

SERIAL 2: 1727

INSTRUCTION BOOK

**REED-PRENTICE 14" & 16"  
SLIDING GEAR HEAD  
TOOLROOM & ENGINE LATHES**

*Purchased from J.P.*

**ALBION CORPORATION**  
1601 WANDA AVENUE  
FERNDALE, MICHIGAN 48220  
313-542-7490

Kimberly Clark Corporation  
400 Mahannah Avenue  
Memphis, Tennessee 38107

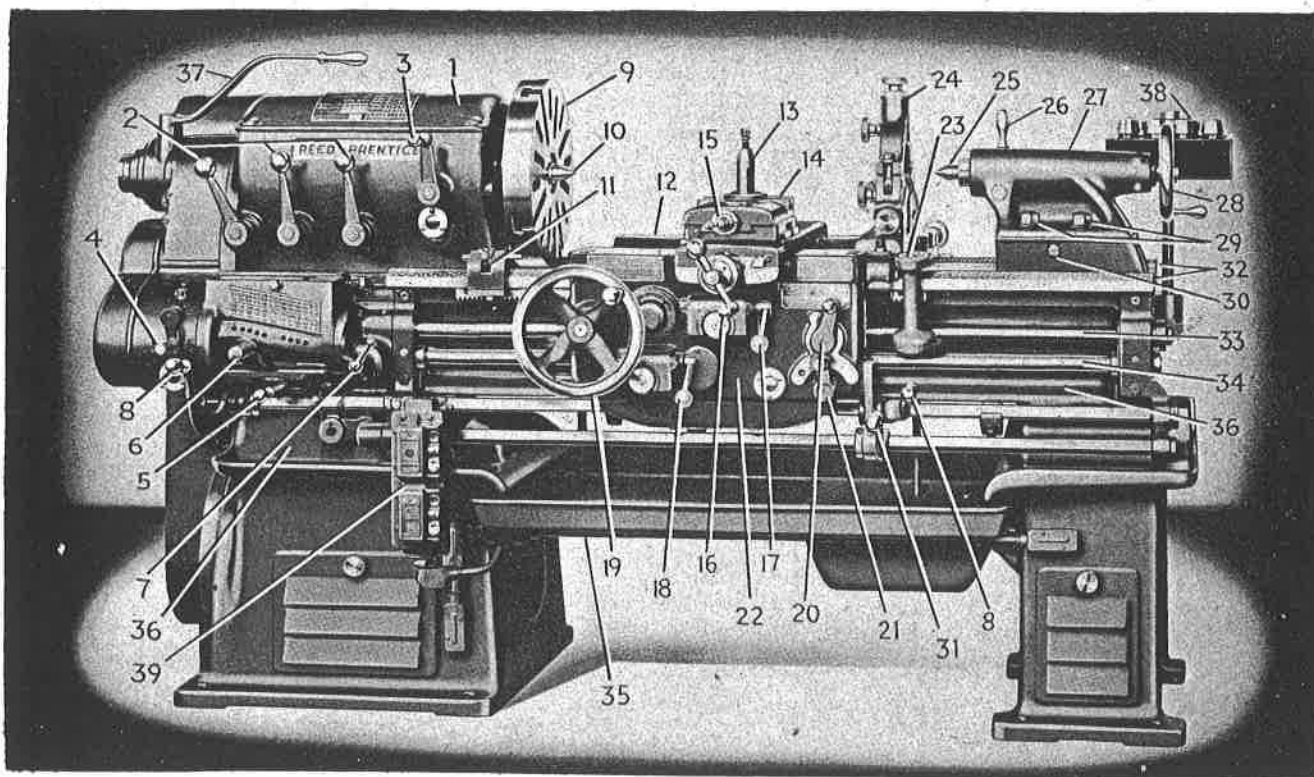
T-17277 313-542-7490

**REED-PRENTICE CORPORATION**  
WORCESTER, MASSACHUSETTS

TABLE OF CONTENTS

<u>GENERAL</u>	<u>Page</u>	<u>HEADSTOCK END</u>	<u>Page</u>
Cleaning . . . . .	3	Change Gear Box . . . . .	10
Construction Features . . . . .	4	Driving Clutch . . . . .	8
Installation . . . . .	4	Headstock . . . . .	7
Leveling . . . . .	4	Motor Drive . . . . .	9
Lubrication . . . . .	5	Speed Plate . . . . .	7
Precautions . . . . .	6	Spindle . . . . .	8
Serial Number . . . . .	4		
 <u>APRON AND CARRIAGE</u>		 <u>TAILSTOCK END</u>	
Apron and Carriage . . . . .	11	Tailstock . . . . .	13
Micrometer Chasing Stop . . . . .	12		
Thread Chasing Dial . . . . .	12		
 <u>ATTACHMENTS</u>		 <u>ORDERING</u>	
Taper Attachment . . . . .	14	Instructions . . . . .	16
Collet Attachment . . . . .	15		
 <u>PLANS</u>		 <u>PARTS LISTS</u>	
Foundation 24891 . . . . .	19	Head . . . . .	20
Head 930-4140 . . . . .	21	Head, Outside . . . . .	21A
Head 930-4205 . . . . .	21B	End Feedworks . . . . .	22
End Feedworks 930-4141 . . . . .	23	Feed Box . . . . .	24
Feed Box 930-4142 . . . . .	25	Bed . . . . .	26
Bed 930-4143A . . . . .	27	Apron . . . . .	28
Apron 930-4144 . . . . .	29	Carriage . . . . .	30
Carriage 930-4145 . . . . .	31	Compound Rest . . . . .	32
Compound Rest 930-4146 . . . . .	33	Tailstock . . . . .	34
Tailstock 930-4147 . . . . .	35	Thread Indicator . . . . .	36
Thread Indicator 930-4167 . . . . .	37	Steady Rest . . . . .	38
Steady Rest 930-4165 . . . . .	39	Follow Rest . . . . .	40
Follow Rest 930-4166 . . . . .	41	Collet Attachment . . . . .	42
Collet Attachment 930-4148 . . . . .	43	Taper Attachment . . . . .	44
Taper Attachment 930-4149 . . . . .	45		
Oiling Diagram 15233 . . . . .	46		

## PRINCIPAL FEATURES OF CONSTRUCTION



Reed-Prentice Sliding Gear Head Lathe

- |  |  |
|--|--|
| <p>1 Headstock</p> <p>2 Speed Change Levers</p> <p>3 Back Gear Lever in Headstock</p> <p>4 Lever for Controlling Series of Feed Change</p> <p>5 2nd Lever for Controlling Series of Feed Change</p> <p>6 Sliding Tumbler Gear Lever</p> <p>7 Lever for Controlling Feed to Lead Screw or Feed Rod</p> <p>8 Spindle Start, Stop and Brake Lever (2 Locations)</p> <p>9 Face Plate</p> <p>10 Live Center</p> <p>11 Micrometer Carriage Stop</p> <p>12 Saddle or Carriage</p> <p>13 Tool Post</p> <p>14 Compound Rest</p> <p>15 Compound Rest Feed Screw Handle</p> <p>16 Carriage Cross Feed Handle</p> <p>17 Power Cross Feed Clutch Lever</p> <p>18 Power Longitudinal Feed Clutch Lever</p> <p>19 Hand Wheel for Longitudinal Carriage Travel</p> | <p>20 Lead Screw Split Nut Lever</p> <p>21 Feed Rod and Lead Screw Safety Lever (Prevents Engaging Both Feeds)</p> <p>22 Apron</p> <p>23 Thread Chasing Dial</p> <p>24 Steady Rest</p> <p>25 Dead Center</p> <p>26 Tailstock Spindle Binding Lever</p> <p>27 Tailstock</p> <p>28 Tailstock Handwheel</p> <p>29 Tailstock Clamping Screws</p> <p>30 Screw for "Setting Over" Tailstock (For Taper Turning)</p> <p>31 Leadscrew Reverse Lever *</p> <p>32 Bed Ways</p> <p>33 Lead Screw</p> <p>34 Feed Rod</p> <p>35 Chip and Oil Pan</p> <p>36 Bed</p> <p>37 Collet Attachment Lever</p> <p>38 Collet Cabinet</p> <p>39 Electric Motor Control Switch</p> |
|--|--|

\* Located on AA Lathes beneath lever #4.



## GENERAL

The Serial Number is stamped on the front surface of the bed at the tailstock end of each lathe. This number identifies the machine and serves as a key to the manufacturer's record.

Cleaning: To prevent rust during shipment the exposed bright parts of the machine are given a coating of heavy grease or slushing compound. This may be washed off with kerosene or naphtha or some of the non-inflammable cleaning agents if preferred. The cleaning operation should be careful and thorough. Remove cover over rear part of cross slide in order to clean the carriage slide and screw.

Correct installation is essential to successful operation and satisfactory performance. Accurate work can only be obtained when lathe rests on a solid foundation. Once the lathe is placed on a firm foundation it should be leveled.

Leveling: For accurate and successful lathe operation the lathe must be absolutely level at head and tail ends, assuring no twist in the bed. Incorrect leveling will eventually cause twist with the result that the lathe will fail to bore or turn true.

Reed-Prentice Lathes are furnished with leveling screws, four for each leg. The location for these leveling screws may be found on the foundation plan.

It is advisable to place a steel plate not less than 1/2" thick under each screw to act as a non-yielding resistance surface.

After the lathe has been placed with screws resting on plates a sensitive precision level should be placed across the flats of the carriage (See cut Page 14) as close as possible to the headstock. When headstock end of lathe is perfectly level, then move carriage to tailstock end. Without moving the level, check tailstock end of lathe and adjust with leveling screws. Repeat this procedure until both ends register perfectly level.

When lathe has third leg it also should be leveled longitudinally. Place level on flat scraped surface of the bed between head and center leg and also between center leg and tailstock, and adjust center leg adjusting screws to remove any "hump" or "sag".

When lathe is part of marine equipment, leveling should take place when ship is in calm water or in dry dock.

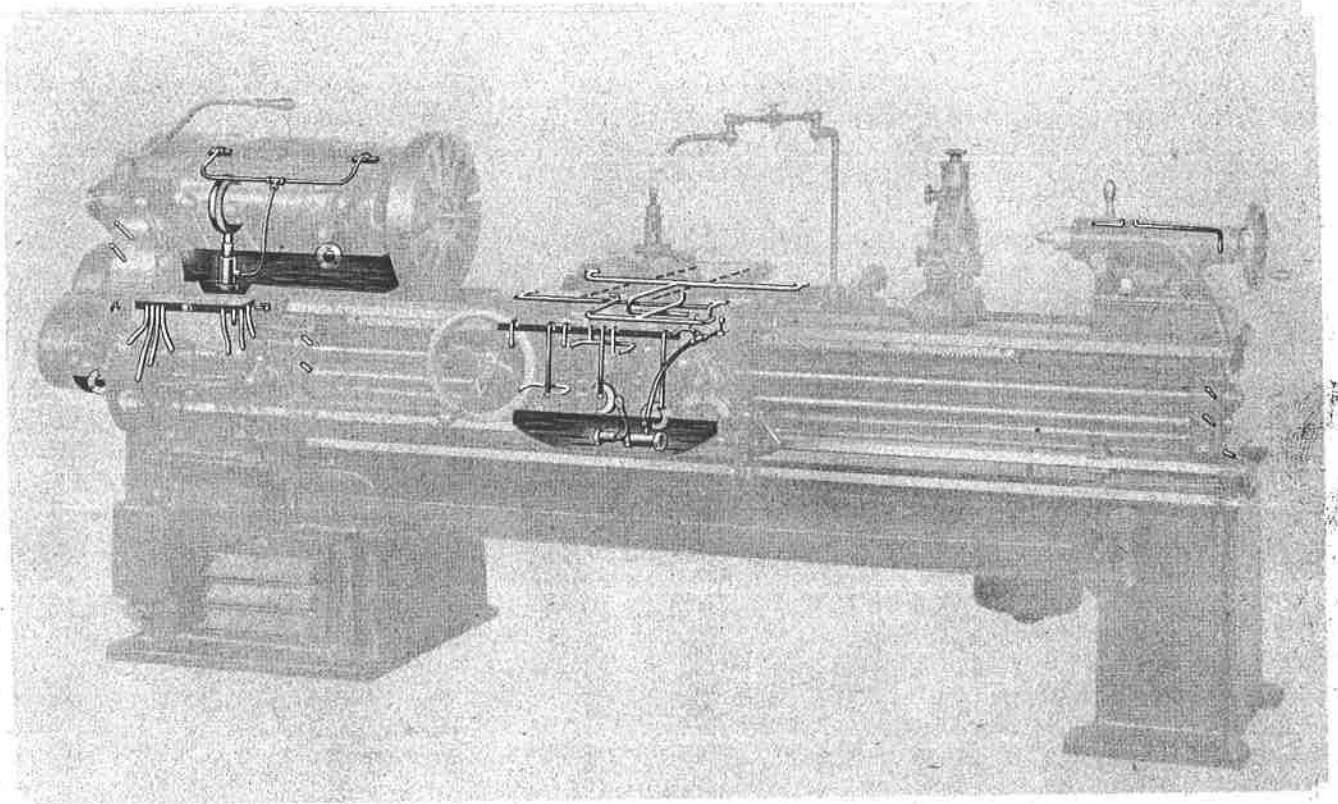
The lathe alignment should be checked regularly.

Lubrication: After the lathe has been set up it should be gone over and all bearings flooded with oil while running at a slow speed. (See oiling diagram on following page.)

The headstock operates in a bath of oil, with oil pump and filtration to main spindle bearings. Automatic oiling of the apron and carriage ways is provided by a pump and distributing system.

The apron oil reservoir and the headstock should be drained, flushed out and refilled with oil as specified at least twice a year. At this time the filters over the main spindle bearings and those in the bottom of the oil pumps should be replaced.

## LUBRICATION SYSTEM

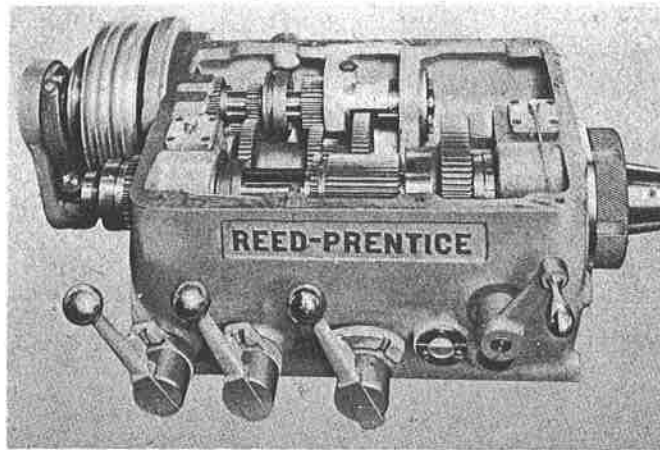


## PRECAUTIONS

Keep the machine clean and well oiled. Avoid putting tools or wrenches and files across the bed of the lathe. If you must keep tools on the bed, a board should be provided so as to protect the finished surfaces of the vees.

Remember that the manufacturer has built precision into the machine and that the bed and carriage "flats" are not intended for use as anvils and that such use is detrimental.

Always use wrenches that are a proper fit on the various bolts and screws so as to avoid turning over the corners and finally getting a condition where a pipe wrench is necessary to get a grip. Suitable wrenches are provided with machine.



HEADSTOCK

Changes in spindle speeds are effected through sliding gears operated by levers on the outside of the headstock. The speeds available and the lever positions necessary to produce each speed required are shown on plate attached to the headstock, as shown in the drawings below.

Proper operation requires disengagement of the driving clutch before moving the shifting levers. A clutch operating lever is placed at the headstock end of the machine so as to be convenient for this operation. The headstock gears are made of Chrome Molybdenum SAE 4150 electric furnace steel properly heat-treated, shaved and lapped. Engaging teeth are rounded to permit the gears to mesh easily. The gears slide upon multiple splined shafts mounted on non-friction bearings.

SLIDING GEAR HEAD		POSITION OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	
REED-PRENTICE CORP. WORCESTER, MASS., U.S.A. DRIVING PULLEY 560 RPM. SERIAL No. _____ CONTRACT No. _____ DATE OF MANUFACTURE _____ INSPECTION _____			18	110
			22	136
			29	171
			36	212
			47	276
			58	342
			73	432
			91	536

14" Speed Plate

SLIDING GEAR HEAD		POSITION OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	
REED-PRENTICE CORP. WORCESTER, MASS., U.S.A. DRIVING PULLEY 500 RPM. SERIAL No. _____ CONTRACT No. _____ DATE OF MANUFACTURE _____ INSPECTION _____			16	98
			19	121
			26	152
			32	188
			42	246
			52	305
			65	385
			81	476

16" Speed Plate

## DRIVING CLUTCH



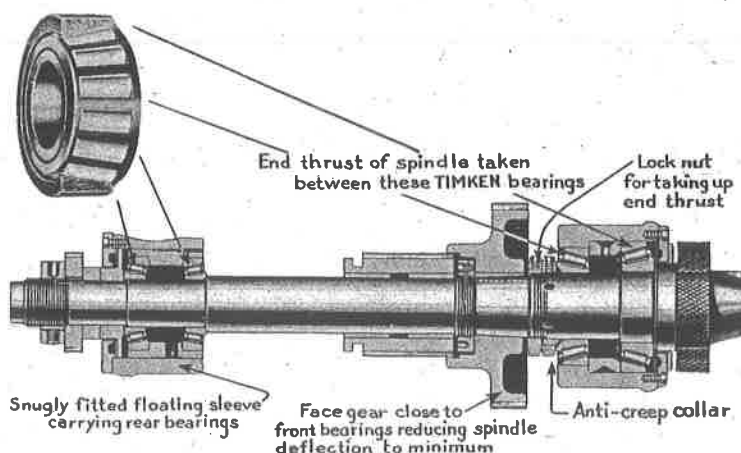
An extremely powerful driving clutch is provided. When properly adjusted it will not slip even under extremely heavy cuts. The discs are of steel, faced with "Raybestos". There is but one point of adjustment, easily accessible and consisting of a nut and lock plate. Adjustment is effected

by removing the lock plate and turning the adjusting nut. Turn to the right to tighten and to the left to release. Re-engage the lock plate in one of the slots provided for the purpose.

A brake is provided for quickly stopping the machine. The clutch and brake are both operated by the clutch levers, one of which is provided at the quick change gear bank and the other at the right hand side of the apron. Both levers are attached to the same operating shaft and operate simultaneously.

## SPINDLE

Due to its rugged construction and the ample size bearings



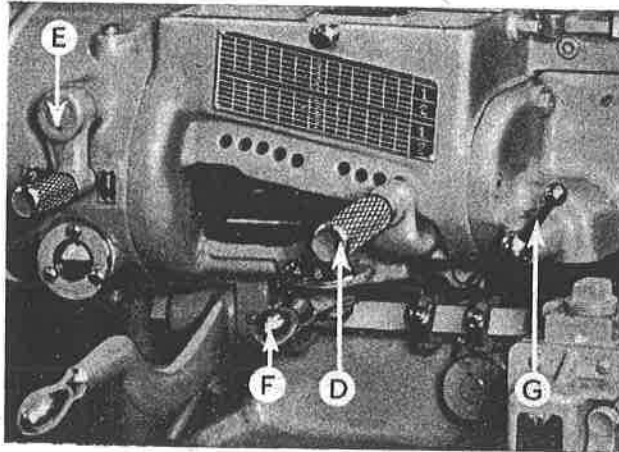


used, the spindle will seldom, if ever, require bearing adjustment. All thrust is taken by the two front bearings, which are adjusted by means of locking collars. Rear bearings are fitted in a snugly fitting floating sleeve, allowing compensation for varying headstock and spindle temperatures. Adjustment of the rear bearings is made by releasing the set screw and turning the adjusting collar which is threaded onto the spindle.

The spindle is SAE 6140 Chrome Vanadium alloy steel, heat-treated and hardened to Rockwell C36-40. The long taper key-drive spindle nose is standard #L-1, Hardened to Rockwell C55-58. The taper spindle bore is a #15 Jarno. A sleeve is provided as standard equipment to supply a #4 Morse taper. Care should be taken, when inserting centers or bushings into the taper spindle bore, to see that the bore is clean and that the piece to be inserted is clean and free from burrs. Spindles may be ruined by battering of the taper bores due to carelessness.

#### MOTOR DRIVE

Adjustment of the driving motor to suit the driving element, whether it be chain, flat belt or multiple vee belt is by movement of a hinged plate upon which the motor is mounted. This adjustment is through a screw and nut at the front of the motor plate. To obtain access to adjusting screw remove door of cabinet leg at head end of the lathe. In the case of belt drives it is necessary to avoid getting oil or grease on the belts when oiling the motor, as oil has a detrimental effect on this type of drive.



### CHANGE GEAR MECHANISM

Power is transmitted to the apron and carriage through the feedworks unit. The rate of feed is controlled by connecting the feedworks gears directly to the spindle. End gears are mounted on anti-friction bearings with "Alemite" system of lubrication and the lower gears run in a bath of oil in an oil tight case provided with a sight oil level gauge.

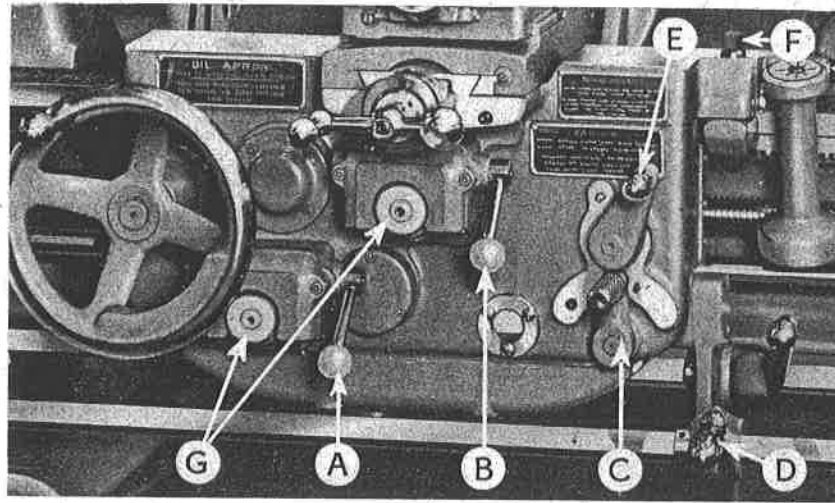
Three levers D, E, & F control the selection of any particular rate of feed. Obtainable rates are listed on index plate. The sliding tumbler lever D is moved directly under the column in which the desired rate is listed. Levers E and F are moved as required to obtain the exact rate.

Lever G moved to the right will transmit the rate of feed in thousandths to the feed rod. Moved to the left, the rate of feed in threads per inch is transmitted to the lead screw.

The screw is mounted in radial ball bearings and is provided with hardened steel and bronze thrust washers.

Feeds from .0025" to .160" per revolution of spindle and threads from 1-1/2 to 96 per inch can be obtained. Special threads, including metric, can be secured by using special gearing in the endworks.

## APRON AND CARRIAGE



The apron and carriage receive power from either the feed rod or the lead screw. The feed rod transmits power through gearing in the apron. Lever A controls friction disc clutch for longitudinal feed and lever B for cross feed. Lever C engages and disengages all of the gearing in the apron. The lead screw reverse lever D will reverse the feed rod rotation, making it possible to change the direction of feed.

For Model AA Lathes not equipped with this feature the lever C is arranged to move in a full arc to reverse the direction of feed.

The lead screw is engaged by a split nut operated by Lever E. The direction of movement of the apron is controlled by lever D which reverses the lead screw. Lathes not equipped with this leadscrew reverse lever mounted on the apron will have a reverse lever mounted directly under the oil gauge on the end feedbox. An interlock prevents engagement of the feed rod and the lead screw simultaneously.

The carriage lock screw F is used when it is desired to maintain the position of the carriage for such operations as "facing".

Adjustable dogs are provided on the control shaft under the feed rod and may be set to disengage the feed rod or lead screw

at a predetermined point when the carriage is moving in either direction. A fixed collar acts as a safety at the limit of travel.

Lubrication of apron and carriage bearings is by means of a small oil pump immersed in an oil reservoir at the bottom of the apron. Oil tubes lead from this pump to the various lubrication centers.

Adjustment of the feed clutch is made by releasing a set screw and turning the adjusting collar G to the right to tighten and to the left to release.

#### THREAD CHASING DIAL

When threading a piece of work, the thread chasing dial is used to determine the exact moment to engage the split nut with the lead screw. Thus the successive cuts will follow the same path. Any of the lines on the dial are used as indicators except when work has a fractional number of threads, such as  $3\frac{1}{2}$ ,  $6\frac{1}{2}$ ,  $11\frac{1}{2}$ . For these fractional pitches the short lines on the dial serve as indicators. When the fraction is not  $\frac{1}{2}$  the dial cannot be used. It will then be necessary to reverse the lead screw to bring the tool back to the starting point.

#### MICROMETER CHASING STOP

When making successive cuts on a thread the tool is withdrawn and returned to the identical position as for the preceding cut by using the micrometer chasing stop. This device is incorporated into the carriage cross screw.



First the tool is set with respect to the work and then the micrometer stop is engaged. The set screw in the stationary casting is tightened and the set screw in the revolving section is loosened. Set screws and instructions on dial are plainly visible.

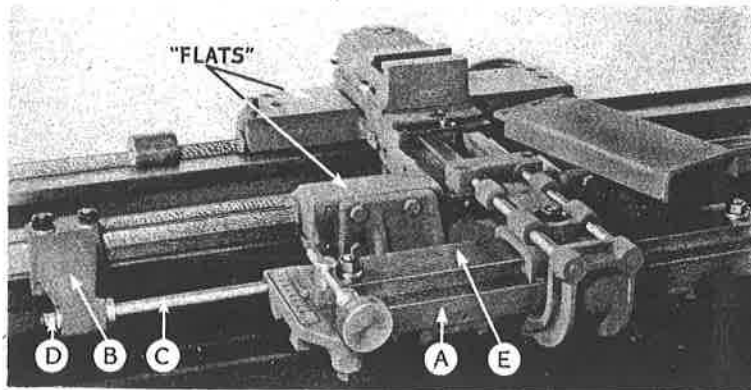
The carriage screw is used to remove the tool from the work at end of one threading cut. Upon starting the successive cuts, turning the carriage screw until the "stop" is reached will locate the tool in the same position. The depth of the new cut is governed by turning the top-slide handle.

#### TAILSTOCK

The tailstock is of the massive two bolt type and is so designed as to permit setting the compound rest parallel with the bed of the lathe. Spindle is carefully fitted and is provided with an equalizing type of binder. A single movement, forward or back, of a convenient lever at the top of the barrel, locks or releases the spindle without affecting alignment.

Lateral adjustment is provided for turning tapers by offsetting the tailstock. When the tailstock is to be offset, it is of course necessary to release the two clamping bolts so as to avoid inaccurate setting due to strains.

## TAPER ATTACHMENT



The taper attachment provides a method for turning tapers that is much more convenient than "setting over" the tailstock. A taper is turned by holding the taper slide "A" stationary as the carriage moves longitudinally. The bed clamp "B" rests on the back vee of the bed and fits over the rod "C" extending from the taper slide "A". The nut "D" is tightened to securely fasten the rod to the bed clamp which in turn is then clamped to the bed.

The angle of taper is controlled by the setting of the taper bar "E". The angle at which this bar is set is duplicated on the work. Two scales at each end of the bar allow quick setting of the taper. One scale reads in degrees of included angle, the other in inches per foot.

A telescoping feed screw is provided in the carriage so that the full range of the taper may be turned without further adjustment.

However, when setting up the taper attachment, it is essential that the carriage slide be set so that it will move freely throughout the length of taper to be cut.

### COLLET ATTACHMENT

The collet attachment consists mainly of a spindle nose piece, a pusher tube, and the operating lever. The operating lever is attached permanently to the machine. The pusher tube may or may not remain in the spindle.

This tube is a long length of narrow walled steel tubing and is not placed in the spindle until the collet attachment is to be used. With the pusher tube in place, the collet is inserted in the spindle. The nose piece is assembled to the spindle nose in the same manner as a face plate or chuck.

The lever operates toggles that force the collet into the taper nose causing it to close up and grip the work.

## PARTS ORDERING INSTRUCTIONS

When ordering any repair parts please supply the following information:

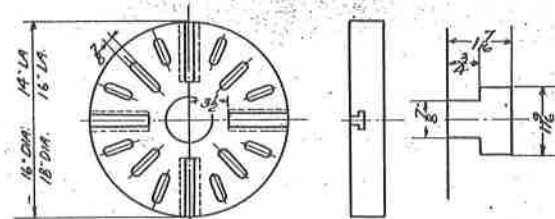
- 1 - Serial number of machine (Stamped on Speed Plate)
- 2 - Model number of machine
- 3 - Part number - if possible
- 4 - When ordering gears - specify
  - (a) - Outside Diameter
  - (b) - Number of teeth
  - (c) - Width of teeth
  - (d) - Diameter of Hole
- 5 - Description and location of part. Reference to the plans listed in table of contents will help identify parts required.

Supplying of complete details as listed will prevent unnecessary delays in filling orders.



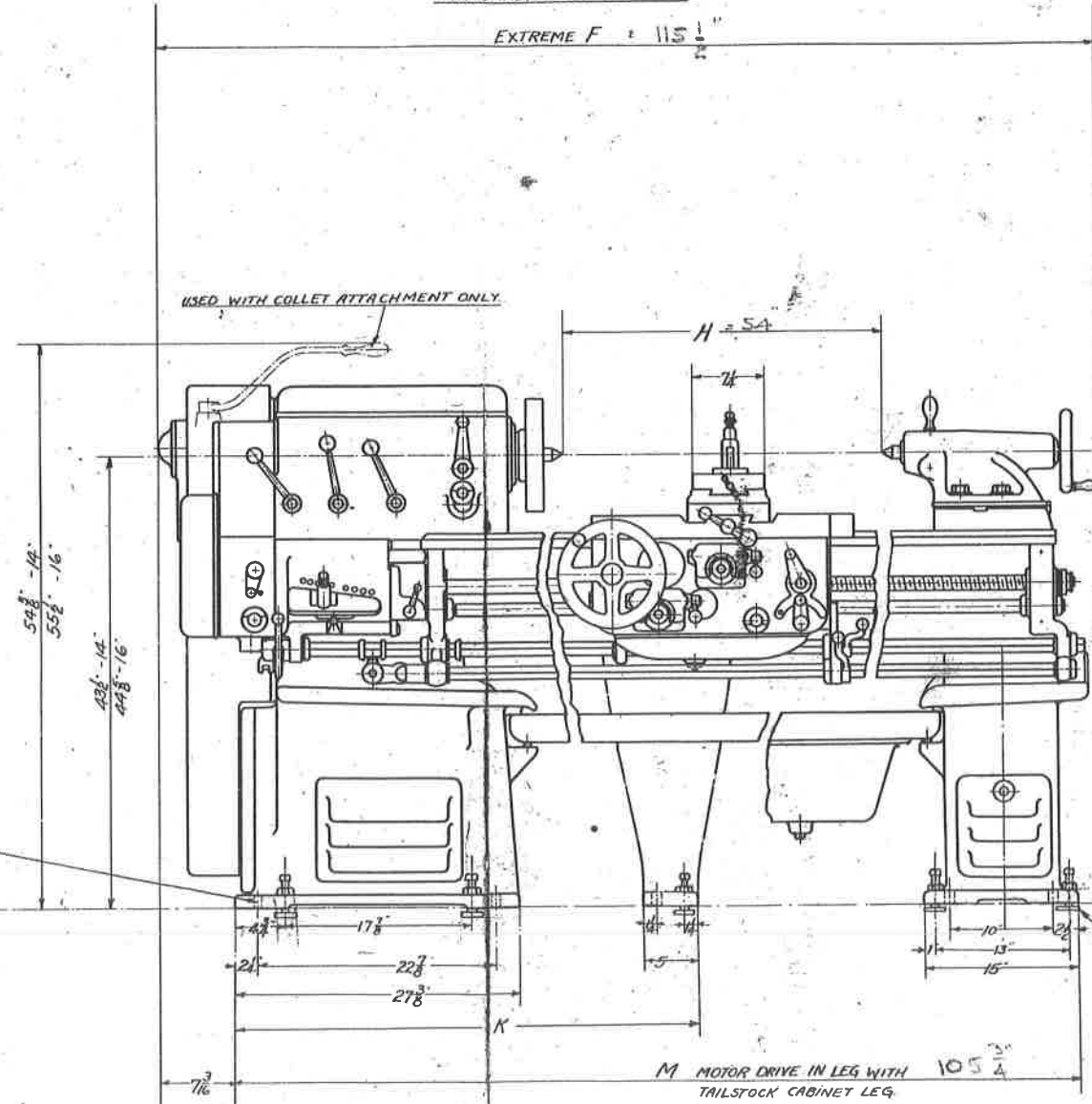
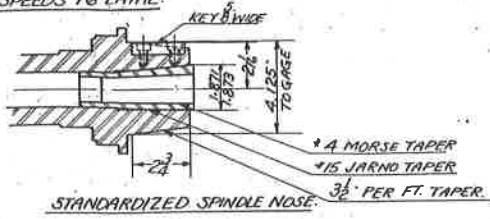
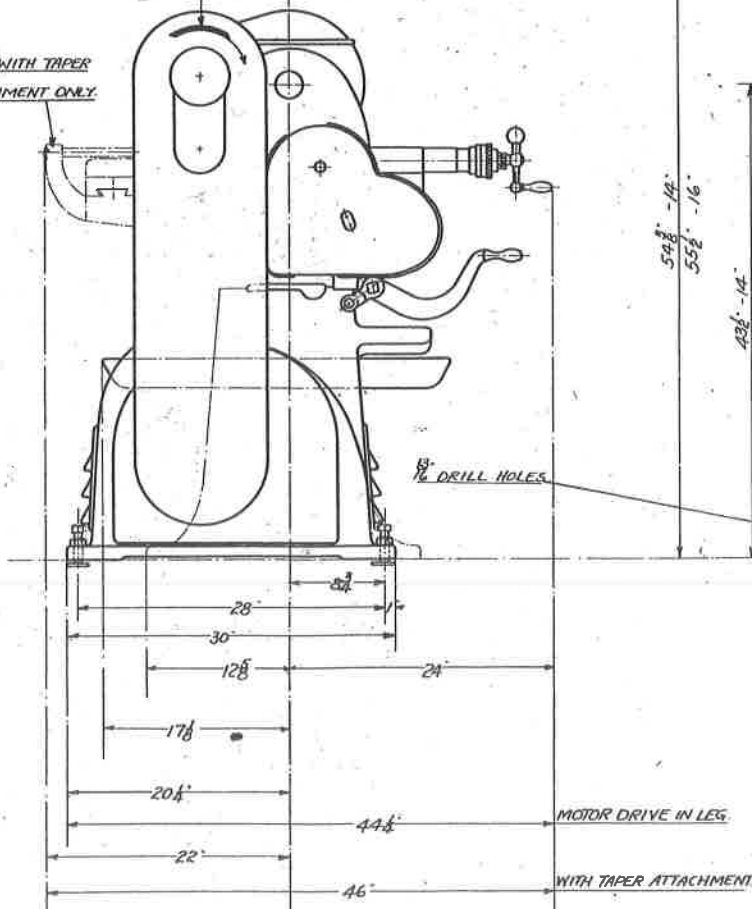
SPINDLE SPEEDS		DRIVING PULLEY		SPINDLE SPEEDS		DRIVING PULLEY		SPINDLE SPEEDS		DRIVING PULLEY	
560 R.P.M.		500 R.P.M.		560 R.P.M.		500 R.P.M.		560 R.P.M.		500 R.P.M.	
POSITION OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	POSITIONS OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	POSITION OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	POSITIONS OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	POSITIONS OF LEVERS ON HEADSTOCK	BACK GEAR LEVER	POSITIONS OF LEVERS ON HEADSTOCK	BACK GEAR LEVER
	18	110		16	98		22	136		19	121
	22	136		19	121		36	212		32	188
	29	171		26	152		58	342		52	305
	36	212		32	188		91	536		81	476
	47	276		42	246	8 SPINDLE SPEEDS 14" LATHE.		8 SPINDLE SPEEDS 16" LATHE.			
	58	342		52	305						
	73	432		65	385						
	91	536		81	476						

16 SPINDLE SPEEDS 14" LATHE. 16 SPINDLE SPEEDS 16" LATHE.

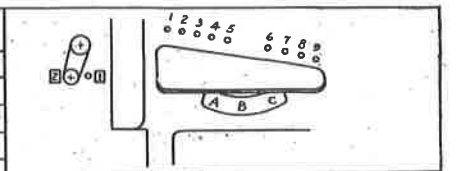


RUN PULLEY THIS WAY  
560 R.P.M. 14"  
500 R.P.M. 16"

USED WITH TAPER ATTACHMENT ONLY.



LENGTH OF BED	F	H	K	M
5 FT.	79 1/2	18	—	69 1/2
6 FT.	91 1/2	30	—	81 1/2
7 FT.	103 1/2	42	—	93 1/2
8 FT.	115 1/2	54	—	105 1/2
9 FT.	127 1/2	66	—	117 1/2
10 FT.	139 1/2	78	68 1/2	129 1/2
12 FT.	163 1/2	102	80 1/2	153 1/2
14 FT.	187 1/2	126	92 1/2	177 1/2
16 FT.	211 1/2	150	104 1/2	201 1/2
18 FT.	235 1/2	174	116 1/2	225 1/2

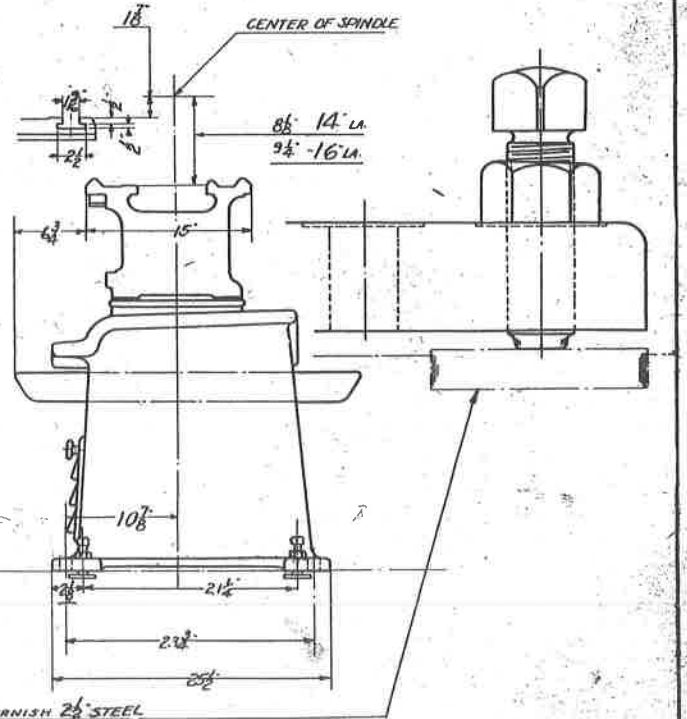


LONGITUDINAL AND CROSS FEEDS  
FEEDS IN THOUSANDTHS OF AN INCH.

TUMBLER POSITION	END LEVER					
	2			1		
	A	B	C	A	B	C
1	160	80	40	20	10	5
2	148	74	37	18	9	4 1/2
3	137	68	34	17	8 1/2	4 1/4
4	120	60	30	15	7 1/2	3 3/4
5	116	58	29	14 1/2	7 1/4	3 1/2
6	96	48	24	12	6	3
7	87	44	22	11	5 1/2	2 3/4
8	83	41 1/2	20 3/4	10 3/4	5 1/4	2 1/2
9	80	40	20	10	5	2 1/2

THREADS PER INCH

TUMBLER POSITION	END LEVER					
	2			1		
	A	B	C	A	B	C
1	16	3	6	12	24	40
2	18	3 1/2	6 1/2	13	26	42
3	18 1/2	3 3/4	7	14	28	46
4	2	4	8	16	32	54
5	2 1/2	4 1/2	9	18	36	58
6	2 1/2	5	10	20	40	60
7	2 1/2	5 1/2	11	22	44	66
8	2 1/2	5 1/2	11 1/2	23	46	68
9	3	6	12	24	48	72



CUSTOMER TO FURNISH 2 1/2" STEEL PLATES (NOT LESS THAN 1/2" THICK) UNDER LEVELING SCREWS.

DRAWN	C.N.S.	DATE	3-25-35	NAME OF PIECE	FOUNDATION PLAN	INTERNAL	
CHECKED				UNIT		SUPERSEDED NO.	21867-13499
TRACED	B	DATE	10-8-35	USED ON MACHINE		SUPERSEDED BY NO.	
TRACING CHECKED				14-16" MODEL B SLIDING GEAR HEAD LATHE.		SCALE	1 1/2" = 12 IN.

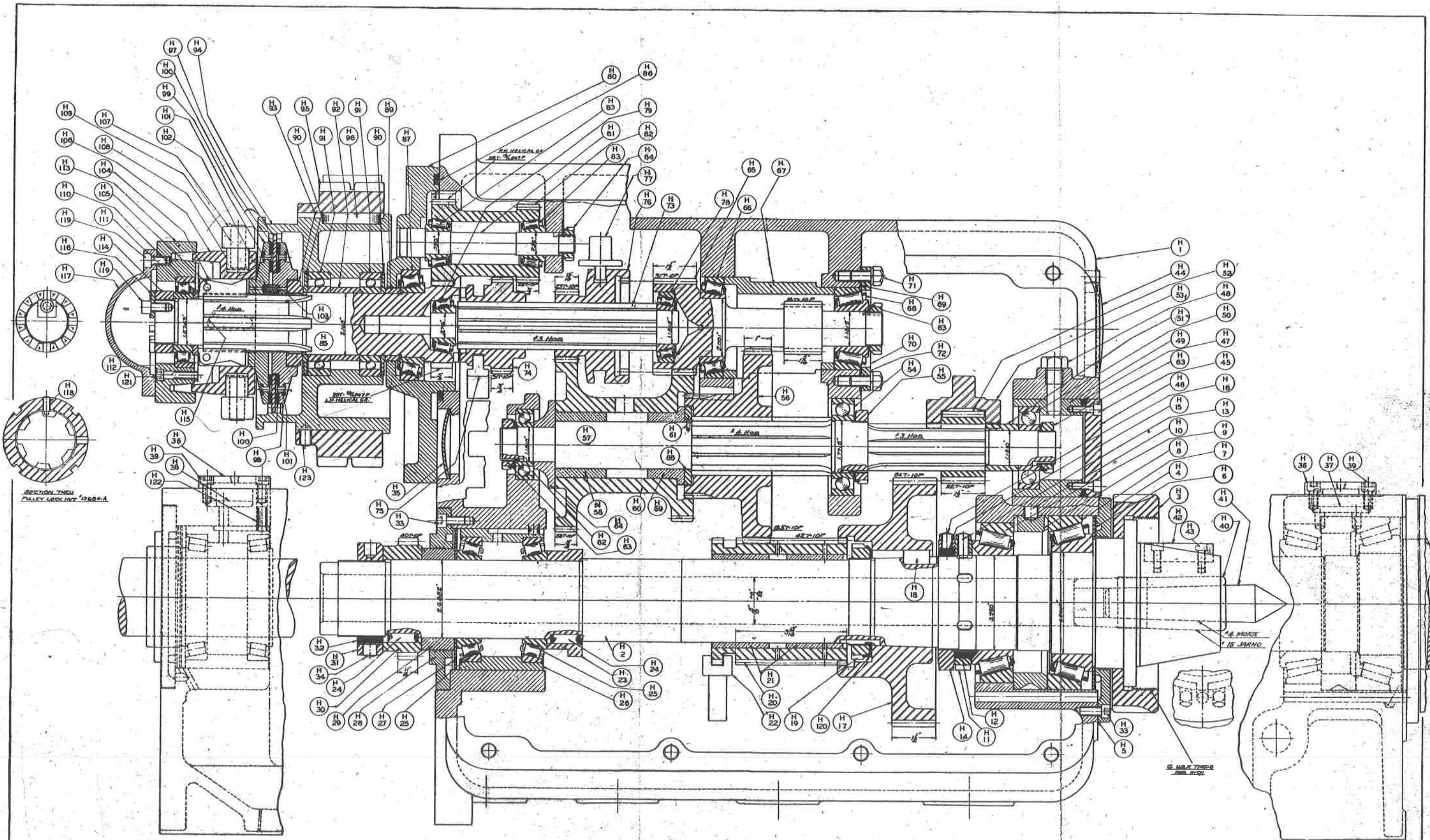
Worcester, Mass., U.S.A.  
24891

16-SPEED HEADSTOCK

Parts List

No.	Part	Quan.	No.	Part	Quan.
H 1	Headstock . . . . .	1	H 63	#6 Fafnir Locknut & Washer . . . . .	3
H 2	Spindle . . . . .	1	H 64	Inter. Shaft Bearing Spacer . . . . .	1
H 3	Spindle Nose Nut . . . . .	1	H 65	Drive Shaft Gear . . . . .	1
H 4	Spindle Bearing Cover Front . . . . .	1	H 66	Timken Bearing #368-362A . . . . .	1
H 5	Gasket - Front Sp. Bearing Cover . . . . .	1	H 67	Drive Shaft Retainer . . . . .	1
H 6	Spindle Oil Slinger . . . . .	1	H 68	Timken Bearing #3190-3120 . . . . .	1
H 7	Timken Bearing #592A-593 . . . . .	1	H 69	Laminated Shim . . . . .	1
H 8	Spindle Bearing Spacer - Front . . . . .	1	H 70	Thrust Washer . . . . .	1
H 9	Timken Bearing #580W - 572 . . . . .	1	H 71	3/8" x 3/4" Hex. Head Cap Screw . . . . .	4
H 10	1/2" x 3/4" Allen Headless Screw - Oval Point . . . . .	1	H 72	3/8" Shakeproof Washer . . . . .	4
H 11	Spindle Bearing Adjusting Collar . . . . .	1	H 73	Drive Shaft . . . . .	1
H 12	Adjusting Key . . . . .	2	H 74	Sliding Gear . . . . .	1
H 13	3/8" x 3/4" Allen Headless Screw - Dog Point . . . . .	3	H 75	1st Reduction Shifter Shoe . . . . .	1
H 14	Spindle Bearing Nut . . . . .	1	H 76	Clutch Drive Shaft Gear Spool . . . . .	1
H 15	Nut Key . . . . .	2	H 77	Clutch Shaft Gear Shoe . . . . .	1
H 16	3/8" x 1/2" Allen Headless Screw - Oval Point . . . . .	2	H 78	Timken Bearing #17118-17244 . . . . .	1
H 17	Face Gear . . . . .	1	H 79	Timken Bearing - Cone & Rollers #1380 . . . . .	1
H 18	Face Gear Key - 1/2" x 1/2" x 7/8" . . . . .	1	H 80	Pulley Bracket . . . . .	1
H 19	Spindle Locknut . . . . .	1	H 81	Double Gear Shaft . . . . .	1
H 20	Spindle Sliding Gear . . . . .	1	H 82	Double Gear . . . . .	1
H 21	Spindle Sliding Gear Bushing . . . . .	2	H 83	Timken Bearing - Cone & Rollers #09078 . . . . .	2
H 22	Spindle Sliding Gear Lever Fork . . . . .	1	H 84	#3 Fafnir Locknut & Washer . . . . .	1
H 23	Oil Pump Cam . . . . .	1	H 85	Clutch Shaft . . . . .	1
H 24	Pump Cam Key - 5/16" x 5/16" x 1" . . . . .	2	H 86	Cork Gasket . . . . .	1
H 25	Timken Bearing #394A-399A . . . . .	2	H 87	Timken Bearing #387-382A . . . . .	1
H 26	Spindle Bearing Sleeve - Rear . . . . .	1	H 88	Inter. Shaft Bearing Spacer . . . . .	1
H 27	Spindle Oil Slinger - Rear . . . . .	1	H 89	Bearing Spacer - Short . . . . .	1
H 28	Spindle Bearing Cover - Rear . . . . .	1	H 90	Bearing Retainer Plate . . . . .	2
H 29	Spindle Bearing Spacer - Rear . . . . .	1	H 91	#3-L-11 New Departure Ball Bearing . . . . .	2
H 30	Spindle Gear . . . . .	1	H 92	Bearing Spacer - Long . . . . .	1
H 31	Spindle Gear Nut . . . . .	1	H 93	Pulley Locknut . . . . .	1
H 32	Spindle Gear Nut Key . . . . .	1	H 94	Pump Pulley and Hub . . . . .	1
H 33	5/16" x 5/8" Allen Socket Hd. Cap Screws . . . . .	11	H 95	57T Sprocket . . . . .	1
H 34	1/2" x 1/2" Allen Hdls. Set Screw - Flat Point . . . . .	1	H 96	Sprocket Key - 3/8" x 3/8" x 2" . . . . .	1
H 35	2-3/8" Welch Plug . . . . .	1	H 97	Clutch Plate . . . . .	1
H 36	Oil Basin Covers . . . . .	2	H 98	Clutch Disc . . . . .	1
H 37	Wool Felt Strainer - Front . . . . .	1	H 99	Clutch Disc - Toggle Carrier . . . . .	1
H 38	Wool Felt Strainer - Rear . . . . .	1	H 100	Clutch Lining . . . . .	2
H 39	5/16" x 1/2" Allen Socket Hd. Cap Screws . . . . .	11	H 101	Tubular Rivets . . . . .	12
H 40	Center Collet . . . . .	1	H 102	Clutch Release Springs . . . . .	3
H 41	Center - Std. #4 Morse . . . . .	1	H 103	Drill Rod Pin - 1/8" x 1-1/8" . . . . .	3
H 42	Spindle Nose Key . . . . .	1	H 104	Toggle . . . . .	2
H 43	1/2" x 5/8" Allen Socket Hd. Cap Screw . . . . .	2	H 105	Toggle Pin . . . . .	2
H 44	3" Welch Plug . . . . .	1	H 106	Clutch Spool . . . . .	1
H 45	1/2" x 3/4" Allen Socket Hd. Cap Screw . . . . .	4	H 107	Clutch Fork . . . . .	1
H 46	Inter. Shaft Bearing Housing Cover . . . . .	1	H 108	Clutch Shoe . . . . .	2
H 47	ALLPAX Packing . . . . .	1	H 109	Clutch Shoe Pins - 1/2" x 1 1/2" Drill Rod . . . . .	2
H 48	Inter. Shaft Bearing Housing Screw . . . . .	1	H 110	Abutment Collar . . . . .	1
H 49	Inter. Shaft Bearing Housing . . . . .	1	H 111	R-140 Norma-Hoffman Bearing . . . . .	1
H 50	#306 Fafnir Ball Bearing . . . . .	1	H 112	Bearing Retainer Ring . . . . .	1
H 51	Back Gear Stop Collar . . . . .	1	H 113	Pulley Outboard Bracket . . . . .	1
H 52	Back Gear Pinion . . . . .	1	H 114	Clutch Adjusting Nut . . . . .	1
H 53	Back Gear Pinion Fork . . . . .	1	H 115	Clutch Spool Key - 1/4" x 3/8" x 1-9/16" . . . . .	2
H 54	#209 Fafnir Ball Bearing . . . . .	1	H 116	Clutch Adjusting Nut Lock . . . . .	1
H 55	#9 Fafnir Locknut and Washer . . . . .	1	H 117	Pulley Shaft Cover . . . . .	1
H 56	Inter. Shaft Sliding Gear . . . . .	1	H 118	1/2" x 5/8" Allen Headless Screw - Dog Point . . . . .	1
H 57	Intermediate Shaft . . . . .	1	H 119	5/16" x 1/2" Allen Socket Head Cap Screw . . . . .	7
H 58	Inter. Shaft Double Gear Bushing - Plain . . . . .	1	H 120	Spindle Face Gr. Lock Washer . . . . .	1
H 59	Inter. Shaft Double Gear Bushing - Flanged . . . . .	1	H 121	1/2" x 1 1/2" Allen Socket Head Cap Screw . . . . .	13
H 60	Inter. Shaft Double Gear . . . . .	1	H 122	3/8" x 7/8" C. R. Pin . . . . .	1
H 61	3/16" x 1/2" C. R. Pin . . . . .	1	H 123	3/8" x 1/2" Allen Hdls. Screw - Dog Point . . . . .	2
H 62	#206 Fafnir Ball Bearing . . . . .	1			





SECTION THRU VALVE LOOKING FROM 3388-A

R.B.C.		ASSEMBLY	REED-PRENTICE CORP.	
HEAD - 16 SPEED		MADE IN U.S.A.		930-4140
14" x 16" Model D - S. Gr. No. LATHE		MADE IN U.S.A.		930-4140

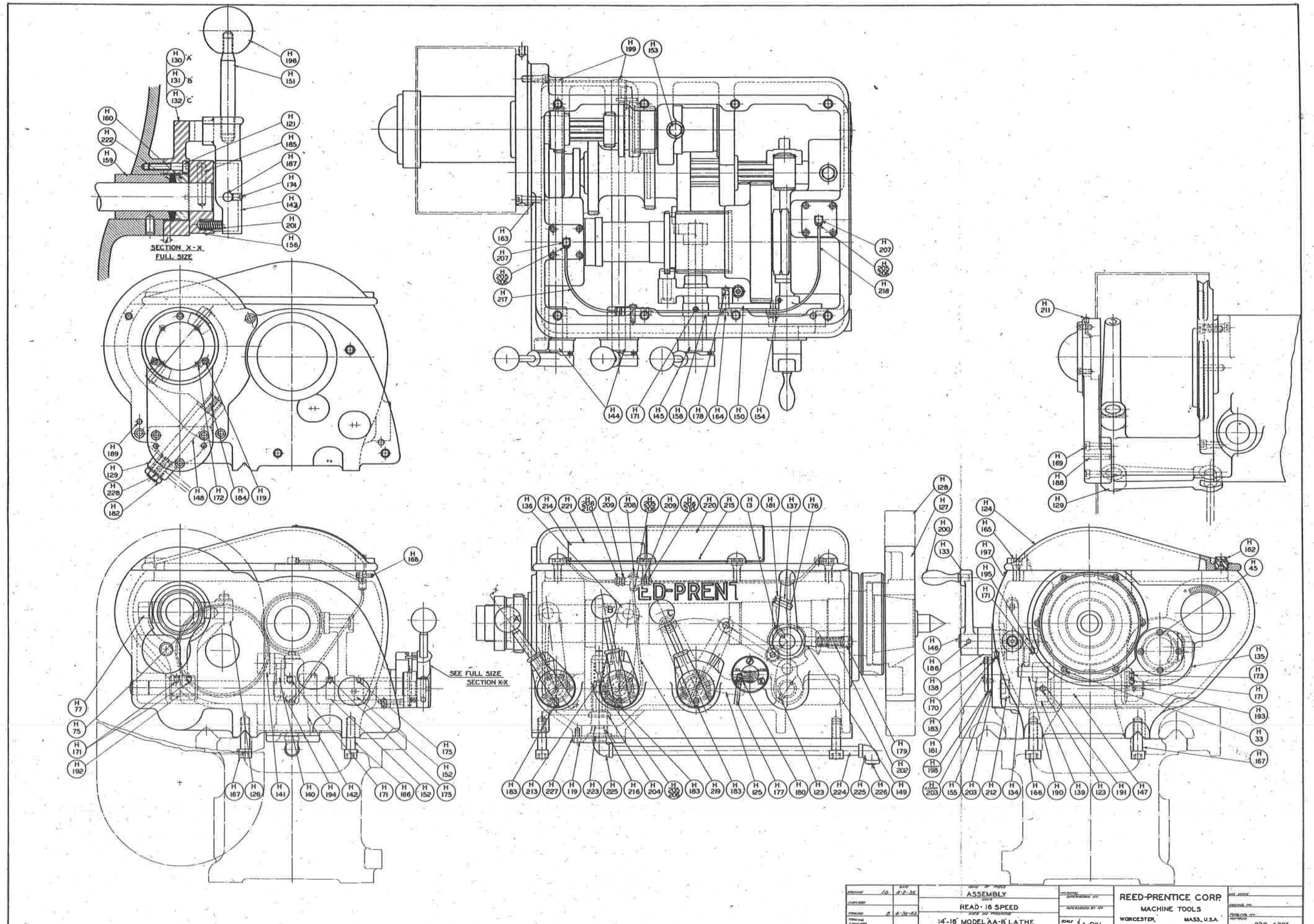
SEE ALSO 930-4205

16-SPEED HEADSTOCK

Parts List

No.	Part	Quan.	No.	Part	Quan.
H 124	Head Cover . . . . .	1	H 177	3/8" x 2" Allen Hdls. Screw - Oval Point . . .	1
H 125	Spindle Sliding Gear Lever . . . . .	1	H 178	1/2" x 1/2" Allen Hdls. Screw - Oval Point . . .	1
H 126	Gear Shifter (Pulley) . . . . .	1	H 179	3/4" x 5/8" Allen Hdls. Screw - Cup Point . . .	1
H 127	Small Face Plate - 11" Diameter . . . . .	1	H 180	3/8" Thin Hex. Nut . . . . .	1
H 128	Large Face Plate - 16" Diameter . . . . .	1	H 181	3/8" Std. Hex. Nut . . . . .	1
H 129	Pulley Clutch Fork . . . . .	1	H 182	3/4"-10 Special Hex. Nut . . . . .	1
H 130	Lever Locating Block "A" . . . . .	1	H 183	5/16" x 1/2" Allen Hdls. Screw - Dog Point . . .	4
H 131	Lever Locating Block "B" . . . . .	1	H 184	#4 x 1-3/4" Taper Pin . . . . .	1
H 132	Lever Locating Block "C" . . . . .	1	H 185	#5 x 2-5/8" Taper Pin . . . . .	3
H 133	Back Gear Hand Lever . . . . .	1	H 186	#5 x 2" Taper Pin . . . . .	1
H 134	Back Gear Shifter Cam . . . . .	1	H 187	3/8" x 2-5/8" C. R. Pin . . . . .	3
H 135	Back Gear Shifter Lever . . . . .	1	H 188	3/8" x 2" C. R. Pin . . . . .	2
H 136	Clutch Shaft Sliding Gear Lever . . . . .	1	H 189	3/8" x 1" C. R. Pin . . . . .	1
H 137	Spindle Sliding Gear Shaft Index . . . . .	1	H 190	3/4" x 2-1/8" Drill Rod Pin . . . . .	1
H 138	Back Gear Lever Shaft Bushing . . . . .	1	H 191	3/16" x 3/16" x 3/4" Round End Key . . . . .	1
H 139	Back Gear Cam Lever . . . . .	1	H 192	3/16" x 3/16" x 1 1/2" Round End Key . . . . .	2
H 140	Inter. Shaft Sliding Gear Lever . . . . .	1	H 193	3/16" x 3/16" x 1 1/4" Center Tit Key . . . . .	1
H 141	Inter. Shaft Sliding Gear Fork . . . . .	1	H 194	3/16" x 3/16" x 1 1/2" Round End Key . . . . .	1
H 142	Oil Pump Bracket . . . . .	1	H 195	3/16" x 3/16" x 2" Tit Key . . . . .	1
H 143	Shifter Hand Lever . . . . .	3	H 196	Black Ball - 1-3/4" Diameter . . . . .	3
H 144	1st and 2nd Reduction Shifter Shaft . . . . .	2	H 197	Head Cover Gasket . . . . .	1
H 145	3rd Reduction Shifter Shaft . . . . .	1	H 198	Oil Window . . . . .	1
H 146	Back Gear Lever Shaft . . . . .	1	H 199	1-1/8" Welch Plug . . . . .	2
H 147	Back Gear Shifter Shaft . . . . .	1	H 200	Model 824 Cinn. Handle . . . . .	1
H 148	Pulley Clutch Arm Shaft . . . . .	1	H 201	Spring . . . . .	3
H 149	Operating Lever Lock Plunger . . . . .	1	H 202	Lock Plunger Spring . . . . .	1
H 150	Shifter Gear Lever Link . . . . .	1	H 203	Oil Window Gasket . . . . .	2
H 151	Shifter Lever Handle . . . . .	3	H 204	Oil Pump . . . . .	1
H 152	Shifter Lever Collar . . . . .	3	H 205	5/32" Compression Bushing . . . . .	4
H 153	Drive Shaft Retainer Screw . . . . .	1	H 206	5/32" Compression Sleeve . . . . .	6
H 154	Gear Shaft Lever Link Screw . . . . .	1	H 207	5/32" Elbow Adapter . . . . .	2
H 155	Oil Window Seat . . . . .	1	H 208	Junction - 3-Way . . . . .	1
H 156	Shifter Hand Lever Hub . . . . .	3	H 209	Drip Plug FJB5B2500 . . . . .	2
H 158	Shifter Lever Collar . . . . .	1	H 210	5/32" Compression Nut . . . . .	2
H 159	Reduction Shaft Bushing . . . . .	3	H 211	#1 Bowen Oiler . . . . .	1
H 160	Shifter Lever Packing Nut . . . . .	3	H 212	1 1/4" Countersunk Pipe Plug . . . . .	1
H 161	Oil Window Frame . . . . .	1	H 213	1/2" Shakeproof Lock Washer . . . . .	1
H 162	Pipe Plug . . . . .	1	H 214	#4 x 5/16" Parker Drive Screws . . . . .	4
H 163	7/16" x 1 1/4" Allen Socket Hd. Cap Screw . . . . .	4	H 215	#4 x 3/8" Parker Drive Screws . . . . .	6
H 164	1/2" x 1" Allen Socket Hd. Cap Screw . . . . .	1	H 216	3/4" x 3/8" Reducing Bushing . . . . .	1
H 165	1/2" x 1 1/4" Allen Socket Hd. Cap Screw . . . . .	8	H 217	5/32" x 9" Tubing . . . . .	1
H 166	5/8" x 1-3/4" Allen Socket Hd. Cap Screw . . . . .	2	H 218	5/32" x 12-3/4" Tubing . . . . .	1
H 167	5/8" x 2" Allen Socket Hd. Cap Screw . . . . .	2	H 219	5/32" x 16 1/2" Tubing . . . . .	1
H 168	1/4" x 1" Hex. Hd. Screw . . . . .	1	H 220	Speed Plate . . . . .	
H 169	7/16" x 1-3/4" Allen Socket Hd. Cap Screw . . . . .	3	H 221	Caution Plate . . . . .	
H 170	1/4" x 5/8" French Hd. Screw . . . . .	3	H 222	ALLPAX Packing - 3/8" Coil Form . . . . .	24"
H 171	3/8" x 3/8" Allen Headless Screw - Dog Point . . . . .	6	H 223	3/8" x 1" Close W. I. Nipple . . . . .	1
H 172	1/4" x 1" Allen Socket Head Cap Screw . . . . .	4	H 224	3/8" x 18-1/8" W. I. Nipple . . . . .	1
H 173	3/8" x 3/8" Allen Hdls. Screw - Oval Point . . . . .	1	H 225	3/8"- 90° M. I. Elbow . . . . .	2
H 174	1/4" x 3/8" Allen Hdls. Screw - Cup Point . . . . .	3	H 226	3/8" Allen Pipe Plug . . . . .	1
H 175	5/16" x 5/16" Allen Hdls. Screw - Dog Point . . . . .	3	H 227	Oil Pump Bracket Gasket . . . . .	1
H 176	3/8" x 1-1/2" Allen Hdls. Screw - Oval Point . . . . .	1	H 228	3/4" Shakeproof Lockwasher . . . . .	1





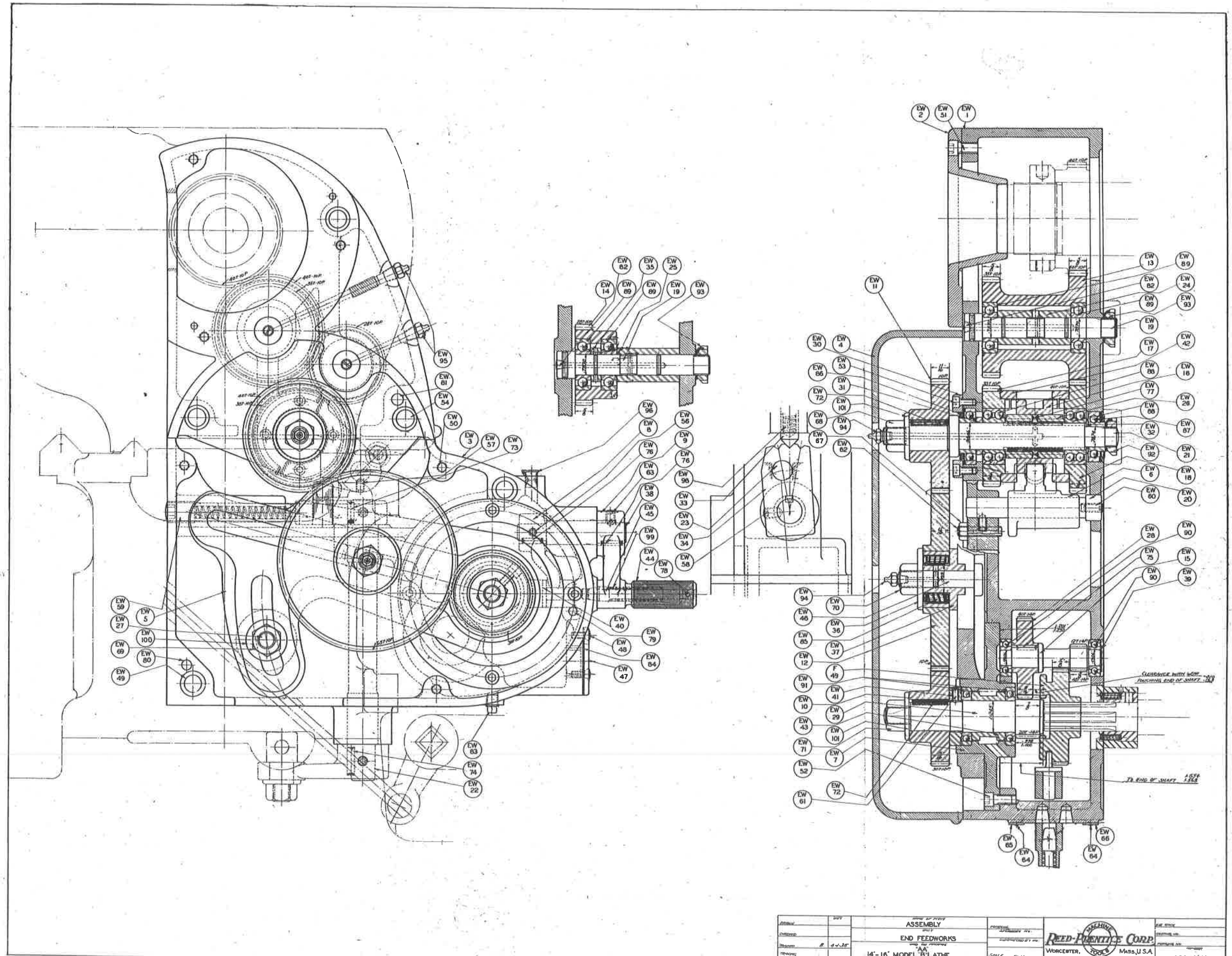
DESIGNED BY	DATE	SCALE	REVISIONS	APPROVED BY
CHECKED BY				
DRAWN BY				
DATE				
PROJECT	14'-18" MODEL AA-B LATHE		SCALE 1/2" = 1" FULL	
REED-PRENTICE CORP. MACHINE TOOLS WORCESTER, MASS., U.S.A.			930-4205	

END FEEDWORKS ASSEMBLY

Parts List

No.	Part	Quan.	No.	Part	Quan.
EW 1	Top Housing . . . . .	1	EW 56	5/16" x 7/16" Allen Hdls.Scr. - Sl.Gr. Shift Lev. - inner	1
EW 2	Top Housing Cover . . . . .	1	EW 57	5/16" x 1/2" Allen Hdls. Scr. - Top Housing .	1
EW 3	Housing . . . . .	1	EW 58	3/8" x 1/2" " " " - Plunger Plate	1
EW 4	Housing Cover . . . . .	1	EW 59	3/4" x 1" " " " - Housing . . .	1
EW 5	End Sweep . . . . .	1	EW 60	5/16" x 5/8" " " " - Cl.Shifter Sh.	1
EW 6	Clutch Shifter . . . . .	1	EW 61	1/4" x 1/2" Hdls. Set Scr. - Bearing Nut . .	1
EW 7	Sweep Bearing . . . . .	1	EW 62	3/8" x 1-3/4" Hdls. Set Scr. - Top Housing .	1
EW 8	Sliding Gear Shifter Lever - inner	1	EW 63	5/16" x 1/2" Hdls. Set Scr. - Sl. Gr. Shift Lev. - outer	1
EW 9	Sliding Gear Shifter Lever - outer	1	EW 64	#0 x 1/4" Parker Drive Scr. Fd. No. Plates .	4
EW 10	Change Gear 30T . . . . .	1	EW 65	Feed Plate #1 . . . . .	1
EW 11	Change Gear 40T . . . . .	1	EW 66	Feed Plate #2 . . . . .	1
EW 12	Change Gear 70T Sweep . . . . .	1	EW 67	3/8" Std. Hex. Nut Cl. Shifter Stop Screw . .	1
EW 13	Dumb Bell Gear . . . . .	1	EW 68	5/8" Std. Hex. Nut Sliding Clutch Shaft . . .	1
EW 14	Reversing Pinion . . . . .	1	EW 69	5/8" Std. Hex. Nut Sweep Binder Stud . . . .	1
EW 15	Back Gear Pinion . . . . .	1	EW 70	5/8" Std. Hex. Nut Inter. Ch. Gear Bolt . . .	1
EW 16	Sliding Clutch . . . . .	1	EW 71	5/8" Std. Hex. Nut Change Gear Pinion . . . .	1
EW 17	Small Clutch Gear . . . . .	1	EW 72	1/4" x 1/4" x 1-3/8" Rd. End Key Sl. Cl. Sh.& Chg. Gr. Pin.	2
EW 18	Large Clutch Gear . . . . .	1	EW 73	1/4" x 1/4" x 9/16" Rd. End Key - Vertical Sh.	1
EW 19	Dumb Bell & Rev. Pinion Shaft . . . . .	2	EW 74	1/4" x 1/4" x 1" Rd. End Key - Vertical Shaft	1
EW 20	Clutch Shifter Shaft . . . . .	1	EW 75	3/16" x 3/16" x 3/4" Rd. End Key - Back Gear Pinion . . .	1
EW 21	Sliding Clutch Shaft . . . . .	1	EW 76	3/16" x 3/16" x 3/4" Rd. End Key - Shifter Lever Stud .	2
EW 22	Vertical Shaft . . . . .	1	EW 77	Tit Key - Sliding Clutch Bearing . . . . .	2
EW 23	Plunger Plate Stud . . . . .	1	EW 78	#0 x 1" Taper Pin Sl. Gear Shifter Lever Hdl.	1
EW 24	Dumb Bell Gear Spacer . . . . .	1	EW 79	5/16" x 7/8" C. R. Pin Sweep Bearing . . . .	1
EW 25	Reverse Pinion Shaft Sleeve . . . . .	1	EW 80	3/8" x 1" C. R. Pin - Housing . . . . .	1
EW 26	Sliding Clutch Bearing . . . . .	1	EW 81	7/16" x 1" C. R. Pin - Top Housing . . . . .	1
EW 27	Reverse Plate Stud . . . . .	1	EW 82	1/8" Std. Pipe Plug Dumb Bell & Rev. Pin. Sh.	2
EW 28	Back Gear . . . . .	1	EW 83	1/4" Std. Pipe Plug - Housing . . . . .	1
EW 29	Change Gear Pinion . . . . .	1	EW 84	Oil Window - Housing . . . . .	1
EW 30	Sliding Clutch Shaft Brg. Cover . . . . .	1	EW 85	SC-403 Hyatt Brg. Change Gear (sweep) . . . .	1
EW 31	Sliding Clutch Shaft Brg. Spacer . . . . .	1	EW 86	#205-J Fafnir Felt Seal Brg. - Sl. Clutch Sh.	1
EW 32	Sliding Clutch Shaft Brg. Washer . . . . .	1	EW 87	#204-J Fafnir Felt Seal Brg. - Sl. Clutch Sh.	1
EW 33	Detent Plunger . . . . .	1	EW 88	#5205W Fafnir Double Row Brg. - Sl. Clutch Sh.	2
EW 34	Plunger Plate . . . . .	1	EW 89	#204 Fafnir Single Row Brg. - Dumb Bell & Rev. Pinion Sh. .	4
EW 35	Reverse Pinion Spacer . . . . .	1	EW 90	#202 Fafnir Brg. - Back Gear Pinion . . . . .	2
EW 36	Inter. Change Gear Washer . . . . .	1	EW 91	S-11 Norma-Hoffman Ball Brg. - Sweep Bearing.	2
EW 37	Inter.Change Gear Bearing . . . . .	1	EW 92	#4 Fafnir Locknut & Washer - Sl. Cl. Shaft .	1
EW 38	Shifter Lever Stud . . . . .	1	EW 93	#4 Fafnir Locknut & Washer - Dumb Bell & Rev. Pin. Shaft .	2
EW 39	Bearing Filler . . . . .	1	EW 94	1/8" Alemite Fitting Inter. Ch. Gr. Belt & Sl. Cl. Sh..	2
EW 40	Sliding Gear Shifter . . . . .	1	EW 95	1/8" Alemite Fitting - Top Housing . . . . .	2
EW 41	Bearing Nut . . . . .	1	EW 96	#404 Gits Oiler - Housing . . . . .	1
EW 42	Clutch Gear Spacer . . . . .	1	EW 97	Alemite Grease Gun . . . . .	1
EW 43	Bearing Spacer . . . . .	1	EW 98	Spring - Plunger . . . . .	1
EW 44	Sliding Gear Shifter Lever Handle . . . . .	1	EW 99	Spring - Sl. Gr. Sh. Lever Lock Pin. . . . .	1
EW 45	Sliding Gear Shifter Lever Lock Pin . . . . .	1	EW 100	11/16" x 1-3/4" x 9/64" Th. Washer - Sweep Binder Stud.	1
EW 46	Inter. Change Gear Bolt . . . . .	1	EW 101	41/64" H x 1-1/2" O.D. x 3/16" Th. Washer Ch. Gr. Pin. & Sl. Cl. Shaft .	2
EW 47	Oil Window Frame . . . . .	1			
EW 48	Oil Window Screws . . . . .	3			
EW 49	5/8" x 5-1/2" Allen Fil. Hd. Scr. - Housing .	2			
EW 50	3/8" x 4" Allen Fil. Hd. Scr. - Housing Cov.	3			
EW 51	3/8" x 3/4" " " " - Top Hsg. Cov.	3			
EW 52	5/16" x 3/4" " " " - Sweep Brg.	4			
EW 53	1/4" x 1/2" " " " - Sl.Cl.Sh.Brg. Cover . . . . .	4			
EW 54	5/8" x 5 1/2" " " " - Top Housing .	3			
EW 55	5/16" Hex. Allen Scr. Wrench Housing Cov.Scrs.	1			





Part No.	EW	ASSEMBLY	REV. 1	DATE	
Part No.	EW	END FEEDWORKS	REV. 1	DATE	
Part No.	EW	14-16" MODEL B LATH	REV. 1	DATE	
Part No.	EW		REV. 1	DATE	

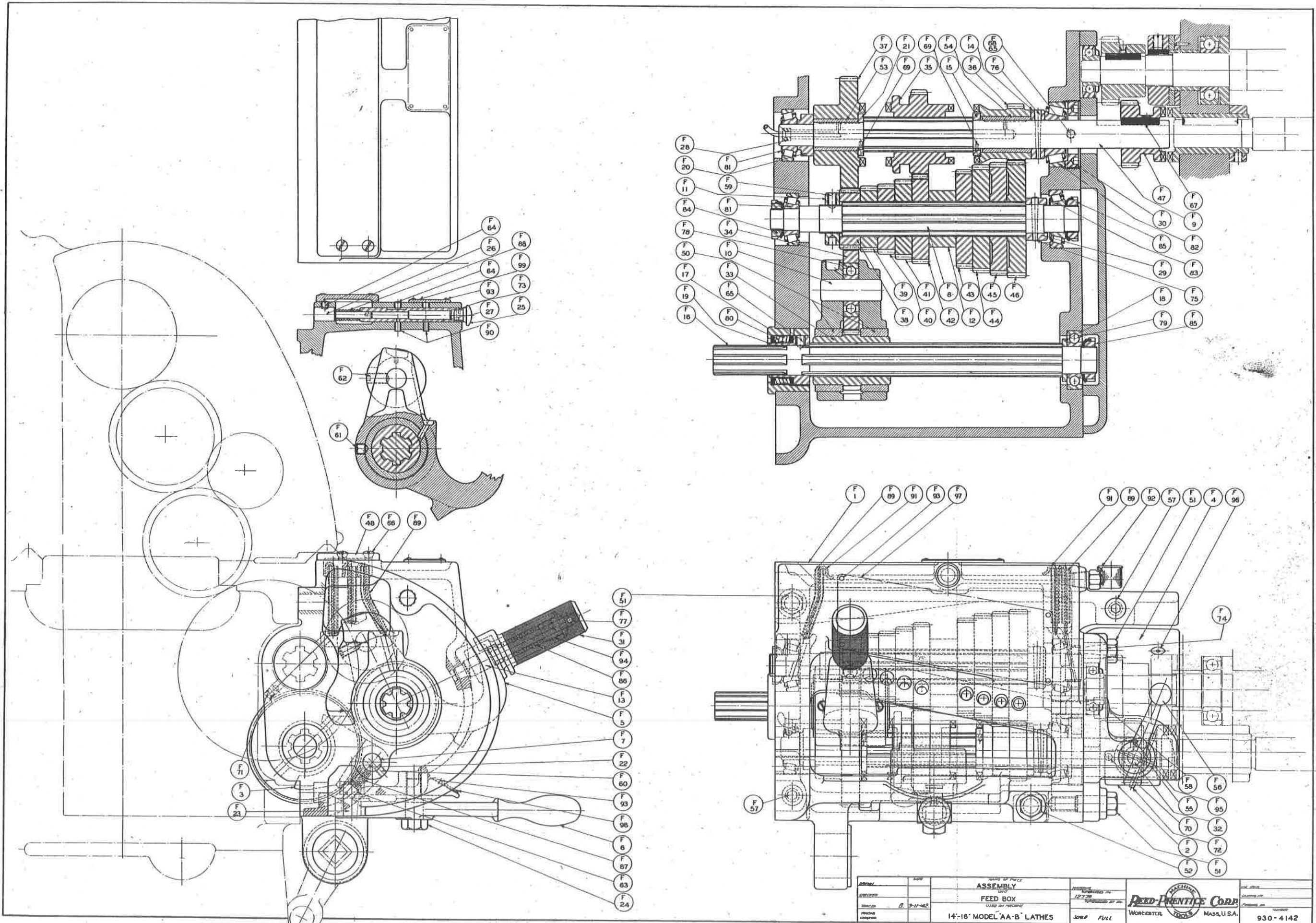


FEED BOX ASSEMBLY

Parts List

No.	Part	Quan.
F 1	Feed Box . . . . .	1
F 2	Feed Rod Clutch Shifter . . . . .	1
F 3	Sliding Clutch Shifter . . . . .	1
F 4	Feed Rod Clutch Housing . . . . .	1
F 5	Sliding Tumbler . . . . .	1
F 6	Sliding Clutch Lever . . . . .	1
F 7	Shifter Rod . . . . .	1
F 8	Cone Gear Shaft . . . . .	1
F 9	Clutch Gear Shaft . . . . .	1
F 10	Tumbler Idler Gear Shaft . . . . .	1
F 11	Cone Gear Nut . . . . .	1
F 12	Cone Gear Spacer . . . . .	1
F 13	Tumbler Plunger . . . . .	1
F 14	Clutch Gear Collar . . . . .	1
F 15	Clutch Gear Shaft Washer . . . . .	1
F 16	Tumbler Shaft . . . . .	1
F 17	Tumbler Shaft Bushing . . . . .	1
F 18	Tumbler Shaft Washer . . . . .	1
F 19	Tumbler Shaft Sleeve . . . . .	1
F 20	Clutch Gear Shaft Spacer . . . . .	1
F 21	Clutch Gear Shaft Washer . . . . .	1
F 22	Detent . . . . .	1
F 23	Sliding Clutch Lever Stud . . . . .	1
F 24	Sliding Clutch Lever Screw . . . . .	1
F 25	Oil Plunger Knob . . . . .	1
F 26	Oil Plunger Piston . . . . .	1
F 27	Oil Plunger . . . . .	1
F 28	Oil Retainer . . . . .	1
F 29	Cone Gear Shaft Collar . . . . .	1
F 30	Clutch Shaft Bearing Nut . . . . .	1
F 31	Pull Pin Handle . . . . .	1
F 32	Feed Rod Clutch Ecc. . . . .	1
F 33	Sliding Tumbler Pinion . . . . .	1
F 34	Sliding Tumbler Idler Gear . . . . .	1
F 35	Sliding Clutch Gear . . . . .	1
F 36	Small Clutch Gear . . . . .	1
F 37	Large Clutch Gear . . . . .	1
F 38	Cone Gear 24T . . . . .	1
F 39	Cone Gear 26T . . . . .	1
F 40	Cone Gear 28T . . . . .	1
F 41	Cone Gear 32T . . . . .	1
F 42	Cone Gear 36T . . . . .	1
F 43	Cone Gear 40T . . . . .	1
F 44	Cone Gear 44T . . . . .	1
F 45	Cone Gear 46T . . . . .	1
F 46	Cone Gear 48T . . . . .	1
F 47	Lead Screw Clutch . . . . .	1
F 48	Oil Reservoir Cover . . . . .	1
F 49	Sliding Gear (See 930-4141) . . . . .	1
F 50	Tumbler Pinion Bushing . . . . .	2
F 51	Body Fit Screw - Short . . . . .	3
F 52	Body Fit Screw - Long . . . . .	1
F 53	Large Clutch Gear Bushing . . . . .	1
F 54	Small Clutch Gear Bushing . . . . .	1
F 55	Fd. Rd. Cl. Lever Handle Pin . . . . .	1
F 56	Feed Rod Cl. Ecc. Lever . . . . .	1
F 57	1/2" x 1 1/4" Allen Fil. Hd. Scr. . . . .	2
F 58	3/8" x 1" Allen Fil. Hd. Scr. . . . .	1
F 59	5/16" x 1/2" Allen Hdls. Screw . . . . .	1
F 60	5/16" x 3/8" Allen Hdls. Screw . . . . .	1
F 61	3/8" x 5/16" Allen Hdls. Screw . . . . .	2
F 62	3/8" x 3/4" Allen Hdls. Screw . . . . .	1
F 63	5/8" x 1/2" Allen Hdls. Screw . . . . .	2
F 64	1/4" x 1/4" Allen Hdls. Screw . . . . .	1
F 65	5/16" x 3/8" Allen Hdls. Screw . . . . .	2
F 66	1/4" x 1/2" French Hd. Scr. . . . .	3
F 67	1/4" x 1/4" x 1-3/8" Tit Key . . . . .	1
F 68	7/32" D. x 1/8" Lg. Copper Plug . . . . .	1
F 69	1/8" x 1/4" C. R. Pin . . . . .	2
F 70	1/4" x 1-1/16" C. R. Pin . . . . .	1
F 71	1/4" x 1/4" C. R. Pin . . . . .	4
F 72	3/16" x 2-1/8" D. R. Pin . . . . .	1
F 73	#0 x 1/2" Taper Pin . . . . .	1
F 74	#6 x 1 1/2" Taper Pin . . . . .	2
F 75	#4 x 1 1/2" Taper Pin . . . . .	1
F 76	#4 x 1-3/4" Taper Pin . . . . .	1
F 77	#2 x 1 1/4" Taper Pin . . . . .	1
F 78	#204 Fafnir Brg. Single Row . . . . .	1
F 79	#205 Fafnir Brg. Single Row . . . . .	1
F 80	#94712 Hyatt Brg. . . . .	1
F 81	#05079-05185 Timken Brg. . . . .	2
F 82	#1986-1932 Timken Brg. . . . .	1
F 83	#07098-07204 Timken Brg. . . . .	1
F 84	#4 Fafnir Locknut & Washer . . . . .	1
F 85	#5 Fafnir Locknut & Washer . . . . .	2
F 86	Spring . . . . .	1
F 87	Spring . . . . .	1
F 88	Spring . . . . .	1
F 89	5/16" O.D. Brass Tube . . . . .	Various
F 90	3/16" O.D. Brass Tube . . . . .	Various
F 91	1/4" Gits Wicking . . . . .	Various
F 92	#1702 Gits Oil Gage . . . . .	1
F 93	#4 x 5/16" Parker Dr. Scrs. . . . .	10
F 94	Bushing - Pull Pin . . . . .	1
F 95	#302 Gits Oiler - Fd. Rod Cl. Housing . . . . .	1
F 96	#2C Bowen Oiler - Fd. Box & Fd.Box Cl. Hsg..	2
F 97	Feed Index Plate - Feed Box . . . . .	1
F 98	Sliding Gear Index Plate - Feed Box . . . . .	1
F 99	Oil Instruction Plate - Feed Box . . . . .	1





REV.	DATE	DESCRIPTION	BY	CHKD.
		ASSEMBLY		
		FEED BOX		
		USED ON MACHINE		
		14"-16" MODEL "AA-B" LATHES		
		SOLE FULL		

REED-PRENTICE CORP.  
WORCESTER, MASS., U.S.A.

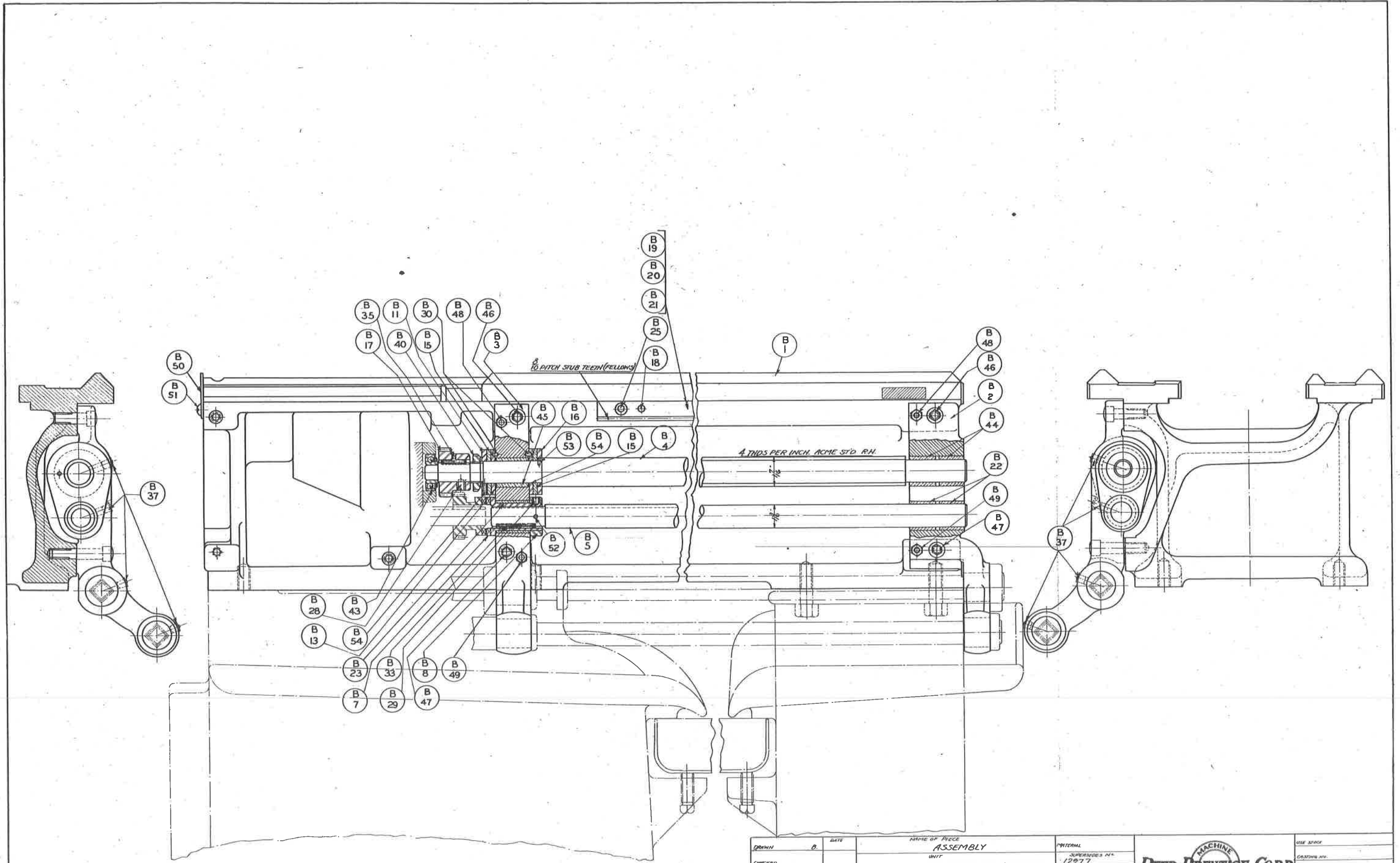
930-4142

BED

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>
B 1	Bed . . . . .	1
B 2	Lead Screw Bracket - Tail End . . . . .	1
B 3	Lead Screw Bracket - Head End . . . . .	1
B 4	Lead Screw . . . . .	1
B 5	Feed Rod . . . . .	1
B 7	Feed Rod Clutch . . . . .	1
B 8	Feed Rod Clutch Collar . . . . .	1
B 11	Lead Screw Thrust Washer . . . . .	1
B 13	Lead Screw Thrust Washer . . . . .	2
B 15	Lead Screw Thrust Washer . . . . .	2
B 16	Lead Screw Thrust Washer . . . . .	1
B 17	Lead Screw Gear . . . . .	1
B 18	Rack Pin . . . . .	*
B 19	Rack . . . . .	*
B 20	Rack . . . . .	*
B 21	Rack . . . . .	*
B 22	Feed Rod Bushing . . . . .	2
B 23	Feed Rod Clutch Bushing . . . . .	1
B 25	3/8" x 1 1/2" Allen Fil. Hd. Cap Screw - Rack . .	*
B 28	3/8" x 1/2" Allen Hdls. Set Screw Dog Pt. - Lead Screw Gear	1
B 29	3/8" x 3/8" Allen Hdls. Set Scr. Dog Pt. - Feed Rod Clutch Collar	1
B 30	1/8" x 3/8" C.R. Pin - Lead Screw Bracket . . .	2
B 33	1/4" x 1/4" x 2" Round End Key - Feed Rod . . . . .	1
B 35	1/4" x 1/4" x 1 1/4" Center Tit Key - Lead Screw Gear	1
B 37	#2 Bowen Oiler - Lead Screw Bracket . . . . .	8
B 40	#6 Fafnir Lock Nut & Washer - Lead Screw . . .	1
B 43	#204J Fafnir Ball Bearing - Lead Screw . . . . .	1
B 44	Lead Screw Bushing - Tail End . . . . .	1
B 45	Lead Screw Bushing - Head End . . . . .	1
B 46	1/2" x 1 1/4" Allen Fil.Hd.Cap Scr. - Lead Scr.Brkts.	2
B 47	3/8" x 2" Allen Fil.Hd.Cap Scr. - Lead Scr.Brkts.	2
B 48	#7 x 1 1/2" Threaded Taper Pin with Nut- Lead Scr. Brackets	2
B 49	#7 x 2 1/4" Threaded Taper Pin with Nut- Lead Scr. Brackets	2
B 50	Bed Cover Plate . . . . .	1
B 51	#10-24 x 1/4" Button Head Screw - Bed Cover Plate	2
B 52	#4 x 2" Taper Pin - Feed Rod Clutch Collar . .	1
B 53	3/16" x 3/8" C. R. Pin - Lead Screw . . . . .	1
B 54	5/32" x 11/16" C. R. Pin - Lead Scr.Thr.Washer	1

\* Quantity varies. Give bed length when ordering.



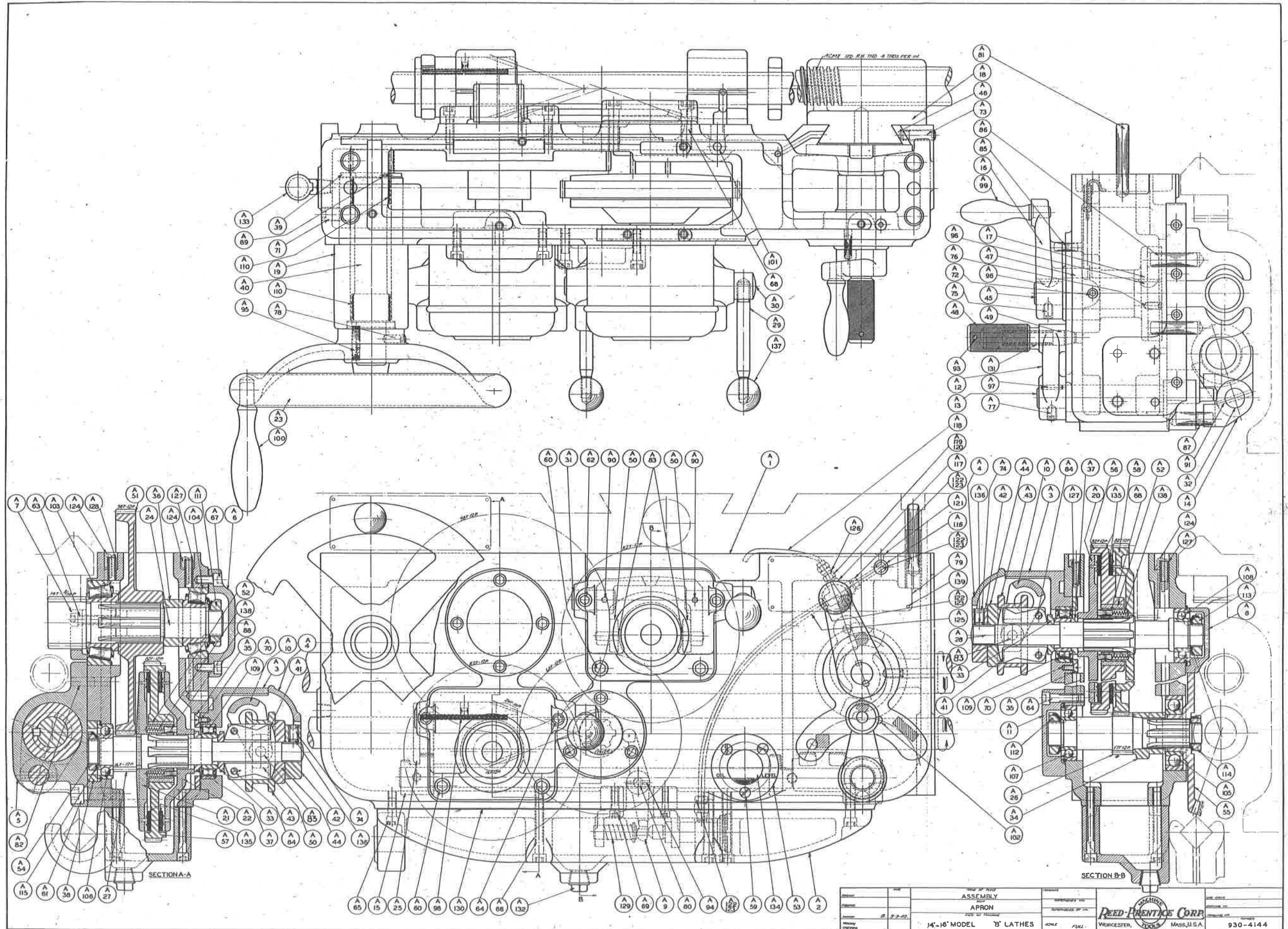
DRAWN CHECKED FINISHED MACHINE CHECKED	B.  B.	DATE  8-15-35	NAME OF PIECE <b>ASSEMBLY</b> UNIT <b>BED-LEAD SCR. REVERSE</b> USED ON MACHINE <b>14-16" MODEL B SLID. GR. HD. LATHE.</b>	MATERIAL SUPERSEDES NO. 12977 SUPERSEDED BY NO.		USE SPEC. DRAWING NO. PART NO. NUMBER <b>930-4143A</b>
--	--------------	---------------------	---	--	--	--



930-4144  
APRON ASSEMBLY

Parts List

No.	Part	Quan.	No.	Part	Quan.	No.	Part	Quan.
A 1	Apron . . . . .	1	A 51	Rack Pinion Gear . . . . .	1	A 94	#0 x 1" Taper Pin - Pump Lever . . . . .	1
A 2	Oil Pan . . . . .	1	A 52	Gear Bushing . . . . .	2	A 95	5/16" x 5/16" x 1 1/4" Rd. End Key - Handwheel Pinion . . . . .	1
A 3	Hand Lever Bracket . . . . .	2	A 53	Oil Window Frame . . . . .	1	A 96	#606 Woodruff Key - Open & Shut Nut Shaft . . . . .	2
A 4	Hand Lever Bracket Cover . . . . .	2	A 54	Fafnir Lock Nut . . . . .	1	A 97	3/16" x 3/16" x 7/8" Rd. End Key - Rev.Cr.Sh. . . . .	1
A 5	Feed Rod Bracket. . . . .	2	A 55	Bevel Gear . . . . .	1	A 98	1/4" x 1/4" x 3 1/4" Tit Key - Bevel Pinion . . . . .	1
A 6	Rack Pinion Brg. Cap - outer . . . . .	1	A 56	Cross Feed Clutch Gear - plain . . . . .	1	A 99	Mod. #823 Cinn. Handle - O. & S. Nut Cam Lever . . . . .	1
A 7	Rack Pinion Brg. Cap - inner . . . . .	1	A 57	Long. Feed Clutch Gear . . . . .	1	A 100	Mod. #837 Cinn. Handle - Handwheel . . . . .	1
A 8	Cr. Fd. Cl. Sh. Brg.Retainer . . . . .	1	A 58	Cross Feed Clutch Gear - splined . . . . .	1	A 101	5/16" x 1/2" C.R. Pin - Apron . . . . .	1
A 9	Pump Lever . . . . .	1	A 59	Oil Window Screws - 1/4" x 1/2" French Hd. . . . .	3	A 102	1/4" x 5/8" C. R. Pin - Apron . . . . .	1
A 10	Clutch Yoke . . . . .	2	A 60	7/16" x 3/4" Allen Fil. Scr. Hand Lev.Bracket . . . . .	8	A 103	3490-3420 Timken Brg. - Rack Pinion Shaft . . . . .	1
A 11	Bevel Gear Shaft Cap . . . . .	1	A 61	1/2" x 1" " " " Feed Rod Bracket . . . . .	4	A 104	2689-2631 Timken Brg. - Rack Pinion Shaft . . . . .	1
A 12	Reverse Lever . . . . .	1	A 62	5/16" x 1" " " " Hand Lev.Br.Cov. . . . .	4	A 105	#207K Fafnir Ball Brg. - Bevel Gear Shaft . . . . .	1
A 13	Reverse Crank & Shaft . . . . .	1	A 63	5/16" x 3/4" " " " Rack Pinion Brg. Cap - inner . . . . .	4	A 106	#205G Fafnir Ball Brg. - Long. Fd. Cl. Shaft. . . . .	1
A 14	Bevel Pinion Shifter R. H. . . . .	1	A 64	5/16" x 1" " " " Bev.Gr.Shaft Cap . . . . .	3	A 107	#205G Fafnir Ball Brg. - Bevel Gear Shaft . . . . .	1
A 15	Bevel Pinion Shifter L. H. . . . .	1	A 65	5/16" x 1" " " " Oil Pan . . . . .	2	A 108	#205G Fafnir Ball Brg. - Cr. Fd. Cl. Shaft . . . . .	1
A 16	Open & Shut Nut Cam Lever . . . . .	1	A 66	5/16" x 2 1/4" " " " Oil Pan . . . . .	4	A 109	#A-1205TS Hyatt Roller Brg. - Fd. Cl. Shaft . . . . .	2
A 17	Open & Shut Nut Cam . . . . .	1	A 67	5/16" x 3/4" " " " Rack Pinion Brg. Cap - outer . . . . .	4	A 110	#B-2016 Torrington Needle Brg. - Handwheel . . . . .	2
A 18	Open & Shut Nut . . . . .	1	A 68	3/8" x 7/8" " " " Cr. Fd. Cl. Sh. Brg. Retainer . . . . .	2	A 111	#5 Fafnir Locknut & Washer - Rack Pin. Shaft. . . . .	1
A 19	Handwheel Bushing . . . . .	1	A 69	1/4" x 5/8" " " " Oil Pump . . . . .	2	A 112	#5 Fafnir Locknut & Washer - Bevel Gr. Shaft. . . . .	1
A 20	Cross Feed Clutch Disc. . . . .	1	A 70	#10-24 x 1/2" Flat Hd. Cap Scr. Feed Sh. Brg. Retainer . . . . .	6	A 113	#5 Fafnir Locknut & Washer - Cr. Fd. Cl. Sh. . . . .	1
A 21	Long. Feed Clutch Disc - inner . . . . .	1	A 71	1/2" x 3/4" Allen Hdls. Scr. Handwheel Bshg.. . . .	1	A 114	#4 Fafnir Locknut & Washer - Bevel Gr. Shaft. . . . .	1
A 22	Long. Feed Clutch Disc - outer . . . . .	1	A 72	5/16" x 5/8" " " " Camshaft Bushing . . . . .	1	A 115	#5 Fafnir Lock Washer - Long. Fd. Cl. Shaft . . . . .	1
A 23	Hand Wheel. . . . .	1	A 73	3/8" x 1 1/2" " " " Gib . . . . .	4	A 116	Special Fitting Oil Pump Pipe to Apron - Bijur #B-3481 . . . . .	1
A 24	Rack Pinion . . . . .	1	A 74	3/8" x 1 1/2" " " " Clutch Adj. Nut. . . . .	2	A 117	3-Way Junction - JHQ B-3065 . . . . .	1
A 25	Bevel Pinion . . . . .	1	A 75	5/16" x 1/2" " " " Open & Shut Nut Cam Lever . . . . .	1	A 118	3/32" x .016" Wall x 19-1/2" Copper Tubing . . . . .	1
A 26	Bevel Gear Shaft . . . . .	1	A 76	1/4" x 1/2" " " " Open & Shut Nut Cam . . . . .	1	A 119	3/32" Compression Nut - B-3312 . . . . .	1
A 27	Long. Feed Clutch Shaft . . . . .	1	A 77	5/16" x 1/2" " " " Reverse Lever . . . . .	1	A 120	3/32" Compression Sleeve - B-3313 . . . . .	1
A 28	Cross Feed Clutch Shaft . . . . .	1	A 78	3/8" x 3/4" " " " Handwheel . . . . .	1	A 121	Cork Washer - Apron - Bijur #A-4115 . . . . .	1
A 29	Clutch Lever . . . . .	2	A 79	Caution Plate - Apron . . . . .	1	A 122	5/32" Compression Bushing Oil Tubing - Bijur #B-1371 . . . . .	4
A 30	Clutch Lever Shaft. . . . .	2	A 80	3/8" x 1-1/2" C.R. Pin - Pump Lever . . . . .	1	A 123	5/32" Compression Sleeve Oil Tubing - Bijur #B-1061 . . . . .	4
A 31	Yoke Shaft . . . . .	2	A 81	7/16" x 2-1/2" C.R. Pin - Apron to Carriage . . . . .	2	A 124	1/4" x 3' Bowen Wicking Apron . . . . .	1
A 32	Bevel Pinion Shifter Rod. . . . .	1	A 82	5/16" x 7/8" C.R. Pin - Feed Rod Brackets . . . . .	4	A 125	5/32" x .025" Wall x 15" Lg. Copper Tubing Oil Pump . . . . .	1
A 33	Toggle Abutment . . . . .	2	A 83	3/8" x 13/16" D.R. Pin - Clutch Yoke . . . . .	4	A 126	Drip Plug - MJC #5 - #B-3370 . . . . .	1
A 34	Pump Cam . . . . .	1	A 84	1/4" x 1" D.R. Pin - Toggle Carrier . . . . .	4	A 127	5/16" x 1" Brass Oil Tube - Apron . . . . .	6
A 35	Feed Shaft Brg.Retainer . . . . .	2	A 85	5/16" x 7/8" D.R. Pin - Apron . . . . .	1	A 128	5/16" x 7/8" Brass Oil Tube - Apron . . . . .	1
A 36	Spacer . . . . .	1	A 86	1/2" x 1-3/4" D.R. Pin - Open & Shut Nut . . . . .	2	A 129	Bijur Lubricator Pump - Symbol "GHD" - C1814. . . . .	1
A 37	Spacer . . . . .	2	A 87	1/2" x 1-3/8" D.R. Pin - Rev. Crank Shaft . . . . .	1	A 130	Gasket - Oil Pan - Vellumoid #12940-C . . . . .	1
A 38	Spacer . . . . .	1	A 88	1/4" x 1/2" C.R. Pin - Feed Clutch . . . . .	12	A 131	Spring - Reverse Lever Lock Pin - V-330-22-2. . . . .	1
A 39	Handwheel Pinion Washer . . . . .	1	A 89	1/8" x 3/16" C.R. Pin - Handwheel Pinion . . . . .	1	A 132	1/2" Std. Pipe Plug - Oil Pan . . . . .	1
A 40	Handwheel Pinion . . . . .	1	A 90	#2 x 1-1/2" Taper Pin - Clutch Yoke . . . . .	4	A 133	Gits Oil Cup - Apron - #618 "KV" . . . . .	1
A 41	Toggle . . . . .	4	A 91	#4 x 1-1/2" Taper Pin - Bevel Pinion Shifter R. H. . . . .	1	A 134	Oil Window - Apron - 1506-A . . . . .	1
A 42	Clutch Adjusting Nut . . . . .	2	A 92	#4 x 1-1/2" Taper Pin - Bev.Pin.Sh. L.H. . . . .	1	A 135	Clutch Liners - Feed Clutch - 12963-A . . . . .	4
A 43	Clutch Shifter Spool . . . . .	2	A 93	#0 x 1" Taper Pin - Reverse Lever Handle . . . . .	1	A 136	9/32" dia. x 1/8" Copper Plug - Cl. Adj. Nut. . . . .	2
A 44	Toggle Carrier . . . . .	2				A 137	Clutch Lever Ball - 12891-A . . . . .	2
A 45	Open & Shut Nut Cam Shaft . . . . .	1				A 138	Spring - Clutch - 14513-A . . . . .	12
A 46	Gib . . . . .	1				A 139	#4 x 5/16" Parker Drive Scrs. - Caution Plate . . . . .	4
A 47	Open & Shut Nut Cam Shaft Bushing . . . . .	1						
A 48	Reverse Lever Handle . . . . .	1						
A 49	Reverse Lever Lock Pin . . . . .	1						
A 50	Clutch Shifter Shoe . . . . .	4						



TITLE <b>ASSEMBLY</b> <b>APRON</b> PART OF DRAWING NO.	DRAWN BY J. S. S.	CHECKED BY J. S. S.	APPROVED BY J. S. S.	DATE 1-1-44	REED-PRENTICE CORP. WORCESTER, MASS., U.S.A.	930-4144
14"-16" MODEL 'B' LATHES		WORK FULL		930-4144		



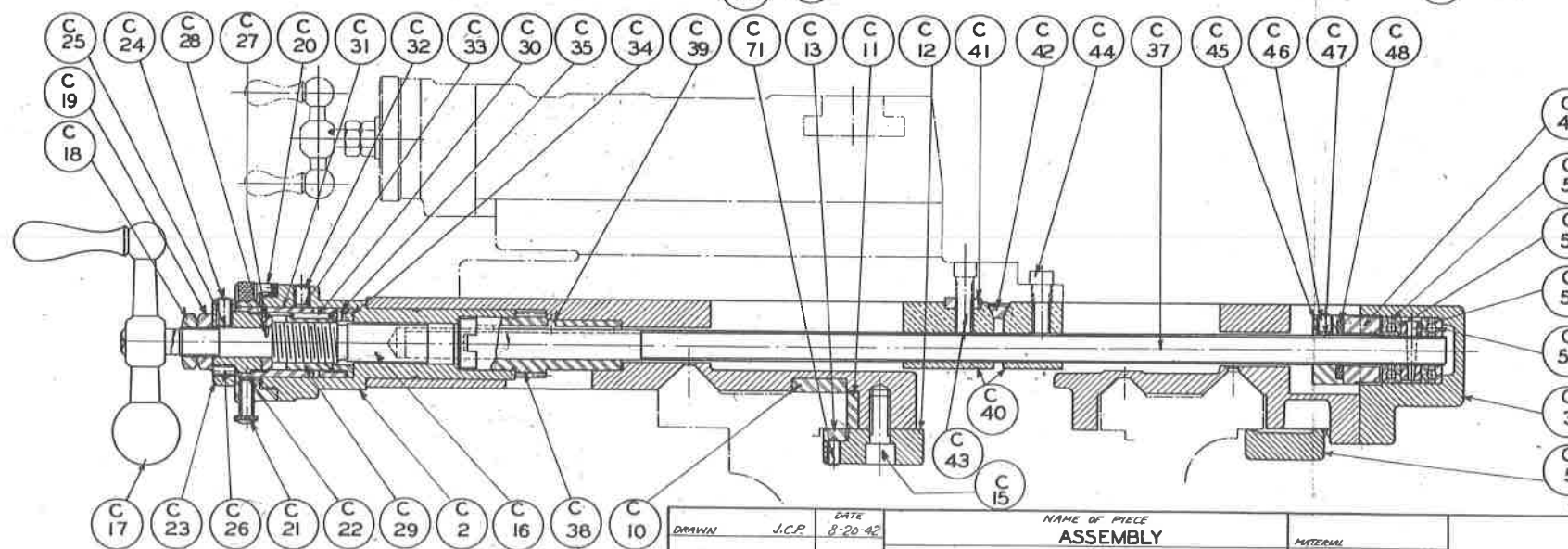
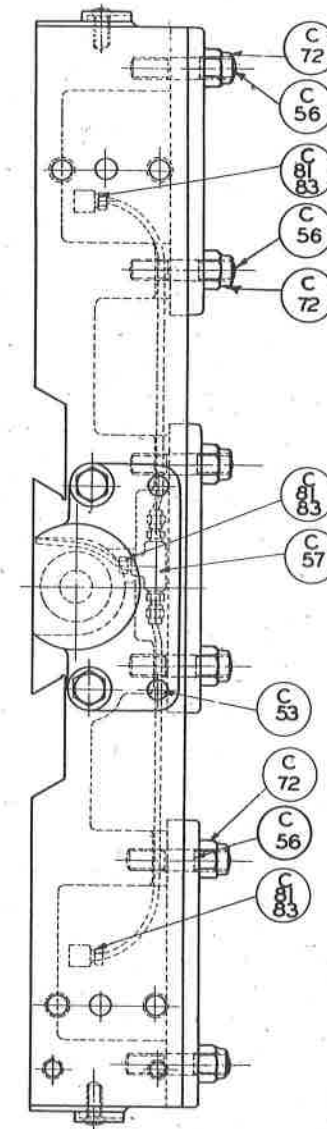
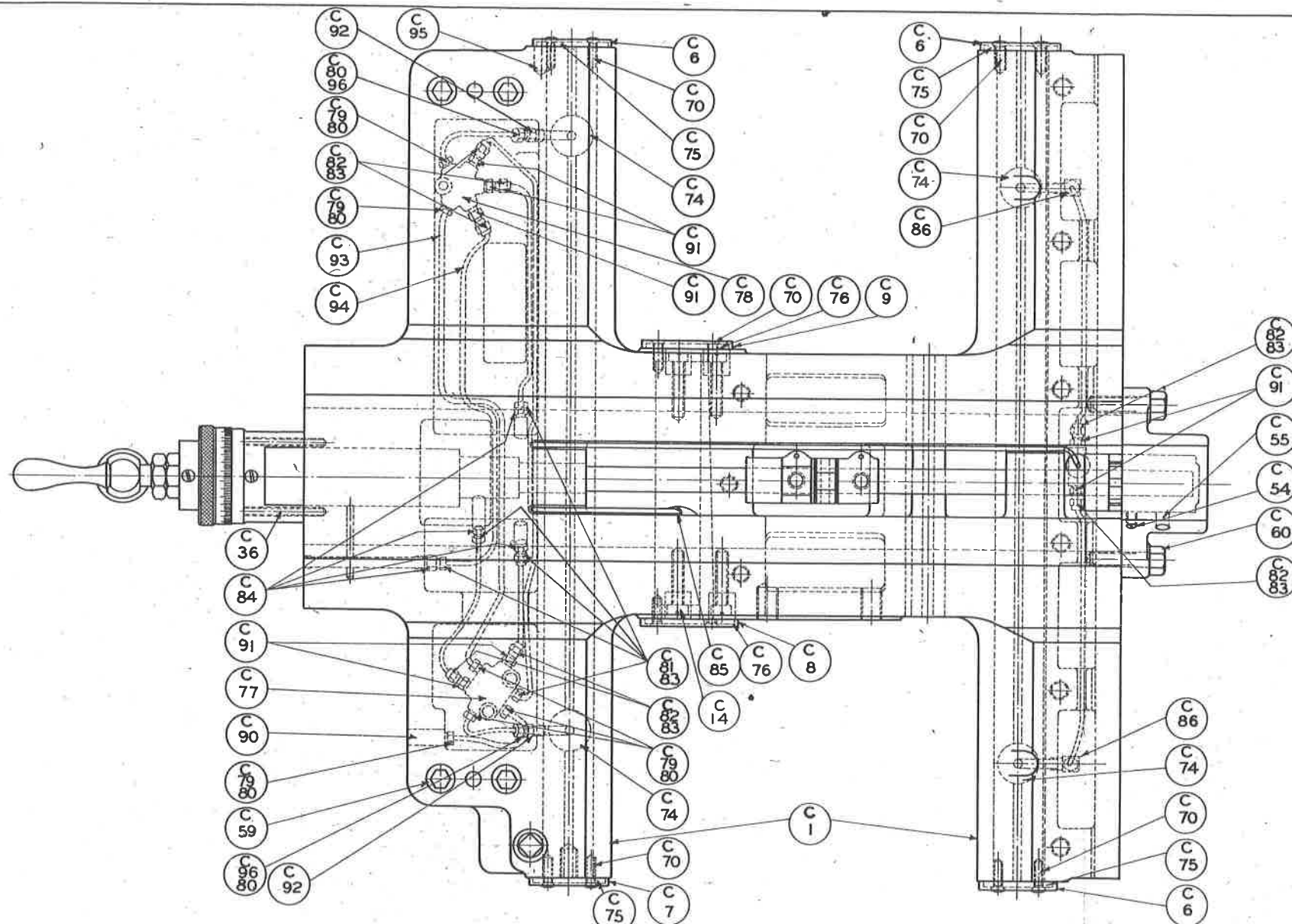
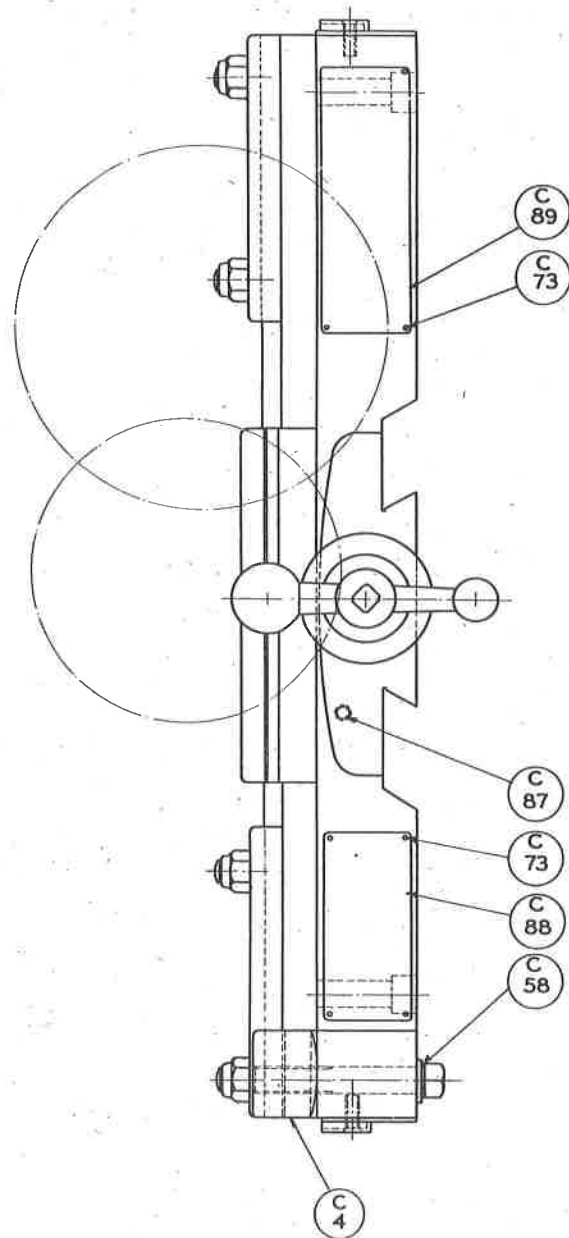
Drawing #930-4145

CARRIAGE ASSEMBLY

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>		<u>No.</u>	<u>Part</u>	<u>Quan.</u>
C 1	Carriage . . . . .	1		C 44	7/16" x 1" Allen Fil.Hd.Scr.Compensating Nut . . . . .	1
C 2	Cross Feed Screw Bushing . . . . .	1		C 45	Cross Feed Screw Dirt Shield . . . . .	1
C 3	Cross Feed Screw Thrust Bracket . . . . .	1		C 46	3/8" x 3/8" Allen Hdls.Scr., Dirt Shield . . . . .	1
C 4	Carriage Clamp . . . . .	1		C 47	9/32" x 1/8" Copper Plug, Dirt Shield . . . . .	1
C 5	Carriage Gib, Rear . . . . .	3		C 48	1 1/2" O.D. 3/4" I.D. x 3/16" Felt,Dirt Shield . . . . .	1
C 6	Carriage Wiper Plate . . . . .	3		C 49	Cr.Fd.Screw Thrust Bearing Nut . . . . .	1
C 7	Carriage Wiper Plate . . . . .	1		C 50	#N-1804 Fafnir Bearings, Cross Feed Screw . . . . .	2
C 8	Bed Flat Wiper Plate - Right . . . . .	1		C 51	Cross Feed Screw Thrust Bearing Seat Nut . . . . .	1
C 9	Bed Flat Wiper Plate - Left . . . . .	1		C 52	#2 x 1 1/2" Taper Pin, Cross Feed Screw . . . . .	1
C 10	Flat Bearing Gib . . . . .	1		C 53	7/16" x 1 1/4" C.R.Pin Cr.Fd.Scr.Thrust Bracket . . . . .	2
C 11	Flat Bearing Gib, Vertical . . . . .	1		C 54	3/8" x 3/8" Allen Hdls.Scr.Cr.Fd.Scr.Thr.Brkt. . . . .	1
C 12	Front Carriage Gib . . . . .	1		C 55	#3 Bowen Oiler Thrust Bracket . . . . .	1
C 13	Front Carriage Gib Plate . . . . .	1		C 56	Carriage Gib Stud . . . . .	6
C 14	Gib Adjusting Screw . . . . .	4		C 57	Bijur 3-way Junction . . . . .	1
C 15	1/2" x 1 1/4" Allen Fil.Hd.Scr.Front Carriage Gib . . . . .	3		C 58	Clamp Screw . . . . .	1
C 16	Cross Feed Screw Pinion Shaft . . . . .	1		C 59	Apron to Carriage,Screw . . . . .	4
C 17	Mod.#727 Cinn.Ball Crank, Cross Feed Screw . . . . .	1		C 60	1/2" x 1 1/2" Hex Hd.Screw Thrust Bracket . . . . .	2
C 18	3/4"-16 SAE Dble.Chamfer Check Nut,Fd.Scr.Shaft . . . . .	1		C 70	1/4"-20 x 1/2" French Hd.Scr.Wiper Plates . . . . .	12
C 19	3/4"-16 SAE Single " " " " " " . . . . .	1		C 71	5/16" Allen Hdls.Scr.Front Carriage Gib . . . . .	4
C 20	Cross Feed Screw Dial . . . . .	1		C 72	1/2" Hex Jam Nuts, Hardened . . . . .	12
C 21	Cross Feed Screw Dial Thumb Screw . . . . .	1		C 73	#4 x 5/16" Parker Drive Screws . . . . .	8
C 22	7/32" x 3/32" Copper Plug Cr.Fd.Screw Dial . . . . .	1		C 74	Bed "v" Oil Felt (round) . . . . .	4
C 23	Pinion Shaft Sleeve . . . . .	1		C 75	Bed "v" Wiper . . . . .	4
C 24	3/8" x 5/8" Hdls.Set Scr,Pinion Shaft Sleeve . . . . .	1		C 76	Bed Flat Wiper . . . . .	2
C 25	9/32" x 1/16" Copper Plug, Pinion Shaft Sleeve . . . . .	1		C 77	Junction, 6-way Double . . . . .	1
C 26	1/4" x 1/2" Allen Hdls. Screw Stop Bushing . . . . .	1		C 78	Junction, 5-way . . . . .	1
C 27	Stop Plate . . . . .	1		C 79	5/32" Compression Bushing . . . . .	6
C 28	1/8" x 1/4" C.R.Pin,Cr.Fd.Scr.Pinion Shaft . . . . .	1		C 80	5/32" Compression Sleeve . . . . .	8
C 29	Stop . . . . .	1		C 81	3/32" Compression Bushing . . . . .	7
C 30	1/8" x 1/8" x 1" Rd. End Key, Stop . . . . .	1		C 82	3/32" Compression Nut . . . . .	8
C 31	Stop Bushing . . . . .	1		C 83	3/32" Compression Sleeve . . . . .	15
C 32	3/8" x 1/2" Hdls. Set Scr., Cr.Fd.Scr.Bushing . . . . .	1		C 84	3/32" Straight Adapter . . . . .	4
C 33	9/32" x 1/16" Copper Plug, Cr.Fd.Scr.Bushing . . . . .	1		C 85	3/32" Drive Bushing . . . . .	1
C 34	Stop Bushing Plug . . . . .	1		C 86	3/32" Elbow Adapter . . . . .	2
C 35	1/8" x 1/2" C.R. Pin Stop Bushing . . . . .	1		C 87	1/8" Std. Pipe Plug, Carriage . . . . .	1
C 36	1/4" x 2 1/4" Allen Fil.Hd.Scr.Cross Feed Scr.Bush. . . . .	2		C 88	Thread Indicator Instruction Plate . . . . .	1
C 37	Cross Feed Screw . . . . .	1		C 89	Apron Oil Plate . . . . .	1
C 38	Cross Feed Screw Pinion . . . . .	1		C 90	Special Bijur Fitting . . . . .	1
C 39	3/16" x 3/16" x 3" Tit Key,Cr.Fd.Scr.Pinion . . . . .	1		C 91	Drip Plug M.J.C.-00-B3364 . . . . .	7
C 40	Cr.Fd.Scr. Compensating Nut . . . . .	1		C 92	Drip Plug M.J.A.-00-B2629 . . . . .	2
C 41	Compensating Nut Dowel . . . . .	1		C 93	3/32" Tubing . . . . .	Various
C 42	Compensating Nut Wedge . . . . .	1		C 94	5/32" Tubing . . . . .	Various
C 43	7/16" x 1 1/4" Allen Fil.Hd.Scr.Compensating Nut . . . . .	1		C 95	Stop Screw Plug . . . . .	1
				C 96	5/32" Compression Nut . . . . .	2



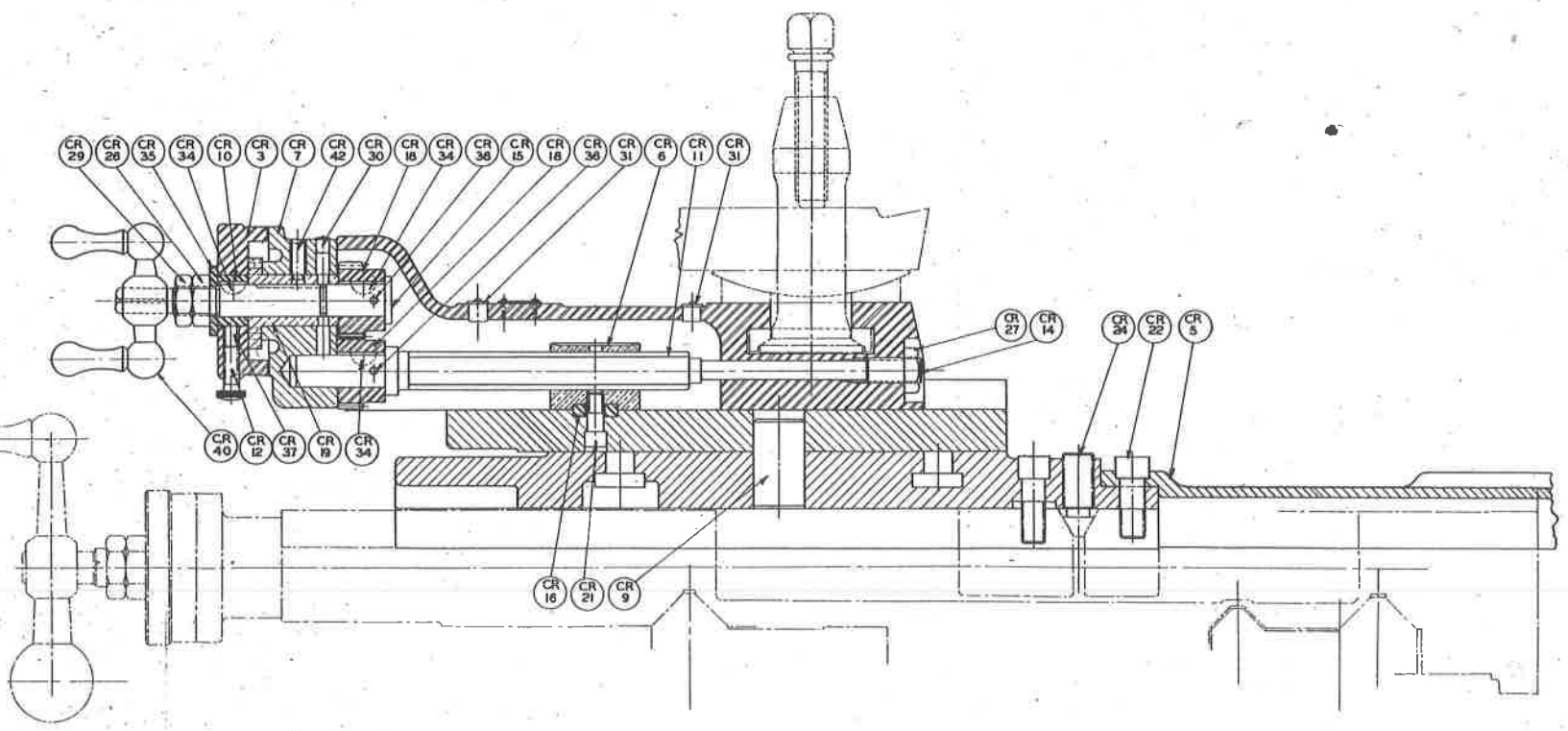
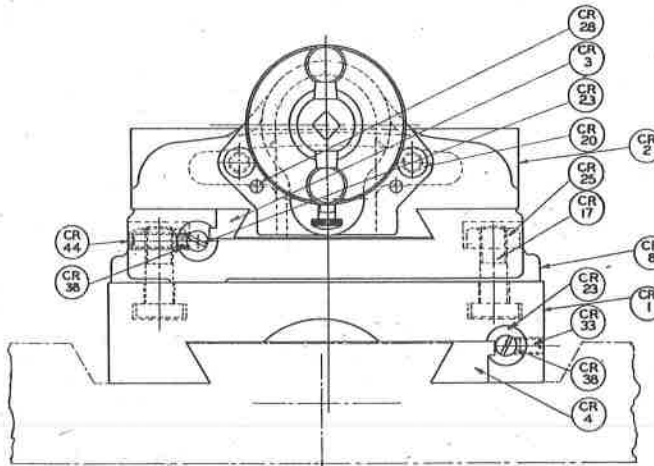
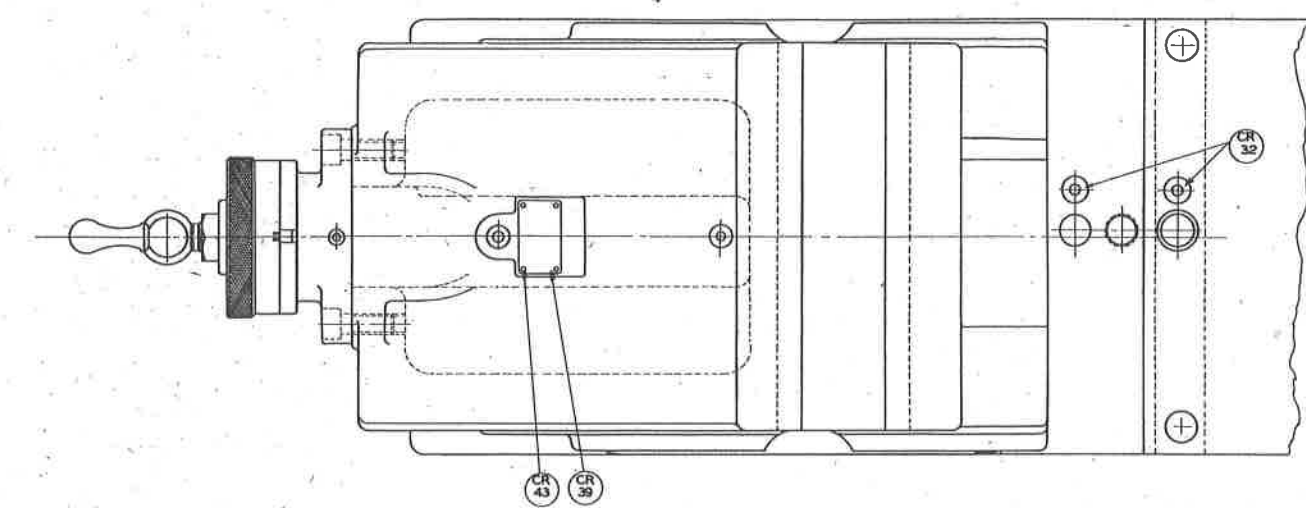


DRAWN CHECKED TRACED TYPING CHECKED	J.C.P. B. B.	DATE 8-20-42 8-22-42	NAME OF PIECE <b>ASSEMBLY</b> UNIT <b>CARRIAGE</b> USED ON MACHINE <b>14"-16" MODEL "AA"-B LATHES</b>	MATERIAL SUPERSEDES NO. SUPERSEDED BY NO. SCALE $\frac{1}{2}$ SIZE	WORCESTER, MASS., U.S.A.	BSK. STOKR. CASTING NO. FORGING NO. NUMBER <b>930 - 4145</b>
---	--------------------	----------------------------	--	---	--------------------------	--

COMPOUND REST ASSEMBLY

Parts List

No.	Part	Quan.
CR 1	Bottom Slide . . . . .	1
CR 2	Top Slide . . . . .	1
CR 3	Top Slide Gib . . . . .	1
CR 4	Bottom Slide Gib . . . . .	1
CR 5	Chip Guard . . . . .	1
CR 6	Top Slide Screw Nut . . . . .	1
CR 7	Top Slide Gear Stud Bushing . . . . .	1
CR 8	Swivel Slide . . . . .	1
CR 9	Swivel Slide Stud . . . . .	1
CR 10	Top Slide Dial Bushing . . . . .	1
CR 11	Top Slide Screw . . . . .	1
CR 12	Top Slide Dial Thumb Screw . . . . .	1
CR 13	Top Slide Dial . . . . .	1
CR 14	Top Slide Thrust Screw . . . . .	1
CR 15	Top Slide Gear Stud . . . . .	1
CR 16	Top Slide Nut Dowel . . . . .	1
CR 17	Swivel Bolt . . . . .	2
CR 18	Top Slide Gear . . . . .	2
CR 19	Top Slide Gear Stud . . . . .	1
CR 20	3/8"-16 x 1" Allen Socket Hd. Cap Scr. Top Slide Gear Stud Bushing . . . . .	2
CR 21	5/16"-18 x 3/4" Allen Socket Hd. Cap Scr. Top Slide Screw Nut . . . . .	1
CR 22	3/8" Spec. Fil. Hd. Scr. Chip Guard . . . . .	2
CR 23	5/16" Spec. Gib Scr. Bottom Slide & Swivel Slide . . . . .	2
CR 24	5/8"-11 x 1" Allen Hdls. Scr. Bottom Slide . . . . .	1
CR 25	1/2"-20 Spec. SAE Nut Swivel Bolt . . . . .	2
CR 26	9/16"-18 SAE Single Chamfer Check Nut Top Slide Gear Stud . . . . .	1
CR 27	1/2"-20 SAE Check Nut Top Slide Thrust Screw . . . . .	1
CR 28	#2 x 1" Taper Pin Top Slide Gear Stud Bushing . . . . .	2
CR 29	9/16"-18 SAE Dbl. Chamfer Check Nut Top Slide Gear Stud . . . . .	1
CR 30	#0 Bowen Oiler Top Slide Gear Stud Bushing . . . . .	1
CR 31	#2 Bowen Oiler Top Slide . . . . .	2
CR 32	#3 Bowen Oiler Bottom Slide and Chip Guard . . . . .	2
CR 33	5/16" x 1/2" Allen Hdls. Set Scr. Bottom Slide . . . . .	1
CR 34	#3 Woodruff Key Top Slide Screw and Gear Stud . . . . .	3
CR 35	Washer Top Slide Screw . . . . .	1
CR 36	#2 x 1-1/8" Taper Pin Top Slide Gear . . . . .	2
CR 37	1/4" Dia. x 3/8" Lg. Copper Plug Top Slide Dial . . . . .	1
CR 38	7/32" x 1/4" Copper Plug Bottom Slide . . . . .	2
CR 39	#2 x 1/4" Parker Drive Scr. Top Slide Oil Plate . . . . .	4
CR 40	Mod. 766 Cinn. Compound Rest Handle . . . . .	1
CR 41	J. H. Williams Finished Wrench #605 . . . . .	1
CR 42	5/16"-18 x 3/4" Allen Hdls. Scr. Stud Bushing . . . . .	1
CR 43	Top Slide Oil Plate . . . . .	1
CR 44	5/16"-18 x 7/8" Allen Hdls. Scr. & Swivel Slide . . . . .	1



DATE	REV.	NAME OF PREP	GENERAL	DATE
		ASSEMBLY		
		USER	SUPERVISOR NO.	
		COMPOUND REST	SUPERVISOR BY	
		USED ON MACHINE	SCALE	
		AA	FULL	
		M-16 MODEL B LATHE		



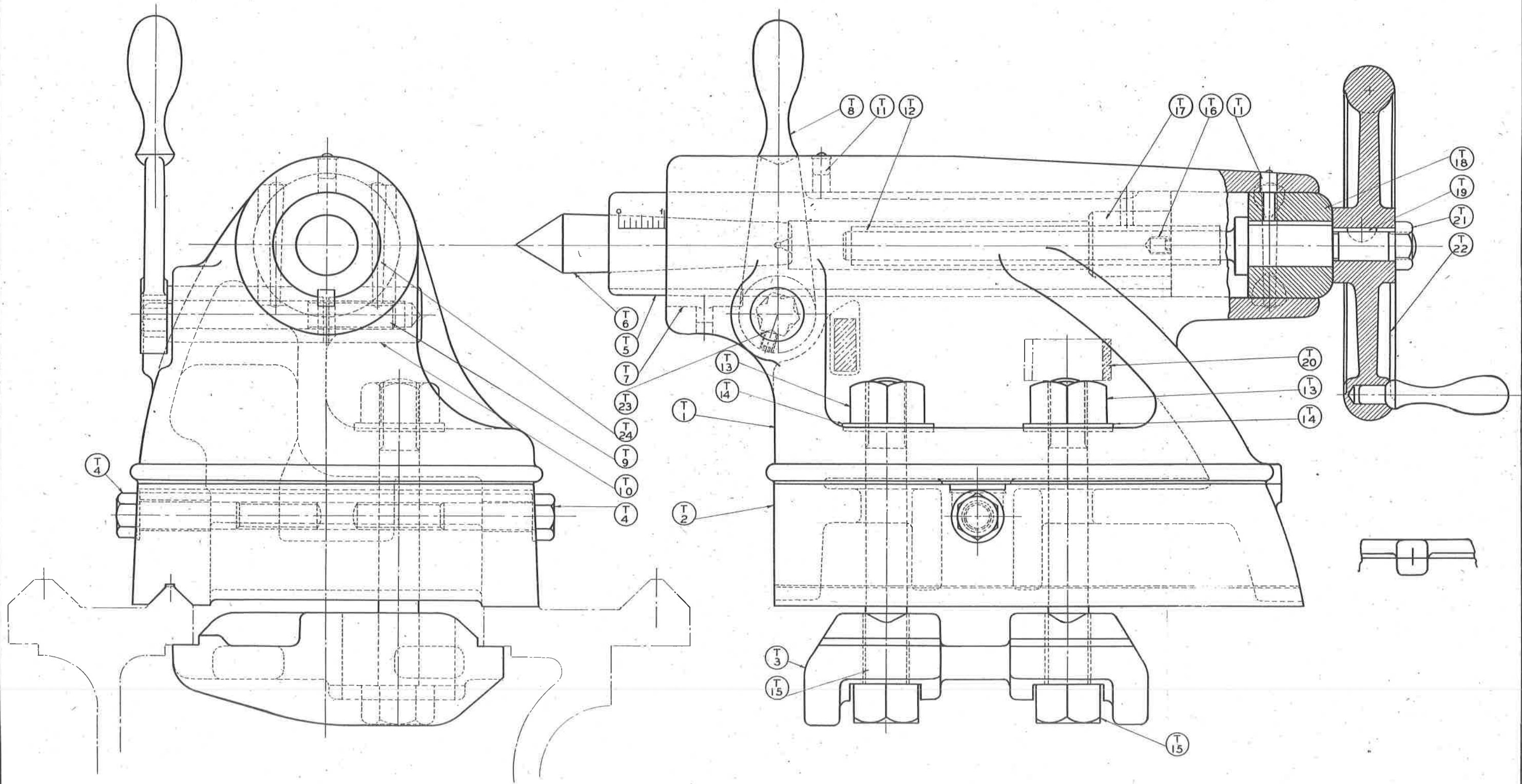


Drawing #930-4147

TAILSTOCK ASSEMBLY

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>
T 1	Tailstock Top . . . . .	1
T 2	Tailstock Base . . . . .	1
T 3	Clamp . . . . .	1
T 4	5/8" - 11 x 4" Set Over Screw . . . . .	2
T 5	Spindle (English) . . . . .	1
T 6	Std. #4 Morse Taper Center . . . . .	1
T 7	3/8" x 3/8" x 1-3/4" Tit Key . . . . .	1
T 8	Binder Handle . . . . .	1
T 9	Binder Screw . . . . .	1
T 10	Binder (in 2 pieces) . . . . .	1
T 11	3/8" Bowen Oilers . . . . .	2
T 12	Screw . . . . .	1
T 13	7/8" Std. Hex. Nut . . . . .	2
T 14	Clamp Stud Washer . . . . .	2
T 15	7/8" x 8" Std. Coupling Bolt Hex. Head . . . . .	2
T 16	3/8" x 1/2" Allen Hdls. Set Screw . . . . .	2
T 17	Spindle Nut . . . . .	1
T 18	End Bushing . . . . .	1
T 19	#9 Woodruff Key . . . . .	1
T 20	Box Type Wrench . . . . .	1
T 21	5/8"-18 SAE Jamb Nut . . . . .	1
T 22	Handwheel & Handle . . . . .	1
T 23	5/16" x 1/2" Allen Cone Pt. Screw . . . . .	1
T 24	#6 x 2-3/4" Taper Pin . . . . .	2



DESIGN	DATE	NAME OF PIECE TAILSTOCK ASSEMBLY	MATERIAL	USE STOCK
CHECKED		UNIT TAILSTOCK	SUPersedes NO.	CASTING NO.
TRACED	J C 8-31-42	USED ON MACHINE 14-16 MODEL 'AA-B' LATHE	SUPerseded BY NO.	FORGING NO.
TRACING CHECKED			SCALE FULL	NUMBER 930-4147



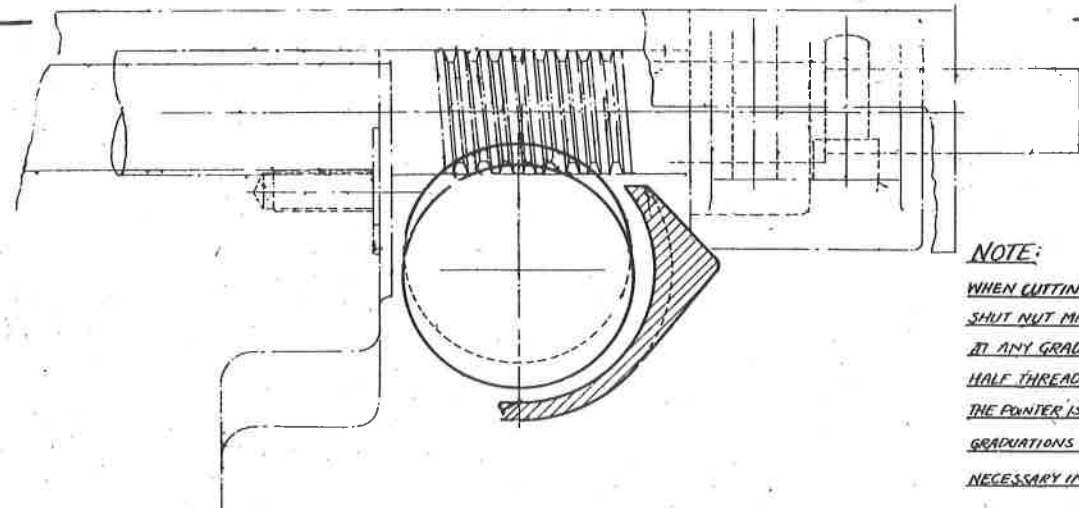
Drawing #930-4167

THREAD INDICATOR

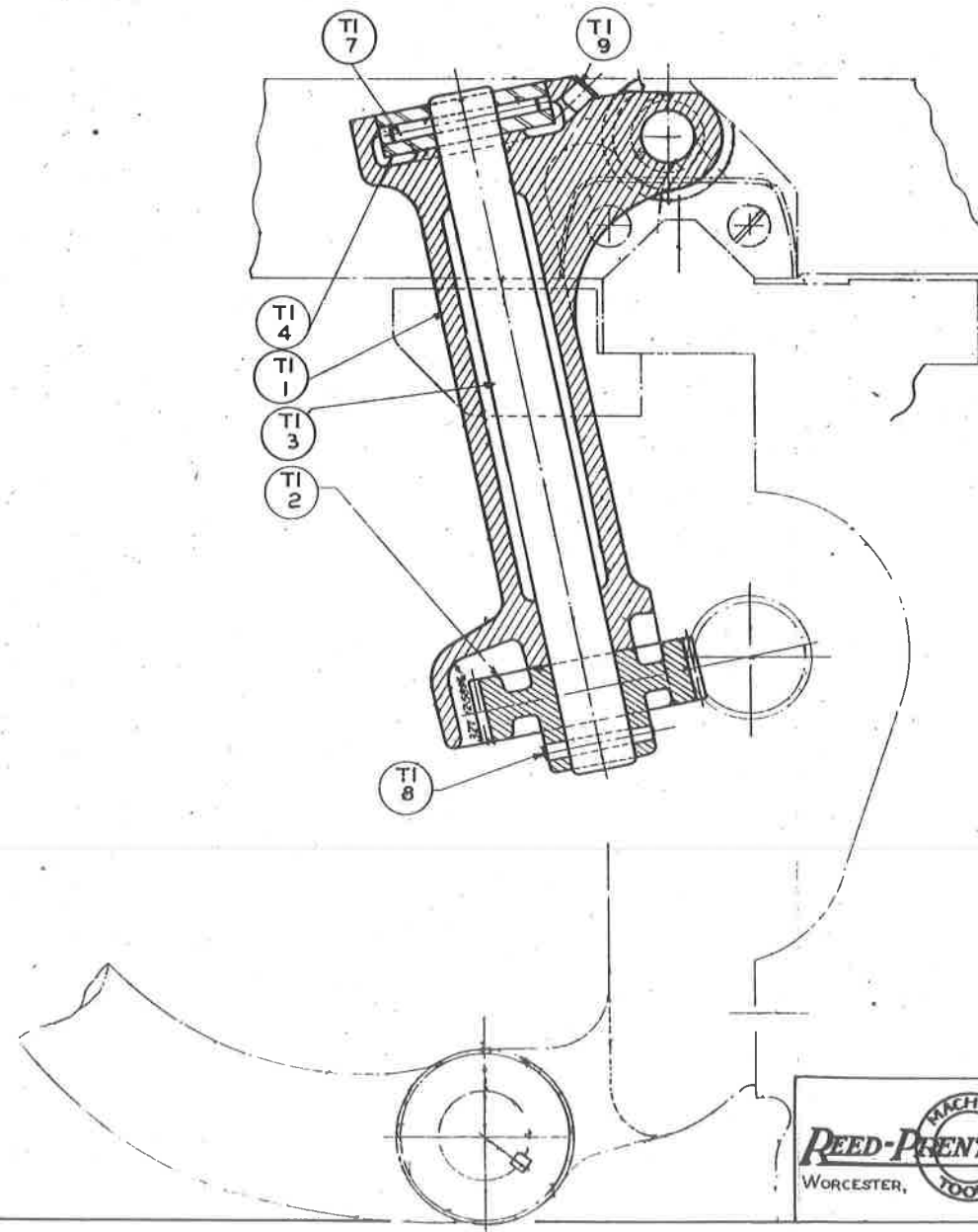
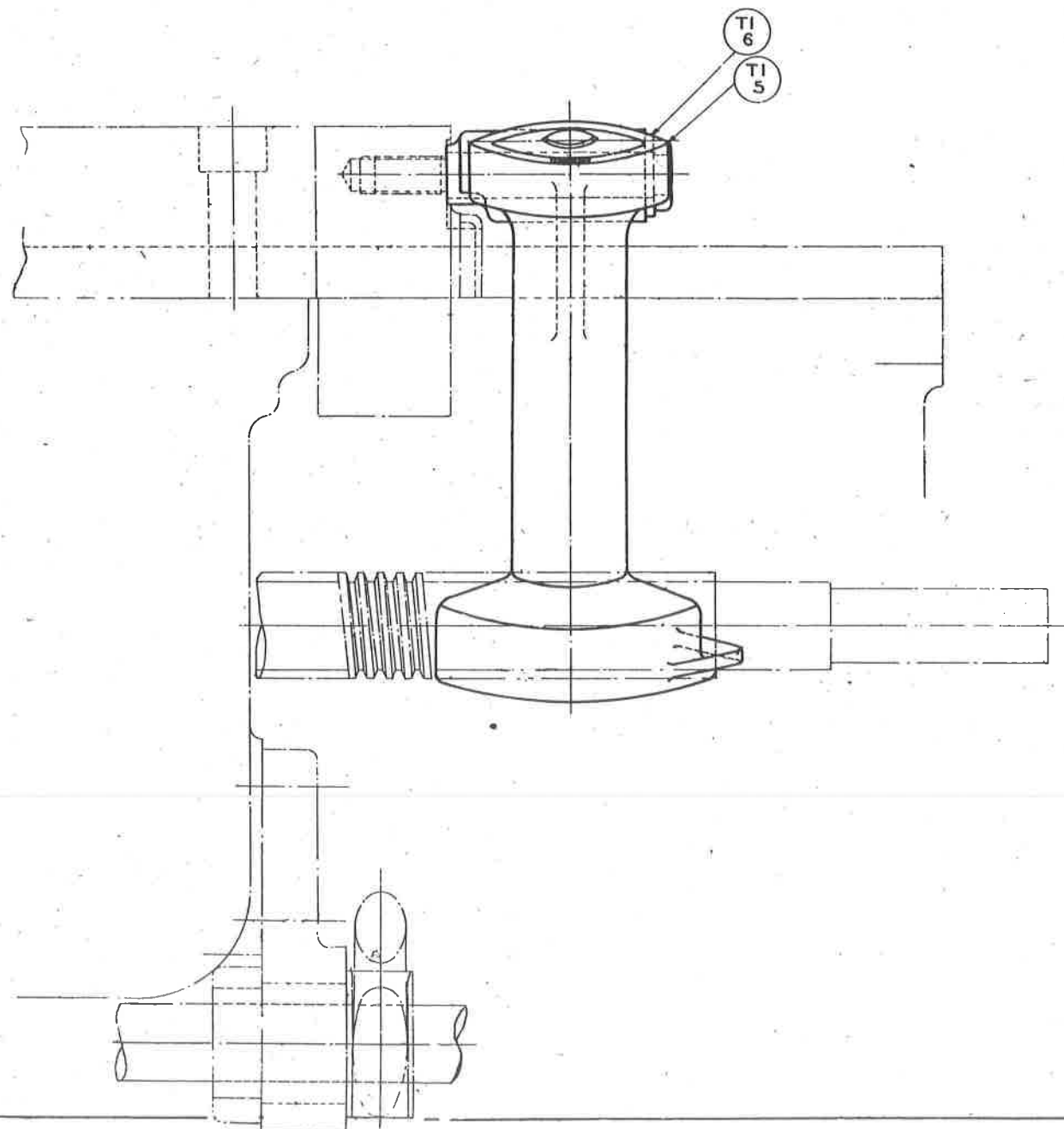
Parts List


<u>No.</u>	<u>Part</u>	<u>Quan.</u>
TI 1	Stand . . . . .	1
TI 2	Indicator Gear . . . . .	1
TI 3	Dial Shaft . . . . .	1
TI 4	Indicator Dial . . . . .	1
TI 5	Shoulder Screw . . . . .	1
TI 6	Washer . . . . .	1
TI 7	#2 x 1-3/4" Taper Pin - Indicator Dial . .	1
TI 8	#2 x 1-1/4" Taper Pin - Indicator Gear . .	1
TI 9	#0 Bowen Oiler (style "C") - Stand . . . .	1





**NOTE:**  
 WHEN CUTTING ANY STANDARD THREAD THE OPEN & SHUT NUT MAY BE ENGAGED WHEN THE POINTER IS AT ANY GRADUATION. WHEN CUTTING 1/2" OR ANY HALF THREAD THE NUT MUST BE ENGAGED ONLY WHEN THE POINTER IS AT A LONG GRADUATION. OR IF USING SMART GRADUATIONS THEY ALONE MUST BE USED, AS IT IS NECESSARY IN SUCH CASES TO SKIP THE LONG GRADUATIONS



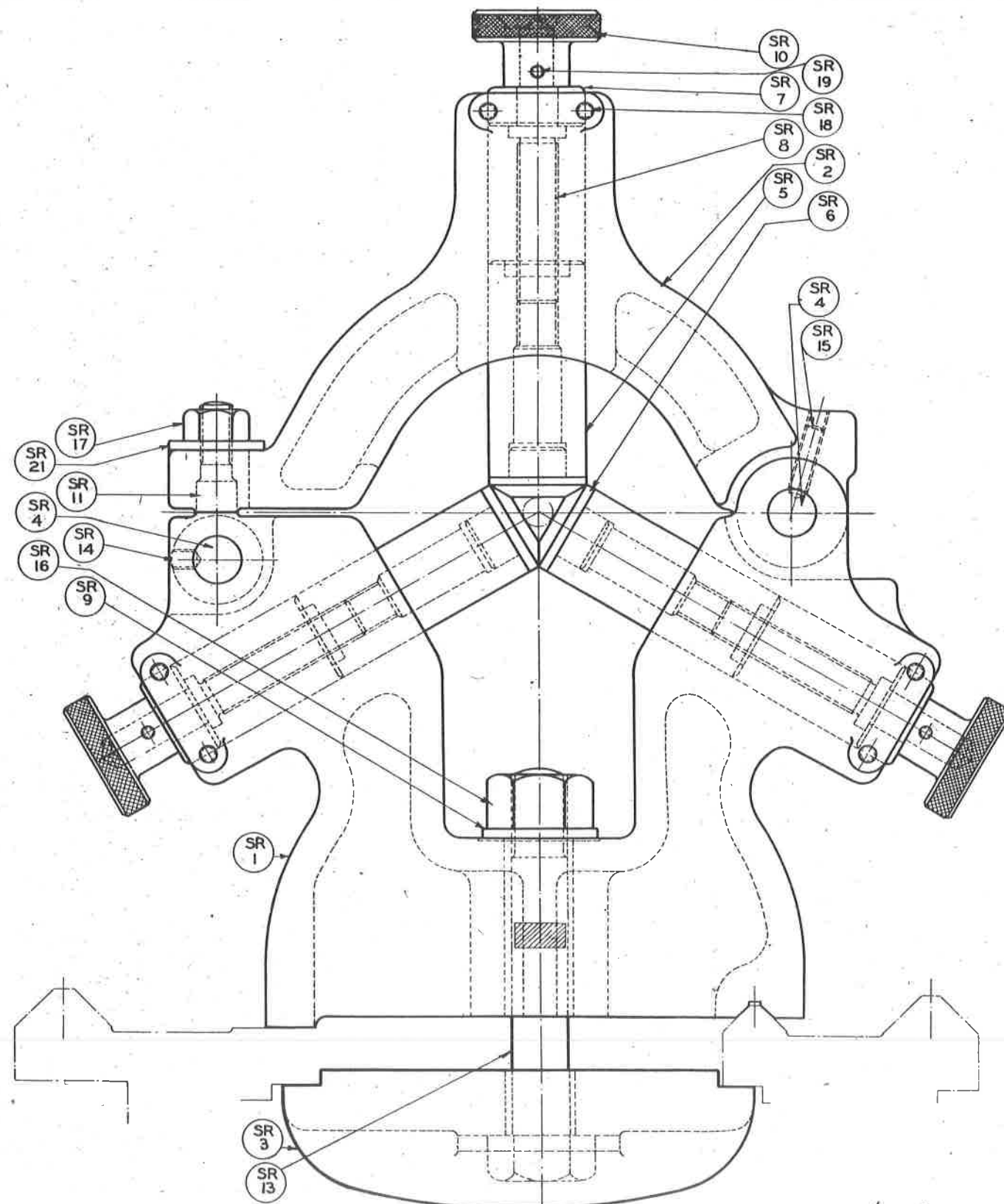
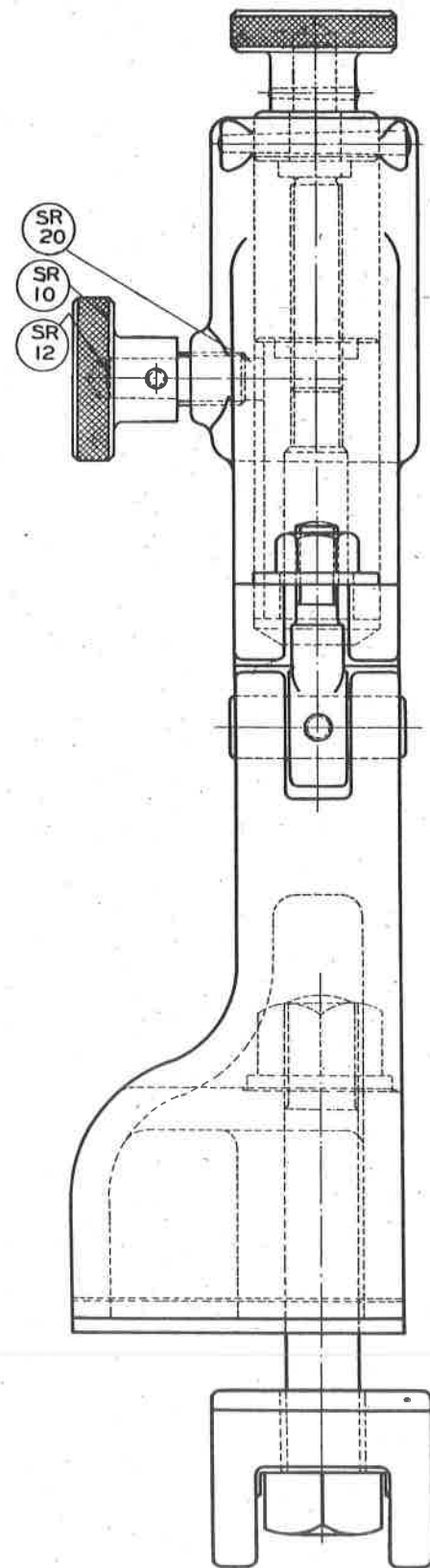
	TRADE MARK <b>ASSEMBLY</b>	
	<b>THREAD INDICATOR</b> <small>USED ON MACHINE</small> <b>14-16" MODEL AA-B' LATHE</b>	
WORCESTER, MASS. U.S.A.	DRAWN BY TRACED BY	NUMBER <b>930-4167</b>


Drawing #930-4165

STEADY REST

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>
SR 1	Steady Rest Base . . . . .	1
SR 2	Steady Rest Top . . . . .	1
SR 3	Shoe . . . . .	1
SR 4	Stud . . . . .	2
SR 5	Jaw . . . . .	3
SR 6	Jaw End Plug . . . . .	3
SR 7	Adj. Screw Bearing . . . . .	3
SR 8	Adj. Screw . . . . .	3
SR 9	Steady Rest Bolt Washer . . . . .	1
SR 10	Kandknob . . . . .	6
SR 11	Eye Bolt . . . . .	1
SR 12	Jaw Tightener Screw . . . . .	3
SR 13	7/8" x 7-1/8" Hex.Hd.Bolt (steady rest)	1
SR 14	5/16" x 3/8" Allen Hdls. Set Scr. (eye bolt)	1
SR 15	5/16" x 1" Allen Hdls. Set Scr. (steady rest top)	1
SR 16	7/8" Std. Hex. Nut (steady rest bolt)	1
SR 17	5/8" Std. Hex. Nut (eye bolt)	1
SR 18	#5 x 2-1/4" Taper Pin (steady rest top & base)	6
SR 19	#3 x 1" Taper Pin (handknob)	6
SR 20	1/2" Dia. x 3/16" Thick Copper Plug (jaw tightener scr.)	3
SR 21	1-3/8" Dia. x 11/16" Hole x 1/8" Thick Washer (eye bolt)	1



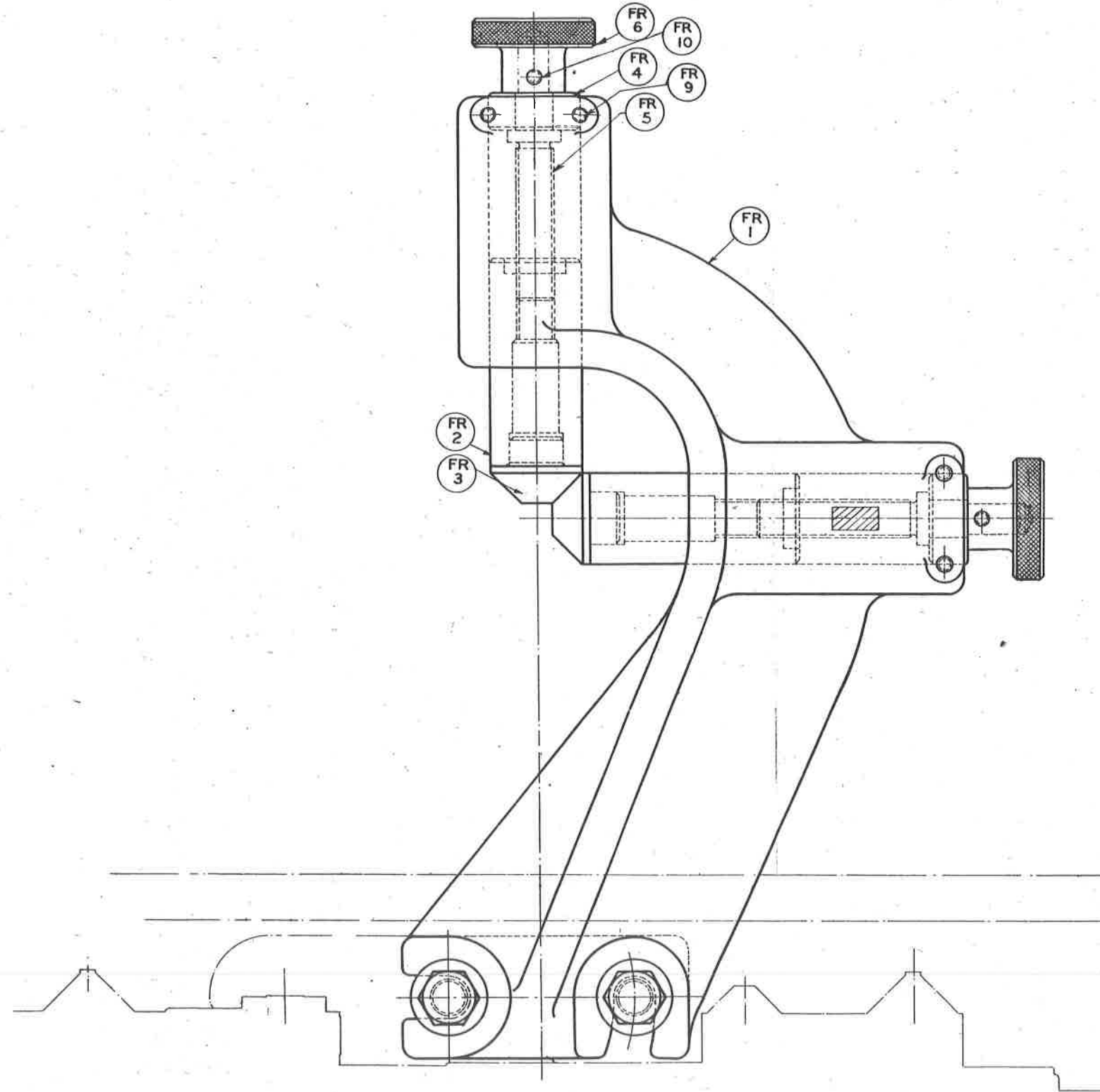
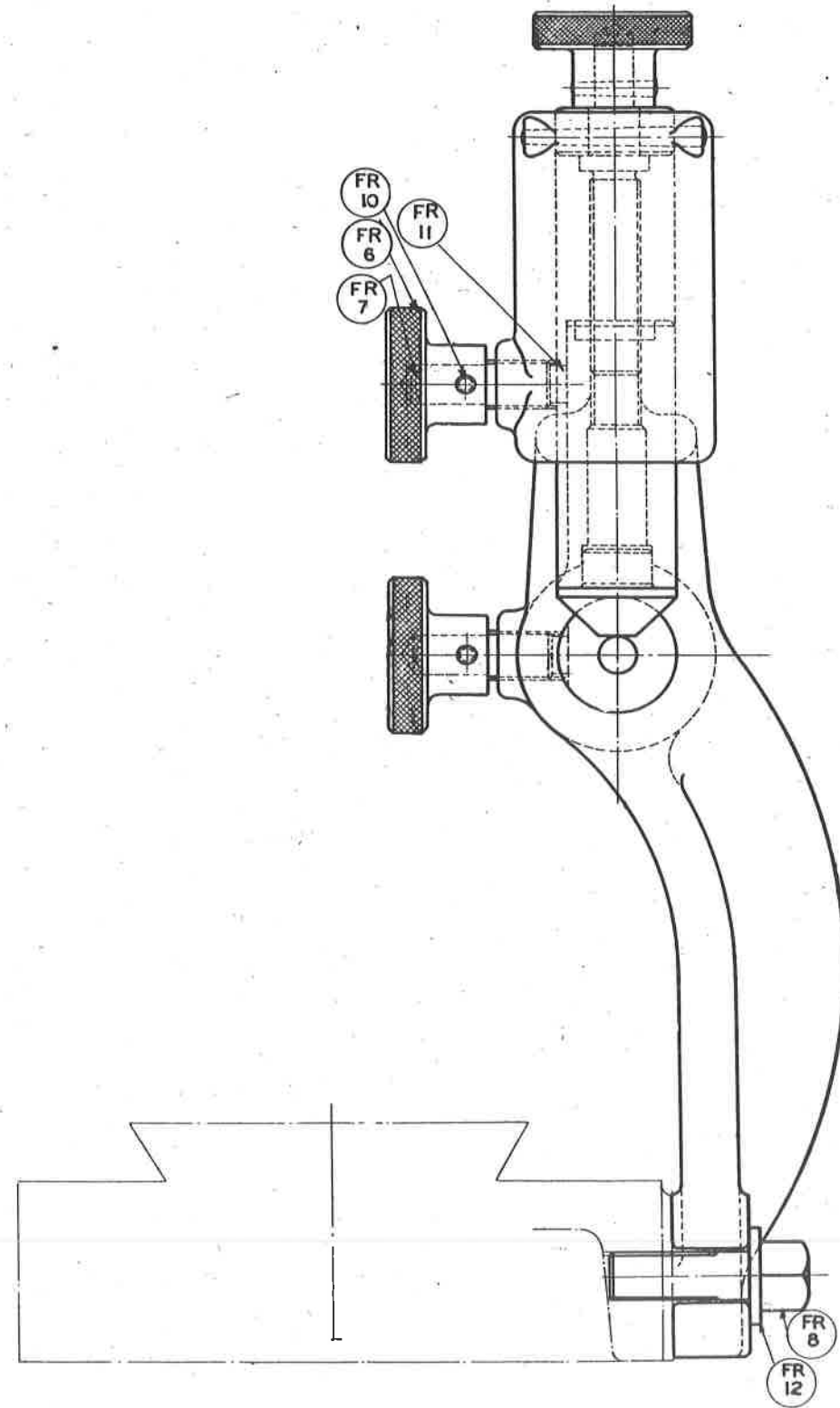
DESIGN	DATE	NAME OF PIECE	MATERIAL	CAPACITY $\frac{1}{2}$ TO $4\frac{3}{4}$ " 	USE STOCK
CHECKED		ASSEMBLY UNIT	SUPERSEDES NO.		CASTING NO.
TRACED	B 5-1-35	STEADY REST	SUPERSEDES BY NO.	WORCESTER, MASS., U.S.A.	FABRIKING NO.
TYPING CHECKED		USED BY MACHINE 14-16 MODEL "B" LATHE	SCALE FULL		NUMBER 930-4165

Drawing #930-4166

FOLLOW REST

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>
FR 1	Follow Rest . . . . .	1
FR 2	Jaw . . . . .	2
FR 3	Jaw End Plug . . . . .	2
FR 4	Adj. Scr. Bearing . . . . .	2
FR 5	Adjusting Screw . . . . .	2
FR 6	Handknob . . . . .	4
FR 7	Jaw Tightener Screw . . . . .	2
FR 8	5/8" x 2" Hex. Hd. Scr. (follow rest) . . . . .	2
FR 9	#5 x 2-1/4" Taper Pin (follow rest) . . . . .	4
FR 10	#3 x 1" Taper Pin (adj. scr. handknob) . . . . .	4
FR 11	1/2" Dia. x 3/16" Thick Copper Plug (jaw tightener screw)	2
FR 12	1-3/8" Dia. x 11/16" Hole x 1/8" Thick Washer (follow rest) .	2



CAPACITY  $\frac{1}{2}$ " TO 4 $\frac{3}{4}$ "

DESIGNED	C.H.S.	DATE	NAME OF PIECE	MATERIAL	SEE STOCK
CHECKED			ASSEMBLY	SUPERSEDES NO.	CASTING NO.
TRACED	R.P.	4-29-35	FOLLOW REST	SUPERSEDES BY NO.	PARTING NO. NUMBER
TRACING CHECKED			USED ON MACHINE "AA"	SCALE	930-4166
			14-16 MODEL "B" LATHE	FULL SIZE	

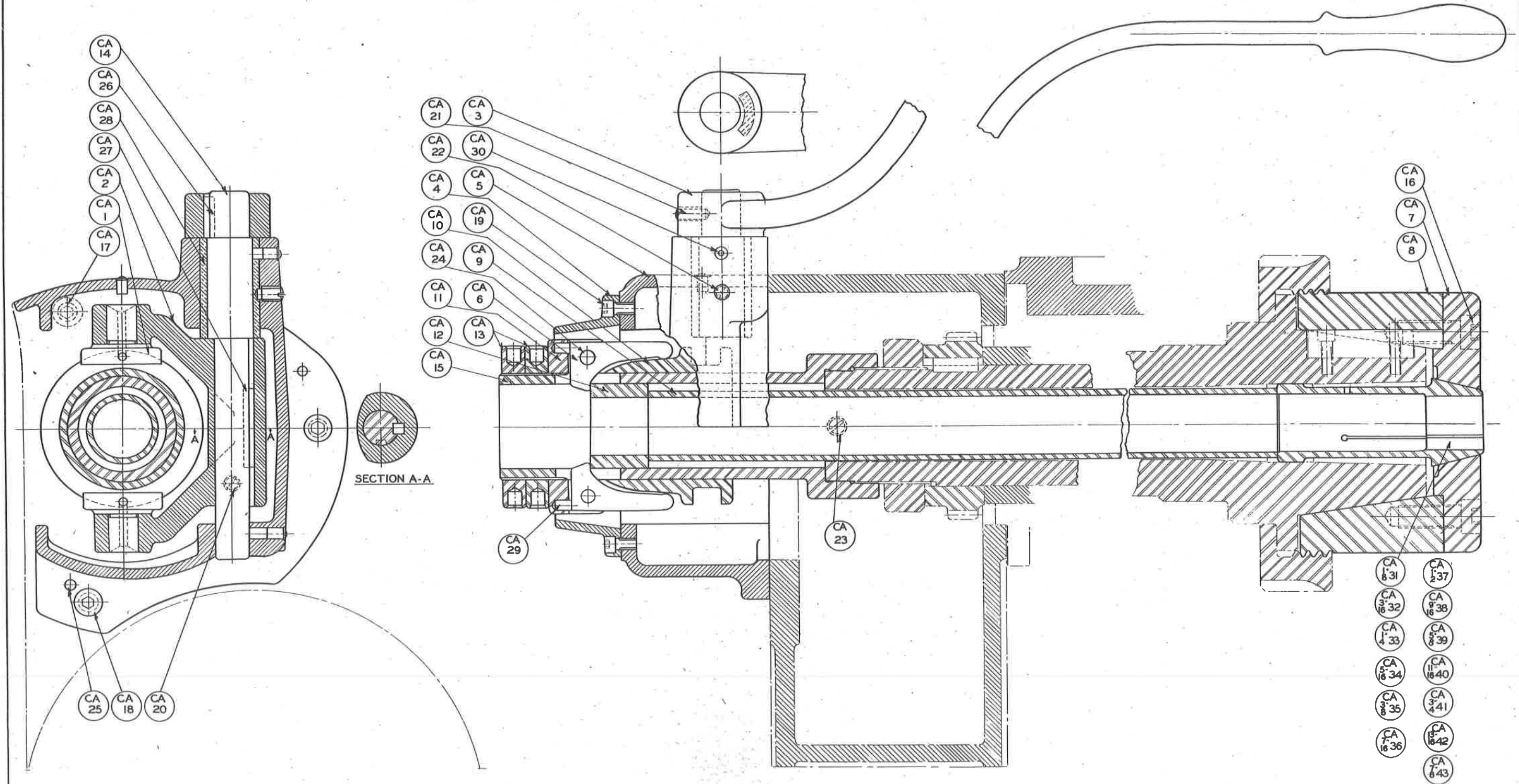




COLLET ATTACHMENT ASSEMBLY

Parts List

<u>No.</u>	<u>Part</u>	<u>Quan.</u>
CA 1	Yoke . . . . .	2
CA 2	Yoke Lever . . . . .	1
CA 3	Hand Lever . . . . .	1
CA 4	End Cover . . . . .	1
CA 5	Housing . . . . .	1
CA 6	Toggle . . . . .	2
CA 7	Closer Body . . . . .	1
CA 8	Collet Closer . . . . .	1
CA 9	Tube . . . . .	1
CA 10	Spool . . . . .	1
CA 11	Toggle Carrier . . . . .	1
CA 12	Toggle Bearing . . . . .	1
CA 13	Lock Nut . . . . .	2
CA 14	Yoke Lever Shaft . . . . .	1
CA 15	Sleeve . . . . .	1
CA 16	1/2" x 1 1/4" Allen Fil. Hd. Scr. - Collet Closer . . . . .	6
CA 17	3/8" x 3 1/2" Allen Fil. Hd. Scr. - Housing . . . . .	1
CA 18	3/8" x 1" Allen Fil. Hd. Scr. - Housing . . . . .	2
CA 19	1/4" x 1/2" Allen Fil. Hd. Scr. - End Cover . . . . .	3
CA 20	5/16" x 1/2" Allen Hdls. Set Scr. - Yoke Lever . . . . .	1
CA 21	5/16" x 5/8" Allen Hdls. Set Scr. - Hand Lever . . . . .	1
CA 22	5/16" x 1/2" Allen Hdls. Set Scr. - Housing . . . . .	1
CA 23	3/8" x 1/2" Allen Hdls. Set Scr. - Sleeve . . . . .	1
CA 24	5/16" x 1 1/2" Dr. Rod Pin - Toggle Carrier . . . . .	2
CA 25	1/4" x 7/8" C.R. Pin - Housing . . . . .	2
CA 26	1/4" x 1/4" x 7/8" Rd. End Key - Yoke Lever Shaft. . . . .	1
CA 27	1/4" x 1/4" x 1-3/4" Rd. End Key - Yoke Lever Shaft. . . . .	1
CA 28	Bunting Bushing #E 526 - Housing . . . . .	1
CA 29	1/4" x 3/8" Dr. Rod Pin - Toggle Carrier . . . . .	2
CA 30	1/4" Bowen Oiler - Housing . . . . .	3
CA 31	1/8" Collet . . . . .	1
CA 32	3/16" Collet . . . . .	1
CA 33	1/4" Collet . . . . .	1
CA 34	5/16" Collet . . . . .	1
CA 35	3/8" Collet . . . . .	1
CA 36	7/16" Collet . . . . .	1
CA 37	1/2" Collet . . . . .	1
CA 38	9/16" Collet . . . . .	1
CA 39	5/8" Collet . . . . .	1
CA 40	11/16" Collet . . . . .	1
CA 41	3/4" Collet . . . . .	1
CA 42	13/16" Collet . . . . .	1
CA 43	7/8" Collet . . . . .	1



DRAWN	DATE	NAME OF DIE <b>ASSEMBLY</b>	MATERIAL	USER STOCK
CHECKED		UNIT <b>COLLET ATTACHMENT</b>	SUPERSEDED NO.	CASTING NO.
TRACED	J.C. 9-2-42	USED ON MACHINE <b>14-16 MODEL A &amp; B LATHE</b>	SUPERSEDED BY NO.	FORGING NO.
TECHNICAL CHECKED			SCALE <i>FULL</i>	NUMBER <b>930-4148</b>



TAPER ATTACHMENT ASSEMBLY

Parts List

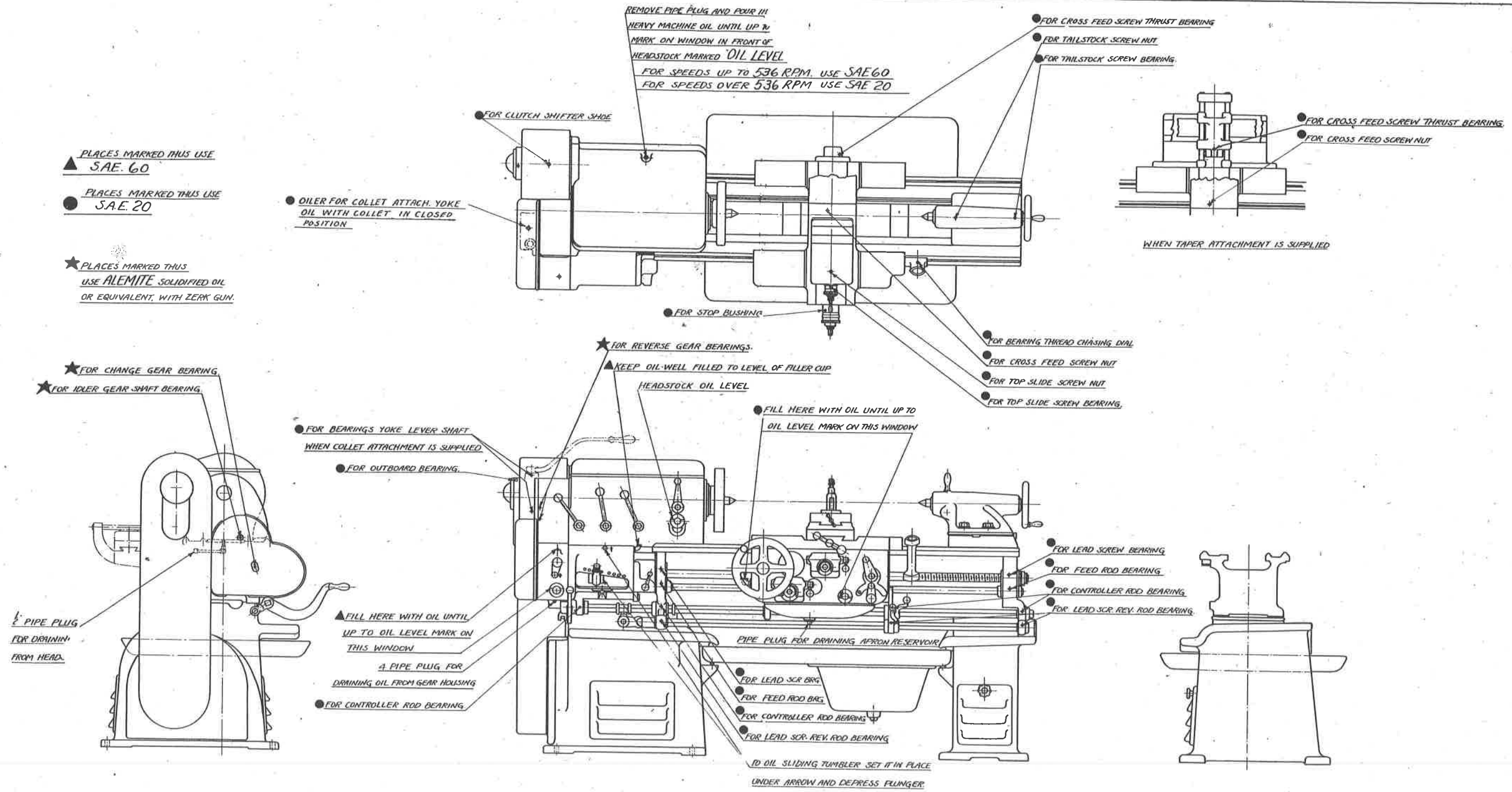
<u>No.</u>	<u>Part</u>	<u>Quan.</u>
TA 1	Taper Slide . . . . .	1
TA 2	Taper Bar . . . . .	1
TA 3	Bed Clamp . . . . .	1
TA 4	Taper Slide Gib . . . . .	1
TA 5	Cross Feed Screw Thrust Bracket . . . . .	1
TA 6	Chip Guard . . . . .	1
TA 7	Main Bracket . . . . .	1
TA 8	Taper Shoe . . . . .	1
TA 9	Gib Screw . . . . .	8
TA 10	Taper Slide Holding Collar . . . . .	1
TA 11	Taper Shoe Gib . . . . .	1
TA 12	Taper Bar Pivot . . . . .	1
TA 13	Pointer . . . . .	1
TA 14	Taper Bar Adj. Scr. Nut . . . . .	1
TA 15	Bed Clamp Stud . . . . .	2
TA 16	Taper Slide Holding Rod . . . . .	1
TA 17	Bed Clamp Plate . . . . .	1
TA 18	Taper Bar Adj. Scr. Pivot . . . . .	1
TA 19	Thrust Bracket Support Pin . . . . .	2
TA 20	Taper Shoe Stud . . . . .	1
TA 21	Taper Bar Adj. Scr. Knob . . . . .	1
TA 22	Taper Bar Adj. Scr. . . . .	1
TA 23	5/8" x 1-3/4" Hex. Hd. Scr. - Main Bracket.	4
TA 24	3/8" x 3/8" Allen Hdls.Scr. - Cr. Fd. Scr. Thr. Bracket.	1
TA 25	3/8" x 1" Allen Hdls. Scr. - Taper Shoe . .	4
TA 26	1/2" x 3/8" Flat Hd. Scr. - Scale . . . . .	2
TA 27	3/8" Std. Hex. Check Nut Taper Shoe Gib Scr.	4
TA 28	5/8" Std. Hex. Nut Taper Slide Holding Rod.	1
TA 29	5/8" Std. Hex. Nut Taper Shoe Stud . . . . .	1
TA 30	5/8" Std. Hex. Nut Taper Bar Bolt . . . . .	2
TA 31	5/8" Std. Hex. Nut Taper Bar Adj.Scr. Pivot	1
TA 32	5/8" Std. Hex. Nut Bed Clamp Stud . . . . .	2
TA 33	3/8" Std. Hex. Check Nut - Gib Screw . . . . .	7
TA 34	3/8" x 3/4" Allen Fil. Hd. Scr. - Chip Guard . . . . .	2
TA 35	5/8" x 1 1/2" Hex. Hd. Scr. - Main Bracket . .	2
TA 36	Taper Bar Bolt - Taper Bar . . . . .	2
TA 37	Scale - Taper Slide . . . . .	1
TA 38	Spring - Pointer . . . . .	1
TA 39	#2 Bowen Oiler - Cr. Fd. Scr. Thr. Bracket.	1
TA 40	#4 x 5/16" Parker Dr. Scr. - Oil Plate . . . . .	4
TA 41	5/16" x 1/8" Copper Plug - Cr. Fd. Scr. Thr. Bracket	1
TA 42	#2 x 1 1/4" Taper Pin - Taper Bar Adj. Scr. Knob . . . . .	1
TA 43	#2 x 1-3/8" Taper Pin - Taper Slide Holding Rod Collar . . . . .	1
TA 44	#5 x 1 1/2" Taper Pin - Main Bracket . . . . .	2
TA 45	3/8" x 1-3/8" C. R. Pin - Main Bracket . . . . .	2
TA 46	41/64" x 3/16" x 1 1/2" Steel Washer - Taper Bar Bolt . . . . .	2
TA 47	41/64" x 3/16" x 1 1/2" Steel Washer - Taper Bar Adj.Scr.Pivot	1
TA 48	41/64" x 3/16" x 1 1/2" Steel Washer - Taper Sl. Holding Rod . . . . .	1
TA 49	41/64" x 3/16" x 1 1/2" Steel Washer - Bed Clamp Stud . . . . .	2
TA 50	21/32" x 5/32" x 1-7/8" Steel Washer - Taper Shoe . . . . .	1
TA 51	Oil Plate - Chip Guard . . . . .	1



PLACES MARKED THUS USE  
▲ SAE. 60

PLACES MARKED THUS USE  
● SAE. 20

★ PLACES MARKED THUS  
USE ALEMITE SOLIDIFIED OIL  
OR EQUIVALENT, WITH ZERK GUN.



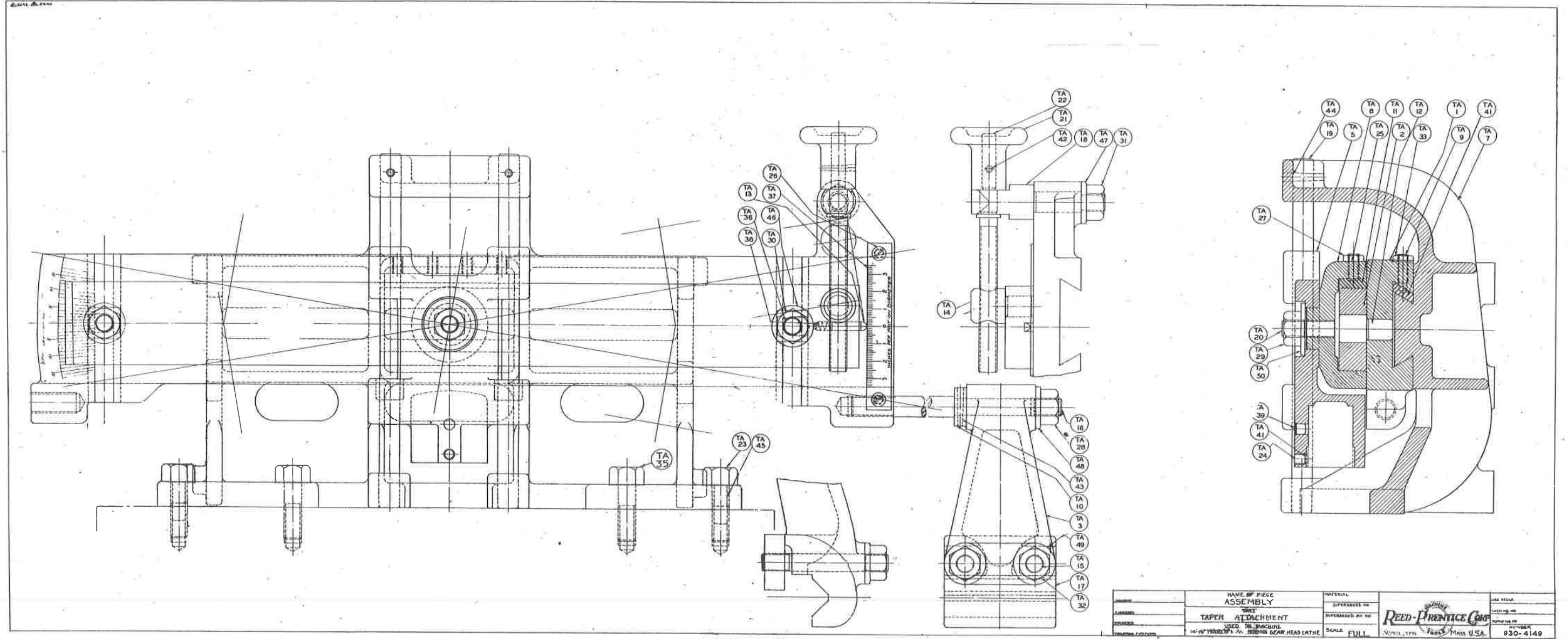
**OILING LATHE**

AMPLE LUBRICATION IS ESSENTIAL TO SECURE GOOD RESULTS AND PRESERVE THE BEARINGS.  
IT IS FALSE ECONOMY TO USE ANY BUT THE BEST OILS. AFTER BEING CLEANED AND SET-UP THE  
LATHE SHOULD BE GONE OVER AND ALL BEARINGS FLOODED WITH OIL WHILE RUNNING IDLE AT A SLOW SPEED.

DRAWN	C.H.S.	DATE	5-15-35	NAME OF PIECE	OILING DIAGRAM	MATERIAL		USE SPEC.	
CHECKED				UNIT		SUPERSEDES NO.	1350A	DESIGN NO.	
TRACED	B	5-16-35		USED ON MACHINE		SUPERSEDED BY NO.		DRAWING NO.	
TRACING CHECKED				14-16" MODEL B SLIDING GEAR HEAD LATHE		SCALE	1/2" = 1 FOOT.	15233	







NAME OF PIECE	MATERIAL	USE STOCK
ASSEMBLY	SUPPLEMENT NO.	LASTING NO.
DATE	REFERENCES BY NO.	REVISION NO.
TAPER ATTACHMENT	SCALE FULL	REED-PRENTICE CORP. NUMBER 930-4149
USED ON MACHINE	SCALE FULL	MADE IN MASS. U.S.A.
14" 40' 1500 RPM 1 1/2" 3000 RPM GEAR HEAD LATHE		