

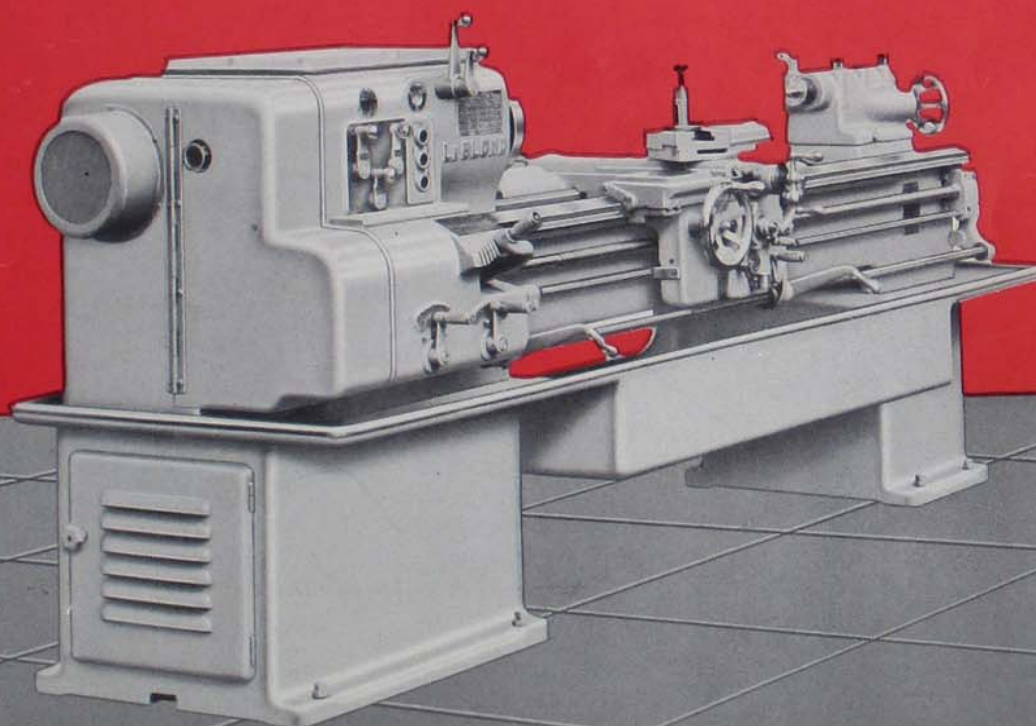
JAN 16 1950



LeBLOND
HEAVY DUTY
ENGINE LATHE

WITH 24-SPEED HEADSTOCK

BULLETIN HD-101



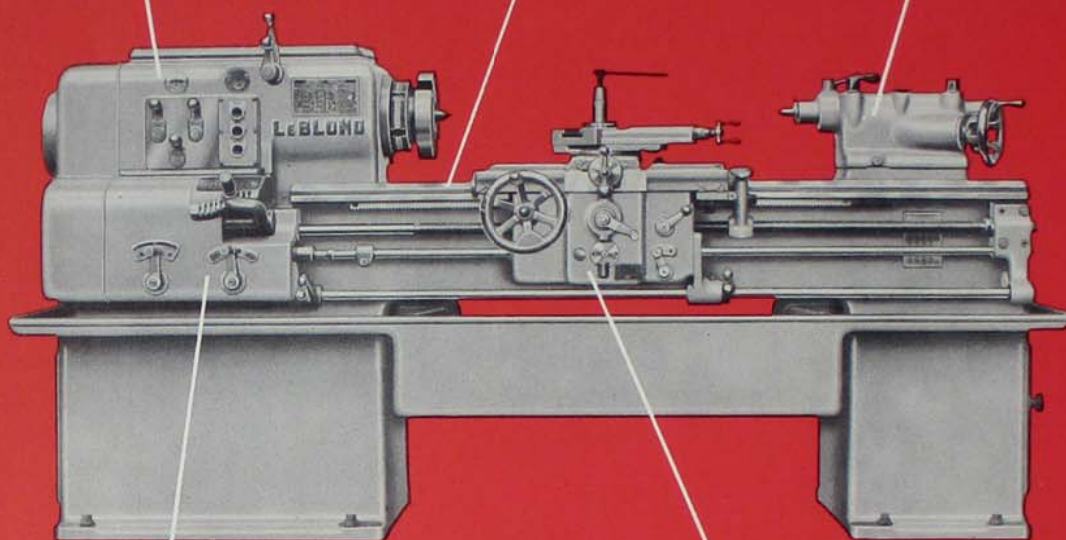
L
E
B
L
O
N
D



24-SPEED GEARED HEADSTOCK

HARDENED AND GROUND STEEL BED WAYS, FRONT AND REAR

THRUST-LOCK TAILSTOCK



TOTALLY ENCLOSED QUICK CHANGE BOX

ONE-PIECE APRON

the new 12" LeBlond heavy duty engine lathe

engineered and built to turn a wide variety of work efficiently

... to meet the exacting demands of today's and tomorrow's schedules.

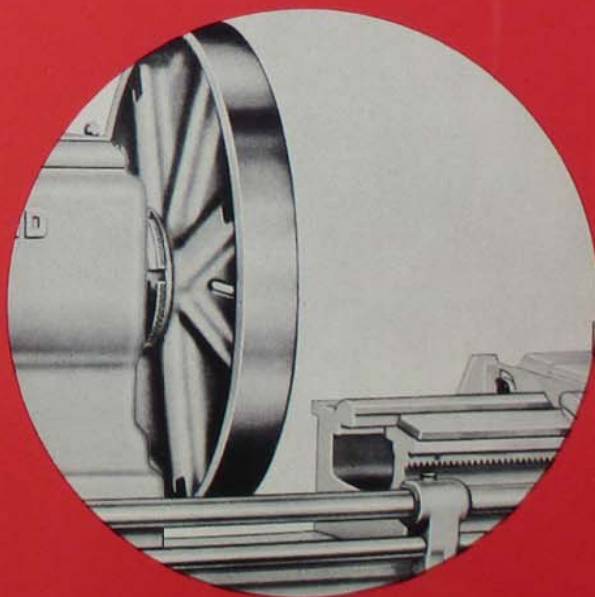
24-speed geared headstock standard . . . 12-speed headstock optional

LEBLOND PLAIN BED GAP LATHES

Ideal for the shop required to produce a great variety of turning jobs, the LeBlond Plain Bed Gap Lathes offer a considerably wider range of work possibilities. In addition to the increased capacity, these Gap Lathes have all the improvements and labor-saving devices of standard LeBlond Heavy Duty Engine Lathes. Available in sizes 12" to 32".

12" GAP BED DIMENSIONS

Swing over gap	25¼"
Width of gap	14"
Distance from spindle nose to end of gap	8½"
Distance from face plate to end of gap	8"
Special face plate diameter	25"
Cross slide travel	13¼"



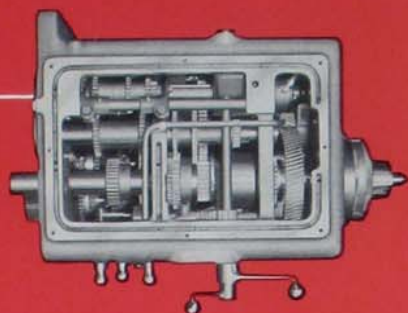


THREE-BEARING SPINDLE

Maintains eight times the rigidity of a two-bearing spindle. Reduces weight drag, cutting pressure and wear. Runs true under hard use. Front and center bearings provide pre-loading thrust greater than heaviest working pressure of lathe.

24-SPEED GEARED HEADSTOCK

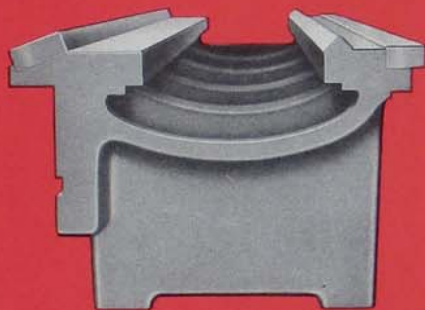
Three shift levers, operating a multiple gear train, control 24 selective speeds. All high speed gears are hardened and ground. Forced feed lubrication to all moving parts from oil reservoir located in bed.



ENCLOSED QUICK CHANGE BOX

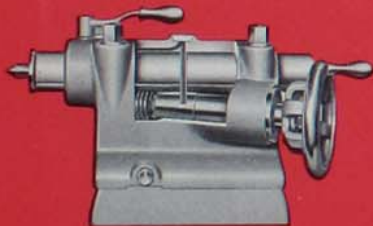
Modern design of the quick change box puts gears inside a protective oil-tight case. Lubricant is pumped automatically from the main oil reservoir. Requires a minimum of operator attention. Offers 60 changes of feeds and threads. Quadrant gear and all shafts mounted on anti-friction bearings.

*Important
standard features
of this new LeBlond lathe...*



HARDENED AND GROUND STEEL BED WAYS

Furnished as standard equipment front and rear. The strips are hardened to 62-65 Rockwell C (600 Brinell), are replaceable, and are fitted to conform to LeBlond's compensating vee-way principle.



THRUST-LOCK TAILSTOCK

Unique design of the tailstock has the handle set at an angle to the spindle, rather than at the end, as in ordinary tailstocks. This is accomplished by a worm and rack construction which provides positive safety lock against thrust, puts the handwheel in easy reach of the operator, allows bar stock to pass through the spindle hole, and makes full-length support possible even when spindle is extended.



ONE-PIECE APRON

One-piece with double walls which carry rack-pinion, rack-wheel, and handwheel on anti-friction bearings. This construction maintains accurate alignment under excessive strains. Positive jaw feed clutch with single lever for both cross and length feed. All bearings in the apron, cross slide, and the front and rear ways of the bed are lubricated by a positive "one-shot" system.

CAPACITY

Swing over bed and carriage ways	14½"
Swing over compound rest	8¼"
Distance between centers	30"
Center distance increases in increments of	24"
Size of tool	½" x 7/8"
Collet capacity, spindle nose type	1¾"
Steady rest	4½"
Follow rest	2½"
Face plate, small, diameter	9"
Face plate, large, diameter	14½"

HEADSTOCK

Spindle speeds, number	12 or 24
Spindle speeds, 24-speed head, rpm	25, 33, 44, 52, 60, 69, 81, 92, 107, 125, 140, 169, 193, 222, 250, 290, 335, 400, 435, 520, 600, 695, 920, 1250
Spindle speeds, 12-speed head, high speed range, rpm	53 to 1250
Spindle speeds, 12-speed head, low speed range, rpm	25 to 590
Spindle bearing diameter front, center, rear	3¾", 2¾", 2¾"
Front spindle bearing, Timken Precision, outside diameter	6"
Radial load at 100 rpm pounds	7985
Thrust load at 100 rpm pounds	6915
Center spindle Timken bearing, outside diameter	4.7244"
Radial load at 100 rpm, pounds	5205
Rear spindle roller bearing, outside diameter	3.937"
Radial load at 100 rpm, pounds	7000
Spindle, size of hole, straight	1½"
Spindle, size of hole, taper (No. 5 Morse)	1.748"
Spindle, size of center, Morse No.	4
Spindle nose, taper key, size	No. 11
Spindle nose, diameter, large end of taper	4½"
Headstock length on bed	23¾"

BED

Length, standard	6'6"
Length increases in increments of	24"
Width	14¼"
Depth	11½"

CARRIAGE

Length on ways	23¾"
Bearing surface, sq. in.	104
Bridge width	6¾"
Cross slide travel	13"
Compound rest travel	2¾"

FEEDS—THREADS

Feed and thread changes	60
Feeds, range	.002" - .126"
Threads per inch, range	2 - 120
Leadscrew diameter and threads per inch	1¾" - 4

TAPER ATTACHMENT

Maximum taper per foot	3"
Turns at one setting	15"

TAILSTOCK

Spindle diameter	2¾"
Center, Morse No.	3
Spindle travel and set-over	10" - 1"
Length on ways	12½"

MOTOR RECOMMENDED

Standard spindle speeds	7½ hp. - 1800 rpm
Frame size, N.E.M.A.	284

WEIGHT—FLOOR SPACE (30" CENTER DISTANCE)

Net, lbs.	4100
Domestic, lbs.	4500
Export, lbs.	5200
Weight each additional 24" of bed, lbs.	300
Floor space required	95" x 42"
Distance spindle center to floor	40¾"

Standard Quick Change Box: 2, 2¼, 2½, 2¾, 2⅞, 3, 3¼, 3½, 3¾, 4, 4½, 5, 5½, 5¾, 6, 6½, 6¾, 7, 7½, 8, 9, 10, 11, 11½, 12, 13, 13½, 14, 15, 16, 18, 20, 22, 23, 24, 26, 27, 28, 30, 32, 36, 40, 44, 46, 48, 52, 54, 56, 60, 64, 72, 80, 88, 92, 96, 104, 108, 112, 120.

STANDARD EQUIPMENT

Hardened and ground steel bed ways front and rear, two cabinet legs, small face plate, compound rest with hinged dirt guard, No. 1 tool post assembly, chasing dial, single automatic length stop, drill sleeve with tang driver, shear wipers, centers and necessary wrenches.

EXTRA EQUIPMENT

Hydra-Trace duplicating attachment, taper attachment, chip pan, steady rest, follow rest, power rapid traverse, face plates, turret tool post, draw-in attachment, pump, piping and tank, connected rests, plain block rests, positive and automatic length stops, single or multiple positive cross stops, profiling attachment, coarse threading attachment, and metric transposing gears.

THE R. K. LEBLOND MACHINE TOOL CO., CINCINNATI 8, OHIO, U. S. A.
WORLD'S LARGEST MANUFACTURERS OF A COMPLETE LINE OF LATHES

New York 9, N. Y., Singer Bldg., 149 Broadway, COOrdinaTion 7-6021

Detroit 8, Michigan, New Center Building, TRinity 3-5361

Chicago 8, Ill., 20 N. Wacker Drive, STain 2-3561

LeBLOND