

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"	10 K	10"	13"	14½"	16"
A	9¼	10	10⅝	13⅝	14⅝	16¼
B	...		6¾	8¾	10¼	11⅝
C	5½	6¼	5⅞	7¾	8¾	9⅝

SPINDLE NOSE THREAD

Size Lathe	9" and 10 K	10" and 13" 1½" Collet	13"-1½" Collet	14½"-¾" Collet	14½"-1½" Collet	16"
E	1½-8	2¼-8	1⅞-8	2¼-6	2⅜-6	2⅜-6
F	1⅞	1⅞	1⅞	1⅞	1⅞	1⅞
G	1.509	2.259	1.884	2.259	2.384	2.384
H	⅞	1⅞	1⅞	1⅞	1⅞	1⅞

SPINDLE TAPER, SPINDLE HOLE, SPINDLE LENGTH

Size Lathe	9"	10 K	10"-1½" Collet	13"-1½" Collet	13"-1½" Collet	14½"-¾" Collet	14½"-1½" 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	49/64	55/64	113/32	1	113/32	1⅞	113/32	113/32
N	2	2	2	3	3	3	3	3
J	12¼	12¼	1323/32	193/16	211/16	2231/64	2429/64	2411/16

TOOL POST OPENING

Size Lathe	9" and 10 K	10"	13"	14½"	16"
D	19/32	19/32	13/64	17/32	17/32
M	13/32	13/32	19/32	21/32	23/32
N	7/8		1¼	1¾	1¾

COMPOUND REST TOP

Size Lathe	9" and 10 K	10"	13"	14½"	16"
C	11/32	11/32	1⅝	127/32	21/16
G	7/8	1	1¼	17/16	1⅝
J	9/32	21/64	7/16	7/16	7/16
K	9/32	9/32	13/32	17/32	17/32
Y	2½	2⅞	3⅝	4	4½
W	19/32	113/32	149/64	21/64	217/64

COMPOUND REST BASE

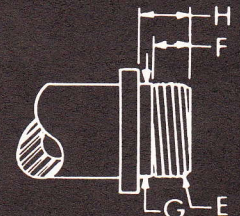
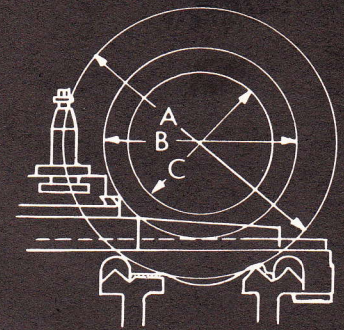
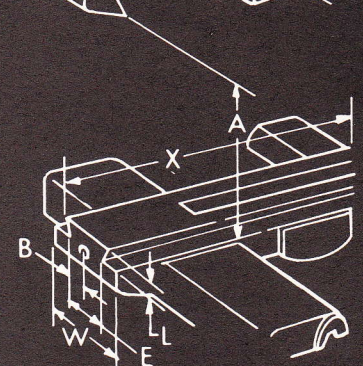
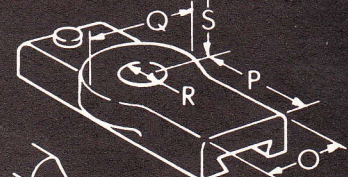
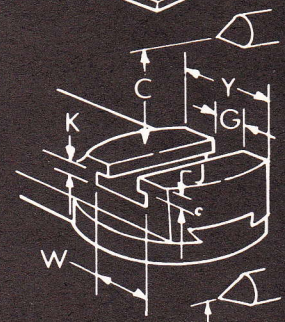
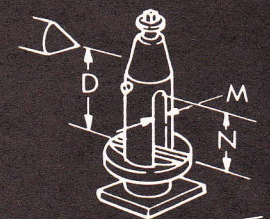
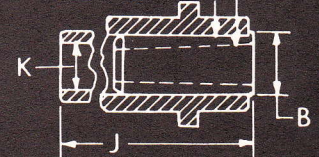
Size Lathe	9"	10 K	10"	13"	14½"	16"
O	2⅝	2⅝	2⅞	4	4⅞	4⅝
P	3⅞	3⅞	3⅞	4½	5⅞	5¾
Q	43/16	43/16	43/16	51/16	6⅞	67/16
R	1⅞	1⅞	1⅞	2¼	2½	2¾
S	2⅞	261/64	251/64	3¾	43/16	4⅞

SADDLE DOVETAIL

Size Lathe	9"	10 K	10"	13"	14½"	16"
A	319/32	363/64	361/64	57/32	5¾	63/16
B	.7655	.7655	.8328	1.1753	1.2690	1.4253
E	1.5253	1.5253	1.6032	2.1631	2.4756	2.7256
L	23/64	23/64	7/16	9/16	9/16	9/16
W	3¼	3¼	3⅝	4⅞	4⅞	5⅝
X	101/16	101/16	117/8	161/32	181/16	197/8

South Bend Lathe

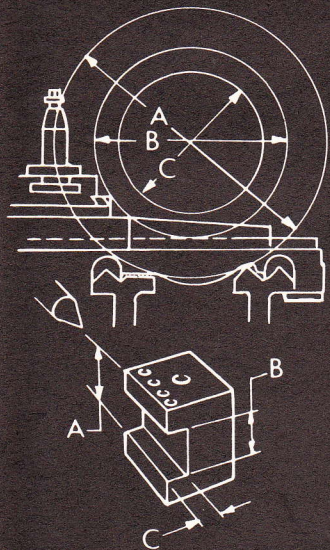
400 WEST SAMPLE STREET SOUTH BEND, INDIANA 46621

ONE OF THE **Amsted** INDUSTRIESMORSE TAPER-N
TAPER PER FT.-D

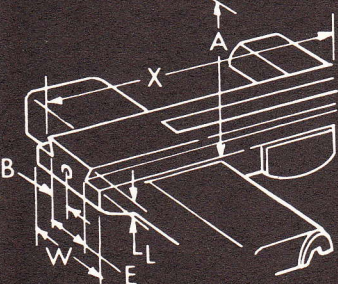
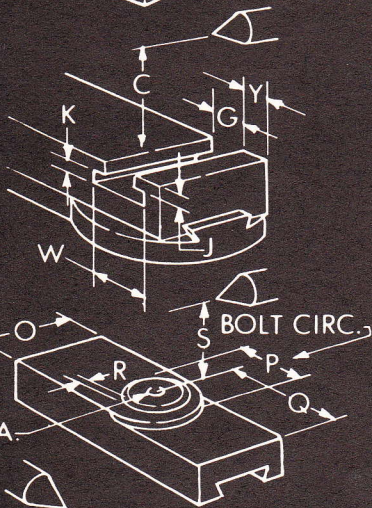
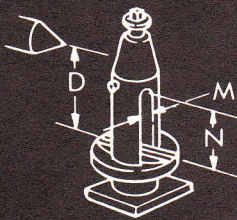
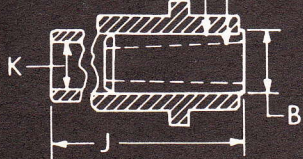
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MORSE TAPER - N
TAPER PER FT.-D



SWING OVER BED, SADDLE, COMPOUND REST

Size Lathe	1307	14"	17"
A	13 $\frac{1}{4}$	14 $\frac{1}{8}$	17 $\frac{1}{8}$
B	8 $\frac{3}{4}$	...	11 $\frac{1}{4}$
C	7 $\frac{1}{4}$	8 $\frac{1}{4}$	10 $\frac{1}{2}$

HEAVY DUTY TOOL POST

Size Lathe	1307	14"	17"
A	$\frac{7}{8}$	3" D-1	1 $\frac{3}{4}$
B	1 $\frac{1}{2}$	CamLock	2
C	$\frac{3}{4}$	...	1

SPINDLE TAPER, SPINDLE HOLE, SPINDLE LENGTH

Size Lathe	1307	14"	17"
B	1.500	1.5285	2.875
D	.6240	.624	.6315
K	1 $\frac{13}{32}$	1 $\frac{13}{32}$	2 $\frac{9}{16}$
N	4 $\frac{1}{2}$	3	5
J	24 $\frac{7}{8}$	22 $\frac{1}{16}$	33 $\frac{9}{16}$

TOOL POST OPENING

Size Lathe	1307	14"	17"
D	5 $\frac{7}{64}$	1 $\frac{3}{64}$	1 $\frac{1}{2}$
M	$\frac{7}{16}$	1 $\frac{9}{32}$	1 $\frac{13}{16}$
N	1 $\frac{1}{32}$	1 $\frac{1}{4}$	2

COMPOUND REST TOP

Size Lathe	1307	14"	17"
C	1 $\frac{3}{8}$	1 $\frac{5}{8}$	2 $\frac{7}{64}$
G	1 $\frac{1}{8}$	1 $\frac{1}{4}$	1 $\frac{1}{8}$
J	$\frac{7}{16}$	$\frac{7}{16}$	$\frac{7}{16}$
K	2 $\frac{5}{64}$	1 $\frac{13}{32}$	1 $\frac{17}{32}$
Y	1 $\frac{3}{16}$	...	1
W	1 $\frac{1}{16}$	1 $\frac{49}{64}$	2 $\frac{1}{2}$

COMPOUND REST BASE

Size Lathe	1307	14"	17"
O	5 $\frac{1}{4}$	4 $\frac{3}{8}$	7
P	3 $\frac{7}{8}$	5 $\frac{1}{16}$	5 $\frac{1}{4}$
Q	2 $\frac{5}{8}$	5 $\frac{21}{32}$	6
R	1 $\frac{1}{16}$	2 $\frac{1}{2}$	$\frac{9}{16}$
S	3 $\frac{13}{16}$	4 $\frac{1}{16}$	4 $\frac{43}{64}$
T	$\frac{5}{8}$	...	1 $\frac{1}{2}$

SADDLE DOVETAIL

Size Lathe	1307	14"	17"
A	5	5 $\frac{41}{64}$	6 $\frac{19}{64}$
B	1.3362	1.175	1.4343
E	2.6724	2.163	2.7463
L	$\frac{1}{2}$	$\frac{9}{16}$	3 $\frac{5}{64}$
W	..	4 $\frac{1}{4}$	7
X	15	15 $\frac{27}{32}$	22 $\frac{1}{4}$