

South Bend lathe tooling dimensions for the following lathes:
9", 10K, 10", 13", 14-1/2" and 16".

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 | 10½ | 13½ | 14¾ | 16¼ |
| B | ... | ... | 6¾ | 8¾ | 10¼ | 11½ |
| C | 5½ | 6¼ | 5¾ | 7¾ | 8¾ | 9¾ |

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 | 1¾-8 | 2¼-6 | 2¾-6 | 2¾-6 |
| F | 1½ | 1¾ | 1½ | 1¾ | 1¾ | 1¾ |
| G | 1.509 | 2.259 | 1.884 | 2.259 | 2.384 | 2.384 |
| H | 7/8 | 1¾ | 1¾ | 1¾ | 1¾ | 1¾ |

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 | 4/4 | 5/4 | 1½/2 | 1 | 1½/2 | 1½ | 1½/2 | 1½/2 |
| N | 2 | 2 | 2 | 3 | 3 | 3 | 3 | 3 |
| J | 12¼ | 12¼ | 13¾/2 | 19¾/6 | 21¼/6 | 22¾/4 | 24¾/4 | 24¼/6 |

TOOL POST OPENING

| Size Lathe | 9" and 10 K | 10" | 13" | 14½" | 16" |
|------------|-------------|------|------|------|------|
| D | 1½/2 | 1½/2 | 1¾/4 | 1¾/2 | 1¾/2 |
| M | 1½/2 | 1½/2 | 1¾/2 | 2½/2 | 2¾/2 |
| N | 7/8 | ... | 1¼ | 1¾ | 1¾ |

COMPOUND REST TOP

| Size Lathe | 9" and 10 K | 10" | 13" | 14½" | 16" |
|------------|-------------|------|------|------|------|
| C | 1½/2 | 1½/2 | 1¾ | 1¾/2 | 2¼/6 |
| G | 7/8 | 1 | 1¼ | 1¾/6 | 1¾ |
| J | ¾/2 | 2¼/4 | ¾/6 | ¾/6 | ¾/6 |
| K | ¾/2 | ¾/2 | 1¾/2 | 1¾/2 | 1¾/2 |
| Y | 2½ | 2¾ | 3¾ | 4 | 4½ |
| W | 1¾/2 | 1¾/2 | 1¾/4 | 2¼/4 | 2¼/4 |

COMPOUND REST BASE

| Size Lathe | 9" | 10 K | 10" | 13" | 14½" | 16" |
|------------|------|------|------|------|------|------|
| O | 2¾ | 2¾ | 2¾ | 4 | 4¾ | 4¾ |
| P | 3¾/6 | 3¾/6 | 3¾/6 | 4½ | 5¾/6 | 5¾ |
| Q | 4¾/6 | 4¾/6 | 4¾/6 | 5¼/6 | 6¾/6 | 6¾/6 |
| R | 1¾ | 1¾ | 1¾ | 2¼ | 2½ | 2¾ |
| S | 2¼/6 | 2¼/4 | 2¾/4 | 3¾ | 4¾/6 | 4¾ |

SADDLE DOVETAIL

| Size Lathe | 9" | 10 K | 10" | 13" | 14½" | 16" |
|------------|--------|--------|--------|--------|--------|--------|
| A | 3¼/2 | 3¾/4 | 3¾/4 | 5¾/2 | 5¾ | 6¾/6 |
| B | .7655 | .7655 | .8328 | 1.1753 | 1.2690 | 1.4253 |
| E | 1.5253 | 1.5253 | 1.6032 | 2.1631 | 2.4756 | 2.7256 |
| L | 2¾/4 | 2¾/4 | ¾ | ¾ | ¾ | ¾ |
| W | 3¼ | 3¼ | 3¾ | 4¾/6 | 4¾ | 5¾ |
| X | 10¼/6 | 10¼/6 | 11¾ | 16¼/2 | 18¾/6 | 19¾ |



400 WEST BAMPLE STREET SOUTH BEND, INDIANA 46621

