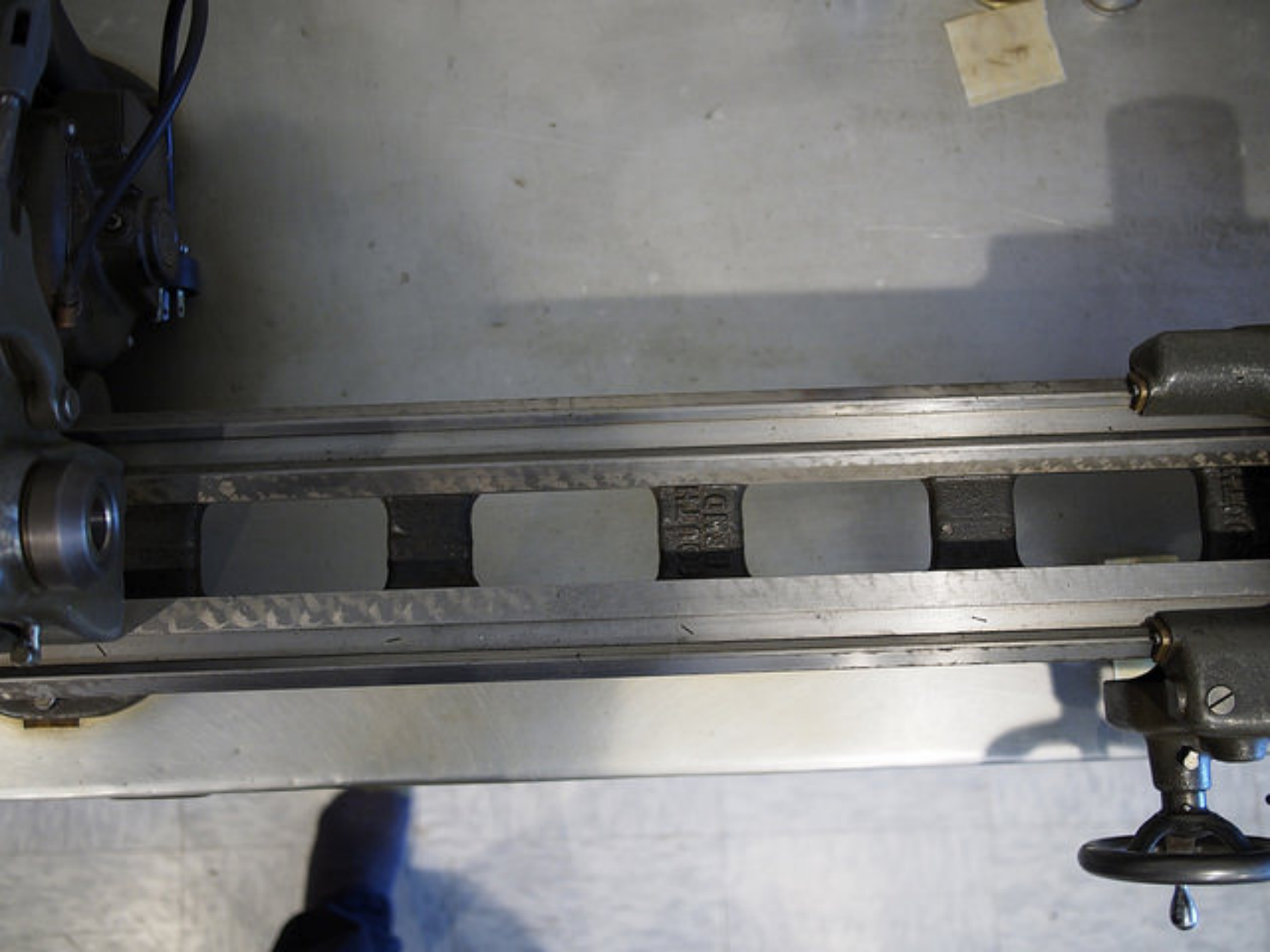










SCREW THREADS AND POWER FEEDS ENGLISH LEAD SCREW - 8 THREADS PER INCH

THREADS PER INCH	STUD GEAR	LEADER GEAR	SCREW GEAR	CODE FEEDS	LONG FEEDS
4 - 24	FIG. 1	48			
4 1/2 - 24	FIG. 1	84			
5 - 16	FIG. 1	40			
5 1/2 - 16	FIG. 1	44			
6 - 16	FIG. 1	48			
6 1/2 - 16	FIG. 1	52			
7 - 16	FIG. 1	56			
7 1/2 - 16	FIG. 1	60			

AUTOMATIC POWER FEEDS
THROUGH FRICITION CLUTCH
IN INCHES PER REVOLUTION
OF HEADSTOCK SPINDLE

8 - 32	FIG. 2	32			
9 - 32	FIG. 2	36			
10 - 32	FIG. 2	40			
11 - 32	FIG. 2	44			
11 1/2 - 32	FIG. 2	48			
12 - 32	FIG. 2	48			
13 - 32	FIG. 2	52			
14 - 32	FIG. 2	56			
16 - 24	FIG. 2	48			
18 - 24	FIG. 2	56			
20 - 16	FIG. 2	40			
22 - 16	FIG. 2	44	.0048	.0156	
24 - 16	FIG. 2	48	.0042	.0142	
26 - 16	FIG. 2	52	.0038	.0131	
27 - 16	FIG. 2	54	.0037	.0126	
28 - 16	FIG. 2	56	.0036	.0122	
32 - 16	FIG. 2	60	.0034	.0114	

32 - 32	FIG. 3	32	.0031	.0107	
36 - 32	FIG. 3	36	.0028	.0098	
40 - 32	FIG. 3	40	.0025	.0088	
44 - 32	FIG. 3	44	.0023	.0078	
48 - 32	FIG. 3	48	.0022	.0074	
48 - 32	FIG. 3	48	.0021	.0071	
52 - 32	FIG. 3	52	.0019	.0066	
54 - 32	FIG. 3	54	.0018	.0063	
56 - 32	FIG. 3	56	.0018	.0061	
60 - 32	FIG. 3	60	.0017	.0057	
64 - 16	FIG. 3	32	.0016	.0054	
72 - 16	FIG. 3	24	.0014	.0047	
80 - 16	FIG. 3	20	.0013	.0042	
96 - 16	FIG. 3	16	.0011	.0035	
96 - 16	FIG. 3	16	.0011	.0035	
104 - 16	FIG. 3	16	.0010	.0033	
112 - 16	FIG. 3	16	.0009	.0030	
128 - 16	FIG. 3	16	.0008	.0026	

144 - 10	FIG. 4	30	.0021		
----------	--------	----	-------	--	--



LUBRICATION CHART

HEADSTOCK BEARINGS

KEEP OIL CUPS FILLED WITH
GOOD GRADE OIL CORRESPONDING
IN BODY TO S.A.E. 10. USE MACHINE
OIL, NOT AUTO ENGINE OIL.
FLUSH CLEAN EVERY 6 MONTHS.

APRON RESERVOIR

KEEP FILLED WITH GOOD GRADE
OIL CORRESPONDING IN BODY TO
S.A.E. 10. USE MACHINE OIL, NOT
AUTO ENGINE OIL.
FLUSH CLEAN EVERY 6 MONTHS.

GENERAL LATHE LUBRICATION

OIL REGULARLY. OILY WIPERS
NECESSARY. OILING GOOD GRADE
OIL CORRESPONDING IN BODY TO
S.A.E. 10. USE MACHINE OIL, NOT
AUTO ENGINE OIL.

ANTI-FRICTION BEARINGS

SEALED BEARINGS REQUIRE NO
LUBRICATION. WHERE GREASE
SPINDLES ARE PROVIDED, USE
GREASE SPECIFIED IN BEARING
MANUFACTURER'S CATALOG FOR
PARTICULAR APPLICATION.

SOUTH BEND
PRECISION LATHES
MODEL 60

S

SEE LENGTH
TABLE NO. 1

THREADS PER INCH	STUD GEAR	SCREW GEAR	INLET GEAR	GRIND FEEDS	LONG FEEDS
4	24	FIG. 1	48		
4½	24	FIG. 1	34		
5	16	FIG. 1	40		
5½	16	FIG. 1	44		
6	16	FIG. 1	48		
6½	16	FIG. 1	52		
7	16	FIG. 1	56		
7½	16	FIG. 1	60		

AUTOMATIC POWER FEEDS
THROUGH FRICTION CLUTCH
IN INCHES PER REVOLUTION
OF HEADSTOCK SPINDLE

8	32	FIG. 2	32		
9	32	FIG. 2	36		
10	32	FIG. 2	40		
11	32	FIG. 2	44		
11½	32	FIG. 2	46		
12	32	FIG. 2	48		
13	32	FIG. 2	52		
14	32	FIG. 2	56		
15	24	FIG. 2	48		
16	24	FIG. 2	54		
20	16	FIG. 2	40		
22	16	FIG. 2	44	.0046	.0155
24	16	FIG. 2	48	.0042	.0142
26	16	FIG. 2	52	.0039	.0131
27	16	FIG. 2	54	.0037	.0126
28	16	FIG. 2	56	.0036	.0122
30	16	FIG. 2	60	.0034	.0114

32	32	FIG. 3	32	.0031	.0107
36	32	FIG. 3	36	.0028	.0095
40	32	FIG. 3	40	.0025	.0085
44	32	FIG. 3	44	.0023	.0078
46	32	FIG. 3	46	.0022	.0074
48	32	FIG. 3	48	.0021	.0071
52	32	FIG. 3	52	.0019	.0066
54	32	FIG. 3	54	.0019	.0063
56	32	FIG. 3	56	.0018	.0061
60	32	FIG. 3	60	.0017	.0057
64	16	FIG. 3	32	.0016	.0053
72	16	FIG. 3	36	.0014	.0047
80	16	FIG. 3	40	.0013	.0043
88	16	FIG. 3	44	.0011	.0039
96	16	FIG. 3	48	.0011	.0037
104	16	FIG. 3	52	.0010	.0035
112	16	FIG. 3	56	.0009	.0033
120	16	FIG. 3	60	.0008	.0030

160	16	FIG. 4	80	.0021	
-----	----	--------	----	-------	--

SOUTH BEND
PRECISION LATHE
MODEL 89



CAT. NO. 142
BED LENGTH
CHART NO. 5



FIG. 1



FIG. 2



FIG. 3



FIG. 4

LUBRICATION CHART

HEADSTOCK BEARINGS

KEEP OIL CUPS FILLED WITH GOOD GRADE OIL CORRESPONDING IN BODY TO S.A.E. 10. USE MACHINE OIL. NOT AUTO ENGINE OIL. FLUSH CLEAN EVERY 6 MONTHS.

APRON RESERVOIR

KEEP FILLED WITH GOOD GRADE OIL CORRESPONDING IN BODY TO S.A.E. 10. USE MACHINE OIL. NOT AUTO ENGINE OIL. FLUSH CLEAN EVERY 6 MONTHS.

GENERAL LATHE LUBRICATION

OIL REGULARLY DAILY WHERE NECESSARY. USING GOOD GRADE OIL CORRESPONDING IN BODY TO S.A.E. 10. USE MACHINE OIL. NOT AUTO ENGINE OIL.

ANTI-FRICTION BEARINGS

SEALED BEARINGS REQUIRE NO LUBRICATION. WHERE GREASE OPENINGS ARE PROVIDED, USE GREASE SPECIFIED IN BEARING MANUFACTURER'S CATALOG FOR PARTICULAR APPLICATION.