

## 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.

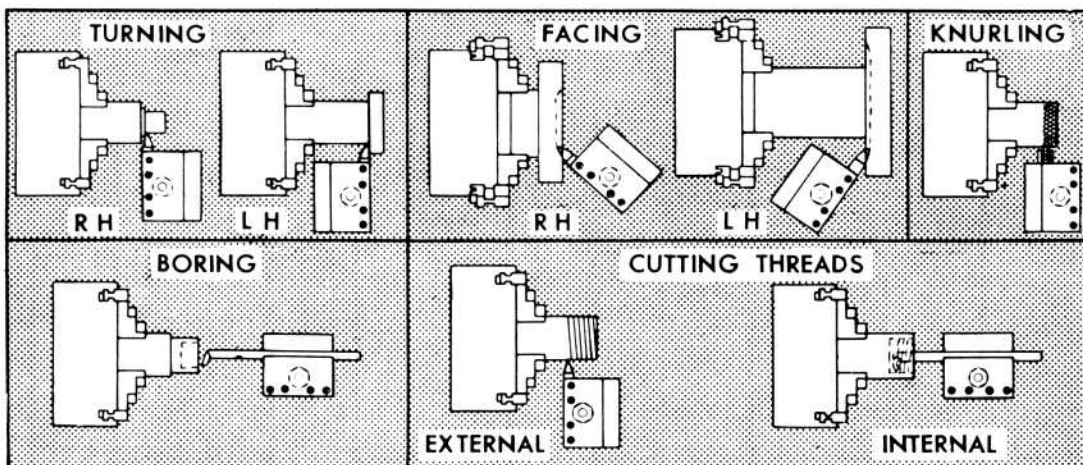
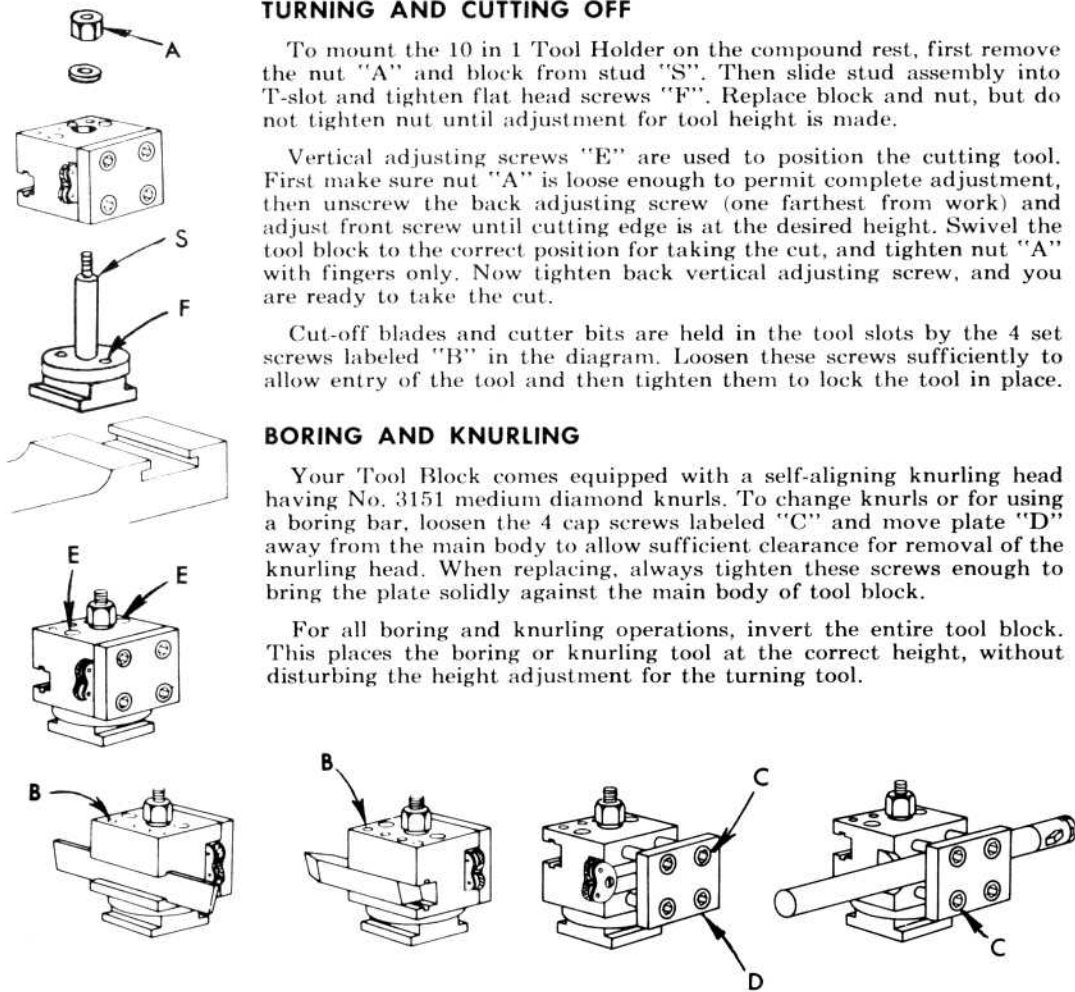
Vertical adjusting screws "E" are used to position the cutting tool. First make sure nut "A" is loose enough to permit complete adjustment, then unscrew the back adjusting screw (one farthest from work) and adjust front screw until cutting edge is at the desired height. Swivel the tool block to the correct 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.

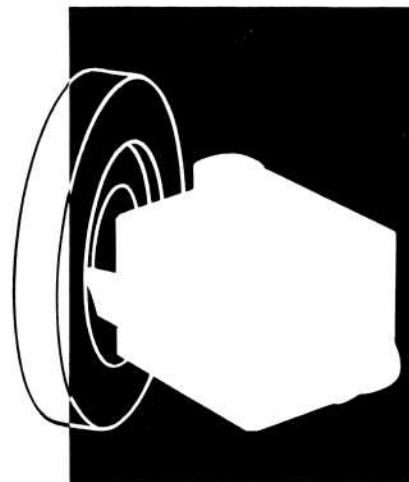
### BORING AND KNURLING

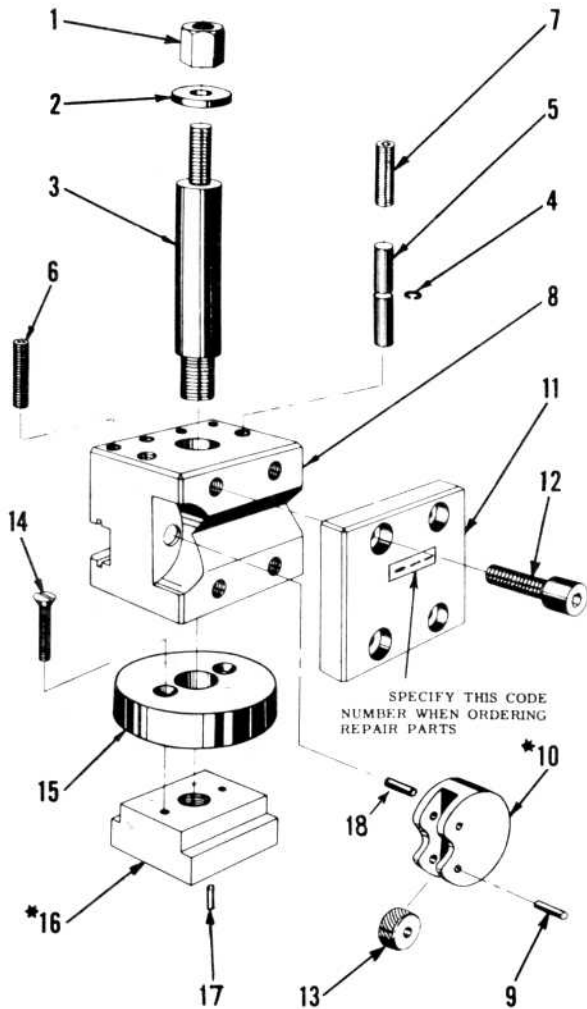
Your Tool Block comes equipped with a self-aligning knurling head having No. 3151 medium diameter knurls. To change knurls or for using a boring bar, loosen the 4 cap screws labeled "C" and move plate "D" away from the main body to allow sufficient clearance for removal of the knurling head. When replacing,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

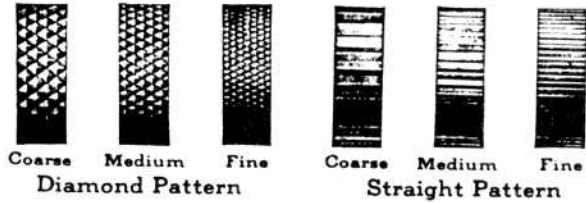


**SOUTH  
BEND**  
**10  
IN ONE  
10**  
**TOOL  
BLOCK**





**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
CE3150	FINE DIAMOND	5/8" x 5/16"
CE3151	MED. DIAMOND	5/8" x 5/16"
CE3152	COARSE DIAMOND	5/8" x 5/16"
CE3153	FINE STRAIGHT	5/8" x 5/16"
CE3154	MED. STRAIGHT	5/8" x 5/16"
CE3155	COARSE STRAIGHT	5/8" x 5/16"

**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.		PART NO.		PART NO.		PART NO.		PART NO.	
1	NUT	PT283NK1		PT283NK1		PT283R1		PT283R1		PT283R1	
2	WASHER	PT1673NR1		PT1673NR1		PT1674T1		PT1675FH1		PT1675FH1	
3	STUD	PT1464NR1		PT1464NR1		PT1464T1		PT1464F1		PT1464H1	
4	SNAP RING	NOT USED		NOT USED		PT1474T1		PT1474FH1		PT1474FH1	
5	ADJ. PIN	NOT USED		NOT USED		PT1473T1		PT1473FH1		PT1473FH1	
6	DOG PT. SCR.	121x16		121x16		121x124		121x224		121x224	
7	ADJ. DOG PT. SCR.	121x22R		121x22R		121x312		121x412		121x412	
8	BLOCK			PRICE		ON		REQUEST			
9	KNURL STUD	PT1476NH1		PT1476NH1		PT1476NH1		PT1476NH1		PT1476NH1	
10	KNURL HD. (18)	*AS1475NH1		*AS1475NH1		*AS1475NH1		*AS1475NH1		*AS1475NH1	
11	CLAMP	PT1461NK1		PT1461R1		PT1461T1		PT1461F1		PT1461H1	
12	CAP SCREW	114x16		114x16		114x124		114x224		114x224	
13	KNURLS			SEE		TABULATION		ABOVE			
14	FLAT HD. SCR.	103x212		103x212		103x212		103x614		103x618	
15	BASE	PT1462NR1		PT1462NF1		PT1462T1		PT1462F1		PT1462H1	
16	CLAMP (1-2-3-17)	*AS1463NK1		*AS1463R1		*AS1463T1		*AS1463F1		*AS1463H1	
17	PIN OR SCREW	160x18		160x18		120x906		120x906		120x906	
18	PIN	160x45		160x45		160x45		160x45		160x45	