

THE R. K. LEBLOND MACHINE TOOL COMPANY, CINCINNATI 8, OHIO • LARGEST MANUFACTURER OF A COMPLETE LINE OF LATHES

Authorized By
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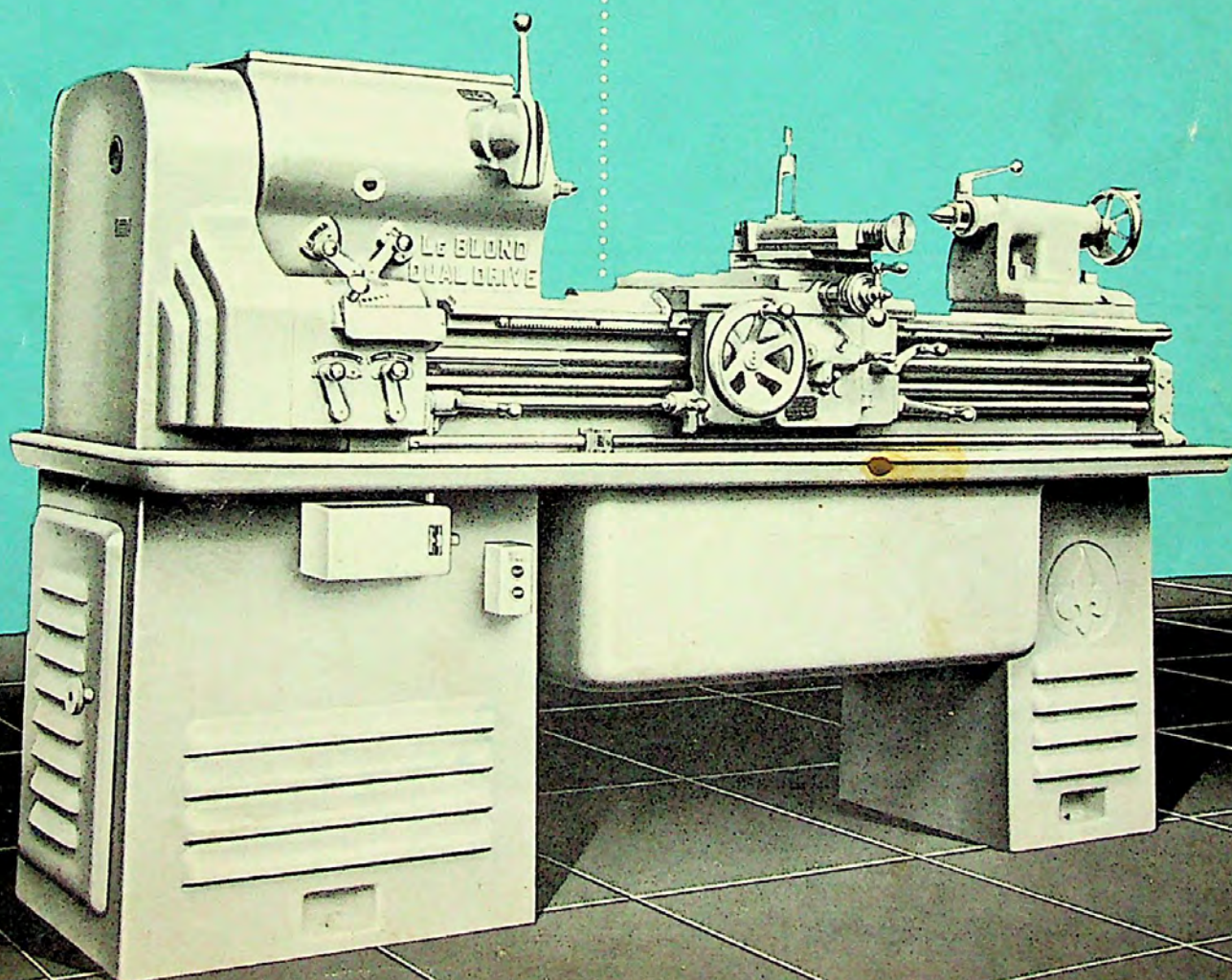
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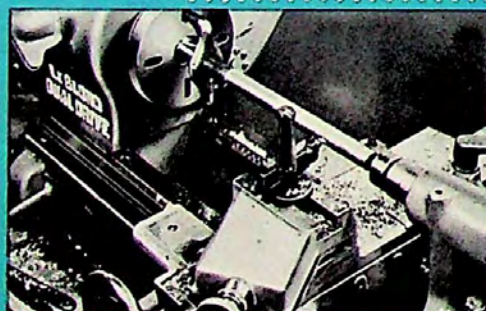
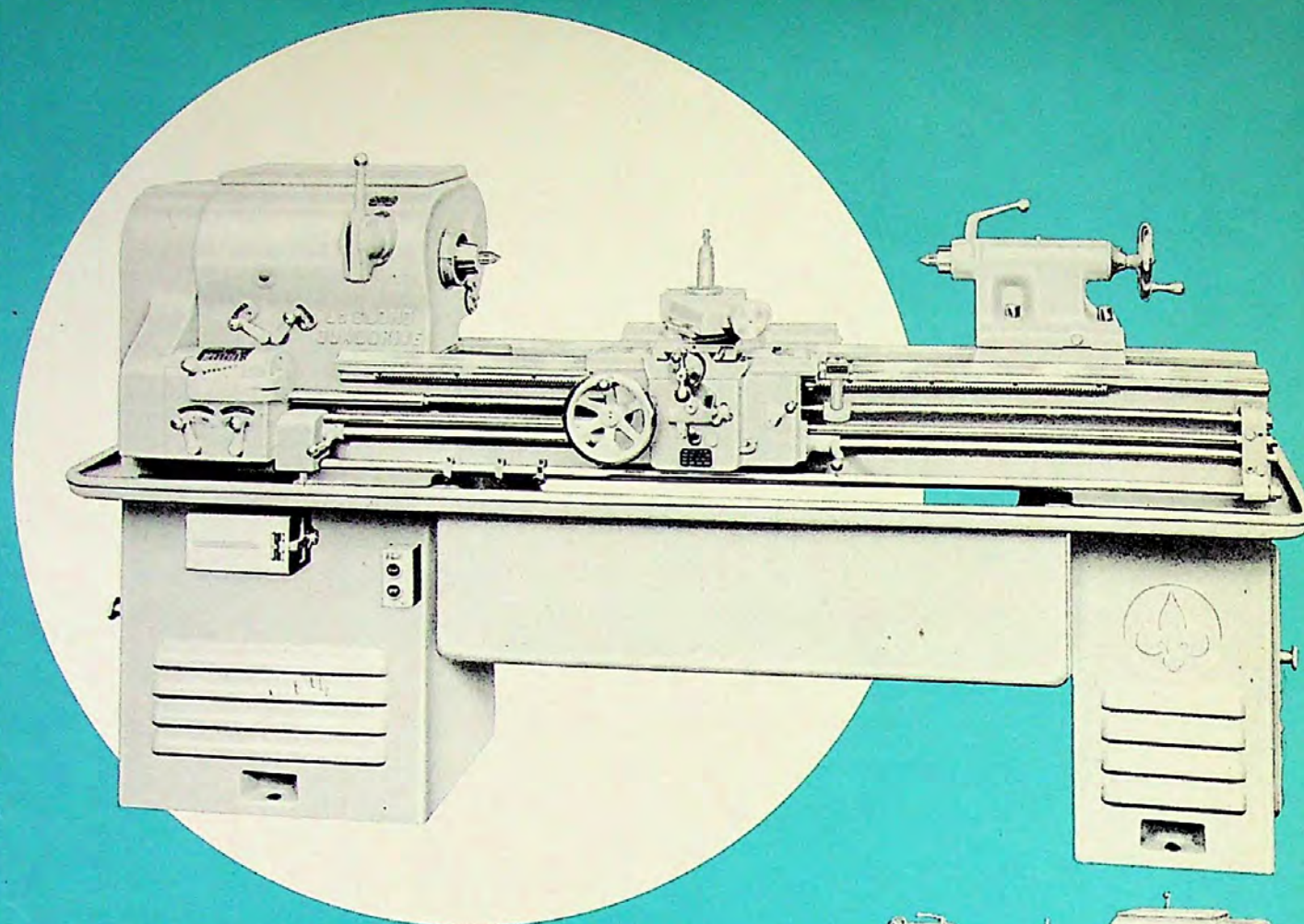
LEBLOND

DUAL DRIVE LATHES

BULLETIN NO. 4

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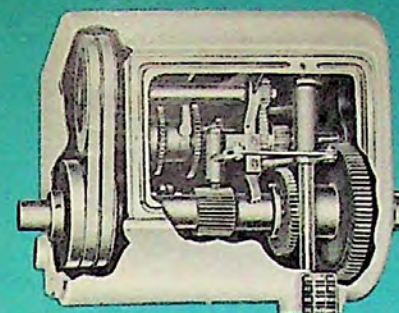
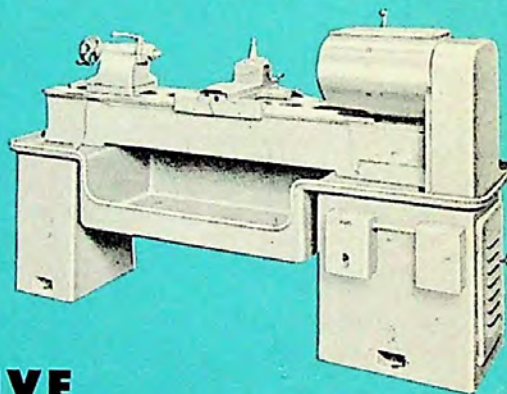
★ DUAL DRIVE

DOES DOUBLE DUTY

Here, in one lathe, are the spindle ranges for heavier stock reduction AND for high speeds used with carbide tools!

Two separate and distinct ranges include, first, eight speeds . . . 4 low and 4 intermediate with driving power for heavy duty turning and thread cutting and, second, four high speeds with full power for use with carbide tools.

All 12 spindle speeds are controlled by a single lever for utmost simplicity. Hardened and ground steel bed ways are now furnished as standard equipment for extra, longer-lasting accuracy. And Dual Drive comes equipped with electric brake and apron spindle control. Finally, Dual Drive's clean-lined appearance makes operators proud to handle it . . . makes you proud to own it!

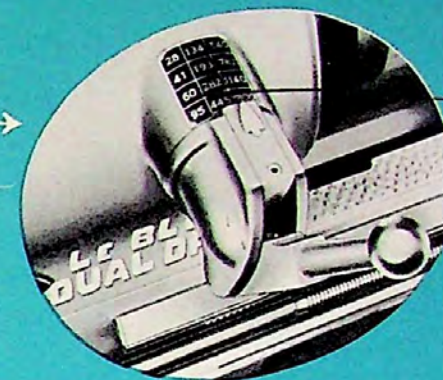


COMBINATION GEAR-BELT DRIVE HEADSTOCK

Simplified, compact, powerful, quiet. Two separate drives: direct belt drive for high speeds; gear drive for low and intermediate speeds, high power. Alloy steel gears throughout. All drive shafts, including spindle, move on anti-friction bearings; feed drive from spindle mounted on bronze bearings. Automatic forced feed lubrication.

SINGLE LEVER SPEED CONTROL—RAPID SPEED SELECTOR

One lever controls all twelve spindle speeds. Subdivided plate contains spindle speeds and a guiding arrow for quick settings. Operator merely shifts the guiding arrow to the speed required.

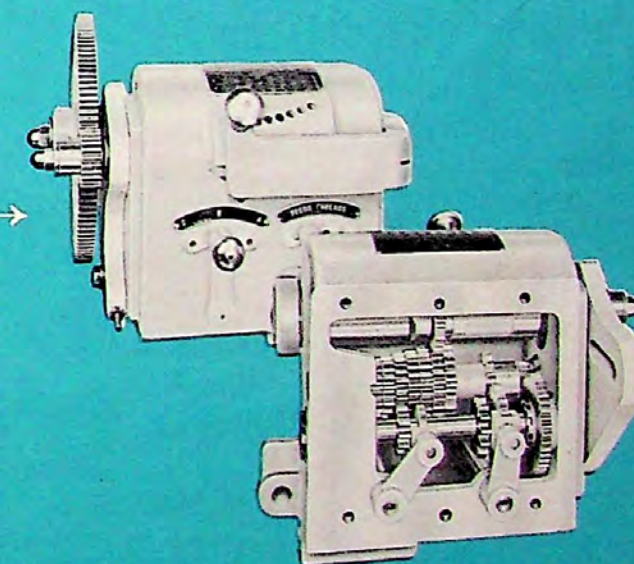


HARDENED AND GROUND STEEL BED WAYS

All Dual Drive lathes are now fitted with hardened and ground steel bed ways front and rear at no additional charge. The strips are hardened to 62-66 Rockwell C (600 Brinell), retain lubricant and thereby reduce friction and wear, and are replaceable in the event of accidental damage. In addition, the front way is fitted to conform to LeBlond's compensating vee-way principle.

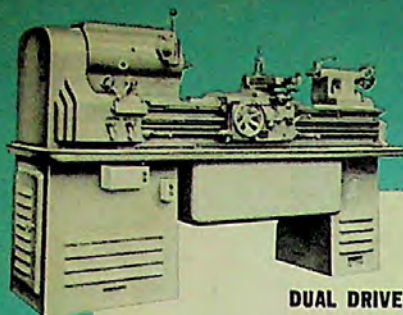
TOTALLY ENCLOSED AUTOMATICALLY LUBRICATED QUICK CHANGE BOX

Modern design of the quick change feed box puts gears inside a protective case. Lubricant is pumped automatically from main oil reservoir . . . no attention required from operator. Husky in size to handle heaviest loads. Drive, tumbler and cone gears all flame hardened.



ONE-PIECE DOUBLE WALL APRON . . . no plates. Positive jaw feed clutch and gear train are totally enclosed, have double bearing and are lubricated by one-shot forced feed

system. Single lever controls both cross slide and carriage movement and is interlocked to prevent engagement when leadscrew is in use. No risk of conflicting ratios or directions.



LEBLOND DUAL DRIVE SPECIFICATIONS

DUAL DRIVE STANDARD FEATURES

- 12 spindle speeds: 4 high, 8 low and intermediate.
- Single lever speed control, with direct reading speed plate and arrow indicator.
- Feed box totally enclosed. Drive, tumbler, and cone gears flame hardened. Lubricated automatically.
- Electric Brake and apron spindle control.
- Single lever positive jaw feed control in all directions, interlocked to prevent engagement when leadscrew is in use.
- Hardened and ground steel bed ways front and rear.
- Multiple automatic length stops.
- Automatic re-setting safety device on feed rod disengages rod and feed mechanism for overload protection.
- Reverse to leadscrew, control at headstock.
- 3 hp main drive motor.
- Standard No. L00 taper spindle nose.
- Automatic lubrication through headstock and feed box.
- Hardened alloy steel gears and anti-friction bearings.
- Deep steel chip pan.
- Tool storage locker.
- Chromium plated handles.

STANDARD EQUIPMENT

3-hp 1800 rpm open type ball bearing motor, electric brake and power pack, non-reversing magnetic starter and push buttons, electric reversing drum switch with apron control. Hardened and ground steel bed ways front and rear, small face plate, graduated compound rest, No. 1 tool post assembly, taper spindle sleeve, standard No. L00 taper spindle nose, chasing dial, adjustable thread cutting stop, multiple automatic length stops, cabinet legs, chip pan, centers and necessary wrenches, lag screws and washers.

EXTRA EQUIPMENT

Electric duplicating attachment, taper attachment, steady rest, follow rest, grinding attachment, coolant system, milling and keyway cutting attachment, micrometer carriage stops, drill pad, special centers, metric transposing gears, turret tool post, turret on bed, chucks, tools and many others.

Thread Range (Gear drive only): 4, 4.5, 5, 5.5, 5.75, 6, 6.5, 7, 8, 9, 10, 11, 11.5, 12, 13, 14, 16, 18, 20, 22, 23, 24, 26, 28, 32, 36, 40, 44, 46, 48, 52, 56, 64, 72, 80, 88, 92, 96, 104, 112, 128, 144, 160, 176, 184, 192, 208, 224

Feed Range (Gear drive): .0017, .0020, .0022, .0023, .0024, .0026, .0029, .0033, .0038, .0041, .0044, .0046, .0048, .0053, .0059, .0066, .0076, .0081, .0088, .0092, .0097, .0106, .0118, .0132, .0151, .0163, .0177, .0184, .0194, .0212, .0236, .0265, .0303, .0326, .0354, .0368, .0386, .0424, .0472, .0531, .0607, .0653, .0708, .0736, .0772, .0849, .0944, .1062

Feed Range (Direct belt drive): .0004, .0005, .0006, .0007, .0008, .0009, .001, .0011, .0012, .0013, .0014, .0016, .0018, .002, .0022, .0023, .0024, .0026, .0029, .0032, .0037, .004, .0043, .0045, .0047, .0052, .0058, .0065, .0074, .008, .0086, .009, .0094, .0104, .0115, .013, .0148, .016, .0172, .018, .0189, .0208, .023, .026

CAPACITY

Swing over bed and carriage wings	15"
Swing over compound rest	9 1/2"
Distance between centers	30"
Size of tool (forged)	3/4" x 1 1/4"
Size of tool (tool holder)	3/4" x 1 3/4"
Collet capacity, spindle nose type	1 3/4"
Steady rest	4"
Follow rest	2 3/4"

HEADSTOCK

Spindle speeds, number	12
Spindle speeds, gear drive, rpm	{ 28, 41, 60, 95, 134, 193, 282, 445
Spindle speeds, belt drive, rpm	540, 782, 1140, 1800
Driving pulley dia., No. of vee belts	10" - 4
Driving pulley speed, rpm	520
Front spindle bearing diameter	2 3/4"
Rear spindle bearing diameter	2"
Front spindle anti-friction bearing, o.d.	4 1/4"
Rear spindle anti-friction bearing, o.d.	3 1/2"
Spindle size of hole	1 1/2"
Spindle size of center	Morse No. 4
Spindle nose, std. taper size and diameter	No. L00-2 3/4"

BED

Length, standard	5' 9"
Increases of increments of	12"
Width	11"
Depth	9 3/4"

CARRIAGE

Length on ways	17 1/4"
Bridge, width	6 1/4"
Cross slide travel	9 1/2"
Compound rest travel	4"

FEEDS-THREADS

Feeds, gear drive, number	48
Feeds, direct belt drive, number	48
Feeds, range (gear drive)	.0017" - .1062"
Feeds, range (direct belt drive)	.0004" - .026"
Threads, gear drive only, number	48
Threads per inch, range	4-224
Leadscrew, threads per inch	6

TAPER ATTACHMENT

Maximum taper per foot	3 1/2"
Turns at one setting	10"

TAILSTOCK

Spindle diameter	2-3/16"
Spindle size of center	Morse No. 4
Spindle travel	5 1/2"

MOTOR FURNISHED

Horsepower	3
Speed	1800 rpm

WEIGHT—FLOOR SPACE

Domestic shipping weight, lbs.	2900
Floor space required, approximate	84" x 36"

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LARGEST MANUFACTURER OF A COMPLETE LINE OF LATHES

NEW YORK 6, N. Y., Singer Bldg., 149 Broadway, COurtland 7-6621

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