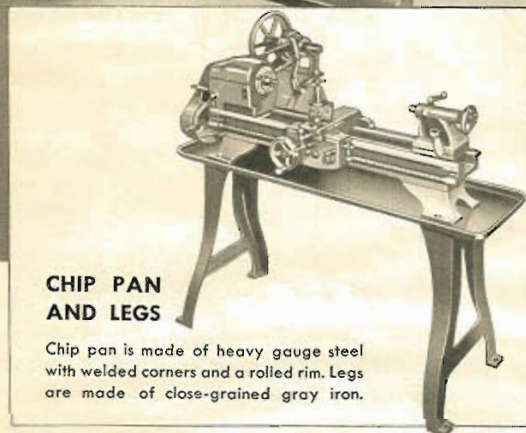
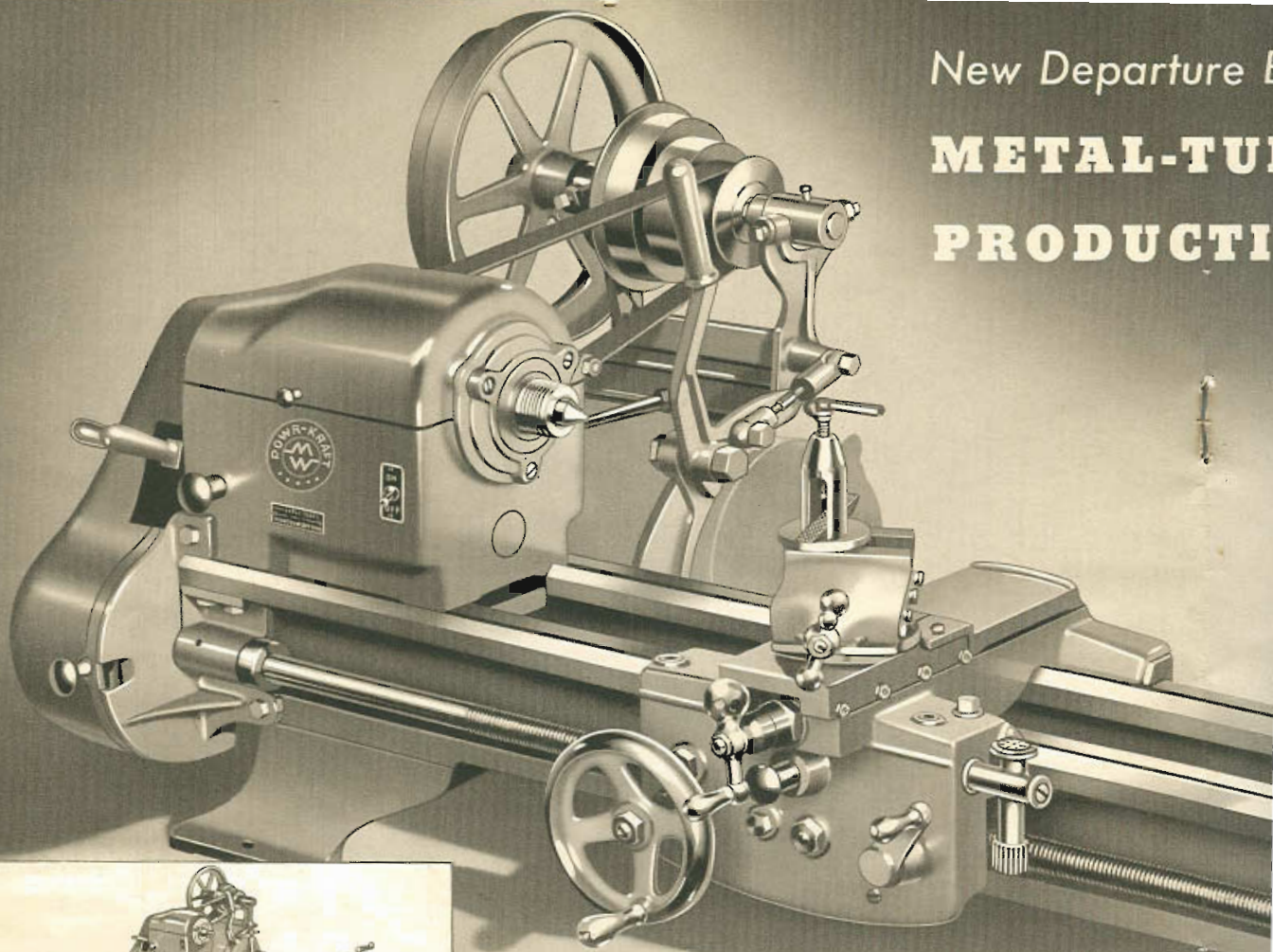
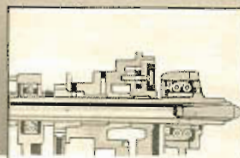


New Departure B  
**METAL-TURNING**  
**PRODUCTS**

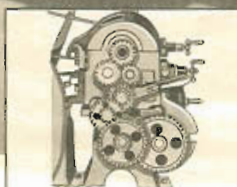


**CHIP PAN AND LEGS**

Chip pan is made of heavy gauge steel with welded corners and a rolled rim. Legs are made of close-grained gray iron.



**HEAD-STOCK SPINDLE** runs on two sets of large New Departure Ball Bearings!



**MACHINE-CUT SEMI-STEEL GEARS** ... far superior to the usual die-cast type!



**LONGITUDINAL AND CROSS FEEDS** are both powered ... both are reversible!



**FULLY** double ways precision



**PORTABLE COOLANT PUMP**

200 gal. per hour! Handles all but extremely viscous fluids. 4-gal. tank 13½x10x7-in. 6-ft. ½-in. hose, ⅓₀ H.P. motor, flow control valve, spray nozzle, motor switch, 7-ft. cord with plug. Bracket for 2¾-in. columns and 12-in. spray tube at right, extra.

**PERMANENT ACCURACY:** Guaranteed by features found only in the costliest lathes! Compare every point ... then compare the price!

**BED:** Of alloy iron castings ... seasoned ... internal stresses removed! Precision ground double Flat and prismatic V ways are 6⅜" wide.

**GEARS:** Machine-cut, semi-steel ... *not die-cast!* And they're extra wide; back and reverse gears are ⅜-in., change gears ⅞-in. Rack and pinion type back-gears are fully enclosed. Conventional, quick-change reversing gears.

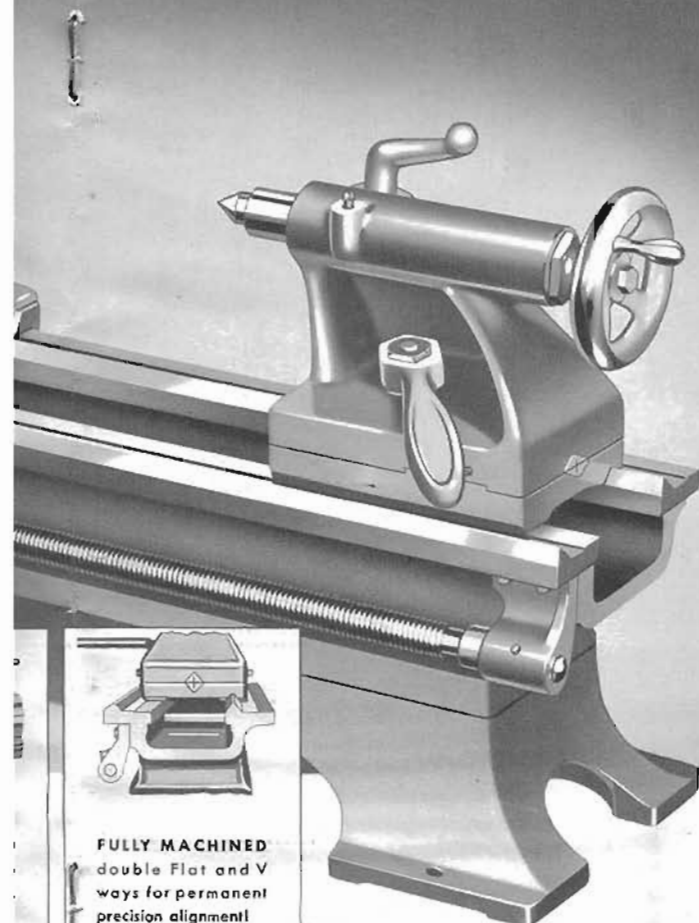
**DRIVE:** 3-step cone pulley with flat belt drive to lathe. 2-step V-belt drive from V-type motor pulley to flat counter shaft pulley. 12 speeds. Motor pulley ½, ⅝, ¾ bore. State size. V-belt not incl. 84 R 9962 ½x41-in. recommended.

**HEAD-STOCK:** Tempered, precision-ground, steel spindle rides on two sets of matched, grease-sealed, pre-loaded New Departure Ball Bearings! Maximum collet capacity ½-in. Has hinged safety guard.

**TAIL-STOCK:** No. 2 Morse Taper. Self-ejecting type with 2⅛" quill travel. ⅜" offset for taper turning. ⅛" calibrations on spindle.

rture Ball Bearing Headstock!

# -TURNING CTION LATHE



**FULLY MACHINED**  
double Flat and V  
ways for permanent  
precision alignment!

**CARRIAGE:** Fully equipped with power cross feed and power longitudinal feed. Compound rest with adjustable gibbs swivels 180°, locks at any angle. Compound rest and cross feed screws have adjustable micrometer collar graduated in 1-1000's. Carriage has 9-in. bearing surface on ways and is equipped with wipers for cleaning the ways!

**84 R 700.** Metal-Turning Production Lathe. Complete with flat leather belt, pulleys, 6-inch face plate, tool post, adjustable thread-cutting dial, head-stock and tail-stock centers, head-stock spindle sleeve, wrenches, instructions. Motor is not included. Shipping weight is 320 lbs.

**84 R 772.** Steel Chip Pan. Shipping weight 22 lbs.

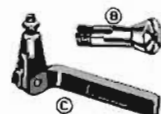
**84 R 771.** Set of 2 Gray-Iron Legs. Shipping weight 90 lbs.

**84 R 14115.** Coolant Pump, 110 volt. 60 cyc. A.C. Wt. 40 lbs.

**84 R 14130.** Coolant Pump, 220 volt. 60 cyc. A.C. Wt. 40 lbs. (See price list for additional coolant pump accessories)



**A Draw-in Collet Chuck.** Accurately holds round work up to 1/2 in. Hollow draw-in bar extends through headstock. Threaded at spindle end to hold collet in the closing sleeve. Allows rods to pass through spindle. Includes spindle cap and closing sleeve (no collets). **84 R 783**



**B Split Holding Collet** for chuck at left. Precision ground. For round work. 15 sizes, by 32nds. 1/8-3/8 in. **84 R 792**



**C Turret Head.** Uses 6 cutters with 1 chucking operation! 2 1/2-in. diam. head. Six 3/8-in. holes. 1 1/4-in. plugs must be machined to sizes of cutters. Tapered pin and index holes prevent side-play. No. 2 Morse Shank to fit Tail-stock. Cutters not included. **84 R 812**

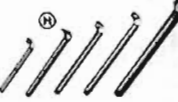
**C Tool Holder.** Reversible yoke for R.H. or L.H. Takes boring bars below. Wrench and boring bar included. **84 R 832**



**E Face Plates** for any lathe with 1 1/4 to 8-thread spindle. Fully machined, perfectly balanced. Cast iron. 6-in. size has 3 closed and one open slot for lathe dogs. Slots all closed on 8-in. size. **84 R 773.** 6-inch size. **84 R 786.** 8-inch size.



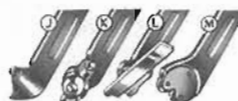
**F Lathe Dogs** of highest quality, drop-forged bar steel. 1/2, 3/4, 1 and 1 1/2-in. sizes. **84 R 8811**



**H Boring Bars** for boring, turning and threading work of small internal diameters. Highest quality high-speed steel. Available in the following sizes:

**G Clamp-Type.** Lathe Dog for square, rectangular, hex or round work. Drop forged. 1 1/2-in. Mounts without removing work. **84 R 835.**

3/8 x 4 1/2-in. 1/4 x 4-in.  
3/8 x 6-in. 1/4 x 5-in.  
3/8 x 7-in. **84 R 831**



**Steel Tool Holders**  
**J** 84 R 822. Straight.  
**K** 84 R 820. Right Hand  
**L** 84 R 821. Left Hand  
**M** 84 R 823. Threadtool.  
**K** 84 R 824. Cut-off R.H.  
**L** 84 R 794. Blade.  
**M** 84 R 825. Knurling Tool. Med. Diamond.  
**84 R 826.** Knurling Roller for above tool.



**N, P, R, S Tungsten-Carbide Tipped Bits**... cut faster and hold cutting edge longer! Center, left hand, right hand turning. Each in 4 types, for steel and malleable iron, cast-iron, brass, or aluminum. See price list.  
**S** 84 R 828. High Speed Steel Blanks. Set of six.



**T Follower Rest** for small rods. Mounts on back of carriage. Two adjustable cast-iron jaws. **84 R 795**

**V Steady Rest.** Clamps to bed ways—prevents "whipping." For work up to 3-in. diam. Adjustable cast iron jaws. **84 R 796**

## PRODUCTION LATHE SPECIFICATIONS

Swing over bed	10 inches
Between Centers	24 inches
Bed Length	42 inches
Overall Length	50 inches
Spindle Bearings	New Departure Ball
Power Cross Feed	Equipped
Compound Rest Travel	6 1/2 inches
Cross Slide Travel	2 1/2 inches
Main Drive	3-Step Cone Pulley
Speeds (with back gears)	12 (30-1450 R.P.M.)
Lead Screw	3/8-8 Acme Threaded
Spindle—Nose	1 1/2-8 R.H.
Taper	No. 3 Morse with sleeve to No. 2 Hole
Hole	25/32 inches
Tailstock Taper	No. 2 Morse
Tailstock Ram Travel	2 1/8 inches
Tailstock set-over	11/16 inches
Thread Range	4-216 R.H. or L.H.