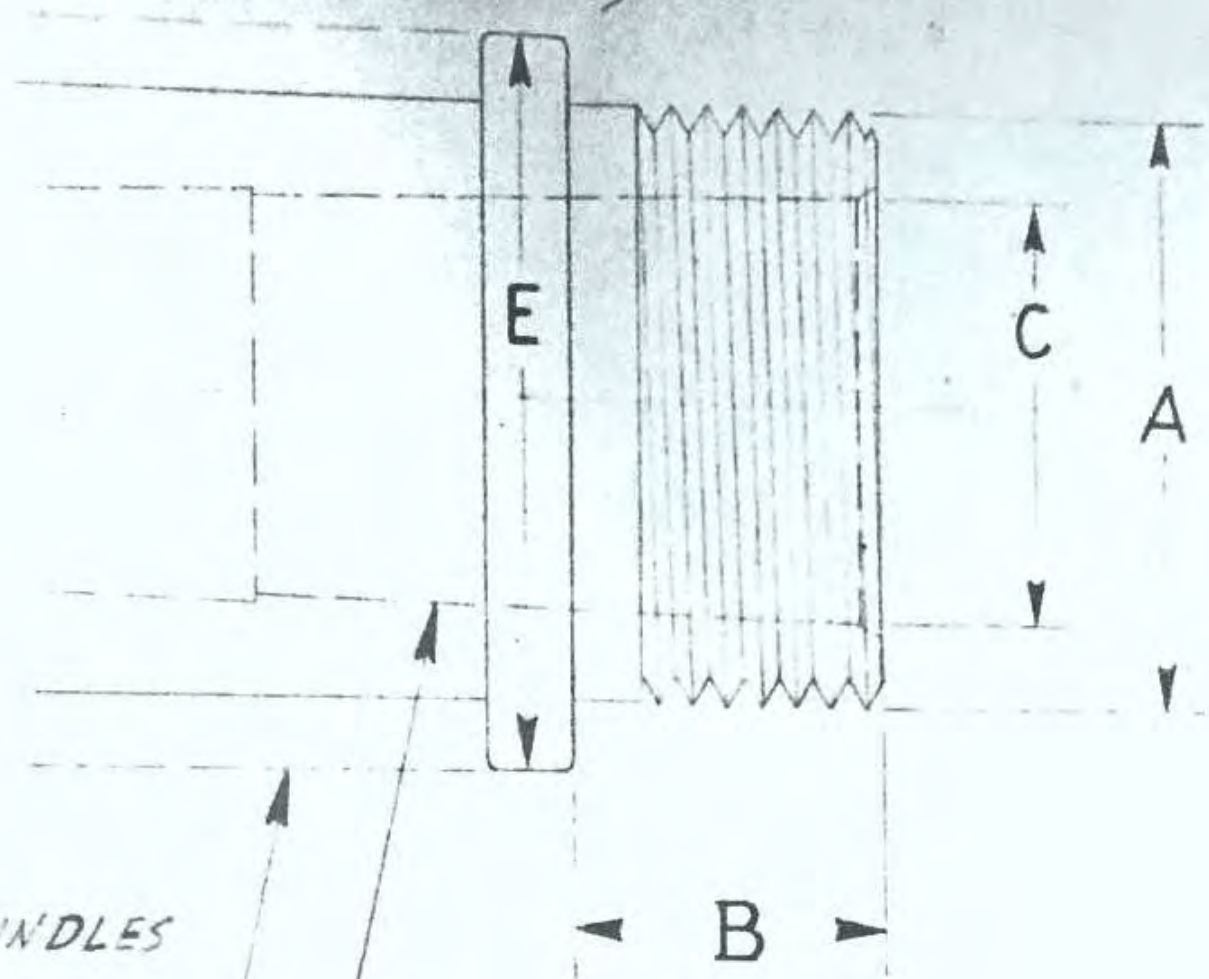


SPINDLE NOSE DIMENSIONS (CURRENT DESIGN)



SOME DESIGN SPINDLES
ARE STRAIGHT

"D" IS TAPER IN INCHES
PER FOOT

SOUTH BEND LATHE WORKS
SPINDLE NOSE DIMENSIONS
Chart 102

SPINDLE NOSE DIMENSIONS - Chart 102 - SHEET No. 1 OF 3

LATHE SIZE	BEGINNING DATE	APPROXIMATE STOPPING DATE	A DIAMETER OF THREADS	B LENGTH OF NOSE	C TAPER DIAMETER	D TAPER PER FT.	E SHOULDER DIAMETER
8	10-23-31	11-12-31	1-1/4--10	7/8	0.872	0.602	1-11/16
8	11-12-31	1-16-33	1-3/8--10	7/8	0.938	0.602	1-13/16
9 REG.	12-2-20	8-3-21	1--1/4--8	15/16	0.700	0.602	1-9/16
9 JR.	8-3-21	1-9-40	1-1/2--8	15/16	0.938	0.602	1-15/16
9 TOOLMAKER	12-22-32	3-16-34	1-1/2--8	15/16	0.938	0.602	1-15/16
9W	2-12-34	4-24-35	1-3/8-10	7/8	0.938	0.602	1-13/16
9W	4-24-35	CURRENT 9"	1-1/2--8	7/8	0.938	0.602	1-13/16
9L		9-14-39	2-1/4--8	1-3/16	1.6295	0.602	2-23/32
10	3-17-10	6-13-11	1-1/8--8	1	0.700	0.602	1-9/16
10	6-13-11	12-30-13	1-1/8--10	1	0.475	0.602	1-9/16
10	7-17-39	11-12-51	1-7/8--8	1-3/16	1.231	0.623	2-1/4
10L	2-30-36	CURRENT	2-1/4--8	1-3/16	1.6295	0.602	2-23/32
11	11-18-10	3-30-19	1-1/2--8	1-1/4	0.700	0.602	1-7/8
11	3-30-19	8-8-21	2-3/8--6	1-1/8	0.938	0.602	1-15/16
11	8-8-21	7-1-41	1-5/8--8	1-1/8	1.015	0.602	2-3/32

THIS TABLE DOES NOT INCLUDE EXPERIMENTAL SPINDLES OR SPECIAL SPINDLES REQUESTED BY CUSTOMERS

DATA BASED ON ENGINEERING DRAWINGS AVAILABLE 2-24- 45

CURRENT SPINDLE NOSES SEE SHEET No. 3

SOUTH BEND LATHE WORKS

SPINDLE NOSE DIMENSIONS - Chart 102 - Sheet No. 2 OF 3

LATHE SIZE	BEGINNING DATE	APPROXIMATE STOPPING DATE	A DIAMETER OF THREADS	B LENGTH OF NOSE	C TAPER DIAMETER	D TAPER PER FT.	E SHOULDER DIAMETER
12	5-12-10	11-30-16	1-1/2--8	1-1/4	0.700	0.602	1-7/8
13	1-11-11	8-8-21	1-3/4--8	1-3/8	0.939	0.602	2-1/4
13	8-8-21	12-12-24	1-7/8--8	1-3/8	0.939	0.602	2-3/8
13	12-12-24	12-23-41	1-7/8--8	1-3/8	1.231	0.623	2-11/32
13 BRAKE DRUM	3-21-28	4-6-37	1-7/8--8	1-3/8	1.231	0.623	2-11/32
14	2-10-15	12-31-18	2--8	1-5/8	1.231	0.623	2-3/8
14-1/2	12-26-39	9-8-48	2-1/4--6	1-5/8	1.325	0.602	2-5/8
15	3-24-14	6-22-22	2-1/4--8	1-7/8	1.325	0.602	2-5/8
15	6-22-22	12-16-24	2-1/4--8	1-5/8	1.325	0.602	2-5/8
15	12-16-24	1-25-35	2-1/4--6	1-5/8	1.325	0.602	2-5/8
16	7-17-12	6-5-22	2-3/8--8	2	1.532	0.602	2-3/4
16	6-5-22	12-19-22	2-3/8--8	1-3/4	1.532	0.602	2-3/4
16	12-19-24	12-30-26	2-3/8--6	1-3/4	1.532	0.602	2-15/16
16	12-30-26	11-14-39	2-3/8--6	1-3/4	1.567	0.602	2-15/16
16-16/24	11-14-39	CURRENT	2-3/8--6	1-3/4	1.6295	0.602	2-7/8
18	7-17-12	11-1-18	2-3/8--8	2	1.532	0.602	2-3/4
18	11-1-18	7-23-25	2-5/8--6	1-7/8	1.537	0.602	3-1/16
18	7-23-25	1-25-35	2-5/8--6	1-7/8	1.6295	0.602	3-3/16
21	9-1-16	2-20-19	2-3/4--5	2	1.7401	0.623	3-7/16
21	2-20-10	11-5-29	3--5	2	1.7401	0.623	3-11/16
24	1-29-17	10-30-18	3--5	2-1/8	1.997	0.623	3-11/16
24 BRAKE DRUM	10-30-18	4-6-37	3-1/4--5	2-1/8	1.997	0.623	3-15/16

THIS TABLE DOES NOT INCLUDE EXPERIMENTAL SPINDLES OR SPECIAL SPINDLES REQUESTED BY CUSTOMERS
 DATA BASED ON ENGINEERING DRAWINGS AVAILABLE 2-24- 45
 CURRENT SPINDLE NOSE SEE SHEET No. 3
 SOUTH BEND LATHE WORKS

SPINDLE NOSE DIMENSIONS - Chart 102 - Sheet No. 3 OF 3

LATHE SIZE	BEGINNING DATE	APPROXIMATE STOPPING DATE	A DIAMETER OF THREADS	B LENGTH OF NOSE	C TAPER DIAMETER	D TAPER PER FT.	E SHOULDER DIAMETER
9	4-24-35		1-1/2--8	7/8	0.938	0.602	1-13/16
10K	9-19-47		1-1/2--8	7/8	0.938	0.602	1-13/16
10R	7-21-39	11-12-51	1-7/8--8	1-3/16	1.231	0.623	2-1/4
10L	2-20-36		2-1/4--8	1-3/16	1.6295	0.602	2-23/32
13	6-18-46		2-1/4--8	1-3/16	1.6295	0.602	2-23/32
14-1/2	5-29-46		2-3/8--6	1-3/4	1.6295	0.602	3-3/16
16-16/24	11-14-39		2-3/8--6	1-3/4	1.6295	0.602	2-7/8

**THIS TABLE DOES NOT INCLUDE EXPERIMENTAL SPINDLES OR SPECIAL SPINDLES REQUESTED BY CUSTOMERS
SOUTH BEND LATHE WORKS**