

# TOOLING DIMENSIONS

for South Bend Lathes

All dimensions are in inches and are subject to change

## SWING OVER BED, SADDLE, COMPOUND REST

Size Lathe	9"	Light Ten	10"	13"	14½"	16"
A	9¼	10	10⅞	13⅞	14⅝	16¼
B	...	...	6¾	8¾	10¼	11⅞
C	5½	6¼	5⅞	7¾	8¾	9⅝

## SPINDLE NOSE THREAD

Size Lathe	9" and Light Ten	10" and 13" 1" Collet	13"-1¼" Collet	14½"-¾" Collet	14½"-1" Collet	16"
E	1½-8	2¼-8	1⅞-8	2¼-6	2⅜-6	2⅜-6
F	1⅛	1⅝	1⅞	1⅝	1⅜	1⅜
G	1.509	2.259	1.884	2.259	2.384	2.384
H	⅞	1⅜	1⅜	1⅝	1¼	1¼

## SPINDLE TAPER, SPINDLE HOLE, SPINDLE LENGTH

Size Lathe	9"	Light Ten	10"-1" Collet	13"-1¼" Collet	13"-1" Collet	14½"-¾" Collet	14½"-1" Collet	16"
B	.938	.938	1.629	1.231	1.629	1.325	1.629	1.629
D	.602	.602	.602	.623	.602	.602	.602	.602
K	¾	27/32	1⅜	1	1⅜	1⅞	1⅜	1⅜
N	2	2	2	3	3	3	3	3
J	12¼	12¼	13 <sup>23</sup> / <sub>32</sub>	19 <sup>3</sup> / <sub>16</sub>	21 <sup>1</sup> / <sub>16</sub>	22 <sup>31</sup> / <sub>64</sub>	24 <sup>29</sup> / <sub>64</sub>	24 <sup>11</sup> / <sub>16</sub>

## TOOL POST OPENING

Size Lathe	9" and Light Ten	10"	13"	14½"	16"
D	19/32	19/32	1¾	17/32	17/32
M	13/32	13/32	19/32	21/32	23/32
N	7/8	7/8	1¼	1¾	1¾

## COMPOUND REST TOP

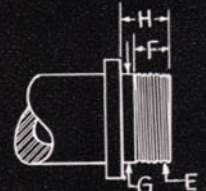
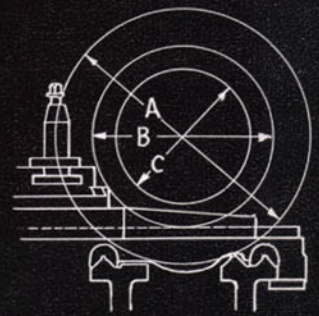
Size Lathe	9" and Light Ten	10"	13"	14½"	16"
C	1½	1½	1⅝	1 <sup>27</sup> / <sub>32</sub>	2⅛
G	⅞	1	1¼	1⅞	1⅝
J	9/32	2¼	7/16	7/16	7/16
K	9/32	9/32	19/32	17/32	17/32
Y	2½	2⅞	3⅝	4	4½

## COMPOUND REST BASE

Size Lathe	9" and Light Ten	10"	13"	14½"	16"
O	2⅝	2⅞	4	4⅞	4⅝
P	3⅝	3⅞	4½	5⅞	5¾
Q	3½	3⅞	5¼	5⅝	6
R	1⅜	1⅞	2¼	2½	2¾
S	2⅞	2 <sup>51</sup> / <sub>64</sub>	3¾	4⅞	4⅞

## SADDLE DOVETAIL

Size Lathe	9" and Light Ten	10"	13"	14½"	16"
A	319/32	3 <sup>61</sup> / <sub>64</sub>	5 <sup>3</sup> / <sub>32</sub>	5¾	6 <sup>3</sup> / <sub>16</sub>
B	.7655	.8328	1.1753	1.2690	1.4253
E	1.5253	1.6032	2.1631	2.4756	2.7256
L	23/64	7/16	9/16	9/16	9/16
W	3¼	3⅞	4⅞	4⅞	5⅞
X	10⅞	11⅞	16 <sup>1</sup> / <sub>32</sub>	18 <sup>5</sup> / <sub>16</sub>	19⅞



MORSE TAPER N  
TAPER PER FT. D

