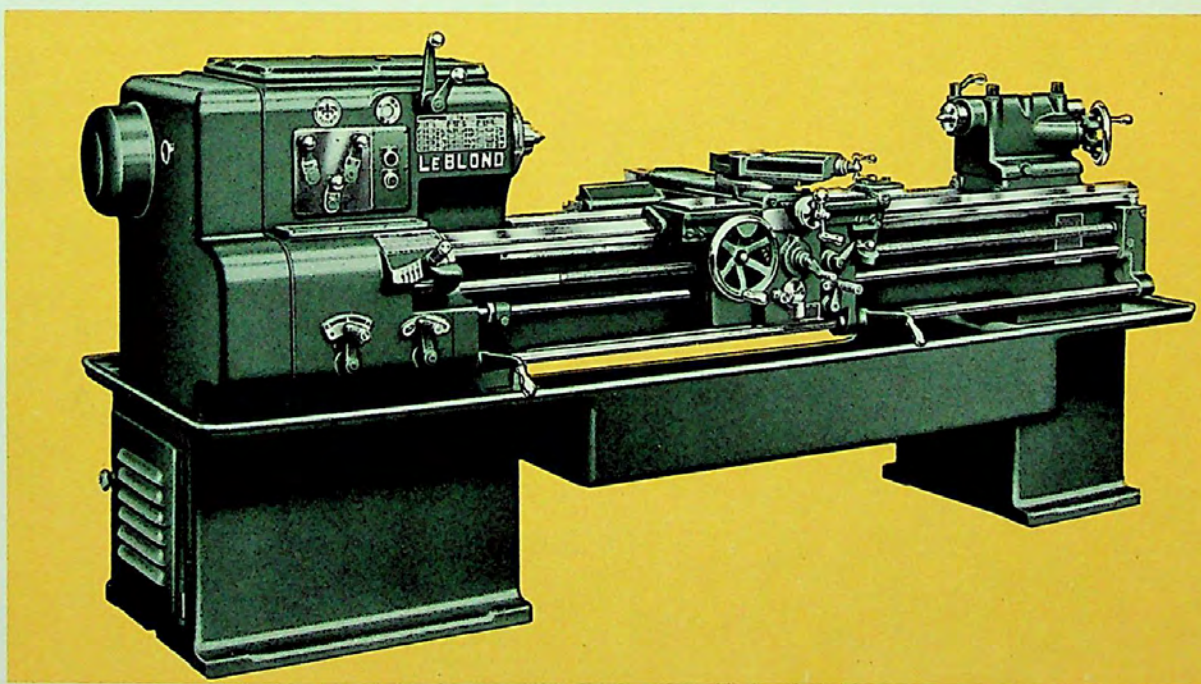


**BULLETIN HD-112**



**14"**

**HEAVY DUTY ENGINE LATHE**



**HEAVY DUTY ENGINE LATHE**



**14"**



**HD-112**

**BULLETIN**

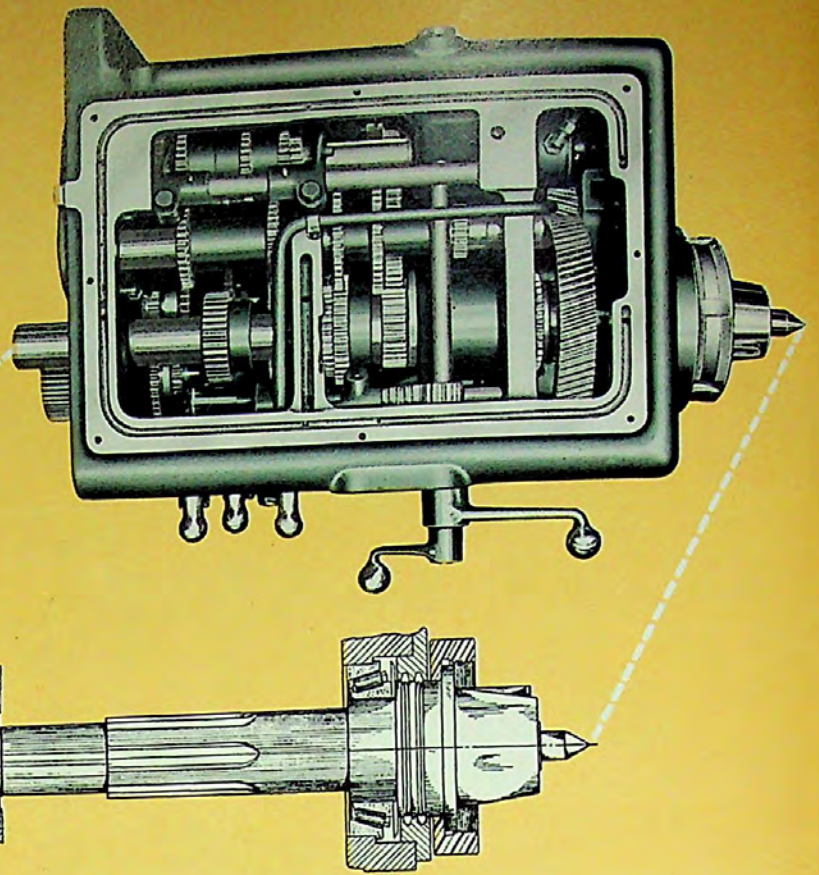
**HEAVY DUTY ENGINE LATHE**



**14"**

**24-SPEED GEARED HEADSTOCK**

Speeds are chosen simply and quickly by means of three shifting levers. All high speed gears are hardened and ground, shafts run in anti-friction bearings. Forced feed lubrication is provided to all moving parts automatically from an oil reservoir in the bed.



**THREE-BEARING SPINDLE**

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

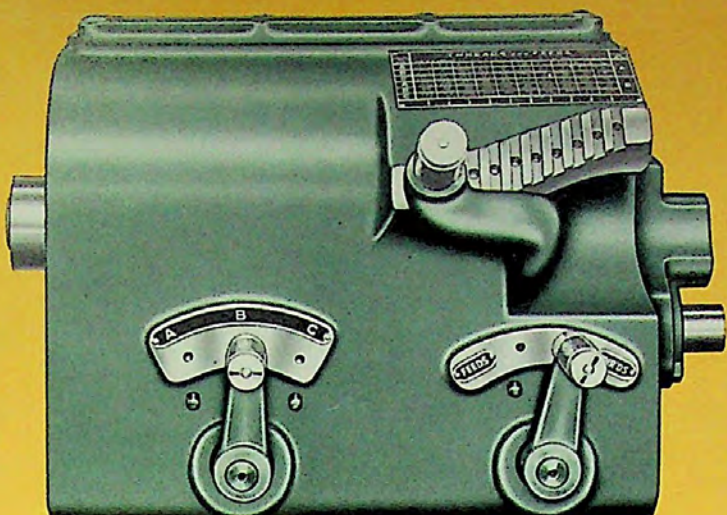
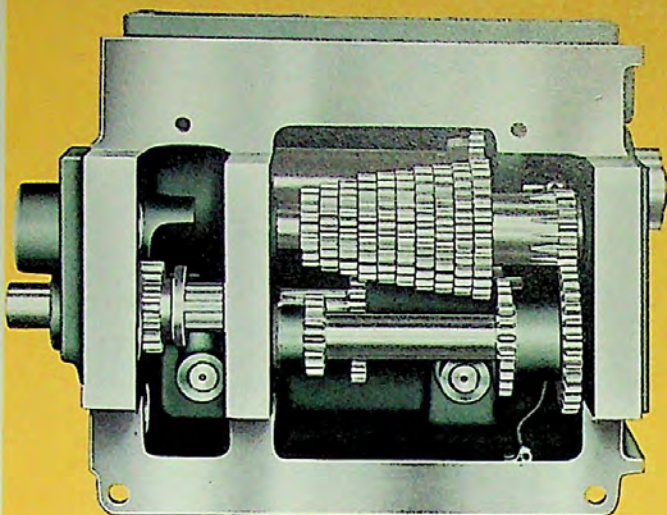
**14"**

**LEBLOND**

**Heavy Duty**

**ENGINE LATHE**

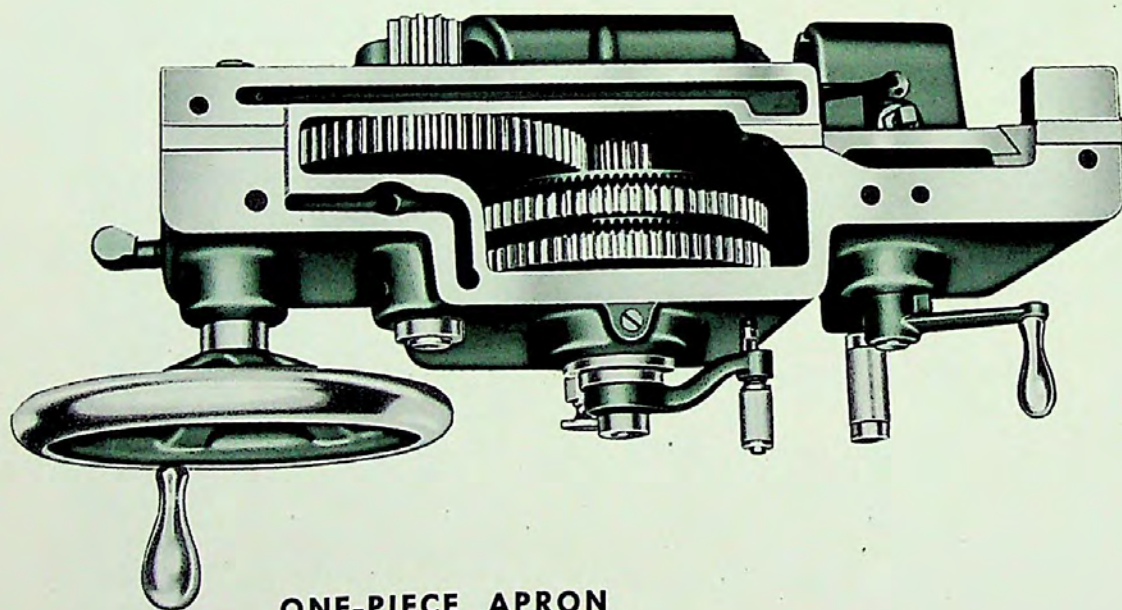




### TOTALLY-ENCLOSED QUICK CHANGE BOX

An oil-tight case encloses the gears of this automatically lubricated feed box. Requires no operator attention. Offers 60 changes of feeds

and threads. Quadrant gear and all shafts are mounted on anti-friction bearings.



### ONE-PIECE APRON

The apron is a one-piece, double-wall casting. It incorporates a positive-jaw feed clutch with a single lever for both cross and length feed. This construction assures accurate alignment under excessive strains. 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.... 16 1/2"  
 Swing over compound rest..... 9 5/8"  
 Distance between centers, base length.... 30"  
 Center distance increases  
 in increments of..... 24"  
 Size of tool (forged)..... 5/8" x 1"  
 Size of tool (tool holder)..... 5/8" x 1 3/8"  
 Steady rest capacity..... 1/2" to 4 3/4"  
 Follow rest capacity..... 1/2" to 2 1/2"  
 Face plate, small, diameter..... 9"  
 Face plate, large, diameter..... 15 1/2"

## HEADSTOCK

Spindle speeds, number..... 24  
 Spindle speeds, 24-speed head, rpm 25, 33, 44,  
 53, 60, 68, 79, 91, 106, 126, 137, 167, 189, 224,  
 246, 290, 330, 400, 430, 520, 590, 697, 910,  
 1250  
 Spindle bearing, diameter,  
 front, center, rear..... 3 5/8", 2 3/8", 2 3/16"  
 Front spindle bearing,  
 Timken Precision, outside diameter..... 6"  
 Radial load at 100 rpm, pounds..... 7985  
 Thrust load at 100 rpm, pounds..... 6915

## SPECIFICATIONS

Center spindle bearing,  
 Timken Precision, 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..... 1 1/2"  
 Spindle, size of taper hole, Morse No..... 5  
 Spindle, size of center, Morse No..... 4  
 Spindle nose,  
 American Standard taper key, size..... L-1  
 Spindle nose, diameter, large end of taper 4 1/8"  
 Headstock length on bed..... 23 7/8"

## BED

Length, 30" centers..... 6'6"  
 Length increases in increments of..... 24"  
 Width..... 14 3/8"  
 Depth..... 10 3/8"

## CARRIAGE

Length on ways..... 23 1/8"  
 Bearing surface, sq. in..... 87  
 Bridge width..... 6 1/2"

Cross slide travel  
 without taper attachment..... 12 1/2"  
 Cross slide travel with taper attachment 12 1/2"  
 Compound rest travel..... 2 7/8"

## FEEDS—THREADS

Feed and thread changes..... 60  
 Feeds, range..... .0021" - .126"  
 Threads per inch, range..... 2 - 120  
 Leadscrew diameter and  
 threads per inch..... 1 1/16", 4

## TAPER ATTACHMENT

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

## TAILSTOCK

Spindle diameter..... 2 5/8"  
 Center, Morse No..... 3  
 Spindle travel and set-over, right or left. 10", 1"  
 Length on ways..... 12 3/8"

## MOTOR RECOMMENDED

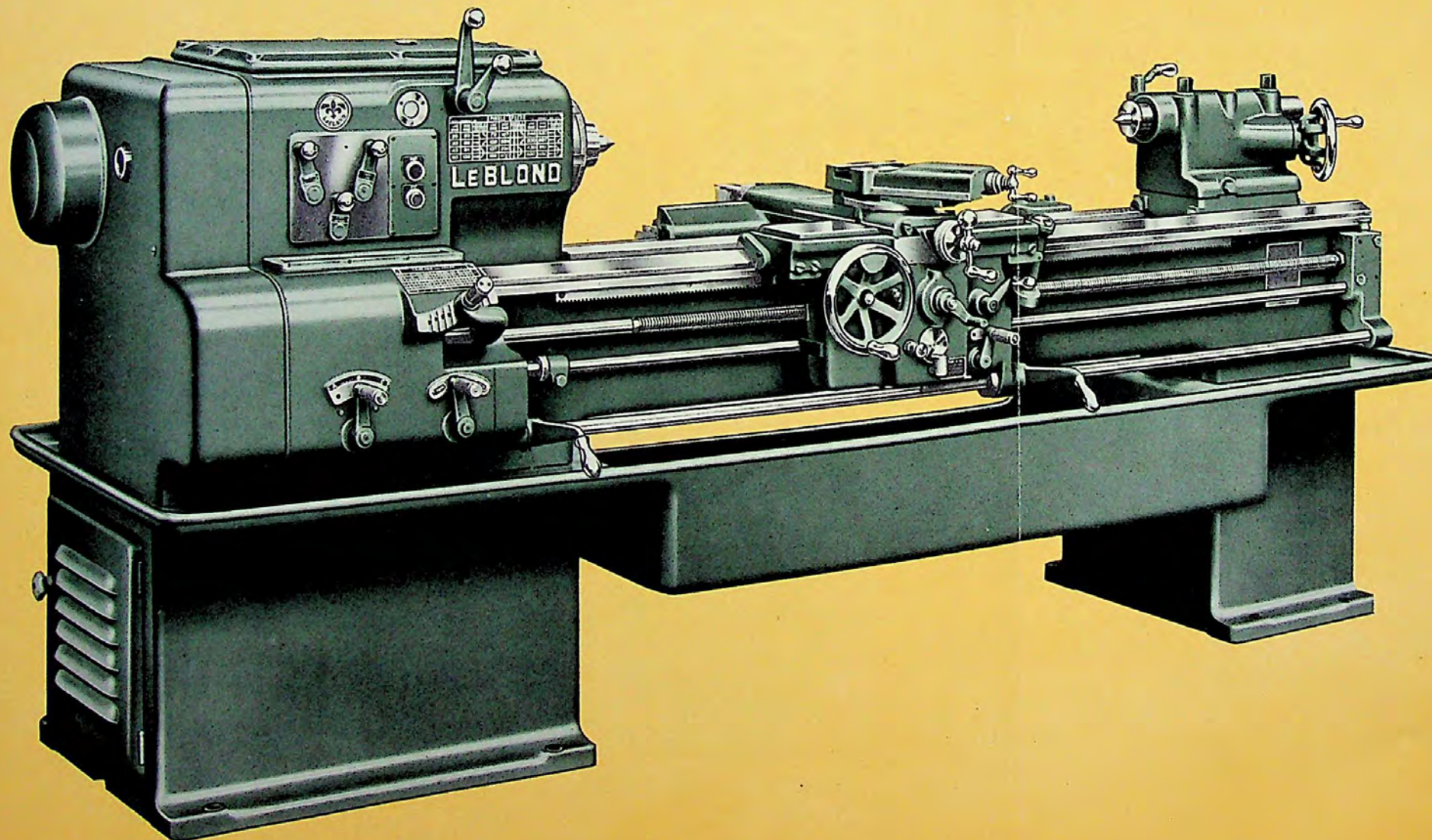
Standard spindle speeds  
 (max.)..... 7 1/2 hp, 1800 rpm  
 Frame size, N.E.M.A..... 284

## WEIGHT—FLOOR SPACE (30" Center Distance)

Net, lbs..... 4300  
 Domestic shipping wt., lbs..... 4700  
 Export shipping weight, lbs..... 5400  
 Weight each additional 24" of bed, lbs.... 320  
 Floor space required  
 without taper attachment..... 42" x 95"  
 Floor space required  
 with taper attachment..... 51" x 95"  
 Distance spindle center to floor..... 42 3/8"

## STANDARD QUICK CHANGE BOX

Threads per inch  
 2, 2 1/4, 2 1/2, 2 3/4, 2 7/8, 3, 3 1/4, 3 3/8, 3 1/2, 3 3/4, 4,  
 4 1/2, 5, 5 1/2, 5 3/4, 6, 6 1/2, 6 3/4, 7, 7 1/2, 8, 9, 10,  
 11, 11 1/2, 12, 13, 13 1/2, 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 replaceable 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; Arranged for motor drive.

## EXTRA EQUIPMENT

Hydra-Trace duplicating attachment; Taper attachment; Chip pan; Steady rest; Follow rest; Large face plate; Turret tool block; Pump, piping and tank; Connected rests; Plain block rests; Positive and automatic length stops; Single or multiple positive cross stops; Coarse threading attachment; Metric transposing gears.



*World's largest builder of a complete line of lathes.*

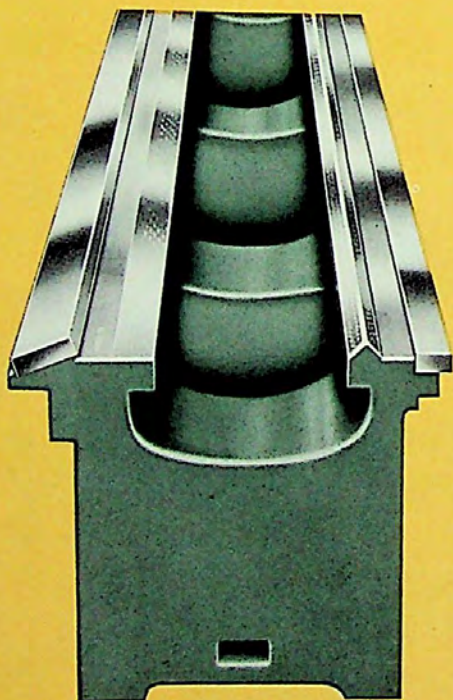
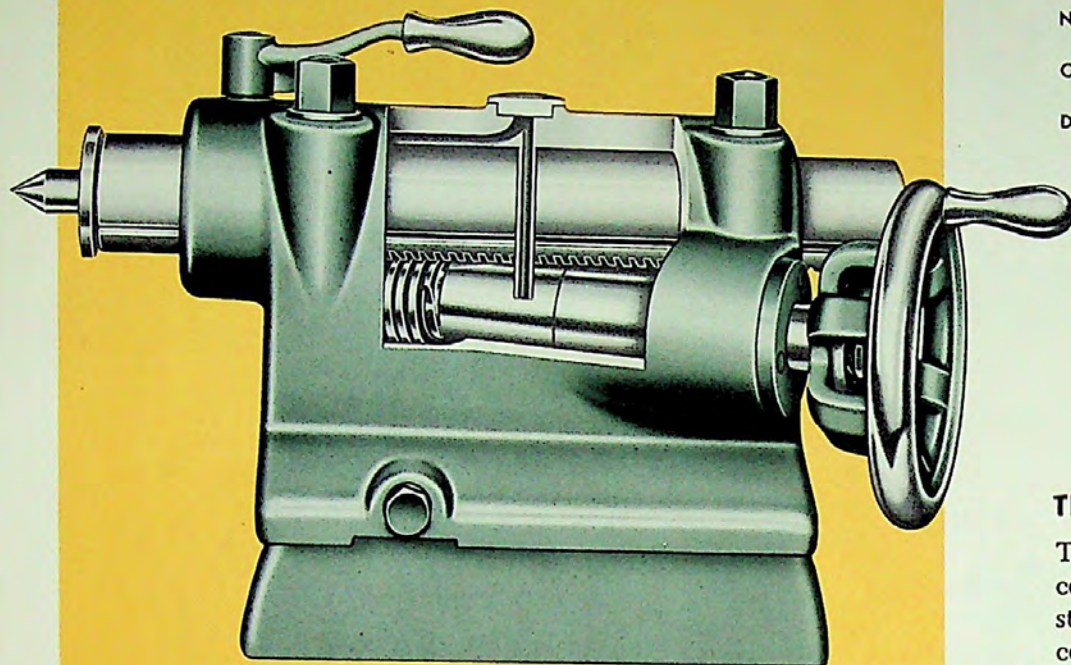


**THE R. K. LeBLOND MACHINE TOOL COMPANY  
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20 N. Wacker Drive, STate 2-5561

**DETROIT 2, MICH.:**  
New Center Bldg., TRinity 3-5561



#### **THRUST-LOCK TAILSTOCK**

This exclusive LeBlond design, incorporating a worm and rack construction, puts the handwheel at a convenient angle to the operator, provides positive safety lock against thrust and exceptionally long travel.

**NOTE** that the spindle, even when extended, is supported by the full length of the tailstock.

#### **HARDENED AND GROUND REPLACEABLE STEEL BED WAYS**

Standard equipment, front and rear, the shears are hardened to 62-65 Rockwell C (600 Brinell). They are fitted to conform to LeBlond's tested and proven compensating vee-way principle.