You get more... in job capacity, versatility and value... with Clausing-Colchester geared-head lathes. They are built to tool room standards of accuracy, and are world renowned for dependability.

Clausing-Colchester lathes, manufactured in England, are the product of one of the world's largest and most modern factories devoted exclusively to the manufacture of precision lathes—backed by the nation-wide Clausing sales, service and dealer organization.

13-inch lathes ... page 6
15-inch lathes ... page 8
17-inch lathes ... page 10
gap bed lathes ... page 12
Bigger spindle capacity is one of the many plus features of Clausing-Colchester lathes — note sizes in chart below.

Spindles are high-tensile forged steel — precision ground their entire length. Nose is American Standard taper key-lock — drive is positive, chucks are easy to install, remove. Nose tapers are hardened.

<table>
<thead>
<tr>
<th>Lathe</th>
<th>17&quot;</th>
<th>15&quot;</th>
<th>13&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hole thru spindle</td>
<td>3 5/16&quot;</td>
<td>2 5/16&quot;</td>
<td>1 5/8&quot;</td>
</tr>
<tr>
<td>Nose taper key drive</td>
<td>L-2</td>
<td>L-1</td>
<td>L-0</td>
</tr>
</tbody>
</table>

Every Clausing-Colchester lathe must turn round to within .0001". This remarkable accuracy is due in part to the Gamet Micron Precision tapered roller spindle bearings with oil-flow lubrication — world-famous for superior accuracy and efficiency. Front bearing is double row — rear is single row, spring loaded for automatic adjustment. Bearing sizes:

<table>
<thead>
<tr>
<th>Lathe</th>
<th>17&quot;</th>
<th>15&quot;</th>
<th>13&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Front spindle bearing O.D.</td>
<td>7 1/2&quot;</td>
<td>5 1/2&quot;</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Rear spindle bearing O.D.</td>
<td>6&quot;</td>
<td>4 3/8&quot;</td>
<td>3 5/8&quot;</td>
</tr>
</tbody>
</table>

Accuracy of each lathe is verified at the factory by inspecting a turned work piece on a Talyrond which records roundness on a graph like the one at right. Work piece and graph are supplied with lathe.
The Clausing-Colchester all-g geared headstock is designed and built to deliver the power required for heavy-duty operations and for smooth performance. Headstock is completely enclosed — gears, shafts and bearings travel in a bath of oil — a feature that adds years to service life.

The headstock gears are shaved, full-contour induction hardened, and honed. Shafts are high-tensile steel — sliding gear shafts are splined. The precision processing of gears and shafts, plus superior spindle bearings, assure high standards of work accuracy.

Controls are grouped for efficient operation. Lever at front operates both switch and brake — control is rapid and sensitive.
Tailstocks have large, tanged spindles—note sizes in chart below. Hole for spindle is honed. Spindle taper and O.D. are induction-hardened and ground. Spindles are graduated, have center ejector. Bed and spindle lock levers are permanently attached for speed and ease in set-up.

<table>
<thead>
<tr>
<th>Lathe</th>
<th>17&quot;</th>
<th>15&quot;</th>
<th>13&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tailstock spindle O.D.</td>
<td>2.687</td>
<td>2.500</td>
<td>1.700</td>
</tr>
</tbody>
</table>

**induction-hardened bed ways**

V-ways and flat ways of bed are induction-hardened and are precision ground to extremely close tolerance. Beds are massive, semi-steel castings with elliptical cross ribbing for maximum rigidity.

**enclosed gear box, 45 threads and feeds**

Quick-change gear box is totally enclosed—mechanism runs in bath of oil. Gears are shaved—shafts are multi-splined high tensile steel.

Power feeds are taken from a separate feed rod. The lead screw is used for thread cutting only—another feature of design that assures longer service and greater accuracy with a Clausing-Colchester. Feed rod has springball clutch that releases rod whenever the load becomes too great and automatically re-engages when strain is removed.

**unequalled versatility**

The wide range of accessories—combined with big work capacity—gives Clausing-Colchester lathes a high degree of versatility. Hydraulic tracer and high-speed threading attachments, for example, equip the lathe for top efficiency in specialized turning, yet in no way interfere with normal lathe operation.
CLAUSING 13" geared head precision lathes

- All-g geared headstock. 16 spindle speeds. Induction hardened gears.
- Headstock and quick-change box totally enclosed — gears, shafts and bearings travel in bath of oil.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- L-0 taper key-drive spindle nose — 1½" bore. Nose is hardened.
- Induction hardened bed ways.
- Separate rod for power feeds — lead screw used for thread cutting only.
- Big tailstock, with tanged spindle, lever-controlled locks.
- Accuracy verified by factory test reports.

straight bed lathes

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6524</td>
<td>13&quot;</td>
<td>24&quot;</td>
<td>52½&quot;</td>
<td>1350 lb.</td>
<td>1860 lb.</td>
</tr>
<tr>
<td>6525</td>
<td>13&quot;</td>
<td>36&quot;</td>
<td>64&quot;</td>
<td>1410 lb.</td>
<td>1920 lb.</td>
</tr>
</tbody>
</table>

www.OzarkToolManuals.com
**specifications**

**capacities**
- Swing over bed: 13"
- Swing over cross slide: 8"
- Swing over carriage wings: 12"
- Distance between centers, flush: 24" or 36"
- Face plate, dia.: 12"
- Driving plate, dia.: 6"
- Follower rest, capacity: 2"
- Steady rest, capacity: 4"

**headstock**
- Hole through spindle: 1 3/16"
- Spindle nose, taper key drive: L-0
- Spindle nose, internal taper: No. 5 MT
- Taper in spindle nose bushing: No. 3 MT
- Spindle center: No. 3 MT
- Spindle bearings, Gamet Micron Precision tapered roller:
  - Front: double row
  - Rear: single row, spring loaded
- Spindle bearing outside diameters:
  - Front: 4"
  - Rear: 3 3/16"

**bed**
- Ways: 2 V, 2 Flat
- Length: 52 1/2" or 64"
- Width: 8 1/2"
- Depth at ends: 11 7/8"
- Depth at center: 8"

**tailstock**
- Spindle, dia.: 1 700"
- Center: No. 3 MT
- Spindle travel: 4 1/4"
- Spindle graduated: 0" to 4 1/4" by 1/8"

**carriage and compound**
- Carriage length: 13 1/2"
- Width of carriage bridge: 6"
- Width of cross slide: 4" Width of compound rest: 3 1/2"
- Cross slide travel: 6 1/2"
- Compound rest travel: 3 3/4"
- Tool post slot: for 3/8" square tools

**spindle speeds**
- Spindle speeds: 16
- Speed range, rpm: 39, 65, 78, 88, 129, 144, 177, 204, 288, 334, 408, 457, 667, 750, 915, 1500
  - Specify voltage when ordering.
- Number of V-belts: 2

**threads and feeds**
- Lead screw: 1/8" — 6 Acme
- Feed rod, dia.: 3/4"
- Number of threads: 45
- Range: 4, 4 1/2, 4 3/4, 5, 5 1/2, 5 3/4, 6, 6 1/2, 7, 8, 9, 9 1/2, 10, 11, 11 1/2, 12, 13, 14, 16, 18, 19, 20, 22, 23, 24, 26, 28, 32, 36, 38, 40, 44, 46, 48, 52, 56, 64, 72, 76, 80, 88, 92, 96, 104, 112
- Number of feeds: 45
- Feed range: 0.068" to 0.0025"
  - NOTE: Threads 4 thru 7 are obtained by using change gear furnished.

**equipment furnished**
- Cabinet base with built-in chip pan, splash guards and coolant tank.
- Two-speed motor, Allen-Bradley magnetic-starter with reversing control.
- 12" face plate, 6" driving plate.
- Two No. 3 MT centers, reducing sleeve.
- Thread dial indicator, Follower rest, tool post, Change gear, Wrenches, Instruction and Parts List Manual. (Design and specifications are subject to change without notice.)
- All-geared headstock. 16 speeds. Induction hardened gears.
- Oil-bath lubricated headstock and quick-change gear box.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- High tensile steel spindle, with L-1 hardened nose — 2¾” bore.
- Induction hardened bed ways.
- Separate rod for power feeds — lead screw used for thread cutting only.

- Massive tailstock, with tanged spindle, lever-controlled locks.
- Built to American standards of tool room lathe accuracy — accuracy verified by factory test report.

**straight bed lathes**

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6534</td>
<td>15”</td>
<td>30”</td>
<td>63”</td>
<td>2100 lb.</td>
<td>2700 lb.</td>
</tr>
<tr>
<td>6535</td>
<td>15”</td>
<td>48”</td>
<td>83”</td>
<td>2250 lb.</td>
<td>2970 lb.</td>
</tr>
</tbody>
</table>
specifications

capacities
Swing over bed ..................... 15"
Swing over cross slide ............... 83/4"
Swing over carriage wings .......... 14"
Distance between centers, flush .... 30" or 48"
Face plate, dia. ...................... 14"
Driving plate, dia. ................. 8"
Follower rest, capacity ............. 21/2"
Steady rest, capacity ............... 5"

headstock
Hole through spindle ................. 21/8"
Spindle nose, taper key drive ........ L-1
Spindle nose, internal taper per foot . 0.732"
Taper in spindle nose bushing ....... No. 4 MT
Spindle center ....................... No. 4 MT
Spindle bearings, Gamet Micron Precision tapered roller:
  Front ....................... double row
  Rear ....................... single row, spring loaded
Spindle bearing outside diameters:
  Front ....................... 51/2"
  Rear ....................... 43/8"

bed
Ways .......................... 2 V, 2 Flat
Length ......................... 65" or 83"
Width .......................... 10"
Depth at ends .................. 143/8"
Depth at center ................. 10"

tailstock
Spindle, dia. ...................... No. 4 MT
Center .......................... No. 4 MT
Spindle travel .................... 6"
Spindle graduated ................. 0" to 6" by 1/8"

carriage and compound
Carriage length .................. 171/2"
Width of carriage bridge ........ 8"
Width of cross slide ............ 51/8"

width of compound rest .......... 41/2"
Cross slide travel ............... 7"
Compound rest travel ............. 43/8"
Tool post slot ................... for 3/8" square tools

spindle speeds
Spindle speeds .................... 16
Speed range, rpm: 30, 58, 60, 82, 115, 120, 153,
                      163, 229, 241, 307, 319, 457, 600, 637, 1200

motor
Two speed ............. 5-11/2 hp, 1800/900 rpm, 3 ph
                     220 or 440 v, 60 c
                     Specify voltage when ordering.
Number of V-belts ............... 3

threads and feeds
Lead screw, dia. ................. 11/4" — 4 Acme
Feed rod, dia. .................... 1"
Number of threads ................. 45
Range .......................... 4, 41/2, 43/4, 5, 51/2, 53/4, 6, 61/2, 7, 8, 9, 91/2,
                      10, 11, 111/2, 12, 13, 14, 16, 18, 19, 20, 22,
                      23, 24, 26, 28, 32, 36, 38, 40, 44, 46, 48, 52,
                      56, 64, 72, 76, 80, 88, 92, 96, 104, 112
Number of feeds .................. 45
Feed range ..................... 0.048" to 0.0017"
NOTE: Threads 4 thru 7 are obtained by using change gear furnished.

equipment furnished
Cabinet base with built-in chip pan, splash guards
and coolant tank. Two-speed motor. Allen-Bradley
magnetic-starter with reversing control. 14" face
plate, 8" driving plate. Two No. 4 MT centers,
reducing sleeve. Thread dial indicator. Follower
rest, tool post. Change gear. Wrenches. Instruction
and Parts List manual. (Design and specifications
are subject to change without notice.)
- 3\(\frac{1}{2}\)" spindle hole, L-2 taper key-drive hardened nose.
- Powerful, all-gearied headstock. 16 speeds. Induction hardened gears.
- Oil bath lubricated headstock and quick-change gear box.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- Induction hardened bed ways.
- Separate rod for power feeds — lead screw used for thread cutting only.
- Heavy tailstock with 2\(\frac{3}{8}\)" tanged spindle, lever-controlled locks.
- Two-speed, 4-8 hp motor.

- Built to American standards of tool room lathe accuracy — accuracy verified by factory test report.

**straight bed lathes**

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6542</td>
<td>17&quot;</td>
<td>78&quot;</td>
<td>120&quot;</td>
<td>4020 lb.</td>
<td>5160 lb.</td>
</tr>
</tbody>
</table>

**capacities**

- Swing over bed ........................................ 17"
- Swing over cross slide ................................ 10\(\frac{1}{8}\"
- Swing over carriage wings ............................ 16"
- Distance between centers, flush ................... 78"
- Face plate, dia. ....................................... 16"
- Driving plate, dia. ................................... 10"
- Follower rest, capacity .............................. 3"
- Steady rest, capacity ................................. 6"
tailstock
Spindle, dia. .................................. 2\(\frac{1}{10}\)" 
Center ........................................ No. 5 MT 
Spindle travel .................................. 6\(\frac{3}{4}\)" 
Spindle graduated .......................... 0" to 6" by \(\frac{1}{8}\)"

carriage and compound
Carriage length ........................... 20" 
Width of carriage bridge ....... 8\(\frac{3}{4}\)" 
Width of cross slide .................. 6\(\frac{3}{4}\)" 
Width of compound rest ........... 5\(\frac{1}{2}\)" 
Cross slide travel ..................... 10\(\frac{1}{2}\)" 
Compound rest travel ............... 6" 
Tool post slot .................. for \(\frac{3}{4}\)" square tools

spindle speeds
Spindle speeds .......................... 16 
Speed range, 1 pm .................. 20, 42, 55, 65, 84, 94, 130, 135, 187, 202, 270, 311, 405, 450, 622, 900

motor
Two speed .................. 8.4 hp, 1800/900 rpm, 3 ph. 
Specify voltage when ordering. 
Number of V-belts .................. 5

threads and feeds
Lead screw, dia. .................. 1\(\frac{1}{2}\)" — 4 Acme 
Feed rod, dia. .................. 1\(\frac{3}{4}\)" 
Number of threads ............... 45 
Range .......................... 4, 4\(\frac{1}{2}\), 4\(\frac{3}{4}\), 5, 5\(\frac{1}{2}\), 5\(\frac{3}{4}\), 6, 6\(\frac{1}{2}\), 7, 8, 9, 9\(\frac{1}{2}\), 10, 11, 11\(\frac{1}{2}\), 12, 13, 14, 16, 18, 19, 20, 22, 23, 24, 26, 28, 32, 36, 38, 40, 44, 46, 48, 52, 56, 64, 72, 76, 80, 88, 92, 96, 104, 112 
Number of feeds .................. 45 
Feed range .................. 0.050" to 0.0018"

NOTE: Threads 4 thru 7 are obtained by using change gear furnished.

equipment furnished
Cast-iron mounting bases with chip and coolant tray. Two-speed motor. Allen-Bradley magnetic-starter with reversing control. 16" face plate, 10" driving plate. Two No. 5 MT centers, reducing sleeve. Thread dial indicator. Follower rest, tool post. Change gear. Wrenches. Instruction and Parts List manual. (Design and specifications are subject to change without notice.)
- Removable bed block — provides 18” swing.
- All-geared headstock. 16 spindle speeds. Induction hardened gears.
- Oil bath lubricated headstock and quick-change box.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- L.0 taper key drive spindle nose. 1¾” boro. Hardened nose.
- Induction hardened bed ways.
- Separate rod for power feeds.
- Two-speed 1½-3 hp motor.

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6526</td>
<td>13”</td>
<td>24”</td>
<td>52½”</td>
<td>1350 lb.</td>
<td>1860 lb.</td>
</tr>
<tr>
<td>6527</td>
<td>13”</td>
<td>36”</td>
<td>64”</td>
<td>1410 lb.</td>
<td>1920 lb.</td>
</tr>
</tbody>
</table>

Swing in gap ................. 18”
Length of gap in front of face plate ........ 4½”
All other specifications same as those for 13” straight bed lathes — see page 7.

- Removable bed block provides 24” swing in gap.
- All-geared headstock. 16 spindle speeds. Induction hardened gears.
- Oil bath lubricated headstock and quick-change gear box.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- 2½⁄₁₆” hole thru spindle. L-1 hardened nose.
- Induction hardened bed ways.
- Separate rod for power feeds.
- Two-speed 2½-5 hp motor.

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6536</td>
<td>15”</td>
<td>30”</td>
<td>65”</td>
<td>2100 lb.</td>
<td>2700 lb.</td>
</tr>
<tr>
<td>6537</td>
<td>15”</td>
<td>48”</td>
<td>83”</td>
<td>2230 lb.</td>
<td>2970 lb.</td>
</tr>
</tbody>
</table>

Swing in gap ................. 24”
Length of gap in front of face plate ........ 6”
All other specifications same as those for 15” straight bed lathes — see page 9.

- 28” swing in gap.
- 3½⁄₆” spindle hole. L-2 tapered spindle nose. Nose is hardened.
- All-geared headstock. 16 speeds. Induction hardened gears.
- Oil bath lubricated headstock and quick-change box.
- Gamet Micron Precision tapered roller bearings with oil-flow lubrication.
- Induction hardened bed ways.
- Separate rod for power feeds — lead screw used for threading only.
- Two-speed 4-8 hp motor.

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Net Weight</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6554</td>
<td>17”</td>
<td>34”</td>
<td>96”</td>
<td>3720 lb.</td>
<td>4620 lb.</td>
</tr>
<tr>
<td>6543</td>
<td>17”</td>
<td>78”</td>
<td>120”</td>
<td>4020 lb.</td>
<td>5160 lb.</td>
</tr>
</tbody>
</table>

Swing in gap ................. 28”
Length of gap in front of face plate ........ 9½”
All other specifications same as those for 17” straight bed lathes — page 11.
accessories

burnerd 3-jaw griptru
direct mount
universal chucks

Concentricity within .0002" total indicator reading is the accuracy you can expect and get with Burnerd GRIPTRU chucks. Once the initial work piece is centered to the required tolerance, duplicate parts can be checked to the same accuracy without further adjustment. GRIPTRU's micro-adjusting mechanism eliminates the need for expensive fixtures... saves time, ups production.

Burnerd GRIPTRU chucks are built to retain their accuracy under the toughest conditions. Bodies are Mehanite, scrolls are heat-treated alloy steel forgings. Pinions are case-hardened nickel steel—three pinions for faster operation. Jaws are case-hardened. Furnished with two sets of jaws, one inside, one outside, and wrench.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>For Spindle</th>
<th>Jaws</th>
<th>Ship Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>131L0</td>
<td>6&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>25/4</td>
</tr>
<tr>
<td>151L0</td>
<td>8&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>58</td>
</tr>
<tr>
<td>151L1</td>
<td>8&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>61</td>
</tr>
<tr>
<td>154L1</td>
<td>10½&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>92</td>
</tr>
<tr>
<td>155L2</td>
<td>12&quot;</td>
<td>ASA—L-2</td>
<td>2 sets, solid</td>
<td>136</td>
</tr>
</tbody>
</table>

burnerd 3-jaw griptru
direct mount
universal chucks

Bodies are high-grade Mehanite for greater strength and long accurate service. Scrolls are precision-machined heat-treated alloy steel. Pinions are case-hardened nickel steel—there are three in each chuck. Jaws are case-hardened. Bodies, bearing and gripping surfaces of jaws are ground.

Universal chucks furnished with two sets of jaws have one inside set, one outside set. Chucks furnished with master jaws have one set of reversible hard tops. Soft blank jaws, and master jaws with soft tops are available — data on request.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>For Spindle</th>
<th>Jaws</th>
<th>Ship Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>31L0</td>
<td>6&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>25/4</td>
</tr>
<tr>
<td>31LO</td>
<td>6&quot;</td>
<td>ASA—L-0</td>
<td>Master w/reversible tops</td>
<td>25/4</td>
</tr>
<tr>
<td>52L0</td>
<td>7½&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>34</td>
</tr>
<tr>
<td>52LOT</td>
<td>7½&quot;</td>
<td>ASA—L-0</td>
<td>Master w/reversible tops</td>
<td>34</td>
</tr>
<tr>
<td>51L0</td>
<td>8&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>47</td>
</tr>
<tr>
<td>51LOT</td>
<td>8&quot;</td>
<td>ASA—L-0</td>
<td>Master w/reversible tops</td>
<td>47</td>
</tr>
<tr>
<td>51L1</td>
<td>8&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>51</td>
</tr>
<tr>
<td>51L1T</td>
<td>8&quot;</td>
<td>ASA—L-1</td>
<td>Master w/reversible tops</td>
<td>51</td>
</tr>
<tr>
<td>53L1</td>
<td>9&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>53</td>
</tr>
<tr>
<td>53L1T</td>
<td>9&quot;</td>
<td>ASA—L-1</td>
<td>Master w/reversible tops</td>
<td>53</td>
</tr>
<tr>
<td>53L2</td>
<td>9½&quot;</td>
<td>ASA—L-2</td>
<td>2 sets, solid</td>
<td>66</td>
</tr>
<tr>
<td>54L2</td>
<td>10½&quot;</td>
<td>ASA—L-2</td>
<td>2 sets, solid</td>
<td>94</td>
</tr>
<tr>
<td>54L2T</td>
<td>10½&quot;</td>
<td>ASA—L-2</td>
<td>Master w/reversible tops</td>
<td>94</td>
</tr>
<tr>
<td>55L2</td>
<td>12&quot;</td>
<td>ASA—L-2</td>
<td>2 sets, solid</td>
<td>136</td>
</tr>
<tr>
<td>55L2T</td>
<td>12&quot;</td>
<td>ASA—L-2</td>
<td>Master w/reversible tops</td>
<td>136</td>
</tr>
</tbody>
</table>

burnerd 6-jaw griptru
direct mount
universal chucks

Indispensable whoever soft or fragile materials or tubing must be chucked and machined to close tolerances. Chucking work to .0002" precision takes but one minute ... duplicate parts are checked to same accuracy at scroll-chuck speed. Furnished with two sets of jaws, one inside, one outside, and wrench.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>For Spindle</th>
<th>Jaws</th>
<th>Ship Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>131ZL0</td>
<td>6&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>27½</td>
</tr>
<tr>
<td>151ZL0</td>
<td>8&quot;</td>
<td>ASA—L-0</td>
<td>2 sets, solid</td>
<td>61</td>
</tr>
<tr>
<td>151ZL1</td>
<td>8&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>64</td>
</tr>
<tr>
<td>154ZL1</td>
<td>10½&quot;</td>
<td>ASA—L-1</td>
<td>2 sets, solid</td>
<td>98</td>
</tr>
<tr>
<td>155ZL2</td>
<td>12&quot;</td>
<td>ASA—L-2</td>
<td>2 sets, solid</td>
<td>142</td>
</tr>
</tbody>
</table>

burnerd 4-jaw griptru
direct mount
independent chucks

Burnerd heavy-duty independent chucks have rugged Mehanite bodies, case-hardened ground steel jaws, heat-treated operating screws. Jaws are reversible. Wrench furnished.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>For Spindle</th>
<th>Jaws</th>
<th>Ship Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>40L0</td>
<td>8&quot;</td>
<td>ASA—L-0</td>
<td>4, reversible</td>
<td>39</td>
</tr>
<tr>
<td>41L0</td>
<td>10&quot;</td>
<td>ASA—L-0</td>
<td>4, reversible</td>
<td>62</td>
</tr>
<tr>
<td>41L1</td>
<td>10&quot;</td>
<td>ASA—L-1</td>
<td>4, reversible</td>
<td>65</td>
</tr>
<tr>
<td>42L1</td>
<td>12&quot;</td>
<td>ASA—L-1</td>
<td>4, reversible</td>
<td>92</td>
</tr>
<tr>
<td>42L2</td>
<td>12&quot;</td>
<td>ASA—L-2</td>
<td>4, reversible</td>
<td>100</td>
</tr>
<tr>
<td>43L2</td>
<td>14&quot;</td>
<td>ASA—L-2</td>
<td>4, reversible</td>
<td>126</td>
</tr>
<tr>
<td>44L2</td>
<td>16&quot;</td>
<td>ASA—L-2</td>
<td>4, reversible</td>
<td>164</td>
</tr>
</tbody>
</table>

semi-finished back plates

Hole finish-bored for tapered spindle nose.

No. 13-218 BACK PLATE for ASA—L-0 spindle nose. 25 lb.
No. 15-417 BACK PLATE for ASA—L-1 spindle nose. 35 lb.
No. 17-519 BACK PLATE for ASA—L-2 spindle nose. 57 lb.
burned lever-operated
dead length
collet chucks
For rapid production chucking of
precision work with Multisize Collets.
Provide dead-length gripping action,
with instantaneous release of work
piece. Work may be chucked, ma-
machined and released without stopping
lathc. Collet tension instantly adjust-
able by hand from heaviest to lightest
grip. Bed linkage and clamp furnished.

Catalog Number For Spindle Bar Stock Capacity Max. Capacity Takes Collet Type Wt. Lb.
13-228 L-0 1/2 1/2 MC 35
15-428 L-2 2 2 MD 85
13-429 L-1 2 2 1/2 ME 78
17-528 L-2 2 1/2 2 1/2 ME 84

end stops A positive adjustable work stop for key operated collet
chucks. Easy to install, adjust, remove.

No. E515 END STOP. For No. KC15/L0. 2 lb.
No. E520 END STOP. For No. KC20/L1. 2 lb.
No. E525 END STOP. For Nos. KC25/L1, KC25/L2.

burned
multisize collets
Each Multisize has a stepless gripping range of 1/8" 10 will replace
at least 100 ordinary collets.

<table>
<thead>
<tr>
<th>USE WITH CHUCK NUMBERS:</th>
</tr>
</thead>
<tbody>
<tr>
<td>KC15/L0</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
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<tbody>
<tr>
<td>MC2 3</td>
<td>—</td>
<td>—</td>
<td>MC8 3</td>
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<td>MC3 3</td>
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<td>MC9 3</td>
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<td>MC19 3</td>
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<td>MC29 3</td>
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<td>MD9 3</td>
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<td>ME9 3</td>
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<td>MC31 3</td>
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<td>MC31 3</td>
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<td>MD10 3</td>
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<td>MC32 3</td>
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<td>ME11 3</td>
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<td>MC33 3</td>
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<td>ME13 3</td>
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<td>ME18 3</td>
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<td>MC41 3</td>
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<td>MC42 3</td>
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<td>ME19 3</td>
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<td>MC43 3</td>
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<td>MC43 3</td>
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<td>MC18 3</td>
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<td>MD20 3</td>
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<td>MC44 3</td>
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<td>MC44 3</td>
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<td>MC19 3</td>
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<td>ME20 3</td>
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<td>MC45 3</td>
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<td>MC20 3</td>
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<td>MD21 3</td>
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<td>MC46 3</td>
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<td>MC46 3</td>
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</tr>
</tbody>
</table>

No. MC14 SET of 11 MULTISIZE COLLETS in metal case.
Consists of collets No. MC3 thru MC13, listed above. 35 lb.
telescopic taper attachment

Has telescoping cross feed screw that eliminates the necessity of disengaging the cross feed for taper operations—doesn't interfere with regular use of cross slide. Screw turns on two ball thrust bearings in taper slide. Has two sets of graduations—one in degrees of taper, the other in inches per foot. Range, 10° both sides of center line (20° included angle) and 4" per foot.

**No. 13-215** TELESCOPIC TAPER ATTACHMENT for 13" lathes serial No. 32175 and higher. Working stroke, 12". 44 lb.

**No. 15-413** TELESCOPIC TAPER ATTACHMENT for 15" lathes serial No. 32687 and higher. Working stroke, 18". 85 lb.

**No. 17-512** TELESCOPIC TAPER ATTACHMENT for 17" lathes serial No. 32707 and higher. Working stroke, 18". 99 lb.

Plain Taper Attachments are available for 13" lathes serial No. 32174 and lower—15" lathes serial No. 32686 and lower—17" lathes serial No. 32706 and lower. Data on request.

**self-indexing hex bed turret**

for straight bed lathes

<table>
<thead>
<tr>
<th></th>
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<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>13-A51</td>
<td>13&quot;</td>
<td>5 1/8&quot;</td>
<td>7 1/2&quot; x 3&quot;</td>
<td>1&quot;</td>
<td>16 1/2&quot;</td>
<td>7 1/2&quot;</td>
<td>6 1/2&quot;</td>
</tr>
<tr>
<td>15-650</td>
<td>15&quot;</td>
<td>7&quot;</td>
<td>3 3/4&quot; x 4&quot;</td>
<td>1 1/2&quot;</td>
<td>16 1/2&quot;</td>
<td>7 1/2&quot;</td>
<td>6 1/2&quot;</td>
</tr>
<tr>
<td>17-650</td>
<td>17&quot;</td>
<td>7&quot;</td>
<td>3 3/4&quot; x 4&quot;</td>
<td>1 1/2&quot;</td>
<td>16 1/2&quot;</td>
<td>7 1/2&quot;</td>
<td>6 1/2&quot;</td>
</tr>
</tbody>
</table>

Turret must be fitted to lathe bed, and holes for tool holders must be bored and reamed on lathe with which turret is to be used.

**turret tool post**

Mounts in tool post slot. Each tool has 3 working positions:

<table>
<thead>
<tr>
<th>Order No.</th>
<th>For Lathe</th>
<th>Tool Size Range</th>
<th>Tool Block Specifications</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>13-4 1/2-5</td>
<td>13&quot;</td>
<td>3/4&quot;</td>
<td>4 TOOL—12 POSITION 4 1/2&quot; sq. x 2 1/2&quot; thick</td>
<td>13 lb.</td>
</tr>
<tr>
<td>13-4 1/2-R</td>
<td>15&quot;</td>
<td>3/4&quot; solid tool or #10 holder</td>
<td>4 TOOL—12 POSITION 4 1/2&quot; sq. x 2 1/2&quot; thick</td>
<td>17 lb.</td>
</tr>
<tr>
<td>17-0-5</td>
<td>17&quot;</td>
<td>#1 solid tool or #1 holder</td>
<td>4 TOOL—12 POSITION 0&quot; sq. x 3 1/2&quot; thick</td>
<td>33 lb.</td>
</tr>
</tbody>
</table>

**rear tool post**

Permits additional operation from rear of cross slide. Mounts quickly, easily on cross slide of lathes listed below.

**No. 13-217** REAR TOOL POST for 13" lathes serial No. 32175 and higher. 15 lb.

**No. 15-418** REAR TOOL POST for 15" lathes serial No. 32687 and higher. 40 lb.

**No. 17-524** REAR TOOL POST for 17" lathes serial No. 32707 and higher. 50 lb.
**five-position carriage stop**

Accurate indexing thru lever control is provided by steel ball under spring tension. Mounts on lathe carriage. Furnished with One-Position Stop, listed below.

- **No. 13-216** 5-POSITION CARRIAGE STOP for 13" lathes serial No. 33162 and higher, 3½ lb.
- **No. 15-416** 5-POSITION CARRIAGE STOP for 15" lathes serial No. 33192 and higher, 4 lb.
- **No. 17-515** 5-POSITION CARRIAGE STOP for 17" lathes serial No. 33207 and higher, 5 lb.

**one-position carriage stop**

Clamps on front bed way on either side of carriage. Same as furnished with 5-Position Carriage Stop.

- **No. 13-214** ONE-POSITION CARRIAGE STOP for 13" lathe, 2 lb.
- **No. 15-414** ONE-POSITION CARRIAGE STOP for 15" lathe, 3 lb.
- **No. 17-514** ONE-POSITION CARRIAGE STOP for 17" lathe, 3 lb.

**micro carriage stop**

Clamps on front bed way. Micrometer control graduated in .001" — hardened stop locks securely in any position.

- **No. 13-2000** MICRO CARRIAGE STOP for Clausing 13" lathes, 3 lb.
- **No. 15-4000** MICRO CARRIAGE STOP for Clausing 15" lathes, 3 lb.
- **No. 17-2000** MICRO CARRIAGE STOP for Clausing 17" lathes, 4 lb.

**gamet rotating center**

Gamet rotating centers are ideal for high speeds and heavy roughing cuts. Point rotates on tapered roller bearings. Bearings are grease packed, pre-loaded and sealed. 60° replaceable points.

- **No. 13-215** GAMET ROTATING CENTER with No. 3 MT shank for 13" lathes, and for 15" lathes serial No. 37105 and lower, 2 lb.
- **No. 17-516** GAMET ROTATING CENTER with No. 4 MT shank for 15" lathes serial No. 37106 and higher, and for 17" lathes serial No. 37716 and lower, 3 lb.
- **No. 17-529** GAMET ROTATING CENTER with No. 5 MT shank for 17" lathes serial No. 37717 and higher, 4 lb.

**face plates for gap bed lathes**

Finish machined, ready to mount on lathe spindle nose.

- **No. 13-303** 18" FACE PLATE for ASA—L-0 spindle nose, 65 lb.
- **No. 15-403** 21" FACE PLATE for ASA—L-1 spindle nose, 105 lb.
- **No. 17-503** 25" FACE PLATE for ASA—L-2 spindle nose, 180 lb.

**steady rest**

- **No. 13-210** STEADY REST for 13" lathes, 4" dia. max. bar capacity, 24 lb.
- **No. 15-410** STEADY REST for 15" lathes, 5" dia. max. bar capacity, 40 lb.
- **No. 17-511** STEADY REST for 17" lathes, 6" dia. max. bar capacity, 60 lb.

**coolant system**

Consists of motor, circulating pump, switch, piping and connections. Patented ball-type shutoff valve permits easy control of coolant flow. Pump capacity is 3½ gallons per minute. Tank capacity, 5 gallons. Pump for 13" and 15" lathes mounts in built-in tank in lathe base — both readily accessible through door in front of lathe. Pump and tank for 17" lathe mount on floor beneath chip pan.

- **No. 13-208** COOLANT SYSTEM for 13" lathes, 37 lb.
- **No. 15-408** COOLANT SYSTEM for 15" lathes, 37 lb.
- **No. 17-508** COOLANT SYSTEM for 17" lathes, 40 lb.
hydraulic tracer attachment

EQUIPS LATHE FOR AUTOMATIC DUPLICATION OF MULTIPLE DIAMETERS, 90° SHOULDERS, TAPPERS, BEAVERS, RADIUS, GROOVES, CHAMFERS AND UNDERCUTS. DOES NOT INTERFERE WITH STANDARD LATHE OPERATIONS.

MOUNTS ON REAR OF CARTRIDGE CROSS SLIDE AT 60° TO AXIS OF LATHE BED. ANGLE SLIDE IS POWERED BY AN INTEGRAL HYDRAULIC CYLINDER. STYLIST ARM PIVOTS ON BALL BEARINGS. CAPACITIES ARE INDICATED BELOW.

COMPLETE WITH MOTOR AND INTEGRAL PUMP, RESERVOIR, LINES, SWITCH, TEMPLATE CENTERS AND SUPPORT BAR. EASILY INSTALLED—HOLES FOR UNIT ARE PRE-DRILLED AND TAPPED.

**No. 13-225** for 13" x 24" lathes, 307 lb.  **No. 15-326** for 15" x 48" lathes, 307 lb.
**No. 13-226** for 13" x 36" lathes, 307 lb.  **No. 17-525** for 17" x 54" lathes, 588 lb.
**No. 15-325** for 15" x 30" lathes, 307 lb.  **No. 17-526** for 17" x 78" lathes, 588 lb.

<table>
<thead>
<tr>
<th>Tracer for Lathe</th>
<th>13&quot;</th>
<th>15&quot;</th>
<th>17&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. Profiling Dia., One Setting</td>
<td>5&quot;</td>
<td>4½&quot;</td>
<td>0-6&quot;, 6-12&quot;</td>
</tr>
<tr>
<td>Max. Template Dia.</td>
<td>5&quot;</td>
<td>4½&quot;</td>
<td>9&quot;</td>
</tr>
<tr>
<td>Max. Copying Length, Straight Bed</td>
<td>31&quot;</td>
<td>24&quot;, 32&quot;</td>
<td>67&quot;</td>
</tr>
<tr>
<td>Max. Copying Length, Gap Bed</td>
<td>27&quot;</td>
<td>27&quot;, 40&quot;</td>
<td>44&quot;, 67&quot;</td>
</tr>
</tbody>
</table>

Specify serial number when ordering for installation on lathe in field.

---

hi-speed thread cutting unit

A CLAUSING-COLCHESTER LATHE EQUIPPED WITH A HI-SPEED THREAD CUTTING UNIT—

★ Cuts threads 5 times faster than by normal methods ★ threads tight to a shoulder at maximum speed ★ eliminates rejects incurred in thread cutting ★ takes full advantage of carbide tools ★ does not restrict normal use of lathe.

Cutting a 13/8"-16 thread ... at 1200 rpm ... is an example of the production obtained with this unit on a Clauising-Colchester lathe. And precision threads are cut every time! The Hi-Speed Unit contains its own half-nuts and engagement mechanism that eliminates all danger of a thread's being "picked up" incorrectly. Tool can't run into work or chuck—adjustable stop disengages half-nuts automatically.

Operation is simple, fool-proof. Pull the handle, and half-nuts engage at the correct point. Carriage travels to pre-set stop which disengages half-nuts. Operator then backs out tool, returns carriage to starting point, feeds the tool and presses starting lever.

Unit is easily installed on lathes in field.

**No. 13-227** for Clauising-Colchester 13" lathes, 23 lb.
**No. 15-427** for Clauising-Colchester 15" lathes, 25 lb.
**No. 17-527** for Clauising-Colchester 17" lathes, 36 lb.
Clausing-Colchester lathes are built to American Standards of tool room lathe accuracy—each must pass tests similar to those shown below. Inspection after inspection, and test after test assure that every lathe measures up to rigid specifications of construction and performance.

The Clausing-Colchester name plate is a symbol of quality, precision and value.

<table>
<thead>
<tr>
<th>TEST</th>
<th>PERMISSIBLE ERROR</th>
<th>ACTUAL ERROR</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>BED LEVEL—TRANSVERSE DIRECTION</td>
<td>When using Precision Level all Readings to be within 0.006 in 12 in. of Bed Length</td>
</tr>
<tr>
<td>2</td>
<td>BED LEVEL—LONGITUDINAL DIRECTION</td>
<td>When using Precision Level along Bed Maximum Reading to be within 0.005 in 12 in. of Bed Length</td>
</tr>
<tr>
<td>3</td>
<td>TAILSTOCK WAY ALIGNMENT</td>
<td>Maximum Reading along length of Bed 0.005 in 48 in.</td>
</tr>
<tr>
<td>4</td>
<td>SPINDLE CENTER RUNOUT</td>
<td>Total Indicator Reading 0 to 0.0004</td>
</tr>
<tr>
<td>5</td>
<td>SPINDLE NOSE RUNOUT</td>
<td>Total Indicator Reading 0 to 0.0003</td>
</tr>
<tr>
<td>6</td>
<td>CAM ACTION OF SPINDLE</td>
<td>Total Indicator Reading with Indicator on rear side of Test Plate 0 to 0.0003</td>
</tr>
<tr>
<td>7</td>
<td>SPINDLE TAPER RUNOUT</td>
<td>Total Indicator Reading at end of 12 in. Test Bar at end of Spindle Nose 0 to 0.0003</td>
</tr>
<tr>
<td>8</td>
<td>HEADSTOCK ALIGNMENT—VERTICAL</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>HEADSTOCK ALIGNMENT—HORIZONTAL</td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>TAILSTOCK SPINDLE ALIGNMENT—HORIZONTAL</td>
<td>Forward at end of Spindle when fully extended 0 to 0.0006</td>
</tr>
<tr>
<td>11</td>
<td>TAILSTOCK SPINDLE ALIGNMENT—VERTICAL</td>
<td></td>
</tr>
<tr>
<td>12</td>
<td>TAILSTOCK TAPER ALIGNMENT—HORIZONTAL</td>
<td>End of 12 in. Test Bar 0 to 0.0005</td>
</tr>
<tr>
<td>13</td>
<td>TAILSTOCK TAPER ALIGNMENT—VERTICAL</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>VERTICAL ALIGNMENT OF HEAD AND TAIL CENTERS</td>
<td>High at Tailstock 0 to 0.001</td>
</tr>
<tr>
<td>15</td>
<td>LEAD SCREW CAM ACTION</td>
<td>Maximum 0.0003</td>
</tr>
<tr>
<td>16</td>
<td>CROSS SLIDE ALIGNMENT</td>
<td>To face hollow or concave only on 12 in. diameter 0 to 0.0005</td>
</tr>
<tr>
<td>17</td>
<td>FACE PLATE RUNOUT</td>
<td>On diameter 0 to 0.0005 on face at normal diameter 0 to 0.001</td>
</tr>
<tr>
<td>18</td>
<td>WORK MOUNTED IN CHUCK</td>
<td>Must turn round 0.0003 Must turn cylindrical on 12 in. length of workpiece 0.0008</td>
</tr>
<tr>
<td>19</td>
<td>WORK MOUNTED IN CENTERS</td>
<td>Must turn cylindrical on a 12 in. length of workpiece 0.0004</td>
</tr>
<tr>
<td>20</td>
<td>LEAD SCREW LEAD PER FT.</td>
<td></td>
</tr>
<tr>
<td>21</td>
<td>BACK LASH ON CROSS FEED SCREW</td>
<td></td>
</tr>
</tbody>
</table>

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