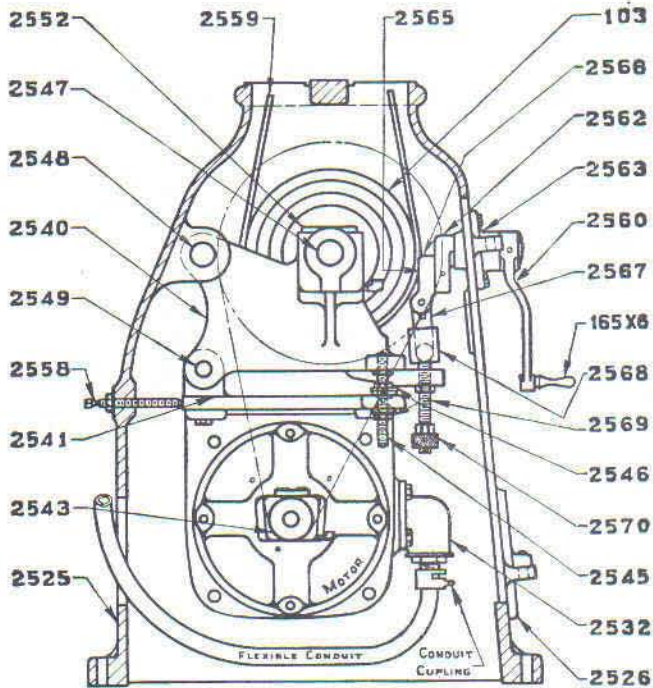


Fig. 28. End View Drawing Showing Position of Parts of Underneath Belt Motor Drive Unit in Assembly.

Part No.	Name of Part
103	Countershaft Cone
165X6	Crank Machine Handle
615A	Oil Cup
739	Switch (Give size lathe and motor specifications)
778	Motor (Specify horsepower, phase, cycle, voltage, and D.C. or A.C.)
2525	Motor Drive Cabinet Leg
2526	Cabinet Leg Front Door
2527	Cabinet Leg Side Door
2530	Motor Chip Guard
2532	Motor Conduit Box
2540	Countershaft Cradle
2541	Motor Plate
2542	Countershaft "V" Pulley
2543	Motor "V" Pulley
2544	"V" Belt
2545	"V" Belt Adjusting Stud
2546	Adjusting Stud Washer
2547	C. S. Cone Shaft
2548	Cone Cradle Shaft
2549	Motor Plate Shaft
2550	Cone Shaft Collar
2552	Oil Ring Hole Cover
2557	Crank Stop Screw and Lock Nut
2558	Motor Plate Stop Screw & Lock Nut
2559	Cone Belt
2560	Tightener Crank with Part 165X6
2562	Tightener Crankshaft
2563	Crankshaft Bushing
2565	Crankshaft Pin
2566	Crankshaft Clevis
2567	Ball Socket
2568	Connecting Sleeve
2569	Adjusting Screw and Lock Nut
2570	Adjusting Nut

Prices quoted on request.

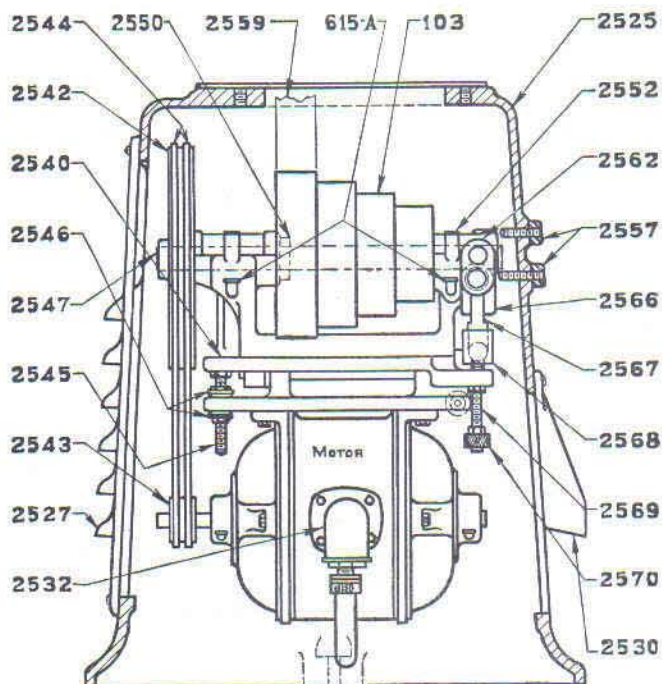


Fig. 29. Front View Drawing Showing Position of Parts of Underneath Belt Motor Drive Unit in Assembly.

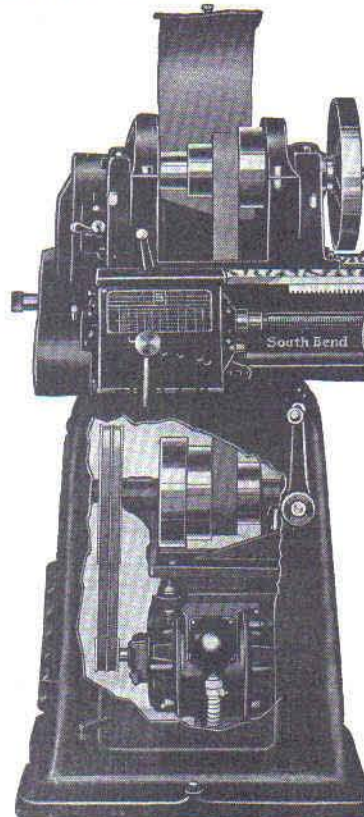


Fig. 30. Front View of Lathe with Underneath Belt Motor Drive Unit.

Specify SERIAL NUMBER OF LATHE when ordering repair parts, tools or attachments for South Bend Lathes.

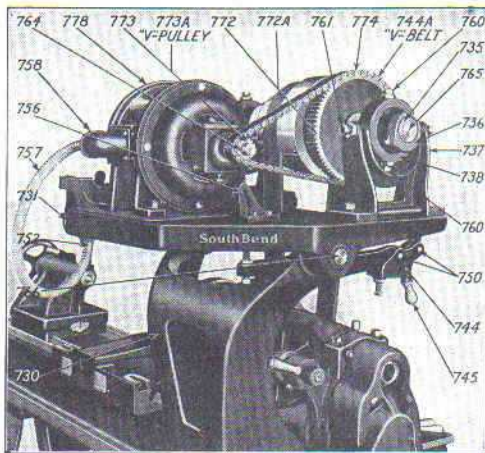


Fig. 31. End View of Silent Chain Motor Drive Unit Showing Location of Parts and Numbers.

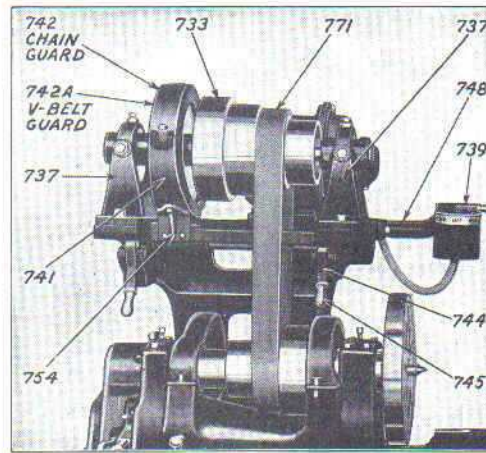


Fig. 32. Front View of Silent Chain Motor Drive Unit Showing Location of Parts and Numbers.

## Silent Motor Drive Parts

(For Silent Chain and V-Belt Types)

Series "O", "N", "R", and "Junior" South Bend Lathes

Part No.	Name of Part
730	Motor Drive Frame.....
731	Motor Drive Top Plate.....
733	Motor Drive Cone.....
735	Motor Drive Shaft Collar.....
736	Motor Drive Bearing (Plain Type).....
737	Motor Drive Bearing Standard.....
738	Motor Drive Bearing Pivot Ring.....
739	Switch (Specify size lathe, and motor specifications).....
741	Motor Drive Chain Guard Case.....
742	Motor Drive Chain Guard Cover.....
742A	Motor Drive "V" Belt Guard.....
744	Motor Drive Belt Adjusting Shoe.....
745	Motor Drive Belt Adjusting Lever.....
748	Switch Bracket.....
750	Belt Adjusting Lever Pins.....
752	Switch Conduit Bushing.....
754	Guard Bracket.....
756	Guard Bracket Foot.....
757	Flexible Conduit.....

Prices quoted on request.

Part No.	Name of Part
758	Flexible Conduit Fitting.....
760	Motor Drive Bearing Screws with Nut.....
761	Motor Drive Pivot Ring Screws with Nut.....
764	Motor Pinion Key.....
765	Motor Drive Countershaft Shaft.....
766	Motor Drive Plate Shaft.....
771	Belt—Price per foot—Specify length.....
771AA	Belt Lacing.....
772	Motor Drive Chain Gear.....
772A	Motor Drive "V" Belt Pulley.....
773	Motor Drive Chain Pinion.....
773A	Motor Drive "V" Belt Pulley.....
774	Motor Drive Chain.....
774A	Motor Drive "V" Belts.....
778	Motor (Specify horsepower, phase, cycle, voltage, and D.C. or A.C.)....
1772	Adjusting Bushing for Frame (15-16-18-inch Lathes).....

### Be Sure to Specify Serial Number of Lathe

The serial number of your 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 your lathe and should always be specified when repair parts or attachments are ordered.



Fig. 33. Serial Number.