

AUG 14 1950

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new! 20"

**LeBLOND
HEAVY DUTY
ENGINE LATHE**

32-SPEED HEADSTOCK

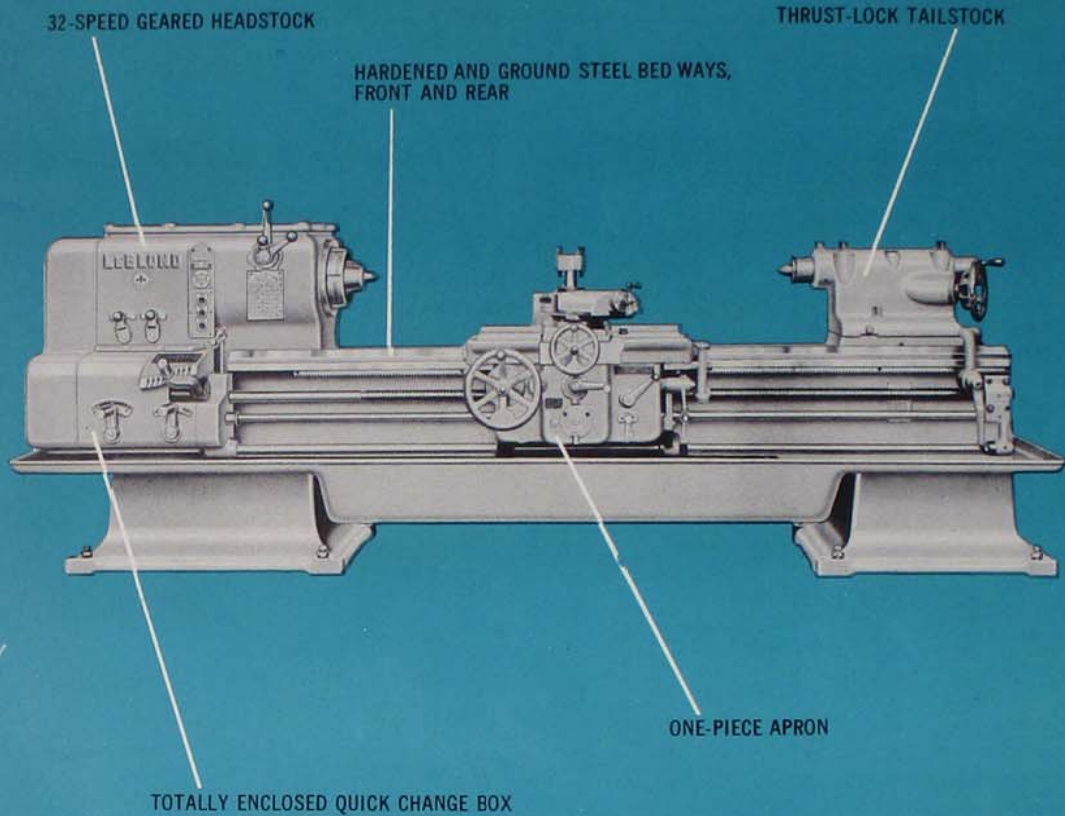
BULLETIN HD-142



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the new 20⁰⁰ LeBlond heavy duty engine lathe

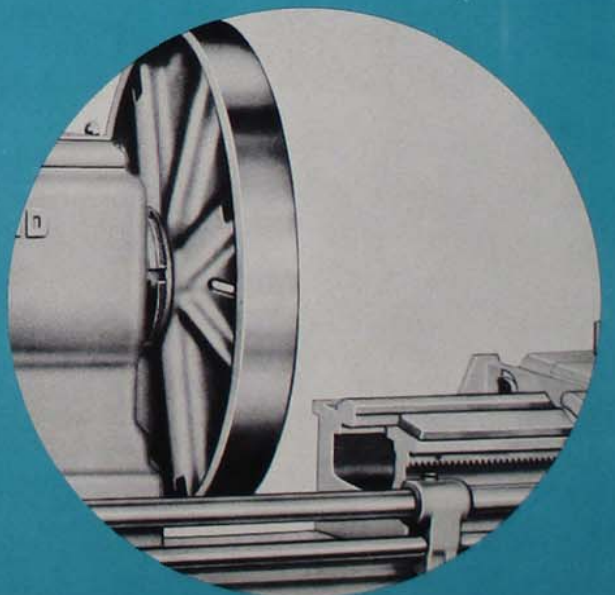
*... with 32 spindle speeds ranging from 9 to 800 rpm ...
totally enclosed, automatically lubricated quick change box ...
hardened and ground steel bed ways ... 60 feed and thread
changes ... and many other LeBlond plus values.
16-speed headstock optional.*

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".

20" GAP BED DIMENSIONS

Swing over gap.....	36"
Width of gap.....	18¾"
Distance from spindle nose to end of gap.....	15¾"
Distance from face plate to end of gap.....	15¾"
Special face plate diameter.....	34"
Cross slide travel.....	20"



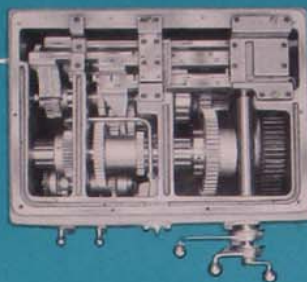


THREE-BEARING SPINDLE

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.

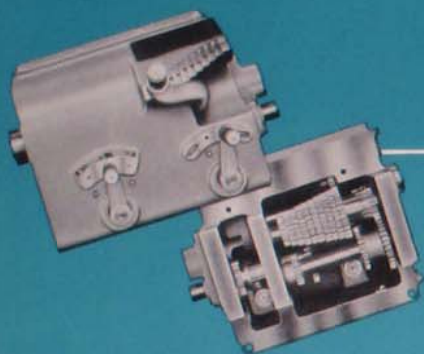
32-SPEED GEARED HEADSTOCK

Three shift levers, operating a multiple gear train, control 32 selective speeds. All high speed gears are hardened and ground. Forced feed lubrication to all moving parts from oil reservoir located in bed.

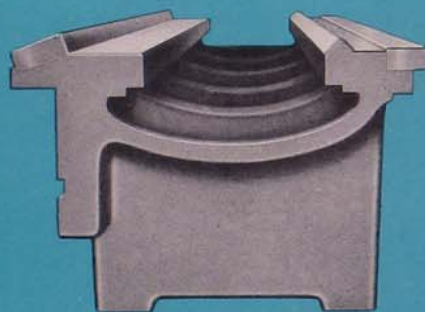


ENCLOSED QUICK CHANGE BOX

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.

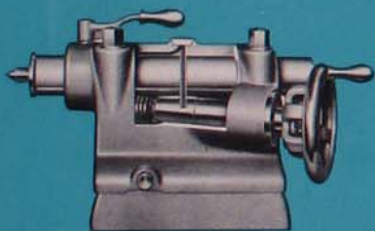


*Important
standard features
of this new LeBlond lathe...*



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 wings.....	22½"
Swing over compound rest.....	14½"
Distance between centers.....	48"
Center distance increases in increments of.....	24"
Size of tool.....	¾" x 1½"
Collet capacity, spindle nose type.....	1¾"
Steady rest.....	7½"
Follow rest.....	4½"
Face plate, small, diameter.....	12"
Face plate, large, diameter.....	21½"

HEADSTOCK

Spindle speeds, number.....	16 or 32
Spindle speeds, 32-speed head, rpm.....	9, 12, 16, 18, 20, 23, 26, 30, 34, 39, 44, 50, 57, 65, 70, 85, 92, 109, 118, 136, 154, 177, 191, 229, 248, 296, 322, 367, 415, 478, 620, 800
Spindle speeds, 16-speed head, high speed range, rpm.....	18 to 800
Spindle speeds, 16-speed head, low speed range, rpm.....	9 to 415
Spindle bearing diameter at front, center, rear.....	5¼", 4¼", 3¾"
Front spindle bearing, Timken Precision, outside diameter.....	9¼"
Radial load at 100 rpm pounds.....	27800
Thrust load at 100 rpm pounds.....	20120
Center spindle Timken bearing, outside diameter.....	6½"
Radial load at 100 rpm, pounds.....	10860
Rear spindle roller bearing, outside diameter.....	5¾"
Radial load at 100 rpm, pounds.....	9950
Spindle, size of hole, straight.....	2¾"
Spindle, size of hole, taper (No. 6 Morse).....	2½"
Spindle, size of center, Morse No.....	5
Spindle nose, taper key drive, size.....	L2
Spindle nose, diameter, large end of taper.....	5¼"
Headstock length on bed.....	33½"

BED

Length, standard.....	9' 5"
Length increases in increments of.....	24"
Width.....	21¾"
Depth.....	15¾"

CARRIAGE

Length on bed.....	32½"
Bearing surface, sq. in.....	224
Bridge width.....	9¾"
Cross slide travel.....	14¾"
Compound rest travel.....	4"

FEEDS—THREADS

Feed and thread changes.....	60
Feeds, range.....	.004" - .250"
Threads per inch, range.....	1-60
Leadscrew diameter and threads per inch.....	1½" - 2

TAPER ATTACHMENT

Maximum taper per foot.....	3½"
Turns at one setting.....	21"

TAILSTOCK

Spindle diameter.....	3¾"
Center, Morse No.....	5
Spindle travel and set-over.....	12" - 1"
Length on bed.....	18"

MOTOR RECOMMENDED

Std. spindle speeds (max.).....	15 or 20 hp. 1200 rpm
Frame size, N.E.M.A.....	365

WEIGHT—FLOOR SPACE (48" center distance)

Net, lbs.....	7825
Domestic, lbs.....	8125
Export, lbs.....	9300
Weight each additional 24" of bed, lbs.....	600
Floor space required.....	130" x 67"
Distance spindle center to floor.....	41"

Standard Quick Change Box: 1, 1½, 1¼, 1¾, 1⅞, 1½, 1⅝, 1¼, 1⅞, 2, 2¼, 2½, 2¾, 2⅞, 3, 3¼, 3⅝, 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.

STANDARD EQUIPMENT

Hardened and ground steel bed ways front and rear, two cabinet legs, small face plate, compound rest with hinged dirt guard, No. 2 tool post assembly, chasing dial, single automatic length stop, drill sleeve with tang driver, shear wipers, center 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 8, N. Y., Singer Bldg., 149 Broadway, COurtland 7-6621
 Detroit 2, Michigan, New Center Building, TRinity 3-5561
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