



RED ARROW

STEEL

BRASS

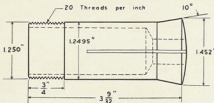
No. 5 SOUTH BEND COLLET

THIS ONE SIZE FITS ALL SOUTH BEND LATHES 10" SWING AND LARGER...

You don't need a separate set of collets for each size lathe when you use South Bend. Our No. 5 collet fits 10", 13", 14½" and 16" swing South Bend Lathes, also the 10", 13" and No. 2-H South Bend Turret Lathes.* This not only effects a substantial saving, but is also a convenience any shop man can appreciate.

South Bend Collets, manufactured with the same exacting care as South Bend Lathes, deliver long, dependable service on precision work. Each collet is carefully inspected and tested, and is packed in a substantial plastic box with transparent lid through which the size can be read for easy selection.

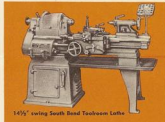
Interchangeability of collets is not the only way you save money with South Bend Lathes. They make your equipment dollars go farther. The cost of special tooling can often be saved by using the many practical attachments available from stock. You'll also notice a difference in power bills. And you'll find South Bend Lathes are readily adaptable to a wide variety of toolroom, maintenance and production jobs.



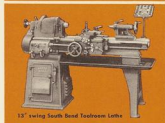
*The 9" and Light Ten South Bend Lathes take smaller collets. Write for information and prices of collet equipment for 9" and Light Ten Lathes.



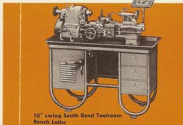
16" swing South Bend Toolroom Lathe



14½" swing South Bend Toolroom Lathe



13" swing South Bend Toolroom Lathe



10" swing South Bend Toolroom Bench Lathe



10" swing South Bend Turret Lathe



No. 2-H South Bend Turret Lathe

← Red Arrow → COLLETS

SOUTH BEND HARDENED AND GROUND THREAD RED ARROW COLLETS To give the utmost in precision, durability and smooth easy operation, we have developed a new line of precision collets with heat-treated and form ground precision threads.

These new hardened and ground thread collets are South Bend's finest "Red Arrow" line. Precision grinding the threads eliminates the darkened area caused by heat treatment of the collet, and gives maximum thread contact in the draw bar.

Each "Red Arrow" is identified with red markings and the plastic box in which it is individually packaged has a red top for positive identification.

These "Red Arrow" collets are only a few cents higher in price than regular milled thread collets. So, for the very finest collet, specify South Bend "Red Arrow."



CE2054	Red Arrow Collets for Round Work, $\frac{1}{4}$ " to 1" capacity in 64ths.
CE2059	Red Arrow Collets for Round Work, decimal hole sizes .0625" to 1.000".
CE2064	Red Arrow Collets for Round Work, metric hole sizes 1.5 mm to 25.0 mm.
CE2064	Red Arrow Collets for Square Work, $\frac{3}{8}$ " to $\frac{1}{2}$ " across flats in 16ths.
CE2069	Red Arrow Collets for Hexagon Work, $\frac{3}{8}$ " to $\frac{1}{2}$ " across flats in 16ths.
CE2077	Set of 16 Red Arrow Collets $\frac{1}{8}$ " to 1" in 16ths. Shipping wt. 11 lbs.
CE2076	Set of 15 Red Arrow Collets $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 32nds. Shipping wt. 11 lbs.
CE2079	Set of 30 Red Arrow Collets $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 64ths. Shipping wt. 20 lbs.

Steel and Brass COLLETS

South Bend Collets are manufactured in our own plants which are equipped with the best facilities obtainable. Constant inspection assures uniformly high quality and precision. Each collet is packed in an individual plastic box with transparent lid. Shipping weight approximately 1 lb. each.

Steel collets are carefully heat-treated for maximum service and are precision ground to exceedingly close tolerances for size and concentricity.

Brass collets have many practical applications. Their low cost makes them desirable for odd sizes or short run jobs. They give good service and can be readily machined on the job for holding tapered or irregular shapes. When worn, they can be rebored to larger diameters.



South Bend No. 5 Collets for 10" - 1" Collet and Larger South Bend Lathes

CE2353	Steel Collets for Round Work, $\frac{1}{8}$ " to 1" capacity in 64ths.
CE2344	Steel Collets for Round Work, decimal hole sizes .0625" to 1.000".
CE2356	Steel Collets for Round Work, metric hole sizes 1.5 mm to 25.0 mm.
CE2176	Steel Collets for Square Work, $\frac{3}{8}$ " to $\frac{1}{2}$ " across flats in 16ths.
CE2183	Steel Collets for Hexagon Work, $\frac{3}{8}$ " to $\frac{1}{2}$ " across flats in 16ths.
CE2435	Set of 16 Steel Collets, $\frac{1}{8}$ " to 1" in 16ths. Ship. wt. 11 lbs.
CE2462	Set of 15 Steel Collets, $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 32nds. Ship. wt. 11 lbs.
CE2463	Set of 30 Steel Collets, $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 64ths. Ship. wt. 20 lbs.

CE2508	Brass Collets for Round Work, $\frac{1}{8}$ " to 1" capacity in 64ths.
CE2508	Brass Collets for Round Work, decimal hole sizes .0625" to 1.000".
CE2503	Brass Collets for Round Work, metric hole sizes 1.5 mm to 25.0 mm.
CE2541	Set of 16 Brass Collets, $\frac{1}{8}$ " to 1" in 16ths. Ship. wt. 11 lbs.
CE2540	Set of 15 Brass Collets, $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 32nds. Ship. wt. 11 lbs.
CE2541	Set of 30 Brass Collets, $\frac{1}{8}$ " to $\frac{1}{2}$ " in odd 64ths. Ship. wt. 20 lbs.



Collets in Sets



CLOSERS FOR STEP CHUCKS

A closer is required for each size of step chuck, with the exception of the 2" size which fits directly into the collet sleeve included in the equipment of the collet attachment.

STEP CHUCK EQUIPMENT

Step chucks are used with either the hand lever type or the hand lever type draw-in chuck attachment for holding dies, gear blanks and similar round work. The construction of the step chuck is similar to that of the collet, except that it is designed for holding larger diameters. A closer is mounted on the lathe spindle nose and the step chuck screws into the threaded hole in the draw bar of the draw-in collet chuck attachment.

STEP CHUCK BLANKS

Catalog Number	Nominal Size	Max. Gap.	Ship. Wt.
CE9998*	2"	3"	4 lbs.
CE9997	3"	3"	4 lbs.
CE9999	4"	4"	5 lbs.
CE9999	5"	5"	5 lbs.
CE9999	6"	6"	13 lbs.

*This step chuck fits directly into collet sleeve and does not require a closer.

Size of Lathe	Taper Step Chuck Sizes	Threaded Spindle	Cam Lock Spindle	Long Taper Spindle
		Cat. No.	Cat. No.	Cat. No.
10" & 10" Turret 13" & 13" Turret	3" and 4" 5" and 6"	CL6309LQ	CA8309LH CA8311LH	CA8309LH CA8311LH
		CL6311LQ		
14 1/2", 16", 16-24", & 2-H	3" and 4" 5" and 6"	CL6309MH	CA8309LH CA8311LH	CA8309LH CA8311LH
		CL6311MH		



COLLET RACK

This collet rack provides a convenient place for keeping collets, centers, spindle sleeves and draw-bar. Holes are provided for 17 collets. Taps along lower edge of collet rack is provided for holding spanner wrench. Clamp for attaching to back V-way of lathe bed is supplied. Price does not include collets or collet attachment.

Catalog Number	Size of Lathe	Ship. Wt.
CE170L	10"-13" Col. & 10" Turret	10 lbs.
CE170Q	13" & 13" Turret	12 lbs.
CE170M	4 1/2"	14 lbs.
CE170H	16", 16-24", & No. 2-H	15 lbs.

HAND LEVER

COLLET ATTACHMENT

Speed and accuracy are combined in the Hand Lever Collet Attachment. Without stopping the lathe spindle, the collet can be released, bar stock fed through the spindle, and the collet tightened again. The gripping action of the collet is adjustable and can be set for any desired tension. Collets are not included.

Size Lathe	For Threaded Spindle	For Cam Lock Spindle	For Long Taper Spindle
	Cat. No.	Cat. No.	Cat. No.
10" & 10" Tur. 13" & 13" Tur. 14 1/2" 16", 16-24" & 2-H	CL5206L	CB5206L	CA5206L
	CL5206Q	CB5206T	CA5206T
	CL5206M	CB5206F	CA5206F
	CL5206H	CB5206H	CA5206H



HAND WHEEL

COLLET ATTACHMENT

This attachment will save you time and trouble in mounting small work in the lathe. Bar and tube stock can be fed through the hollow draw bar which operates the collet. Collets are not included.

Size Lathe	For Threaded Spindle	For Cam Lock Spindle	For Long Taper Spindle
	Cat. No.	Cat. No.	Cat. No.
10" & 10" Tur. 13" & 13" Tur. 14 1/2" 16", 16-24" & 2-H	CL4306L	CB4306L	CA4306L
	CL4306Q	CB4306T	CA4306T
	CL4306M	CB4306F	CA4306F
	CL4306H	CB4306H	CA4306H



Your Choice

3 TYPES OF SPINDLES



Taper Key Drive Spindle



Threaded Spindle



Cam Lock Spindle

All 10"-13" collet and larger South Bend Lathes can be supplied with either a 4" type D1 cam lock spindle or a new 00 L long taper key drive spindle in line of the regular threaded spindle at slight additional cost.

Extra Charges for Type L and Type D1 Spindle Noses

Size of Lathe	Long Taper Type L-Size 00	Cam Lock Type D1-Size 4"
10" & 10" Turret 13" & 13" Turret 14 1/2"		
16", 16-24" & 2-H		

