Clausing lathes are characterized by "dependable accuracy ... versatility ... ease and speed of operation ... ability to 'take it' under grueling operating conditions." The design and construction features that contribute to their superior performance are detailed on the following pages.

There's a Clausing for every type of shop — production, tool room, experimental, school and service. A comparison will quickly show their outstanding value — Clausing is truly the plus value line.

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**6300-series 12¾" lathes**

1½" bore. ASA—L-00 spindle nose. Enclosed headstock, apron, quick-change box—all with oil bath lubrication. Flame hardened bed ways. Timken "Zero Precision" tapered roller bearings. Underneath drive, with choice of variable speed countershaft, 10-speed clutch and brake-equipped countershaft, one or two-speed motors. Out-board spindle-drive pulley.

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**5400-series 12¾" lathes**

1½" bore. 2½" - 8 threaded spindle nose. Double-walled apron, oil bath lubrication. Flame hardened bed ways. Timken "Zero Precision" tapered roller bearings. Underneath drive, with choice of variable speed countershaft with clutch and brake, 10-speed countershaft, one or two-speed motors.

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**4800-series 12¾" lathes**

The Clausing Hydra-Cycle assures maximum economies by performing several machining operations simultaneously or in continuous sequence, to close tolerance.

When the machine is set up for a job, the operator merely loads, presses the starter button, and unloads the finished piece seconds later—the machining operations are performed automatically.

Ease and speed of set up, and low initial and operating costs make it practicable for short as well as long production runs.

Turning, boring, facing, forming, grooving, chamfering, beveling, cut-off—there’s a Hydra-Cycle for handling these operations in combination or singly, as detailed on the following pages.
Load . . . press the starter button . . .
take out machined piece seconds later.

Hydra-Cycle 6415 has hydraulically operated cross slide mounted on hydraulically operated longitudinal table. Four operating cycles are available thru dial selector on control panel.

Cycle 1. Rapid traverse of table—feed to positive stop—rapid return.
Cycle 2. Rapid traverse of table—feed to positive stop—rapid traverse of cross slide—feed to positive stop—rapid return of table and cross slide.
Cycle 3. Rapid traverse of cross slide—feed to positive stop—rapid return. Table is stationary.
Cycle 4. Rapid traverse of table—feed to positive stop—rapid traverse of cross slide—feed to positive stop—rapid return of cross slide—rapid return of table.

At end of cycle, spindle is stopped almost instantly by magnetic brake engaged automatically.

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Hydra-Cycle 6415 has hydraulically operated cross slide and hydraulically operated table, both mounted on bed. It is especially suited to applications where simultaneous cross and longitudinal operations are indicated. Cycles 1, 2 and 3 may be used.

Cycle 1. Rapid traverse of table—feed to positive stop—rapid return. Cross slide is stationary.
Cycle 2. Simultaneous rapid traverse of table and cross slide—both feed to positive stops—rapid return.
Cycle 3. Rapid traverse of cross slide—feed to positive stop—rapid return. Table is stationary.

At end of cycle, spindle stops automatically.
... turn, bore, face, form, groove, chamfer, cut off ...

Hydra-Cycle 6400 has hydraulically operated longitudinal table for turning, boring, drilling, chamfering, plunging. Table may be fed at selected speed for full 8” travel ... it may be advanced at rapid traverse to work where it automatically shifts to selected feed rate ... or it may be set to skip-feed. Also, work may be mounted on table and tool in spindle. Machine operates on cycle 1.

Cycle 1. Rapid traverse of table—feed to positive stop—rapid return.

Spindle stops automatically at end of cycle.

SPECIFICATIONS
- Swing over table: 9”
- Table size: 13” x 14”
- Table travel: 8”
- 4 T-slots, 5” centers, for 5/8” bolts

Hydra-Cycle 6410 has hydraulically operated cross slide mounted on bed for operations such as facing, grooving, forming, chamfering, beveling. With proper arrangement of tools these operations may be performed simultaneously. Cross slide may also be used for cut off. Cycle 3 is used.

Cycle 3. Rapid traverse of cross slide—feed to positive stop—rapid return.

Spindle stops automatically at end of cycle.

SPECIFICATIONS
- Swing over cross slide: 7”
- Cross slide size: 5” x 16”
- Cross slide travel: 5”
- 2 T-slots, 2 1/2” centers, for 3/8” bolts

No. 6400  $4150.00

No. 6410  $4250.00
The hydraulic power unit furnished consists of a 3 gallon per minute pump, with a maximum pressure of 300 P.S.I. Pump is driven by a 3/4 HP motor. A 5 1/4 gallon oil tank mounted on machine base, an adjustable relief valve, pressure gauge and oil filter are supplied.

Headstock spindle turns on "Zero Precision" Timken tapered roller bearings that are held to a tolerance of .00015". Spindle is forged precision-ground steel with 1-3/8" bore and 1" collet capacity. Hardened and ground nose is L-00 tapered key-locked. Headstock is completely enclosed—pump provides continuous lubrication.

Spindle drive motor furnished is 2 HP, 2-speed, constant HP, continuous duty, equipped with magnetic brake. 5-step pulleys provide 10 speeds between 180 and 1960 RPM. 3 modified wedge belts assure full transmission of power from countershaft to spindle. Countershaft spindle turns on ball bearings.

V-ways and flat ways of bed are flame-hardened and precision ground. Bed is a single, massive, semi-steel iron casting, thickly ribbed and braced. Base is 3/16" steel plate—a rigid mount for the machine.

Air chucks, air collets, air expanding mandrels may be used for efficiency in holding of work.

Air controls furnished are located for convenient operation of chucking equipment. Air equipment includes hand operated control valve, regulator valve, gauge, lubricating unit and filter.

Prices, design and specifications are subject to change without notice, and those in effect at date of shipment will apply. Prices are F.O.B. factory.
Easy to set up . . .

simple to operate

Each Clausing Hydra-Cycle comes completely assembled and ready to perform the cycle—or cycles—described. Connect to electrical line, turn cycle-selector and push the buttons—the machine is running.

Work set-ups are easy, fast and inexpensive—simple block tool holders, carbide insert bits and standard boring bars will handle most jobs.

And the prime requirement of an operator is speed in loading and unloading—load, push one button, unload—the machine does the rest, automatically.

All electrical controls are conveniently located at top of headstock. Toggle switch on control panel may be set so spindle stops automatically at end of cycle, or continues running if desired. The other toggle switch permits jogging table for ease and speed in setting up. Switches are interlocked so spindle and cycle will not operate unless pump is running—pilot lights indicate when pump is operating and machine cycling.

12” x 14” table is precision ground and hand fitted to the ways. Has 4 T-slots for holding tools or work. Travel is 8” at any setting. Has easily adjustable positive stop.

Precision ground cross slide is 5” x 16”. Has 2 T-slots for holding tools or work. Two positive stops. 5” maximum travel at any setting.

Table and cross slide are fed by hydraulic cylinders. Feed of each is infinitely variable between 3/16” and 60” per minute, readily adjusted by valve controls.

Feed rate may be constant from starting position, or at rapid traverse to feed position determined simply by the setting of a cam. Skip feeding is obtained by using cam of profile required.
Let Us Figure Your Job

Our engineering department will gladly make recommendations for the most effective use of the Hydra-Cycle — no obligation. Send complete information — drawings of rough and finish part, indicating material, tolerances, finish required, production rate — and, samples of finished and unfinished parts.

Mail to Hydra-Cycle Department, Clausing Division, Atlas Press Company, Kalamazoo, Michigan.

All the operator has to do is load the machine, press a button, take out the machined piece seconds later. The Hydra-Cycle does the rest, automatically, as illustrated at the right.

Six surfaces are machined in the operation illustrated below. As is the case with most jobs that can be handled by the Hydra-Cycle, the tooling required is simple, inexpensive.

The pieces shown above merely suggest the almost endless variety of jobs the Clausing Hydra-Cycle will handle efficiently and economically. Check your work against the specifications listed below.

Specifications

Spindle
“Zero Precision” Timken tapered roller bearings; runs in enclosed headstock with pumped bath of oil; hardened nose is tapered key-type L-00; 1 3/8” hole, 1” collet capacity; internal taper, No. 4 1/2 MT.

Spindle Speeds
Spindle is driven by 2 HP, 2-speed motor. Speeds, at 900 RPM: 180, 250, 635, 790, 980 Speeds, at 1800 RPM: 560, 500, 1270, 1580, 1960

Feeds, Table and Cross Slide
Infininely variable between 3 1/16” and 60” per minute.

Bed
59” long, with 40” right of headstock; flame hardened ways, precision-ground, 2 V and 2 flat ways; swing over bed, 12 3/4”.

Electricals
Spindle drive motor is 2 HP, 2-speed (900-1800 RPM), 3 phase, 220 or 440 V, A.C., 60 cycle, constant HP, continuous duty, class B insulation, equipped with magnetic brake. Pump motor is 220-440 V, 60 C, 3 phase. Switches in control panel operate on 110 V, 60 C, single phase.

Standard Equipment
Hydra-Cycle lathes are furnished as illustrated with steel base, spindle drive motor, hydraulic pump and motor, 5 1/2 gallon reservoir tank, all hydraulic and electrical controls — completely assembled ready for operation. Also furnished — air control panel with hand operated control valve, regulator, gauge, filter and lubricating unit for operating air chuck or collets.

Floor Space Required . . . 35” wide x 83” long.
The plus value features of the new Clausing lathes give you more production capacity and profit potential than have ever before been available in comparable lathes ... at or near their price.

Flame hardened bed ways are standard equipment at no extra cost on all Clausing lathes — a feature that adds years to service and accuracy life. Ways are precision ground to close tolerance after hardening. Beds are massive, close-grained, semi-steel, thickly ribbed and braced for maximum rigidity. Ways — two V-ways and two flat ways — are integral with bed. Casting is rough machined, then naturally aged before hardening and grinding. The Clausing bed is a rugged, precision foundation that maintains alignment of headstock, carriage and tailstock under heavy loads.

The one-piece, double-walled, box-type apron is a rigid housing for the feed mechanism. Gears run on ground steel shafts supported in both front and back walls of apron. Gears and shafts run in bath of oil.

Power feeds are engaged by a positive clutch working through worm and worm gear. Shift knob on face of apron is pushed in and down to engage cross feed — moved out and up for longitudinal feed. Key way in lead screw drives cross and longitudinal feeds. Half-nuts and threads on lead screw are used for threading only. Half-nuts travel in dovetail slide on back wall of apron. Built-in safety lock prevents engaging feeds and half-nuts at same time. Threading dial is furnished.

Saddle bearing surfaces are hand scraped to ways. Plate on each side of saddle bears on bottom of bed ways, preventing lift and twist. Four bed wipers clean and oil the ways. Back of saddle is machined to receive taper attachment. Cross slide bridge is wide and deep — a rigid support for the compound rest. Dovetail ways for cross slide are precision ground. Tops of saddle wings have large ground surfaces for accurate mounting of dial indicators and fixtures. Lock screw anchors saddle to the bed for facing or cut-off operations.

Large diameter Acme thread feed screws, ground dovetail ways and bearing surfaces assure smooth, accurate operation. Gibs provide easy adjustment for wear. Large micrometer feed dials have lock screws for quick positioning.

Tailstock has a No. 3 MT ram with tang socket to handle big tools without slippage — long key guide that absorbs heavy torque loads — large coordinate-type lock — graduations, 0 to 5' by 16ths. Tailstock weighs 26 pounds — a rugged support. Swing-type wrench, permanently attached, controls bed lock. Wipers clean and oil the ways.

Spindles of 6300 and 5400-series lathes turn on large, "Zero Precision" Timken tapered roller bearings. They are made from steel forgings — precision ground to 100% of their entire length — have hardened nose. 4800-series lathe spindles are precision ground alloy steel — turn on selected Timken tapered roller bearings.

Other features of Clausing plus value lathes are described on the following pages.
CLAUSING 12 3/4"
6300-series Lathes

Clausing 6300-series lathes have more advanced design features than any other lathe of comparable size and price.

The headstock is completely enclosed — all gears, shafts, bearings and spindle bearings travel in a pumped bath of oil. No need to get inside headstock — back gears are engaged by pulling handwheel at rear of spindle and moving back gear lever forward. Lead screw reverse lever is conveniently located on front of headstock. Enclosed, box construction provides the rigidity essential for heavy-duty work.

Spindle is machined from a steel forging and precision-ground its entire length. Has 1 3/8" bore. Hardened and ground nose is ASA—L-00 taper key-locked.

Spindle turns on big Timken "Zero Precision" tapered roller bearings. Held to a tolerance of .00015", these fine bearings assure precision performance, long accuracy life, and permit high spindle-speed work, as well as turning at normal speeds.

Quick-change mechanism provides instant selection of 54 threads and feeds. Box is totally enclosed, and mechanism runs in bath of oil for longer service and smoother operation. Gears are 1/2" wide steel, shafts are ground steel. Stack gear shaft turns on ball bearings — other gear shafts in box ride on heavy-duty Oilite bronze bearings. Over-ride clutch prevents tooth damage by assuring proper meshing of stack gears. Box construction assures maximum rigidity.

Lead screw is 7/8" diameter... turns on two Timken tapered roller bearings in gear box to eliminate end play. Has easy-to-replace shear pin.

6300-series lathes are available with choice of two heavy-duty
underneath drives — a variable speed drive, and a 10-speed ball bearing countershaft with clutch and brake.

Lathes with HEAVY-DUTY VARIABLE SPEED COUNTERSHAFT increase production on all operations requiring a variety of spindle speeds by making instantly available any speed between 43 and 222 RPM in back gear drive, and 250 to 1300 RPM in open drive, while lathe is running. Spindle speed range with two-speed motor is 21 to 222 and 125 to 1300 RPM. No need to stop lathe or shift belts. Speeds are changed by turning handwheel on front of lathe cabinet. Easy-to-read chart shows spindle speed selected.

Variable drive pulleys are heat-treated aluminum alloy — turn on self-lubricating bronze bearings. Center disc has integrally cast bronze bearing that slides on ground, chrome-plated steel sleeve. Shaft is hardened, ground and polished steel. Power is transmitted through two heat-resistant, oil-proof cog belts designed especially for variable speed drives.

Lathes with 10-SPEED COUNTERSHAFT WITH CLUTCH AND BRAKE have spindle speeds from 30 to 1300 RPM — five direct, five back geared. Two-speed motor provides 18 spindle speeds from 15 to 1300 RPM. Power is transferred from motor to countershaft thru 5-step V-belt pulleys, and two V-belts drive the spindle. Spindle pulley is outboard — replacing belts is a quick, easy job. Convenient shift lever slacks belt for belt-position changes. Tension is adjusted and maintained by spring mechanism.

Clutch and brake permit instant starts and stops of spindle without stopping motor. Shifting clutch lever to right engages spindle drive, to the left disengages it, and moving lever to extreme left tightens brake shoe, stopping spindle instantly. Lever is conveniently located on front of base.

Clutch is multiple disc, dry operating, with heat-treated steel plates. Shifter has lubricated-for-life ball bearing. Countershaft spindle is ground steel, 63/64” diameter — turns on 3 lubricated-for-life ball bearings. Countershaft pulley turns on 2 lubricated-for-life ball bearings.

There are six ball bearings in the 6300-series countershaft, and the unit is supported in cabinet thru four vibration dampeners — for smoothness and long service life.

Pedestal cabinet furnished is 3/16” steel plate — a rigid, convenient mount. Top is chip pan — has knock-out plug for drain. Column has door for easy access to drive. Tailstock column has two drawers.
6300 - series lathes with variable speed countershaft

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Countershaft</th>
<th>Shipping Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6328</td>
<td>12½&quot;</td>
<td>21½&quot;</td>
<td>47&quot;</td>
<td>Variable Speed</td>
<td>1045</td>
</tr>
<tr>
<td>6329</td>
<td>12½&quot;</td>
<td>33½&quot;</td>
<td>59&quot;</td>
<td>Variable Speed</td>
<td>1110</td>
</tr>
<tr>
<td>6330</td>
<td>12½&quot;</td>
<td>47&quot;</td>
<td>72½&quot;</td>
<td>Variable Speed</td>
<td>1225</td>
</tr>
</tbody>
</table>

Note: If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used.

**MOTORS**

**One Speed Motors**

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2762</td>
<td>Single</td>
<td>1</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot; 50</td>
</tr>
<tr>
<td>2872</td>
<td>Single</td>
<td>1½</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot; 82</td>
</tr>
<tr>
<td>2862</td>
<td>Three</td>
<td>1</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot; 70</td>
</tr>
<tr>
<td>2871</td>
<td>Three</td>
<td>1½</td>
<td>208/220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot; 68</td>
</tr>
<tr>
<td>2867*</td>
<td>Three</td>
<td>1½</td>
<td>208/220/440</td>
<td>60</td>
<td>1140</td>
<td>7/8&quot; 90</td>
</tr>
</tbody>
</table>

*1140 RPM 1½ HP motor recommended for heavy-duty use with variable-speed drive lathes.

**Two Speed Constant Horsepower Motors**

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2876</td>
<td>Three</td>
<td>1½</td>
<td>220</td>
<td>60</td>
<td>1800-900</td>
<td>1-1/8&quot; 110</td>
</tr>
<tr>
<td>2877</td>
<td>Three</td>
<td>1½</td>
<td>440</td>
<td>60</td>
<td>1800-900</td>
<td>1-1/8&quot; 110</td>
</tr>
</tbody>
</table>

Motors for use with 208 and 550 volts also available. Price on request. Note: All motors listed operate satisfactorily on a 10% voltage variation. Other voltages and cycles available.

No. 7618 PUSH BUTTON REVERSING SWITCH for one speed, single and three phase motors. A heavy-duty, double-throw switch that provides across-the-line starting, stopping and reversing. Mounting bracket and cable furnished. 7 lb.

No. 7639 REVERSING SWITCH for three phase, two speed motors. A heavy-duty switch for starting, stopping, reversing and changing speed. Mounting bracket and cable furnished. 7 lb.

Motor and reversing switch are installed and wired when ordered with lathe from factory.
CAPACITIES AND CLEARANCES
Swing over bed ........................................... 12\(\frac{3}{4}\)"
Swing over saddle wings ................................... 12\(\frac{1}{8}\"
Swing over cross slide .................................... 7\(\frac{7}{8}\"
Swing over compound rest ................................ 3\(\frac{3}{4}\"
Distance between centers .............................. 21\(\frac{1}{2}\" - 33\(\frac{1}{2}\" - 47"
Face plate diameter ..................................... 6"

SPINDLE SPEEDS
Range with 1-speed motor ............... infinite between 43 and 222 RPM in back gear drive and 250 to 1300 RPM in open drive.
Range with 2-speed motor ............... infinite between 22 and 222 RPM in back gear drive and 125 to 1300 RPM in direct drive.

HEADSTOCK
Hole thru spindle ....................................... 1\(\frac{3}{8}\"
Maximum collet capacity — spindle nose type .......... 1\(\frac{3}{8}\"
Maximum collet capacity — lever type .................. 1\(\frac{1}{8}\"
Maximum collet capacity — draw bar type .............. 1"
Spindle nose .................................. tapered key-type, ASA—L-00
Spindle nose internal taper ......................... No. 4\(\frac{1}{2}\) MT
Taper in spindle nose bushing ....................... No. 3 MT
Size of center — Morse taper .......................... No. 3 MT
Spindle bearings, Timken "Zero Precision" tapered roller
Spindle belt .................................... variable speed cog belt, 1" wide

BED
Flame hardened ways ............................. 2 V-ways, 2 flat ways
Length ..................................... 47", 50", 73\(\frac{1}{2}\"
Width ....................................... 7\(\frac{7}{8}\"
Depth ................................... 5\(\frac{1}{4}\" deep: 47" centers lathe, 6" deep

CROSS SLIDE AND COMPOUND
Cross slide travel ..................................... 9\(\frac{1}{8}\"
Cross feed screw ....................... 1\(\frac{1}{2}\" dia., 10 Acme threads per inch
Compound rest ................................ graduated 0-90° left and right
Compound travel ................................ 2\(\frac{3}{8}\"
Tool post .................................. 5\(\frac{1}{8}\" x 2" slot. Takes 1\(\frac{1}{2}\" tool bits or tool holder for 5/16" bits

TAILSTOCK
Size of Morse taper center ......................... No. 3
Spindle travel ..................................... 3"
Spindle diameter .................................. 1\(\frac{3}{8}\"
Spindle graduated .................................. 0-3" by 1/16"
Tailstock set-over .................................. 1"

MOTOR
Horsepower recommended ..................... 1 or 1\(\frac{1}{2}\"
RPM recommended, One-speed .................. 1140 or 1725
Two-speed .................................. 1800-500
NFMA frame sizes .......................... 56, 182, 184, 203, 204, 215, 224

Note: If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used. 1140 RPM 1\(\frac{1}{2}\) HP motor is recommended for heavy-duty use with Variable-Speed drive lathes.

EQUIPMENT FURNISHED
6300-series lathes with 10-speed clutch and brake countershaft

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Countershaft Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>6338</td>
<td>12 3/4&quot;</td>
<td>21 1/2&quot;</td>
<td>47&quot;</td>
<td>10 speed, Clutch and Brake 1100</td>
</tr>
<tr>
<td>6339</td>
<td>12 3/4&quot;</td>
<td>33 1/2&quot;</td>
<td>59&quot;</td>
<td>10 speed, Clutch and Brake 1150</td>
</tr>
<tr>
<td>6340</td>
<td>12 3/4&quot;</td>
<td>47&quot;</td>
<td>72 1/2&quot;</td>
<td>10 speed, Clutch and Brake 1260</td>
</tr>
</tbody>
</table>

Note: If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used.

MOTORS

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2762</td>
<td>Single</td>
<td>1</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>50</td>
</tr>
<tr>
<td>2763</td>
<td>Single</td>
<td>1 1/2</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>82</td>
</tr>
<tr>
<td>2862</td>
<td>Three</td>
<td>1</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>70</td>
</tr>
<tr>
<td>2871</td>
<td>Three</td>
<td>1 1/2</td>
<td>208/220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>68</td>
</tr>
</tbody>
</table>

Two Speed Constant Horsepower Motors

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2876</td>
<td>Three</td>
<td>1 1/2</td>
<td>220</td>
<td>60</td>
<td>1800-900</td>
<td>1 1/2&quot;</td>
<td>110</td>
</tr>
<tr>
<td>2877</td>
<td>Three</td>
<td>1 1/2</td>
<td>440</td>
<td>60</td>
<td>1800-900</td>
<td>1 1/4&quot;</td>
<td>110</td>
</tr>
</tbody>
</table>

Motors for 208 and 550 volts also available. Price on request.

Note: All motors listed operate satisfactorily on a 10% voltage variation. Other voltages and cycles available.

No. 7618 PUSH BUTTON REVERSING SWITCH for single and three phase one speed motors. A heavy-duty, double-throw switch that provides across-the-line starting, stopping and reversing. Mounting bracket and cable furnished. 7 lb.

No. 7639 REVERSING SWITCH for three phase, two speed motors. A heavy-duty switch for starting, stopping, reversing and changing speed of three phase two speed motors. Mounting bracket and cable furnished. 7 lb.

Motor and reversing switch are installed and wired when ordered with lathe from factory.
SPECIFICATIONS

CAPACITIES AND CLEARANCES

Swing over bed ........................................... 12 3/4"
Swing over saddle wings ................................ 12 5/8"
Swing over cross slide ................................... 7 5/8"
Swing over compound rest ................................ 5 7/8"
Distance between centers ............................... 21 1/4", 33 1/2", 47"
Face plate diameter .................................... 6"

HEADSTOCK

Hole thru spindle ........................................ 1 3/8"
Maximum collet capacity—spindle nose type ........ 1 1/8"
Maximum collet capacity—lever type .................. 1 1/16"
Maximum collet capacity—draw bar type ............. 1"
Spindle nose .............................................. tapered key-drive, ASA—L-00
Spindle nose internal taper ................................ No. 4 1/2 MT
Taper in spindle nose bushing ........................... No. 5 MT
Size of center—Morse taper ............................. No. 5 MT
Spindle bearings, Timken "Zero Precision" tapered roller
Spindle belt .............................................. 2 V-belts, outboard pulley

BED

Flame hardened ways .................................... 2 V-ways, 2 flat ways
Length .................................................. 47", 59", 72 1/2"
Width .................................................... 5 7/8"
Depth ....................................................... 3 1/8" deep; 47" centers lathe, 6" deep

THREADS AND FEEDS

Thread range ............................................. 54 selections, 4 to 224 Standard
(right or left)
Longitudinal feeds ...................................... .00065" to .0367"
(left or right) p.r.s.
Cross feeds ............................................. .00016" to .00917" p.r.s.
Lead screw .............................................. 7/8" dia., 8 Acme threads per inch
Screw threads per inch ................................ 4, 4 1/2, 5, 5 1/2,
5 3/4, 6, 6 1/2, 6 1/4, 7, 8, 9, 10, 11, 11 1/2, 12, 13, 13 1/2,
14, 16, 18, 20, 22, 23, 24, 26, 27, 28, 32, 36, 40, 44,
46, 48, 52, 54, 56, 64, 72, 80, 88, 92, 96, 104, 108,
112, 128, 144, 160, 176, 184, 192, 208, 216, 224

SPINDLE SPEEDS

Number, with 1-speed motor ............................. 10
Range, with 1 speed motor, RPM ...................... 30, 60, 90,
140, 225 in back gear; 180, 335, 540, 825, 1300 in
direct drive

Number, with 2-speed motor ............................ 18
Range, with 2-speed motor, RPM ...................... 15, 30, 45,
60, 70, 90, 112, 140, 225 in back gear; 90, 167, 180,
270, 335, 412, 540, 650, 825, 1300 in direct drive

CROSS SLIDE AND COMPOUND

Cross slide travel ....................................... 9 1/2"
Cross feed screw ...................................... 1/2" dia., 10 Acme threads per inch
Compound rest ............................................. graduated 0-90° left and right
Compound rest travel ................................... 2 5/8"
Tool post .................................................. 3/8" x 2" slot. Takes 1/2" tool bits
or tool holder for 5/16" bits

TAILSTOCK

Size of Morse taper center ............................ No. 3
Spindle travel ............................................. 3"
Spindle diameter ......................................... 1 3/8"
Spindle graduated ....................................... 0-3" by 1/16"
Tailstock set-over ....................................... 1"

MOTOR

Horsepower recommended ................................. 1 or 1 1/2
RPM recommended, one speed .......................... 1725
Two speed ................................................. 1800-900
NEMA frame sizes ........................................ 56, 182, 184, 203, 204, 215, 224
Note: If motor is not ordered with lathe, indicate RPM
of motor and diameter of motor shaft that will be used.

EQUIPMENT FURNISHED

Pedestal cabinet mount, with chip pan. Ball bearing,
clutch and brake equipped countershaft mounted in
chest. Headstock center, tailstock center, reducing sleeve,
face plate. Wrenches, instruction book.

6900-series lathes with 10-speed countershaft are available
without clutch and brake. Specify these numbers:
No. 6318 12 3/4" LATHE, 21 1/2" centers, 47" bed. 1090 lb.
No. 6319 12 3/4" LATHE, 34 1/2" centers, 59" bed. 1140 lb.
No. 6320 12 3/4" LATHE, 47" centers, 72 1/2" bed. 1250 lb.
Clausing 6300-series turret lathes are ideal for the manufacture of duplicate parts on a production basis. The cross slide and bed turrets provide for eight successive operations. Clutch and brake, operated by lever on front of base, permit instant starts and stops of spindle without stopping motor. And two speed motor, furnished with No. 6361, makes possible changing from high to slow speeds thru conveniently located push button control. Clausing's efficiency, versatility, and ability to hold tolerances on repetitive operations have established records for low cost production in hundreds of plants.

Bed turret head indexes automatically clockwise and may be moved in either direction by hand. The six turret stations are accurately located by a spring-actuated tapered pin. Principal operating parts are hardened. Ways are precision ground.

Cross slide turret provides for turning, forming, facing and cutting-off. Consists of a forward tool post, back slide tool post, double tool cross slide and feed lever. Forward tool post has two slots for cutter bits — one for facing, the other for turning. Rear tool post holds one cutter bit. Positive adjustable stop螺丝 indicate depth of cut. Feed lever speeds up cross turret action.

Headstock, quick-change box and apron are rigid, totally enclosed, box-type construction. Each has oil bath lubrication. Spindle is machined from a steel forging and precision ground on entire length. Has 1 7/8" bore, ASA-L-00 tapered key-lock nose. Nose is hardened, ground. Spindle turns on Timken Zero Precision tapered roller bearings. Bed ways are flame hardened. Quick-change mechanism provides instant selection of 54 threads, feeds.

Ball bearing countershaft provides, with one speed motor, 10 speeds from 30 to 1300 RPM — five direct, five back geared. Two speed motor provides 18 spindle speeds from 15 to 1300 RPM. Two V-belts drive the spindle — spindle pulley is outboard.

**No. 6360 TURRET LATHE** with 1 HP, 1425/1725 RPM, 3-phase, one speed motor, 1 3/8" bore, 59" bed. Furnished with bed turret, cross slide turret, face plate, steel pedestal cabinet mount, motor and reversing switch. 1315 lb.

**No. 6361 TURRET LATHE** with 1 1/2 HP, 1800-900 RPM, 3-phase, two speed motor, 1 3/4" bore, 59" bed. Furnished with bed turret, cross slide turret, face plate, steel pedestal cabinet mount, motor, two-speed reversing switch. 1555 lb.

Important: Specify voltage required — 220 or 440.

The bed turret and cross slide turret supplied with Clausing turret lathes, and other production accessories, are illustrated and described on pages 24, 25 and 26.
Clausing 5400-series lathes are fast, accurate, powerful general-purpose lathes of wide adaptability for the efficient machining of all work within their capacities.

The headstock spindle turns on big Timken "Zero Precision" tapered roller bearings. Held to a tolerance of .00015", these fine bearings assure precision performance, long accuracy life, permit high spindle-speed work as well as turning at normal speeds.

Spindle is machined from a steel forging and precision ground its entire length. Has 1½" bore. Nose is hardened, has 2¼-56 ground threads.

The heavy, box-type headstock assures accurate alignment and rigidity for the heart of the lathe. Top of headstock is recessed — a handy tray for tools. Control levers are located on front of headstock for efficient operation.

Quick-change mechanism provides instant selection of 54 threads or feeds — twenty-seven are obtained by merely shifting two levers on the gear box, and an additional twenty-seven by shifting the position of a sliding gear. Lever and gear positions are shown on large direct-reading chart mounted on front of gear box. All gears in box are ½" wide steel. Ground steel gear shafts turn on ball bearings for smoothness and long service.

5400-series lathes are available with a choice of variable-speed countershaft with clutch and brake, or 10-speed ball bearing countershaft.

**VARIABLE SPEED COUNTERSHAFT** increases production on all operations requiring a variety of spindle speeds by making instantly available any speed between 55 to 270 RPM and 210 to 1600 RPM while lathe is running. Speeds are changed by turning handwheel on front of lathe cabinet. Easy-to-read chart shows speed selected. Power is transmitted to countershaft spindle thru two variable speed cog belts — three V-belts transmit power to lathe spindle.

Clutch and brake, controlled by lever on lathe cabinet, permit instant starts and stops of spindle without stopping motor. Clutch is multiple disc, dry operating, with heat-treated steel plates. Shifts have lubricated, for-life ball bearing. Countershaft spindle is ground steel, 63/64" diameter — turns on 2 lubricated-for-life ball bearings. Countershaft pulley turns on 2 lubricated-for-life ball bearings. Variable speed countershaft with clutch and brake provides the most rugged and efficient drive available on lathes in the Clausing class.

Lathes with **10-SPEED BALL BEARING COUNTERSHAFT** provide, with one-speed motor, 10 spindle speeds from 35 to 1600 RPM — five direct, five back geared. Two-speed motor provides 20 spindle speeds from 17 to 1600 RPM. Power is transferred from motor to countershaft thru 5-step V-belt pulleys. Three V-belts transfer power from countershaft to spindle. Shift lever slacks belt for position changes. Tension is adjusted and maintained by spring mechanism. Countershaft spindle is ground steel 63/64" diameter — turns on 2 sealed-for-life ball bearings — and unit is supported in cabinet thru 4 vibration dampeners, for smoothness and long service.

Pedestal cabinet furnished is 3/16" steel plate — a rigid mount for accurate work. Top is chip pan. Column has door for easy access to drive. Tailstock column has two drawers.

Flange hardened bed ways, automatic apron with oil bath lubrication, heavy-duty tailstock with No. 3 MT ram, and other features that contribute to the outstanding performance of Clausing 5400-series lathes are described on page 3.
**5400-series lathes with variable-speed countershaft, clutch, brake**

**EQUIPMENT FURNISHED**


<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Countershaft Ship. Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5448</td>
<td>123/4&quot;</td>
<td>33&quot;</td>
<td>47&quot;</td>
<td>variable speed with clutch, brake 1050</td>
</tr>
<tr>
<td>8449</td>
<td>123/4&quot;</td>
<td>35&quot;</td>
<td>59&quot;</td>
<td>variable speed with clutch, brake 1150</td>
</tr>
<tr>
<td>3430</td>
<td>123/4&quot;</td>
<td>481/2&quot;</td>
<td>721/2&quot;</td>
<td>variable speed with clutch, brake 1260</td>
</tr>
</tbody>
</table>

**Notes:** If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used.

**MOTORS**

**One Speed Motors**

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2762</td>
<td>Single</td>
<td>1</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>50</td>
</tr>
<tr>
<td>2872</td>
<td>Single</td>
<td>1/2</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>82</td>
</tr>
<tr>
<td>2862</td>
<td>Three</td>
<td>1</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>70</td>
</tr>
<tr>
<td>2871</td>
<td>Three</td>
<td>1/2</td>
<td>208/220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>68</td>
</tr>
</tbody>
</table>

Motors for 208 and 550 volts also available. Price on request.

Other voltages and cycles available.

Motor and reversing switch are installed and wired when ordered with lathe from factory.

**Note:** All motors listed operate satisfactorily on a 10% voltage variation.

**No. 7614 PUSH BUTTON REVERSING SWITCH** for one speed, single and three phase motors. A heavy-duty, double-throw switch that provides across-the-line starting, stopping and reversing. Cable furnished. 41/2 lb.
S P E C I F I C A T I O N S

CAPACITIES AND CLEARANCES

Swing over bed ........................................... 123/4"
Swing over saddle wings .................................. 123/8"
Swing over cross slide ................................... 71/2"
Swing over compound rest ................................ 33/8"
Distance between centers ................................ 23", 35", 481/2"
Face plate diameter ..................................... 6"

HEADSTOCK

Hole thru spindle ........................................ 13/8"
Maximum collet capacity—spindle nose type ............. 13/8"
Maximum collet capacity—lever type .................... 1"
Maximum collet capacity—draw bar type ................ 1"
Spindle nose ........................................... 21/4"-8 threads
Spindle nose internal taper ................................ No. 41/2 MT
Taper in spindle nose bushing .......................... No. 3 MT
Size of center — Morse taper .......................... No. 3 MT
Spindle bearings, Timken "Zero Precision" tapered roller
Spindle belts ........................................... 3 V-belts

BED

Flame hardened ways .................................. 2 V-waves, 2 flat ways
Length .................................................. 47", 59", 721/2"
Width ................................................... 71/2"
Depth ................................................... 31/8" deep; 47" centers lathe, 6" deep

THREADS AND FEEDS

Thread range ........................................... 54 selections, 4 to 224 Standard
( left or right )
Longitudinal feeds ..................................... 000065" to .0367"
(Cross left or right) p.r.s.
Cross feeds ........................................... 00016" to .00917" p.r.s.
Lead screw ............................................. 7/8" dia., 8 Acme threads per inch
Screw threads per inch ................................ 4, 41/2, 5, 51/2,
53/4, 6, 61/2, 63/4, 7, 8, 9, 10, 11, 111/2, 12, 13, 131/2,
14, 16, 18, 20, 22, 23, 24, 26, 27, 28, 32, 36, 40, 44,
46, 48, 52, 54, 56, 64, 72, 80, 88, 92, 96, 104, 108,
112, 128, 144, 160, 176, 184, 192, 208, 216, 224

SPINDLE SPEEDS

Range ........................................ infinite between 35 and 270 RPM
in back gear; 210 to 1600 RPM in open drive

CROSS SLIDE AND COMPOUND

Cross slide travel ..................................... 91/8"
Cross feed screw ...................................... 1/2" dia., 10 Acme threads per inch
Compound rest ........................................ 9-90° left and right
Compound rest travel .................................. 25/8"
Tool post ............................................... 5/16" x 2" slot. Takes 1/2" tool bits
or tool holder for 5/16" bits

TAILSTOCK

Size of Morse taper center ........................... No. 3
Spindle travel ......................................... 3"
Spindle diameter ...................................... 13/8"
Spindle graduated .................................... 0-3" by 1/16"
Tailstock set-over ................................... 1"

MOTOR

IMPORTANT: To assure maximum performance, motors for 5400 Variable Speed Lathes should be installed and performance-tested at the factory. Your own motor may
be sent to us for installation — service performed at cost.
Horsepower recommended ............................. 1 or 11/2
RPM recommended, one speed ........................ 1725
(Two speed motors can not be used with 5400-series
lathes equipped with Variable Speed Countershaft.)
NEMA frame sizes .................................... 56, 182, 184, 203, 204, 224

EQUIPMENT FURNISHED

Pedestal cabinet mount, with chip pan. Variable speed
clutch-and-brake equipped countershaft mounted in cabinet.
Headstock center, tailstock center, reducing sleeve,
face plate. Wrenches, instruction book.

5400-series lathes are available with variable-speed countershaft, without clutch and brake. Specify these numbers:
No. 5428 123/4" LATHE, 24" centers, 47" bed, 1080 lb.
No. 5429 123/8" LATHE, 35" centers, 50" bed, 1140 lb.
No. 5430 123/4" LATHE, 483/4" centers, 721/2" bed, 1250 lb.
CLAUSING 5400-series lathes with 10-speed countershaft

<table>
<thead>
<tr>
<th>Catalog Number</th>
<th>Swing Over Bed</th>
<th>Between Centers</th>
<th>Bed Length</th>
<th>Countershaft</th>
<th>Ship. Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5418</td>
<td>12(\frac{3}{4})&quot;</td>
<td>23&quot;</td>
<td>47&quot;</td>
<td>underneath drive ball bearing</td>
<td>1050</td>
</tr>
<tr>
<td>5419</td>
<td>12(\frac{3}{4})&quot;</td>
<td>35&quot;</td>
<td>59&quot;</td>
<td>underneath drive ball bearing</td>
<td>1110</td>
</tr>
<tr>
<td>5420</td>
<td>12(\frac{3}{4})&quot;</td>
<td>48(\frac{1}{2})&quot;</td>
<td>72(\frac{1}{2})&quot;</td>
<td>underneath drive ball bearing</td>
<td>1220</td>
</tr>
</tbody>
</table>

*Note: If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used.*

**Two Speed Constant Horsepower Motors**

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2876</td>
<td>Three</td>
<td>1(\frac{1}{2})</td>
<td>220</td>
<td>60</td>
<td>1800-900</td>
<td>1(\frac{3}{8})&quot;</td>
<td>110</td>
</tr>
<tr>
<td>2877</td>
<td>Three</td>
<td>1(\frac{1}{2})</td>
<td>440</td>
<td>60</td>
<td>1800-900</td>
<td>1(\frac{3}{8})&quot;</td>
<td>110</td>
</tr>
</tbody>
</table>

Motors for 208 and 550 volts also available. Prices on request. Note: All motors listed operate satisfactorily on a 10% voltage variation. Other voltages and cycles available.

**MOTORS One Speed Motors**

<table>
<thead>
<tr>
<th>No.</th>
<th>Phase</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2762</td>
<td>Single</td>
<td>1</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7(\frac{3}{8})&quot;</td>
<td>50</td>
</tr>
<tr>
<td>2872</td>
<td>Single</td>
<td>1(\frac{1}{2})</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7(\frac{3}{8})&quot;</td>
<td>82</td>
</tr>
<tr>
<td>2862</td>
<td>Three</td>
<td>1</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7(\frac{3}{8})&quot;</td>
<td>70</td>
</tr>
<tr>
<td>2871</td>
<td>Three</td>
<td>1(\frac{1}{2})</td>
<td>208/220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7(\frac{3}{8})&quot;</td>
<td>68</td>
</tr>
</tbody>
</table>

**No. 7614 PUSH BUTTON REVERSING SWITCH** for one speed, single and three phase motors. A heavy-duty, double-throw switch that provides across-the-line starting, stopping and reversing. Cord furnished. 4\(\frac{1}{2}\) lb.

**No. 7649 REVERSING SWITCH** for two speed, three phase motors. A heavy-duty switch for starting, stopping, reversing and changing speed. Cord furnished. 4\(\frac{1}{2}\) lb.

Motor and reversing switch are mounted and wired when ordered with lathe from factory.
CAPACITIES AND CLEARANCES

- Swing over bed ........................................ 12 3/4"
- Swing over saddle wings .......................... 12 3/4"
- Swing over cross slide ............................ 7 3/8"
- Swing over compound rest .......................... 3 3/4"
- Distance between centers .......................... 23", 39", 48 7/8"
- Face plate diameter .................................. 6"

HEADSTOCK

- Hole thru spindle .................................. 13 3/4"
- Maximum collet capacity—spindle nose type ....... 1 3/8"
- Maximum collet capacity—lever type ............. 1 1/16"
- Maximum collet capacity—draw bar type ......... 1"
- Spindle nose ........................................ 2 1/4"-8 threads
- Spindle nose internal taper ........................ No. 4 1/2 MT
- Taper in spindle nose bushing ........................ No. 5 MT
- Size of center—Morse taper ........................ No. 3 MT
- Spindle bearings, Timken "Zero Precision" tapered roller
- Spindle belts ........................................ 3 V-belts

BED

- Flame hardened ways ............................... 2 V-ways, 2 flat ways
- Length ....................................................... 47", 59", 72 1/2"
- Width ......................................................... 7 7/8"
- Depth ......................................................... 5/8" deep; 47" centers lathe, 6" deep

THREADS AND FEEDS

- Thread range ............................................ 54 selections, 4 to 224 Standard
- Longitudinal feeds ..................................... .00065" to .0367" (left or right) p.r.s.
- Cross feeds ............................................ .00016" to .00917" p.r.s.
- Lead screw ............................................. 7/8" dia., 8 Acme threads per inch
- Screw threads per inch ............................... 4, 4 1/2, 5, 5 1/2,
- 6, 6 1/2, 7, 8, 9, 10, 11, 11 1/2, 12, 13, 13 1/2,
- 14, 16, 18, 20, 22, 23, 24, 26, 27, 28, 32, 36, 40,
- 44, 46, 48, 52, 54, 56, 64, 72, 80, 88, 92, 96, 104,
- 108, 112, 128, 144, 160, 176, 184, 192, 208, 216, 224
- (5400-series lathes can be equipped for a wide range of metric threading operations. Write for information.)

SPINDLE SPEEDS

- Number, with 1-speed motor .......................... 10
- Range, with 1-speed motor, RPM ..................... 35, 65, 100, 160, 270 in back gear; 210, 375, 650, 995, 1600 in direct drive
- Number, with 2-speed motor .......................... 20
- Range, with 2-speed motor, RPM ..................... 17, 32, 35, 50, 65, 80, 100, 140, 160, 270 in back gear; 105, 187, 210, 325, 375, 497, 650, 800, 995, 1600 in direct drive

CROSS SLIDE AND COMPOUND

- Cross slide travel .................. 9 1/8"
- Cross feed screw ............................. 1/2" dia., 10 Acme threads per inch
- Compound rest ....... graduated 0-90° left and right
- Compound rest travel ................... 2 5/8"
- Tool post ................................ 5/8" x 2" slot. Takes 1/2" tool bits or tool holder for 5/16" bits

TAILSTOCK

- Size of Morse taper center .......................... No. 3
- Spindle travel .............................................. 5"
- Spindle diameter ......................................... 1 3/8"
- Spindle graduated ................................. 0-3" by 1/16"
- Tailstock set-over ....................................... 1"

MOTOR

- Horsepower recommended ..................... 1 or 1 1/2
- RPM recommended, one speed ........ 1725
- Two-speed ........................................... 1800-900
- NEMA frame sizes ............................. 56, 182, 184, 203, 204, 215, 224
- Note: If motor is not ordered with lathe, indicate RPM of motor and diameter of motor shaft that will be used.

EQUIPMENT FURNISHED


5400-series lathes with 10-speed countershaft are available with the clutch and brake described on page 11. Specify numbers:

- No. 5438 12 1/2" LATHE, 25" centers, 47" bed. 1060 lb.
- No. 5439 12 1/2" LATHE, 48 1/2" centers, 90" bed. 1120 lb.
- No. 5440 12 1/2" LATHE, 48 1/2" centers, 73 1/2" bed. 1260 lb.

Note the heavy-duty construction of the 10-speed countershaft, with 62/64" diameter spindle, ball bearings. 4 V-belts driving the spindle pulley, spring tension mechanism, vibration dampeners.
5400-series 12\(\frac{3}{4}\)" turret lathes

Clausing No. 5460 combines turret lathe production with the efficiency advantages of a variable speed drive equipped with clutch and brake. This fast, powerful, accurate machine will set new standards of productivity on all hand turret lathe operations within its capacity.

Clutch and brake, controlled by convenient lever on lathe cabinet, permit instant starts and stops of spindle without stopping motor. Variable speed mechanism increases production on all operations requiring a variety of spindle speeds by making instantly available any speed between 35 to 270 and 210 to 1600 RPM while lathe is running. 3 V-belts transfer power from countershaft to spindle. Countershaft and clutch mechanism has 6 ball bearings for lasting service.

Spindle is forged steel with 1\(\frac{3}{4}\)" bore. Hardened nose has 2\(\frac{1}{4}\)"-8 thread. Spindle turns on Timken tapered roller bearings. Bed ways are flame hardened. Quick-change mechanism provides instant selection of 54 threads, feeds, Apron is double-walled, has oil bath lubrication.

Bed turret head indexes automatically clockwise and may be moved in either direction by hand. The six turret stations are accurately located by a spring-actuated tapered pin sliding in a sleeve and engaging a tapered bushing in turret head. Principal operating parts are hardened. Ways are precision ground.

Cross slide turret provides for turning, forming, facing and cutting-off. Consists of a forward tool post, back slide tool post, double tool cross slide and feed lever. Forward tool post has two slots for cutter bits—one for facing, the other for turning. Rear tool post holds one cutter bit. Positive adjustable stop screws indicate depth of cut. Feed lever speeds up cross turret action.

No. 5460 TURRET LATHE with 1 HP, 1425/1725 RPM, 3-phase, single speed motor, 1\(\frac{3}{4}\)" bore, 39" bed. Furnished with bed turret, cross slide turret, steel pedestal cabinet mount, motor, reversing switch, face plate. 1315 lb.

**Important**: Specify voltage required—220 or 440.

---

**SPECIFICATIONS**

**BED TURRET**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Number of tool positions</td>
<td>6</td>
</tr>
<tr>
<td>Head finish bored</td>
<td>for 1&quot; tool shanks</td>
</tr>
<tr>
<td>Working travel</td>
<td>6(\frac{3}{4})&quot;</td>
</tr>
<tr>
<td>Minimum working stroke</td>
<td>2(\frac{3}{4})&quot;</td>
</tr>
<tr>
<td>Tool clearance over ram</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Distance between opposite flats</td>
<td>5(\frac{3}{4})&quot;</td>
</tr>
</tbody>
</table>

**CROSS SLIDE TURRET**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Swing over double tool cross slide</td>
<td>4(\frac{3}{4})&quot;</td>
</tr>
<tr>
<td>Cross travel of cross slide</td>
<td>3(\frac{3}{4})&quot;</td>
</tr>
<tr>
<td>For cutter bits up to</td>
<td>3(\frac{1}{2})&quot;</td>
</tr>
<tr>
<td>Power cross feeds</td>
<td>0.00116&quot; to 0.00137&quot;</td>
</tr>
</tbody>
</table>

**MOTOR, SWITCH**

One speed motor...1 HP, 3 phase, 50/60 C, 1425/1725 RPM. Switch...heavy-duty, push-button for starting, stopping, reversing.

*Important*: Specify voltage required — 220 or 440. See page 9 for lathe specifications.
Each Clausing lathe must pass tolerance tests similar to those shown below for 6300-series lathes. Inspection after inspection, and test after test — at every stage of manufacture and assembly — assure that every lathe measures up to rigid specifications of construction and performance.

The individual test report that accompanies each lathe is an assurance it will machine with dependable precision.

1. Bed level, transverse direction, within .0005" in 12".
2. Bed level, longitudinal direction, within .001" in 12".
3. Spindle center runout, 0 to .0005".
4. Spindle nose runout, 0 to .0003".
5. Spindle taper runout, at end of 12" test bar, 0 to .0006"; at end of spindle nose, 0 to .0003".
6. Headstock alignment, vertical, at end of 12" test bar, 0 to .0005".
7. Tailstock spindle alignment, vertical, 0 to .0008".
8. Headstock alignment, horizontal, at end of 12" test bar, 0 to ± .0003".
9. Tailstock spindle alignment, horizontal, 0 to .0005".
10. Tailstock taper alignment, horizontal, at end of 12" test bar, 0 to ± .0005".
11. Tailstock taper alignment, vertical, at end of 12" test bar, 0 to .001".
12. Cross slide alignment and face plate runout, on 12" diameter, 0 to .001".
13. Lathe must turn round with work mounted in chuck to .0003".
14. Running test for smooth operation, 1 1/2" diameter C.R.S., .0025" feed and .125" depth at high speed; lathe must take cut without chatter.
15. Back lash on cross feed screw, .004".
The Clauising No. 6390 is a heavy-duty duplicating lathe that provides automatic reproduction, reducing to hours and minutes jobs that would otherwise require weeks or days. Multiple diameters, tapers, bevels, radii, grooves and chamfers are turned quickly, and to the same accuracy as the template.

Power to firmly feed and hold cutting tool is provided by hydraulic cylinder housed in servo motor mounted on lathe cross slide. Servo motor is integral for quick response — reaction in power cylinder is within a fraction of a second after pressure at stylus changes. Slide feed, in and out, is infinitely variable from 0 to 15” per minute. All critical parts of tracer unit are hardened, ground and machine lapped. Unit is completely sealed against dust and dirt. Template mounting bar is designed for templates made of 1/8” to 3/8” flat stock. Templates may be mild steel, brass or aluminum — stylus pressure is 2 to 3 pounds. Motor, pump, reservoir and pressure gauge are an integral unit and are located on shelf under lathe chip pan.

Tracer does not restrict normal use of lathe — takes but minutes to remove tracer and replace cross feed screw.

Bed ways are flame-hardened and precision ground. Drive is variable speed that makes instantly available any spindle speed from 43 to 222 and 250 to 1300 RPM while lathe is running. Motor furnished is 1 1/2 HP, 3-phase.

Headstock, apron and quick-change box are enclosed — gears and shafts run in oil. Spindle nose is ASA-L-00 tapered key-lock type. Spindle turns on "Zero Precision" Timken tapered roller bearings. Tailstock has a No. 3 MT ram with tang socket. Other features that make the 6390 an outstanding producer are described on pages 3, 4, 5 and 7.

No. 6390 12 3/4" HYDRAULIC TRACER LATHE. 12 3/4" swing over bed, 33 1/2" centers, 59" bed. Flame hardened bed ways, pedestal cabinet, variable speed countershaft, 1 1/2 HP 1140 RPM 60C 3-phase motor, reversing switch, hydraulic tracer complete with single phase motor and switch. 1250 lb.

SPECIFICATIONS

TRACER CAPACITY — Handles work up to 75 1/2" dia., 2 1/2" dia. differential, 18" long.
Slide feed, in and out, infinitely variable from 0 to 15" per minute.

LATHE MOTOR, SWITCH — 1 1/2 HP, 208/220/440 V., 1140 RPM. 3-phase ball bearing motor. Switch — heavy-duty, push button, on, off, reversing switch. All other lathe specifications same as those for No. 6329 — see pages 6 and 7.

HYDRAULIC TRACER ATTACHMENT

Equips any Clauising 12-inch lathe for precision duplicating of multiple diameters, tapers, bevels, shoulders, radii, grooves, chamfers. Handles work up to 2 1/2" diameter differential, and 18" in length. Slide feed, in and out, is infinitely variable from 0 to 15" per minute and is controlled by knob on top of servo. Easily installed. Does not restrict normal use of lathe — takes but minutes to remove tracer and replace cross feed screw. Same as furnished with Clauising tracer lathes. See complete description above.
Accuracy, power, and a high degree of efficiency characterize the performance of the Clausing No. 5490 Hydraulic Tracer Lathe. It combines the production advantages of automatic duplication with the efficiency of a variable speed drive equipped with clutch and brake. Saves time, money, and improves work accuracy on the reproduction of multiple diameters, tapers, bevels, radii, grooves and chamfers.

Tracer unit is identical to that furnished with No. 6390 described on the facing page.

Spindle turns on “Zero Precision” Timken tapered roller bearings. Bed ways are flame hardened. Quick-change mechanism provides instant selection of 54 threads and feeds. Apron is double walled — gears and shafts travel in oil. Tailstock has No. 3 MT with tang socket.

Lathe is powered by heavy-duty 1 1/2 HP 3-phase motor through a variable speed countershaft with clutch and brake. Any spindle speed between 35 to 270 and 210 to 1600 RPM is available instantly while lathe is running — speeds are changed through handwheel on front of lathe cabinet. Power is transmitted to countershaft through variable speed cog belts — three V-belts transmit power to spindle.

Clutch and brake, controlled by lever on lathe cabinet, permit instant starts and stops of spindle without stopping motor. Drive unit is ruggedly built throughout — has six lubricated-for-life ball bearings for smoothness and service.

Other features of lathe are described on pages 5 and 11.

No. 5490 12 1/4" HYDRAULIC TRACER LATHE. 123/4" swing over bed, 35" centers, 35" bed. 50" bed. Flame hardened bed ways, pedestal cabinet, variable speed countershaft with clutch and brake, 1 1/2 HP 1425/1725 RPM 3-phase motor, reversing switch, hydraulic tracer complete with single phase motor and switch. 1250 lb.

SPECIFICATIONS

TRACER CAPACITY — Handles work up to 7 1/4" diam. 2 1/2" diam. differential, 18" long.

Slide feed, in and out, infinitely variable from 0 to 15" per minute.

Pump motor, single phase, 115 V, 60 C. (3-phase motor available, extra.)

Recommended template size, 1/8" to 1/4" flat stock.

LATHE MOTOR, SWITCH — 1 1/2 HP, 208/220/440 V, 50/60 C, 1425/1725 RPM 3-phase, ball bearing motor.

Switch — heavy-duty, push button, on, off, reversing.

All other lathe specifications same as those for No. 5439 — see pages 12, 13.

No. 7703 HYDRAULIC TRACER ATTACHMENT complete with single phase 115V 60C motor and integral pump, reservoir, pressure gauge; servo motor; lines; switch; template bar; mounting bracket. 112 lb.

No. 7704 HYDRAULIC TRACER ATTACHMENT same as No. 7703 except motor is three-phase 220/440 V 50/60 C 1425/1725 RPM. 118 lb.

No. 7705 SPRING LOADED LIVE CENTER. Has needle bearings, bell head with 0 to 115° size range, No. 3 M.T. Improves accuracy and production by automatically providing take-up for work expansion. 15 lb.
Flame hardened bed ways . . . Timken tapered roller bearings . . . automatic apron with oil bath lubrication . . . heavy-duty underneath-drive ball bearing countershaft . . . \( \frac{1}{8} \)" diameter lead screw . . . these and other quality features of expensive lathes are standard on the 4800 series. Yet they cost no more than smaller, tighter machines. They are heavy, rugged, accurate, efficient — outstanding values for production, tool room, maintenance, school and commercial shops.

Headstock spindle turns on selected Timken tapered roller bearings that carry all radial and thrust loads with a minimum of friction. Spindle is alloy steel — has \( \frac{3}{8} \)" bore, \( 1\frac{1}{2} \)"-8 threads. Spindle threads and spindle taper are precision ground. Headstock is thick-walled grey-iron, heavily ribbed for permanent alignment.

Quick-change mechanism provides instant selection of 54 threads or feeds — twenty-seven are obtained by merely shifting two levers on the gear box, and an additional twenty-seven by shifting the position of a sliding gear. All gears in box are \( \frac{1}{2} \)" wide steel — gear shafts are ground steel, turn on ball bearings for smoothness and long service. Lead screw is \( \frac{9}{8} \)" diameter, has easy-to-replace shear pin.

Underneath-drive countershaft provides 10 spindle speeds from 35 to 1600 RPM — live direct, five back geared. Power is transferred from motor to countershaft thru 5-step V-belt pulleys. Three modified wedge belts transfer power from countershaft to spindle. Shift lever slacks belt for quick belt-position changes.

Countershaft spindle is ground steel, \( 63/64 \)" diameter — turns on two sealed-for-life ball bearings — and unit is supported in cabinet thru four vibration dampeners — for smoothness and long service.
Pedestal cabinet furnished is 3/16" steel plate — a rigid mount for the lathe. Top of cabinet is chip pan. Column has door for easy access to drive. Tailstock cabinet has two drawers.

Other features that contribute to the 4800-series record of performance dependability — flame hardened bed ways, double-walled automatic apron with oil bath lubrication, heavy-duty tailstock with No. 3 MT ram and tang socket are described on page 5.

No. 4818 CLAUSSING LATHE. 12½" swing, ½" collet capacity, 24½" centers, 47" bed, underneath-drive countershaft, pedestal cabinet, less motor and switch. 990 lb.

No. 4819 CLAUSSING LATHE. 12½" swing, ½" collet capacity, 46½" centers, 59" bed, underneath-drive countershaft, pedestal cabinet, less motor and switch. 1050 lb.


<table>
<thead>
<tr>
<th>MOTORS</th>
</tr>
</thead>
<tbody>
<tr>
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</tr>
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<td>2762</td>
</tr>
<tr>
<td>2840</td>
</tr>
<tr>
<td>2842</td>
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</tbody>
</table>

Two speed motors and switches listed on page 14 may be used with 4800-series lathes.

Note: All motors listed operate satisfactorily on a 105% voltage variation. Other voltages and cycles available.

No. 7614 PUSH BUTTON REVERSING SWITCH with cord. For one speed, single and three phase motors. A heavy-duty, double-throw switch that provides across-the-line starting, stopping and reversing. 4½ lb.

Motor and reversing switch are installed and wired when ordered with lathe from factory.

SPECIFICATIONS

CAPACITY
Swing: 12½" over bed, 12½" over saddle wings, 7½" over cross slide; 5½" swing over spindex rest; 24½" — 50½" between centers; face plate diameter, 6".

SPINDLE
3½" through hole, ½" collet capacity, drill-bar type, 1¼"/8 threads. Bored for No. 3 MT. Belts — three modified wedge.

BED
7½" wide, 5½" deep. Two V and two flat ways flame hardened and provision ground. Length — 47" and 59".

THREADS
Range 54 selections, 6 to 224. Standard right or left: 4, 4½, 5, 5½, 6, 6½, 7, 8, 8½, 9, 10, 11, 11½, 12, 13, 13½, 14, 16, 18, 20, 22, 23, 24, 25, 26, 27, 28, 32, 42, 46, 48, 52, 54, 56, 64, 72, 80, 88, 92, 96, 104, 108, 112, 128, 144, 160, 176, 184, 192, 208, 216, 224. Lead screw is 7/8" dia., has 8 Acme threads per inch (Metric conversion gears available. Price on request)

FEEDS
Longitudinal feed — 6000ths to 30362ths. Cross feeds — 60000ths to 100517ths P.R.S.

SPINDLE SPEEDS
10 speeds: 35, 65, 100, 160, 270 RPM in back gear; 210, 375, 650, 995, 1600 RPM in direct drive

CROSS SLIDE
9/16" travel; 1/2" dia. screw, Acme threads; collar graduated 0 to 100 by .001".

COMPOUND REST
Graduated 0 to 90° right and left; 2½" travel

TOOL POST
5/8" x 2" slots; takes 1/2" tool bits; no tool holder for 3/4" bits.

TAILSTOCK
15/16" dia. spindle, 3" travel; No. 3 MT; 1" set-over; spindle graduated 0 to 3" by 16ths.

COUNTERSHAFT
Underneath-drive countershaft; lubricated - for lift ball bearings; two 3-step pulleys with 5/8" V-belt; three modified wedge belts, countershaft to spindle.

MOTOR RECOMMENDED 5/4 to 1 HP; 1725 RPM

4800-series lathes with 10-speed countershaft are also available with the clutch and brake described on page 11. Specify these numbers:

No. 4838 12½" LATHE, 24½" centers, 47" bed. 1000 lb.
No. 4839 12½" LATHE, 36½" centers, 59" bed. 1060 lb.
Clausing 5300-series bench lathes have built-in horizontal counterbalance with clutch and brake that permit instant starts and stops of spindle without stopping machine. Countershaft spindle and clutch pulley turn on lubricated-for-life ball bearings. Two-step pulleys from motor to countershaft, and three-step pulleys from countershaft to spindle provide 12 spindle speeds from 29 to 1500 RPM. Drive is powered by B-Belts. Belts are completely guarded.

Other construction features are same as those described on pages 3 and 11 — forged steel spindle with 1 1/4" bore. Timken "Zero Precision" tapered roller bearings, flame hardened bed ways, quick-change mechanism with instant selection of 54 threads and feeds, totally enclosed apron. No. 3 MT tailstock.

No. 5300 12 3/4" CLAUSING BENCH LATHE, 23" centers, 42" bed, quick-change gears, horizontal built-in counterbalance with clutch and brake; less motor, switch. 630 lb.

**4800-SERIES**

**1/2" collet capacity**

Clausing 4800-series 1/2" collet capacity bench lathes have built-in horizontal countbalance with clutch and brake — spindle may be started and stopped instantly without stopping motor. Countershaft spindle and clutch pulley turn on lubricated for life ball bearings. Drive is powered by B-Belts. Provides 12 speeds — 32 to 2170. Headstock hood covers spindle drive belt. Motor mount is integral.

Other construction features are described on pages 3, 70 and 31 — Timken tapered roller bearings, flame hardened bed ways, quick-change mechanism, totally enclosed apron, No. 3 MT tailstock.

No. 4803 12 3/4" CLAUSING BENCH LATHE, 24 1/4" centers, 41" bed, quick-change gears, built-in horizontal counterbalance with clutch and brake; less motor, switch. 345 lb.

No. 4804 12 3/4" CLAUSING BENCH LATHE, 36 1/4" centers, 59" bed, quick-change gears, built-in horizontal counterbalance with clutch and brake; less motor, switch. 580 lb.

No. 4805 12 3/4" CLAUSING BENCH LATHE, 50" centers, 72 1/4" bed, quick-change gears, built-in horizontal counterbalance with clutch and brake; less motor, switch. 670 lb.

**SPECIFICATIONS**

**SPINDLE SPEEDS**

Twelve: 55, 77, 85, 132, 220 in back gear drive; 175, 272, 454, 497, 780, 1500 in direct drive

**COUNTERSHAFT**

Horizontal, built-in, turns on ball bearings; has clutch and brake

**MOTOR RECOMMENDED**

1/2 to 1 HP; 1725 RPM

See page 15 for other specifications.

**EQUIPMENT FURNISHED**

6" face plate, two 60" centers, integral motor mount, belts and pulleys for B-belt drive, wrenches, instruction book.

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**PELLIST CABINETS**

3/16" steel plate — a rigid support for accurate lathe work. Has 2" deep oil and chip pan. Tailstock pedestal has two drawers.

No. 7672 PEDESTAL CABINET for Nos. 5500 and 4800 14 3/4" bed lathes, 340 lb.
No. 7673 PEDESTAL CABINET for Nos. 5510 and 4804 (59" bed) ladhes, 460 lb.
No. 7674 PEDESTAL CABINET for Nos. 5520 and 4805 (72 1/4" bed) lathes, 495 lb.

**CHIP PANS**

Same as supplied with pedestal cabinets.

No. 7655 CHIP PAN for 4800 and 5300 series lathes with 47" bed. 61 lb.
No. 7656 CHIP PAN for 4800 and 5300 series lathes with 59" bed. 78 lb.
No. 7657 CHIP PAN for 4800 and 5300 series lathes with 72 1/4" bed. 88 lb.

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**BELT GUARD for 4800-series Bench Lathes**

No. 7620 BELT GUARD for 4800-series lathes serial No. 15674 and above. Covers motor pulley and belt from motor to countershaft pulley. Ready drilled for easy installation. 12 lb.

**MOTORS**

<table>
<thead>
<tr>
<th>No.</th>
<th>HP</th>
<th>Phase</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft</th>
<th>Wt. Lb.</th>
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<td>60</td>
<td>1725</td>
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<tr>
<td>2762</td>
<td>1</td>
<td>Single</td>
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<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>50</td>
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<tr>
<td>2840</td>
<td>3/4</td>
<td>Three</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>48</td>
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<tr>
<td>2862</td>
<td>1</td>
<td>Three</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>70</td>
</tr>
</tbody>
</table>

No. 7014 PUSH BUTTON REVERSERING SWITCH. For single and three-phase motors. 4 1/2 lb.
ACCESSORIES

TOOL HOLDERS

No. 7577 SET OF 9 TOOL HOLDERS, in metal case. Drop-forged steel, accurately machined and heat treated. Contents of the 9 tool holders listed below. Holders have 5/8 x 15/64 shank - fit directly in tool post slot. 24 lb.

The holders listed below have 5/8 x 1/16 shank - fit directly into tool post slot.

No. 7560 STRAIGHT SHANK TOOL HOLDER, with 5/16" bit, wrench. 2 lb.
No. 7570 LH OFFSET TOOL HOLDER, with 5/16" bit, wrench. 2 lb.
No. 7571 STRAIGHT SHANK CUT-OFF TOOL HOLDER, with 5" radius-ground blade and wrench. 2 lb.
No. 7572 R.H. OFFSET CUT-OFF TOOL HOLDER, with 5" radius-ground blade and wrench. 2 lb.
No. 7574 BORING BAR HOLDER, with 5/8" dia. sleeve-type boring bar, two 5/16" high speed cutter bits with one 5/8" and one 9/16" and two wrenches. Drop-forged steel. Boring bar takes 5/8" bits. Takes bar 1/2 to 1 1/2" dia. 4 lb.
No. 7575 BORING TOOL HOLDER, with bit and wrench. High speed cutter is ground to fit 60 threads. 2 lb.
No. 7576 KNUCKLE TOOL HOLDER, with medium-diameter shaped sleeve. High grade tool steel casters are hardened, tempered. 2 lb.

LATHE CENTERS

No. 7695 TIMKEN BEARING CENTER with No. 3 MT shank. Has pair of matched Timken tapered roller bearings. Bearings grease packed, preloaded and sealed. 11/2 lb.
No. 7659 60° CENTER with No. 3 MT shank. 8 oz.

DRILL PAD

No. 7601 TANG SLEEVE required to adapt No. 2 MT centers, drill pad, crock center and pipe centers listed below to No. 3 MT tailstock. 1 lb.

CROCHET CENTER

No. 330 CROCHET CENTER, V-slot carefully machined. 2" diameter. 1" slots. No. 2 MT shank. No. 7607 sleeve required for No. 3 MT tailstock. 1 lb.

PIPE CENTERS

Support pipe in tailstock for machining and threading.

No. 755 SET OF 8 PIPE CENTERS. Includes: cone listed below, tail stock arbor and thread bearing. No. 7697 sleeve required for No. 3 MT tailstock.
No. 756 PIPE CENTERING CONE. Capacity 1/4 to 4. 1 lb.
No. 757 PIPE CENTERING GUIDE. Capacity 1/4 to 4. 1 lb.
No. 758A TAILSTOCK ARBOR AND THRUM BEARING. No. 2 MT shank. No. 7607 sleeve required for No. 3 MT tailstock. 2 lb.

HEADSTOCK SPINDLE SLEEVES

No. 7620 5/16 to 3 5600; 5600; 6600; 6600 serial 5-65-65 and above 2
7677 45/64 to 3 4500; 5000; 6000; 6600 serial 5-65-65 and above 2
7698 45/64 to 3 5000; 6000 serial 5-65-65 and above 2
7640 45/64 to 3 6000; 200 serial 5-65-65 and below 2
142 4 4000 1

LATHE DOGS

No. 7543 1 1 lb.
7544 1 1 lb.
7545 1 1 lb.
7546 1/2 2 lb.

MILLING ATTACHMENT

No. 7595 MILLING ATTACHMENT. Equips lathe for face milling, cutting keyways and slots, milling dovetails, squaring shafts, making dies and molds, etc. Quickly and easily installed by removing compound rest and clamping base of milling attachment in its place.

Holds work at any angle — base is graduated 90° right and left of center. Position of vise is controlled by a feed screw with micrometer graduated collar. Base of vise is graduated through a full circle and vise can be swivelled to any angle. Side rail ways have gib take-up, V blocks furnished, 17 lb.

Vertical Feed 2° Vise Depth 7°
Vise Camara 5° Jaw Width 10°

CUTTER HOLDING SET

Hold cutter in headstock spindle. Includes, draw bar, sleeve and No. 3 MT holder. Bushings required as listed.

No. 7595 CUTTER HOLDING SET for 600-series lathes, serial No. 2-2623 and above. Use with No. 7600 bushings. 5 lb.
No. 7677 CUTTER HOLDING SET for 5000 and 5400-series lathes. Use with No. 7600 bushings. 5 lb.
No. 7597 CUTTER HOLDING SET for 4800-series lathes. Use with No. 3608 bushings. 2 1/2 lb.

BUSHINGS

No. 7000 SET OF 6 BUSHINGS, required to adapt straight shank and mills and Woodruff Keyway cutter to Nos. 755, 7550 and 7595 holding set.


No. 5638 SET OF 4 BUSHINGS, required to adapt No. 756 straight shank end mills to No. 757 holding set. For holding straight shank milling cutters with shank diameters: 3/32, 7/32 and 5/32. Not required for No. 7676 inside mill. 6 oz.

R. H. SPIRAL END MILLS

For general milling operations — slotting, facing and routing, squaring and unplaining shafts, cutting keyways. Adapted to holding set with bushings listed below. 4 oz. each.

WOODRUFF KEYWAY CUTTERS

No. 753A 5/32 5/32 1/2 1/2 1/16 1/2
753B 7/32 7/32 1/2 1/2 1/16 1/2

ANGULAR CUTTERS

For face-milling, dovetailing and cutting angles less than 90°. Included angle is 60°. Adapted to Nos. 7677, 7597, 7599 and 7598 holding sets with arbors listed below and bushings indicated. 6 oz. each.

No. 744A 1/16 1/4 24
744B 1/16 1/4 20

ARBORS FOR ANGULAR CUTTERS

Required, with 1/4 bushing of No. 7600, to adapt 574 angular cutters to Nos. 7661, 7597, 7599 and 7598 holding sets. Also required to adapt 3/8 angular cutters to No. 759 holding sets.

STEADY REST

No. 7661 STEADY REST. Provides a rigid support for accurately machining long pieces and for end extensions. Clamps to tailstock. Top is shaped. Jaw faces milled — handle works 1/4 x 1/2 in. 17 lb.

FOLLOWER REST

No. 7662 FOLLOWER REST. Ensures accurate work on long slender rods. Quickly mounted on top of carriage saddle — follows exact center of work in rigid position. 9 lb.
A BUCK AJUST-TRU UNIVERSAL CHUCKS

Ajust-Tru chucks have opposed screw mechanism that permits chucking to .0005" precision. Set up takes but one minute. No further adjustment needed on duplicate work — the Ajust-Tru rechucks to .0005" with scroll chuck speed. Adapter is fitted to chuck and lathe spindle. Adapter, two sets of jaws (inside and outside) and wrench are furnished.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>Jaws</th>
<th>For Lathe Series</th>
<th>For Spindle</th>
<th>Lb.</th>
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<td>6</td>
<td>6300</td>
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<td>41 1/2</td>
</tr>
</tbody>
</table>

Ajust-Tru Chucks are available with 3 master and 3 top jaws, and with master jaws only. Prices on request.

B 3-JAW UNIVERSAL CHUCKS

Self-centering jaws are controlled by turning one pinion. Scroll is alloy steel. Body is high-strength semi-steel. Furnished with inside jaws, outside jaws, fitted adapter and wrench. (No. 6613 has threaded body.)

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
<th>For Lathe Series</th>
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<td>ASA-L-000</td>
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</table>

C 4-JAW INDEPENDENT CHUCKS

One-piece body is high-strength semi-steel casting. Face and outer edge are ground. Heat-treated alloy steel jaws are reversible — deep shoulders have raised and ground steps. Nos. 6606 and 10-885B have threaded body. The others are furnished with fitted adapter.

<table>
<thead>
<tr>
<th>No.</th>
<th>Size</th>
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<th>Lb.</th>
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<td>7603</td>
<td>8&quot;</td>
<td>6300</td>
<td>ASA-L-000</td>
<td>26</td>
</tr>
<tr>
<td>7604</td>
<td>10&quot;</td>
<td>6300</td>
<td>ASA-L-000</td>
<td>33</td>
</tr>
</tbody>
</table>

D DRILL CHUCKS

No. 1897 JACOBS DRILL CHUCK, capacity 1/16" drill to 1/2", with key-type wrench. Adapted to headstock and tailstock spindles with No. 1898 arbor (below). 1/3 lb.

No. 40-60 JACOBS DRILL CHUCK, capacity No. 70 drill to 1/2", with key-type wrench. Adapted to headstock and tailstock spindles with No. 7605 arbor (below). 3 lb.

No. 1898 ARBOR to adapt No. 1897 chuck to No. 3 MT lathe headstock or lathestock. 13 oz.

No. 7605 ARBOR to adapt No. 40-60 chuck to No. 3 MT lathe headstock or lathestock. 13 oz.

E HEADSTOCK CHUCKS

Thread directly on 1 1/2" x 8 spindle of 4800 series lathe — No. 375 can be used in No. 3 MT tailstock with arbor listed below.

No. 375 JACOBS HEADSTOCK CHUCK, capacity 1/16" to 1/4". Wrench furnished. Can be used in tailstock with arbor listed below. 4 lb.

No. 1898 No. 3 MT ARBOR for 375 chuck. 13 oz.

No. 375B JACOBS HEADSTOCK CHUCK for 1/8" to 1/4" threaded spindle. Capacity 1/8" to 1/4". Wrench furnished. Not adaptable to tailstock. 5 lb.

F CENTER REST CHUCK

No. 445 JACOBS CENTER REST CHUCK, capacity 1/4" to 1/2". Has bronze jaws for supporting centerless shafts in lathe tailstock. No. 1898 or No. 377 arbor required. 5 lb.

No. 1898 ARBOR to adapt 445 chuck to No. 3 MT tailstock. 8 oz.

No. 377 ARBOR to adapt 445 chuck to No. 2 MT tailstock. 8 oz.
**LEVER-TYPE COLLET CHUCK**

The ideal chucking method for fast, accurate duplicate work on bar stock. Work is fed through hollow torque tube of lever-type attachment, chucking, machined and released without stopping the lathe. Moving hand lever to left tightens collet on work — collet is released by moving lever to right. Collet tension adjustment is made with knurled collar at left end of torque tube. Tapered collet sleeve is ground inside and out to insure concentric closing of collet. Nose can project lathe spindle threads. Furnished with tapered closing sleeve and spindle nose cap.

**Jacobs Collet Chuck**

Equips 5300, 5400 and 6300-series lathes for fast, accurate chucking of round work fed through the spindle — from rough bar stock to soft metals, tubing, plastics and wood up to 1/5" diameter — at every speed and feed. Mounts directly on spindle — compact design permits chucking work close to spindle nose.

Positive-gripping "rubber-flex" collets handle rods of any diameter with a 1/8" work range — set of 11, below, handles all work from 1/8" to 1/5" diameter. When collet is closed, perfect parallelism is maintained between extra long alloy steel jaws and work — accuracy and gripping pressure are constant throughout entire gripping range.

**DRAW-IN COLLET CHUCK**

For accurate chucking of bar stock. It is made in making precision tools and in the production of small parts when extreme accuracy is demanded.

Hollow construction permits rods to be passed through lathe spindle—handwheel releases and tightens collet on work. Tapered sleeve is ground inside and outside. Lathe must be stopped to open and close collet. Includes draw-in spindle, tapered closing sleeve, wrench and spindle nose cap, less collet. (Gives length of lathe spindle when ordering No. 7521.)

**COLLET RACK**

No. 7558 COLLET RACK for Clamping 12½" lathe. A convenient holder for No. 7550 2C collets, wrenches, screwdriver and draw-in collet chuck. Clamps to lathe bed ways. 30 lb.
BED TURRET

The Clausing heavy-duty bed turret equips any Clausing 12" lathe for accurate machining of duplicate parts on a production basis.

The 6 1/2" working travel, 4" tool clearance over ram and 2 1/2" minimum working stroke give unmatched versatility. Extra weight of base, ram and head provide the rigidity for taking heavy cuts. And for long work, stock up to 3/4" can be passed through the turret head.

Bed and ram are heavy grey-iron castings — net weight is 100 pounds. Precision ground ways are 7/16" x 7/16" — both sides are gibbed for take-up. Turret stations are located by a spring-actuated tapered pin sliding in a sleeve and engaging a tapered bushing in turret head. Pin, sleeve and bushing are hardened and finish ground.

Head indexes automatically clockwise and may be moved in either direction by hand if operator desires. Head locks with the most convenient handle yet devised — handle stays in the position the operator wants it — doesn’t turn with head. Speed wrench is furnished for quick positioning of stop screws. Socket head cap screws lock bed in position.

Number of tool positions, 6. Turret head, 5 5/8" hex. Recommended tool hole diameter, 1". Ram is 10 3/8" long.

No. 7616 BED TURRET for Clausing 12-inch lathes, with head rough bored to 7/8". (Head must be finish bored on lathe with which it is to be used.) 135 lb.

No. 7615 BED TURRET with head finish bored for 1" tool shanks when ordered with lathe from factory. 135 lb.

DOUBLE TOOL CROSS SLIDE

Double tool cross slide — provides a two-way front and rear tool post operation that saves time on such operations as turning, facing, and cutting-off of duplicate parts. Mounts in place of carriage cross slide.

Feed lever cuts operating time by speeding up cross feed. Swing-type lock bar on front anchors cross slides together for ball-crank feed, or power feed.

Forward tool post has two slots for 5/8" or 5/16" cutter bits — may be used for facing or turning. Rear tool post holds one 5/8" or 5/16" cutter bit. Positive adjustable stop screws on rear of double tool slide can be quickly set to indicate depth of cut.

No. 7680 DOUBLE TOOL CROSS SLIDE complete as shown above at left, with forward tool post, rear tool post, cross slide assembly and feed lever. 37 1/2 lb.

No. 7631 CROSS SLIDE ASSEMBLY only. Consists of tool cross slide, with stop screws, carriage cross slide and feed lever. 28 lb.

No. 7710 SELF-INDEXING CAM-LOCKING TURRET TOOL POST for Double Tool Cross Slide. Has 12 working positions — indexes to within plus or minus .0005". 5 1/2" square head takes four 1/2" cutter bits, not furnished. 11 lb.

No. 7711 STANDARD TURRET TOOL POST for Double Tool Cross Slide. Has screw locating lever. 12 working positions — indexes to within plus or minus .0005". 5 1/2" square head takes four 1/2" cutter bits, not furnished. 11 lb.

No. 7633 REAR TOOL POST only. For use with No. 7631 cross slide assembly. 5 lb.

No. 7634 SINGLE FORWARD TOOL POST only. For use with No. 7631 cross slide assembly. 4 1/2 lb.

HANDLEVER TAILSTOCK ATTACHMENT

No. 7610 HANDLEVER TAILSTOCK ATTACHMENT. Converts regular tailstock for production drilling, reaming, and centering operations. May be set for repeat operations to any depth up to 5". Does not interfere with normal use of tailstock — spindle may be moved by handlever or handwheel.

For 4900 series lathes, serial No. 16738 and above; all 3800 and 3400 series lathes, 6300 series lathes, serial No. 23639 and above.

26
HEAVY DUTY
GRINDER

The 7651 has the extra weight, strength and power for heavy jobs, plus the accuracy and all-round efficiency required to handle the finest internal and external grinding operations on a production basis. Ideal for grinding tools, dies, gauges, bushings, bearings, shafts, valves, valve seats, etc.

Mounts in tool post slide of lathe compound rest. Coordinate-type clamp locks grinder securely in any vertical or radial position. Vertical position is adjusted by raising screw with knob control.

Has two lubricated-and-sealed-for-life ball bearings. Heavy-duty spindle is 5/8" diameter, accurately ground. Spindle takes 4" external wheel with 7/16" hole, and has socket machined to take taper and screw of quill for holding internal grinding wheels. External wheel is enclosed by iron guard, easily removed for mounting internal quill.

Powered by a 1/4 HP 3450 RPM ball bearing motor — operates on 115 volt 60 cycle AC. Two-step balanced pulleys provide grinding spindle speeds of 4900 and 9100 RPM at full load. Belt is covered by safety guard. Note: Grinding operations require reversing lathe spindle.

No. 7651 HEAVY-DUTY GRINDER for Clausing 12" lathes. Equipped with belt and 4" dia. external grinding wheel mounted on spindle, quill for internal work, 3/4" internal grinding wheel, diamond wheel dresser. Motor has switch, cord and plug. 60 lb.

NOTE: For 4800 series lathes serial 16071 and below, order No. 7650 Grinder.

SPECIFICATIONS — No. 7651 GRINDER
Grinds External Diameters up to 43/4"
Grinds Internal Diameters from 1/8" to 3/4"
Internal Wheel Grind to depth of 3/4"
Base Swivels for Angular Grinding: 0 to 90°
Spindle Speeds: 4900 and 9100 RPM, full load
Motor operates on 115V, 60C, AC. Other motors available on request.

GRINDING WHEELS

Medium Grit. No. 10-476 external wheel mounted on spindle and No. 477-1/4 internal wheel are furnished as standard equipment with the 7651 lathe grinder.

<table>
<thead>
<tr>
<th>No.</th>
<th>Dia.</th>
<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>10-475</td>
<td>External Wheel for Steel, 3/8&quot; thick</td>
<td>4&quot;</td>
</tr>
<tr>
<td>10-476</td>
<td>Internal Wheel</td>
<td>1/8&quot; to 3/4&quot;</td>
</tr>
<tr>
<td>477-1/4</td>
<td>Internal Wheel Grind to depth of 3/4&quot;</td>
<td>1/8&quot;</td>
</tr>
<tr>
<td>477-1/4</td>
<td>Internal Wheel Depth of 1/4&quot;</td>
<td>3/4&quot;</td>
</tr>
<tr>
<td>477-1</td>
<td>Internal Wheel</td>
<td>1/8&quot;</td>
</tr>
<tr>
<td>10-478</td>
<td>Special Cup Wheel for O.D. of Reamers</td>
<td>3/4&quot;</td>
</tr>
<tr>
<td>479</td>
<td>Special Saucer Wheel for Face of Solid Reamers</td>
<td>3/4&quot;</td>
</tr>
</tbody>
</table>

MICA UNDERCUTTER

For servicing armatures. Attaches to top of carriage saddle. Saw is fed through mica by turning lathe carriage handwheel. Height of cutter arbor is adjusted by elevation screw. Saw arbor is driven by a 105-150V, AC-DC, 25-60C motor. Handwheel moves arbor up to 40° to diameter.

No. 7516 MICA UNDERCUTTING ATTACHMENT. Motor has extension cord, switch, and plug. Furnished: Set of 5 high speed undercutting saws (0.015", 0.020", 0.025", 0.030" and 0.035"), 10 lb.

No. 7020 SET OF 10 HIGH SPEED SAWs for No. 7516 undercutter (2 each of the following thicknesses: 0.015", 0.020", 0.025", 0.030" and 0.035"), 1 oz.

TELESCOPIC TAPER ATTACHMENT

The Telescopic Taper Attachment is furnished with a telescoping cross feed screw that eliminates the necessity of disengaging the cross feed for taper operations — permits regular hand feed to be used to bring tool to required work diameter. Takes but seconds to change from straight to taper work.

Taper attachment screw turns on two, pre-loaded, sealed-for-life ball bearings in taper slide. This feature, plus rugged construction, assures dependable accuracy and long service life.

Taper is set by loosening clamp screws at each end of slide and turning vernier adjusting screw.

Cuts external or internal tapers up to 10° long at one setting — resets along bed for longer work. Two easy-to-read sets of graduations — one shows degrees of taper, the other inches per foot. Range 10° both sides of center line (20° included angle) and 4° per foot. When ordered with lathe, taper attachment is installed at factory.

No. 7699 TELESCOPIC TAPER ATTACHMENT for Clausing 12" lathes. 49 lb.

PLAIN TAPER ATTACHMENT

Equips lathe for accurate, efficient handling of every taper job — turning, boring, threading. Rigidly supported by carriage saddle, cross slide and bed, the No. 7515 becomes a permanent part of the lathe — it is not necessary to remove it for straight turning or facing jobs. Loosening one nut and tightening two others puts taper attachment in operation — there are no parts to remove.

Taper attachment is set by loosening clamp screws at either end of slide, and turning vernier adjusting screw until index mark comes to desired position.

Cuts external or internal tapers up to 10° long at one setting — simply reset along bed for longer work. Two easy-to-read sets of graduations show degrees of taper and inches per foot. Range 71/2° both sides of center line (15° included angle) and 3" per foot.

When ordered with lathe, taper attachment is installed at factory.

No. 7515 PLAIN TAPER ATTACHMENT for Clausing 12" lathes. 40 lb.
"For precision milling, drilling, boring and locating operations within their capacity, Clausing vertical mills have no equal. They are the most versatile machines we have, and they are equal in performance and accuracy to any of the larger, more expensive mills in our shop." This report is typical of the experience of hundreds of users.

Clausing's reputation for outstanding performance is a result of the features of design and construction detailed below, and of careful inspection at every stage of manufacture and assembly. Before it leaves the factory, each mill must pass tolerance tests such as:

1. Top of table perpendicular to column ways within .0005" in 6" travel.
2. T-slots parallel to table dovetails within .0005" in 6" travel.
3. T-slots square with cross slide dovetails within .0005".
4. Table parallel to turret within .001".
5. Spindle square with table, front to rear, within .001" TIR in 5" circle.
6. Spindle taper (internal) run-out within .0002" at spindle nose.
7. Thickness of cross slide bearing surfaces uniform to within .001".
8. Table T-slots parallel to table dovetail ways within .0005" in 8" longitudinal travel.

The Clausing vertical mill combines precision, efficiency, versatility and sensitivity to a degree unmatched among milling machines.

The spindle head can be swiveled 180° in a vertical plane and set at any angle, and turret head rotated in a horizontal plane making it possible to mill at all angles with one setup.

The head is a rugged thick-walled casting, accurately machined to close tolerances. Quill bearing is full length. Turret base is accurately machined and hand fitted to column. Overarm is an electric furnace casting, 3 inches in diameter, with 3/8" wall. This rigid, precision construction assures accuracy in every operation.

The spindle is hardened and ground chrome nickel steel — 1 1/2" in diameter, with choice of No. 7 Brown and Sharpe or No. 2 MT bore. Quill is ground and hard chrome plated, 2 1/2" diameter, with 1/8" walls.
Spindle turns in three ball bearings. Upper bearing is large, floating, shielded radial-type. Lower bearing is a pre-loaded double row angular-contact that absorbs both end and radial loads.

Two hand feed controls are furnished for advancing spindle to work. A handwheel actuates pinion through a train of reduction gears for fine feed. A handle engages steel pinion gear that meshes with rack in quill for fast feed. Quill has positive clamp lock for operations with spindle in fixed position.

Power is transmitted to spindle through a 5-step idler pulley, a 4-step spindle pulley, and an internally splined steel driver. Spindle pulley turns on two ball bearings mounted on a ground steel support that is anchored to head.

Idler pulley also turns on two ball bearings — there are seven ball bearings in the Clausing's heavy-duty precision drive and spindle! Idler pulley slides in T-slot in motor support casting — and motor support moves laterally on overarm — making belt position changes a quick, easy job. Pulleys are cast aluminum, machined and balanced.

Brake, controlled by lever on side of head, stops spindle quickly — draw-in bar has exclusive automatic collet ejection mechanism — another time saver. Positive depth stop with graduated dial and easy-to-read scale provides depth control accurate to .001".

Column, knee, saddle and table are heavy normalized iron castings — rigid foundations for accurate work.

Column is thick-walled with 2-inch deep ribs spaced three inches apart. Vee ways for knee bearings are cast integrally with column. Bearing surfaces for column and saddle have full length gibs.

Elevation screw turns on ball thrust bearing. Control handle shaft turns on two more ball bearings, operates screw through steel bevel gears.

Saddle has 6" long dovetail bearings on knee and 10 3/4" bearings on table — a rigid precision support for table. Feed screw is 1 1/2" diameter with ground threads, turns on two ball bearings for smooth, easy action.

Table is a precision support for accurate work — ground on top, sides and dovetails. Has three T-slots in top . . . T-slot in front for the positive adjustable stops . . . full length gib for long, accurate service.

Specifications and listings on page 30.
vertical milling machines

Feed screw is \( \frac{7}{8}'' \) diameter, has ground threads, turns on three ball bearings.

Feed screw dials are \( \frac{3}{8}'' \) diameter, micrometer-graduated in .001", for easy, accurate feeding. Vertical table travel is controlled by large crank . . . dial is graduated in .001". Knee, table and saddle are equipped with gib locks.

Steel cabinet is a rigid mounting for the machine. Top is flanged, has outlet for removal of oil. Shelf, easily accessible through door in left side, provides ample space for storage of tools and accessories.

**No. 8520** CLAUSING VERTICAL MILLING MACHINE with No. 2 MT spindle, less motor. 650 lb.

**No. 8525** CLAUSING VERTICAL MILLING MACHINE with No. 7 Brown & Sharpe spindle, less motor. 650 lb.

Floor cabinet and reversing switch (with switch cord) to accommodate both single and 3-phase motors are furnished with both models.

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**SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table Size</td>
<td>6'' x 24''</td>
</tr>
<tr>
<td>Longitudinal Table Travel</td>
<td>15''</td>
</tr>
<tr>
<td>Cross Table Travel</td>
<td>5''</td>
</tr>
<tr>
<td>Vertical Table Travel</td>
<td>11(\frac{3}{8}'')</td>
</tr>
<tr>
<td>Spindle Travel</td>
<td>3''</td>
</tr>
<tr>
<td>Maximum Distance Spindle to Table</td>
<td>11(\frac{3}{8}'')</td>
</tr>
<tr>
<td>Maximum Distance Spindle to Column</td>
<td>8(\frac{3}{4}'')</td>
</tr>
<tr>
<td>T-slot, Top of Table</td>
<td>9.16''</td>
</tr>
<tr>
<td>T-slot, Front of Table</td>
<td>1(\frac{1}{4}'')</td>
</tr>
<tr>
<td>Spindle Speeds</td>
<td>180, 350, 600, 1000, 1900, 3250 RPM</td>
</tr>
<tr>
<td>Spindle Nose...No. 7 Brown &amp; Sharpe or No. 2 MT Elevation Screw, Knee...Stressproof steel, 7/8'' dia. 10 Acme threads per inch</td>
<td></td>
</tr>
<tr>
<td>Motor Recommended...1/2 or 3/4 HP, 1725 RPM</td>
<td></td>
</tr>
<tr>
<td>Motor Base Takes NEMA Frame Sizes J56, 1186, 1216B</td>
<td></td>
</tr>
<tr>
<td>Overall Dimensions</td>
<td>36'' x 40'' x 66'' high</td>
</tr>
</tbody>
</table>

www.OzarkToolManuals.com
ACCESSORIES

MEASURING ATTACHMENT

The Clauing Measuring Attachment saves time in all drilling and boring operations where holes must be located to very close tolerances. It is especially useful in the machining of dies, jigs, fixtures — essential in any shop engaged in precision machining.

The Measuring Attachment is built to the highest standards of quality and workmanship — rods are accurate to +.0001", the two micrometer heads and dial indicators read to .0001", turrets are precision machined. And every provision is made for lasting service. Rods are hardened. Threads of micrometer heads are ground, hardened and stabilized. Dial indicators have jewel bearings, "no-shock" movement, and are protected by a buffer. Measuring attachment is installed when ordered with machine from factory.

No. 8630 MEASURING ATTACHMENT for Clauing Vertical Milling Machine. Complete with two 1" rods, two 2" rods, two 3" rods, one 4" rod, one 8" rod, two 4"A" micrometer heads, two dial indicators, table trough and saddle trough with indicator holders, two stop brackets with movable stop rods, storage case for rods and micrometer heads. 20 lb.

MOTORS

Single Phase Motors

<table>
<thead>
<tr>
<th>No.</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft Dia.</th>
<th>Wt.</th>
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<tbody>
<tr>
<td>2720</td>
<td>1/2</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
<td>58</td>
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<tr>
<td>2790</td>
<td>3/4</td>
<td>115/230</td>
<td>60</td>
<td>1725</td>
<td>7/8&quot;</td>
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Three Phase Motors

<table>
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<tr>
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<th>HP</th>
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<th>RPM</th>
<th>Shaft Dia.</th>
<th>Wt.</th>
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</thead>
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<tr>
<td>2021</td>
<td>1/2</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>35</td>
</tr>
<tr>
<td>8640</td>
<td>3/4</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8&quot;</td>
<td>48</td>
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</table>

All motors listed above are ball bearing equipped, have single end shaft with 1/4" x 1/8" keyway — do not have switch, cord or plug.

NOTE: All motors listed above will operate satisfactorily on a 10% voltage variation. Other voltages and cycles available — information sent on request.

SPLIT HOLDING COLLETS

Collet tool steel, heat treated, ground inside and outside, and threaded for 3/8"-16 draw bar. Handle round shank tools with diameters between 1/8" to 1/2" in increments of 1/16".

For No. 2 MI Spindle

<table>
<thead>
<tr>
<th>No.</th>
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<tbody>
<tr>
<td>8601</td>
<td>1/4&quot; Collet</td>
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</tr>
<tr>
<td>8602</td>
<td>5/32&quot; Collet</td>
<td>1 lb.</td>
</tr>
<tr>
<td>8603</td>
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<td>1 lb.</td>
</tr>
<tr>
<td>8604</td>
<td>1/8&quot; Collet</td>
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For No. 7 Brown & Sharpe Spindle

<table>
<thead>
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<th>Wt.</th>
</tr>
</thead>
<tbody>
<tr>
<td>8608</td>
<td>5/32&quot; Collet</td>
<td>1 lb.</td>
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<tr>
<td>8609</td>
<td>3/32&quot; Collet</td>
<td>1 lb.</td>
</tr>
<tr>
<td>8610</td>
<td>1/8&quot; Collet</td>
<td>1 lb.</td>
</tr>
<tr>
<td>8611</td>
<td>1/4&quot; Collet</td>
<td>1 lb.</td>
</tr>
</tbody>
</table>

JACOBS CHUCK

No. 8615 JACOBS BALL BEARING CHUCK, capacity No. 70 drill to 1/2". Key-type wrench and 1/2" straight shank arbor furnished. 2 1/2 lb.
CLAUSING 18-inch 
heavy duty drill presses

Clausing drill presses are acclaimed the best producers in their field on continuous heavy-duty production. The reasons for their superior performance, and bigger tool and job capacities are heavier construction throughout, and more powerful and efficient drive.

The Clausing drill press head is a massive thick-walled box-type casting, machined to close tolerances—a rigid, precision housing for the heart of the drill, the spindle and drive units. Note in the illustration at left the heavy-duty construction.

Quill guides and column bearing surfaces are long, and are spaced for maximum accuracy under all loads.

Front of head is split—two Nylock machine screws permit adjustment for wear. Two sets of coordinate steel locks anchor head to column.

Precision-ground spindle is 6 3/4" in diameter—bore is No. 3 Morse taper—travel is 6 1/2". The larger spindle provides larger tool capacity—the longer travel gives more job capacity.

Spindle turns on ball bearings spaced 8 1/2" apart. Upper bearing is lubricated-for-life. Lower bearing is double-row, double shielded. Both races of the lower bearing absorb drill thrust as well as radial thrust. Quill is precision ground steel, 2 3/8" in diameter, with 3/8" thick walls.

The drive is built to efficiently handle the power required for heavy-duty jobs. Power is transmitted to the drill spindle thru a 5-step pulley keyed to the internally splined drive spindle. Drive spindle turns on two lubricated-for-life ball bearings—one is mounted in head, the other in overarm support bracket above pulley. Motor and drive pulleys are cast iron, machined and balanced. Belt is 5/8" B-section.

Motor base is hinged at top—has lever controlled cam-type release for quick belt-position changes. Jackscrew mechanism provides for easy belt tensioning.

Hand feed models have 3-spoke feed wheel. Accurately machined pinion gear and quill rack assure smooth feeding action. Heavy-duty adjustable spring, housed in cap, controls tension. Depth stop
mechanism has two stop-feed nuts — reading is direct on large scale on headstock.

Power feed models have heavy-duty gear-driven power feed that is positive and sure.

Power feed spindle is driven by V-belt from the drill press spindle, and speed is reduced by a drive gear, four sets of change gears, plus a worm and worm gear, as illustrated at right. Power is transferred with maximum efficiency and feed is always in direct relation to drill speed.

Rate of feed is selected by turning knobbled dial — there are no belts to position as with ordinary power feeds. Dial has neutral position that allows gears to idle for hand feed jobs. Engagement clutch is controlled by any of the 3 handles. Kickout clutch on worm shaft disengages power feed automatically at end of each stroke.

Drive gear and change gears are steel, have 3/8” wide faces. Worm is hardened Stress-proof steel. Worm gear is bronze, has 3/16” face, travels in bush of oil. Gear shafts are ground steel, turn on heavy-duty Oiltite bearings. Two more Oiltite bearings float worm free on shaft when feed is disengaged — worm shaft has a ball bearing to absorb thrust. Clutch on pinion shaft is hardened steel—engaging dogs are wear-resistant Tobin bronze. Friction clutch on pinion shaft protects mechanism against overload.

The tables are large, rugged, accurate supports for easy handling of big work and fixtures. Oil table for floor model is a 95-pound casting with 13” x 18” precision ground working surface. Has two parallel 3/8” T-slots spaced 10” apart... drain channel with outlet hole and threaded plug. Column bracket, cast integrally with table, has two lever-controlled locks.

Tilting table has a 12” x 14” ground working surface, with six parallel slots. Table tilts to any desired angle left or right — index pin locates horizontal position quickly, accurately. Two lever-controlled locks anchor table to column.

Base has 12” x 14” ground working surface for accurate handling of large stock. Two 3/8” T-slots, 18” throat capacity. It is a rugged foundation for the entire drill press.

Production base drill has oil base with 16” x 18” working surface.

The Clausing head and table positioning mechanism furnished with single spindle floor drills moves both head and table with a minimum of effort. It is ruggedly built, with two ball thrust bearings, three large steel gears, 3/4”-8 Acme screw, and crank control. Collar, located directly below crank, permits swinging table and mechanism for mounting work on base.
**CLAUSING**

**HEAVY DUTY 18-inch HAND FEED DRILL PRESSES**

**SPECIFICATIONS, ALL MODELS**

<table>
<thead>
<tr>
<th>Specifications</th>
<th>Models</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drills to Center of Circle</td>
<td>18 1/2&quot;</td>
</tr>
<tr>
<td>Drilling Capacity</td>
<td>9/16&quot; in Steel, 1&quot; in Cast Iron</td>
</tr>
<tr>
<td>Spindle Travel</td>
<td>6 1/2&quot;</td>
</tr>
<tr>
<td>Spindle Size</td>
<td>6 1/4&quot;</td>
</tr>
<tr>
<td>No. 3 Morse Taper</td>
<td>Speed Range, with 1725 RPM motor...395, 650, 1100, 1850, 3000</td>
</tr>
<tr>
<td>Speed Range, with 1140 RPM motor.250, 480, 800, 1200, 1950</td>
<td>Bearsings (Spindle) 1 single row ball (lubricated-for-life)</td>
</tr>
<tr>
<td></td>
<td>1 double row ball (double shielded)</td>
</tr>
<tr>
<td></td>
<td>Bearings (Drive Spindle) 2 single row ball (lubricated-for-life)</td>
</tr>
<tr>
<td></td>
<td>Column 5 1/2&quot; dia., 3/8&quot; wall</td>
</tr>
<tr>
<td></td>
<td>Quill Diameter 2 1/2&quot;</td>
</tr>
<tr>
<td></td>
<td>Motor Required 3/4 HP to 1 1/2 HP</td>
</tr>
<tr>
<td></td>
<td>Motor Base Takes NEMA Frames 56, 192, 194, 103, 204, 224, 225</td>
</tr>
</tbody>
</table>

| Machine Number                  | 1900                                        |
| Distance Spindle to Table       | 25"                                         |
| Distance Spindle to Base        |                                             |
| Table Size, Working Surface     | 16" x 18"                                  |
| Overall Dimensions, with motor  | 24" x 49 1/2" x 50 1/2"                    |
| Shipping Weight, less motor     | 480 lb.                                     |

| Machine Number                  | 1810                                        |
| Distance Chuck to Table         | 40"                                         |
| Distance Chuck to Base          | 13" x 18"                                  |
| Table Size, Working Surface     | 12" x 18"                                  |
| Overall Dimensions, with motor  | 21 3/4" x 35 7/8" x 79 1/2"                |
| Shipping Weight, less motor     | 465 lb.                                     |

| Machine Number                  | 1800                                        |
| Distance Chuck to Table         | 40"                                         |
| Distance Chuck to Base          | 12" x 14"                                  |
| Table Size, Working Surface     | 12" x 14"                                  |
| Overall Dimensions, with motor  | 21 1/4" x 35 1/4" x 79 1/2"                |
| Shipping Weight, less motor     | 420 lb.                                     |

**EQUIPMENT FURNISHED**: includes positioning mechanism, belt and pulley guards, 3-spoke feed wheel, depth control stop, belt, 3-step motor pulley, and power feed drive pulley for subsequent installation of power feed drive unit; less motor and switch. (NOTE: 3/4" and 1" bore motor pulleys are available, specify diameter when ordering.)
HEAVY DUTY 18" DRILL PRESSES with GEAR-DRIVEN POWER FEED

SPECIFICATIONS, ALL MODELS

Drills to Center of Circle ........................................... 18½"
Drilling Capacity ................................................... ¾" in Steel, 1" in Cast Iron
Spindle Travel ...................................................... 6½"
Spindle Size ........................................................... 63/64"
Spindle Nose ......................................................... No. 3 Morse Taper
Rates of Feed, per Spindle Revolution...004", .006", .009", .012"
Speed Range, with 1725 RPM Motor...390, 650, 1100, 1850, 3000
Speed Range, with 1140 RPM Motor...250, 480, 600, 1260, 1950
Bearings (Spindle) ...........................................1 single row ball (lubricated-for-life)
Bearings (Spindle) ...........................................1 double row ball (double shielded)
Bearings (Drive Spindle) ......................2 single row ball (lubricated-for-life)
Column ................................................................. 3⅛" dia., ¾" wall
Quill Diameter ..................................................... 2¾"
Motor Required ...................................................... ¾ HP to 1½ HP
Motor Base Takes NEMA Frames...56, 182, 184, 203, 204, 224, 225

<table>
<thead>
<tr>
<th>MODEL</th>
<th>PRODUCTION BASE DRILL</th>
<th>FLOOR-TYPE WITH PRODUCTION OIL TABLE</th>
<th>FLOOR-TYPE WITH FULL TILTING TABLE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine Number</td>
<td>1905</td>
<td>1815</td>
<td>1805</td>
</tr>
<tr>
<td>Distance Spindle to Table</td>
<td>25&quot;</td>
<td>40&quot;</td>
<td>40&quot;</td>
</tr>
<tr>
<td>Distance Spindle to Base</td>
<td>15&quot; x 18&quot;</td>
<td>51&quot;</td>
<td>51&quot;</td>
</tr>
<tr>
<td>Table Size, Working Surface</td>
<td>12&quot; x 14&quot;</td>
<td>12&quot; x 14&quot;</td>
<td>12&quot; x 14&quot;</td>
</tr>
<tr>
<td>Overall Dimensions, with motor</td>
<td>21¾&quot; x 35½&quot; x 79½&quot;</td>
<td>21¾&quot; x 35½&quot; x 79½&quot;</td>
<td>21¾&quot; x 35½&quot; x 79½&quot;</td>
</tr>
<tr>
<td>Shipping Weight, less motor</td>
<td>530 lb.</td>
<td>524 lb.</td>
<td>482 lb.</td>
</tr>
<tr>
<td>Machine Number</td>
<td>1925</td>
<td>1875</td>
<td>1865</td>
</tr>
<tr>
<td>Distance Chuck to Table</td>
<td>25½&quot;</td>
<td>40½&quot;</td>
<td>40½&quot;</td>
</tr>
<tr>
<td>Distance Chuck to Base</td>
<td>51½&quot;</td>
<td>51½&quot;</td>
<td>51½&quot;</td>
</tr>
</tbody>
</table>

With ¾" Jacobs Chuck

All other specifications same as above

EQUIPMENT FURNISHED: includes power feed, positioning mechanism, 3-spoke hand feed wheel, depth control stop, belt and 5-step motor pulley, belt and pulley guards, less motor and switch.

*(NOTE: ⅜" and 1" bore motor pulleys are available, specify diameter when ordering.)*

35
CLAUSING 18" heavy duty 2, 3, 4 spindle drill presses

- Bigger, heavier tables, for easier handling of big jobs, fixtures.
- Greater distance between spindles — plenty of elbowroom for more efficient work at each spindle.
- 17" in front of column brackets, larger oil trough.
- More working surface between ends of table and spindles.

Clausing multiple spindle drills are larger tool and job capacity machines built especially for heavy-duty work. They boost output, reduce parts handling on all jobs requiring a series of drilled and tapped holes. And, they are dependably accurate — spindle is square with table to within .005" in a 12" circle, spindle runout is within .0015" at end of 4" arbor.

---

### WITH No. 3 MORSE TAPER SPINDLE

<table>
<thead>
<tr>
<th>Machine No.</th>
<th>1043</th>
<th>1044</th>
<th>1047</th>
<th>1048</th>
<th>1053</th>
<th>1055</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table, Overall</td>
<td>63/4&quot; x 28/4&quot;</td>
<td>63/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
</tr>
<tr>
<td>Working Surface, Overall</td>
<td>57/2&quot; x 22&quot;</td>
<td>57/2&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
</tr>
<tr>
<td>Center to Center, Spindles</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
</tr>
<tr>
<td>Overall with Motors</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
</tr>
<tr>
<td>Shipping Weight</td>
<td>1320</td>
<td>1420</td>
<td>1540</td>
<td>1690</td>
<td>2450</td>
<td>2550</td>
</tr>
</tbody>
</table>

---

### WITH 3/4" JACOBS CHUCK

<table>
<thead>
<tr>
<th>Machine No.</th>
<th>1045</th>
<th>1046</th>
<th>1049</th>
<th>1051</th>
<th>1056</th>
<th>1057</th>
<th>1052</th>
<th>1053</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table, Overall</td>
<td>63/4&quot; x 28/4&quot;</td>
<td>63/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
<td>90/4&quot; x 28/4&quot;</td>
</tr>
<tr>
<td>Working Surface, Overall</td>
<td>57/2&quot; x 22&quot;</td>
<td>57/2&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
<td>84&quot; x 22&quot;</td>
</tr>
<tr>
<td>Center to Center, Spindles</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
<td>26&quot;</td>
</tr>
<tr>
<td>Overall with Motors</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
<td>83/4&quot; x 41/2&quot; deep x 63/4&quot; wide</td>
</tr>
<tr>
<td>Shipping Weight</td>
<td>1520</td>
<td>1420</td>
<td>1340</td>
<td>1690</td>
<td>2450</td>
<td>2600</td>
<td>2550</td>
<td>2750</td>
</tr>
</tbody>
</table>

### SPECIFICATIONS, ALL MODELS

- Distance Table to Spindle, Maximum: 35"
- Distance Table to Chuck, Maximum: 251/2"
- Front of Table to Center of Spindle: 91/2"
- Column Diameter: 3.443"
- Column to Center of Spindle: 85/8"
- Column Bracket to Center of Spindle: 85/8"
- Spindle Size: 43/32"
- Spindle Diameter: 63/64" or 63/64"
- Feed, P.S.R. (Power Feed Drills): .004", .006", .009", .012"
- Speeds with 1725 RPM motor: 550, 650, 1100, 1850, 3000
- Speeds with 1140 RPM motor: 250, 400, 800, 1200, 1950
- Motor Required: 3/4 HP to 1 1/2 HP
- Wood Shelf: 15" x 15 1/2"

Clausing Multiple Spindle Drills are shipped with columns and heads mounted on table, but table is not mounted on legs.

EQUIPMENT FURNISHED: Head positioning mechanism, belt and pulley guards, depth control stops, belts and cast iron motor pulleys, less motor and switch. (Note: 3/4" and 1" bore motor pulleys are available: specify diameter when ordering.)
In almost every small-part production set-up there are operations where 15" multiple spindle drill presses can save time. They eliminate waste operator motion on series of drilled and tapped holes . . . reduce parts handling . . . boost output.

The massive production oil tables provide plenty of "elbow room" for smooth movement of jigs and fixtures. Tables are heavier for greater accuracy. Heads have exclusive "floating drive" with four ball bearings, six-spindled spindle and drive sleeve, widely spaced column bearings, 3-spoke feed wheel, and efficient positioning mechanism.

### Specifications, All Models

<table>
<thead>
<tr>
<th>Maximum Distance Table to Chuck</th>
<th>36&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum Distance Table to No. 2 MT Spindles</td>
<td>25 1/8&quot;</td>
</tr>
<tr>
<td>Column to Center of Spindle</td>
<td>7 1/2&quot;</td>
</tr>
<tr>
<td>Column Bracket to Center of Spindle</td>
<td>6 1/2&quot;</td>
</tr>
<tr>
<td>Chuck Capacity</td>
<td>1/4&quot;</td>
</tr>
<tr>
<td>Spindle Travel</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Speeds, Hi-Speed Drills, 4</td>
<td>380, 1300, 2440, 5200 RPM</td>
</tr>
<tr>
<td>Speeds, Slo-Speed Drills, 5</td>
<td>600, 800, 1370, 2750, 4400 RPM</td>
</tr>
<tr>
<td>Columns, Ground Steel</td>
<td>23 5/8&quot; dia.</td>
</tr>
<tr>
<td>Motor Recommended</td>
<td>1/6 or 1/2 HP, 1725 RPM</td>
</tr>
<tr>
<td>Motor Base Takes NEMA Frame</td>
<td>56</td>
</tr>
</tbody>
</table>

EQUIPMENT FURNISHED: Head raising mechanism, motor mounting bracket, V-belt, 3/8" diameter bore motor pulley — four-step with hi-speed, five step with slo-speed. Dealer can supply bushings for 1/2" dia. motor shafts.

Cross section of 15" drill press head. Note the rugged construction, the 2 lubrificated-for-life ball bearings that support the steel drive sleeve, the 2 lubrificated-for-life ball bearings that float spindle in quill, the three widely spaced quill guides.
Drill Head and Column Assemblies

Clausing Drill Press Head and Column Assemblies solve drilling problems requiring special placement of the head on Clausing or other drill press tables. And, their heavy-duty construction and big tool capacity make them ideal components for "special" machines.

18" DRILL PRESS HEAD and COLUMN ASSEMBLIES

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1939</td>
<td>No. 3 MT</td>
<td>Hand</td>
<td>220</td>
<td>1941</td>
<td>¾&quot; Chuck</td>
<td>Hand</td>
<td>220</td>
</tr>
<tr>
<td>1940</td>
<td>No. 3 MT</td>
<td>Power</td>
<td>270</td>
<td>1942</td>
<td>¾&quot; Chuck</td>
<td>Power</td>
<td>270</td>
</tr>
</tbody>
</table>

15" DRILL PRESS HEAD and COLUMN ASSEMBLIES

<table>
<thead>
<tr>
<th></th>
<th></th>
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<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1142</td>
<td>½&quot; Chuck</td>
<td>High</td>
<td>108</td>
<td>1462</td>
<td>No. 2 MT</td>
<td>High</td>
<td>108</td>
</tr>
<tr>
<td>1152</td>
<td>½&quot; Chuck</td>
<td>Slow</td>
<td>108</td>
<td>1467</td>
<td>No. 2 MT</td>
<td>Slow</td>
<td>108</td>
</tr>
</tbody>
</table>

DRILL PRESS TABLES

Clausing drill press tables and legs are available separately with column brackets. Prices for table drilled to your specifications submitted on request.

No. 1938 90 x 28 x 24" TABLE only with legs and shelf. Not drilled for column brackets. 1170 lb.
No. 1256 63 x 28 x 24" TABLE only with legs and shelf. Not drilled for column brackets. 880 lb.
No. 1257 30 x 24 x 24" TABLE only with legs and shelf. Not drilled for column brackets. 500 lb.

Drill Press Heads

Clausing drill press heads help you convert awkward, expensive jobs into profitable operations, and at a mere fraction of the cost of "special" machinery. The possibilities of increasing drilling efficiency with Clausing heads are practically unlimited.

18" DRILL PRESS HEADS

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1950</td>
<td>No. 3 MT</td>
<td>Hand</td>
<td>162</td>
<td>1970</td>
<td>¾&quot; Chuck</td>
<td>Hand</td>
<td>162</td>
</tr>
<tr>
<td>1955</td>
<td>No. 3 MT</td>
<td>Power</td>
<td>212</td>
<td>1975</td>
<td>¾&quot; Chuck</td>
<td>Power</td>
<td>212</td>
</tr>
</tbody>
</table>

15" DRILL PRESS HEADS

<table>
<thead>
<tr>
<th></th>
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<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1180</td>
<td>½&quot; Chuck</td>
<td>High</td>
<td>70</td>
<td>1485</td>
<td>No. 2 MT</td>
<td>High</td>
<td>70</td>
</tr>
<tr>
<td>1190</td>
<td>½&quot; Chuck</td>
<td>Slow</td>
<td>70</td>
<td>1495</td>
<td>No. 2 MT</td>
<td>Slow</td>
<td>72</td>
</tr>
</tbody>
</table>
**Drill Press Accessories**

**SINGLE PHASE MOTORS**

<table>
<thead>
<tr>
<th>No.</th>
<th>For Drill</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft Dia.</th>
<th>Wt. Lbs.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2720</td>
<td>15”</td>
<td>1/2</td>
<td>115/240</td>
<td>60</td>
<td>1725</td>
<td>5/8”</td>
<td>32</td>
</tr>
<tr>
<td>2790</td>
<td>18”</td>
<td>3/4</td>
<td>115/240</td>
<td>60</td>
<td>1725</td>
<td>5/8”</td>
<td>50</td>
</tr>
<tr>
<td>2760</td>
<td>18”</td>
<td>1</td>
<td>115/240</td>
<td>60</td>
<td>1725</td>
<td>7/8”</td>
<td>76</td>
</tr>
</tbody>
</table>

**THREE PHASE MOTORS**

<table>
<thead>
<tr>
<th>No.</th>
<th>For Drill</th>
<th>HP</th>
<th>Volts</th>
<th>Cycle</th>
<th>RPM</th>
<th>Shaft Dia.</th>
<th>Wt. Lbs.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2821</td>
<td>15”</td>
<td>1/2</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>5/8”</td>
<td>32</td>
</tr>
<tr>
<td>2840</td>
<td>18”</td>
<td>3/4</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>5/8”</td>
<td>47</td>
</tr>
<tr>
<td>2862</td>
<td>18”</td>
<td>1</td>
<td>220/440</td>
<td>50/60</td>
<td>1425/1725</td>
<td>7/8”</td>
<td>78</td>
</tr>
<tr>
<td>2867</td>
<td>18”</td>
<td>1 1/2</td>
<td>208/220/440</td>
<td>60</td>
<td>1140</td>
<td>7/8”</td>
<td>91</td>
</tr>
</tbody>
</table>

All motors listed above are ball bearing equipped, have single end shaft — do not have switch, cord or plug.

**PUSH BUTTON SWITCHES**

<table>
<thead>
<tr>
<th>No.</th>
<th>Type for Drill</th>
<th>Voltage Cycle</th>
<th>Phase</th>
<th>HP</th>
<th>Wt. Lbs.</th>
</tr>
</thead>
<tbody>
<tr>
<td>2443</td>
<td>Manual 18”</td>
<td>220/440 25 to 60</td>
<td>single</td>
<td>2 at 220</td>
<td>6 1/2</td>
</tr>
<tr>
<td>2444</td>
<td>Manual 18”</td>
<td>220/440 25 to 60</td>
<td>single</td>
<td>2 at 220</td>
<td>6 1/2</td>
</tr>
</tbody>
</table>

Furnished with mounting bracket and motor connection cord.

**MANUAL and MAGNETIC STARTERS**

<table>
<thead>
<tr>
<th>No.</th>
<th>Type</th>
<th>For Drill</th>
<th>Voltage Cycle</th>
<th>Phase</th>
<th>HP</th>
<th>Wt. Lbs.</th>
</tr>
</thead>
<tbody>
<tr>
<td>*7505</td>
<td>Manual 18”</td>
<td>110/220/440 25 to 60</td>
<td>single</td>
<td>1/2 at 110</td>
<td>6 1/2</td>
<td></td>
</tr>
<tr>
<td>*2506</td>
<td>Magnetic 10”</td>
<td>220 50/60</td>
<td>three</td>
<td>2 at 220</td>
<td>3 1/2</td>
<td></td>
</tr>
<tr>
<td>*2510</td>
<td>Magnetic 18”</td>
<td>440 50/60</td>
<td>three</td>
<td>2 at 440</td>
<td>7 1/2</td>
<td></td>
</tr>
<tr>
<td>*2511</td>
<td>Magnetic 18”</td>
<td>110/220 60</td>
<td>single</td>
<td>1 at 110</td>
<td>11</td>
<td></td>
</tr>
</tbody>
</table>

*No. 2505 thru 2511 are equipped with heater coils to protect motor against overload and low voltage. When ordering, specify catalog number of Clauing motor and voltage of line to which heater coil will be furnished. If motor is other than Clauing, specify voltage, cycle, phase, amperage. Mount on motor support base — bracket and motor connection cord are furnished.

**SAFETY BELT GUARD FOR 15” DRILLS**

No. 1240 SAFETY GUARD for 15” drill presses. Covers entire drill press drive. Pin lugs permit quick raising for speed changes. May be ordered separately or with drill. Ready tapped for easy installation. 7 lb.

**JACOBS CHUCKS FOR 18” DRILL PRESSES**

The Jacobs Chucks listed below have No. 3 Jacobs tapered hole, key-type wrench. May be adapted to No. 5 MT spindles with No. 1898 arbor, below.

No. 1896 JACOBS CHUCK, capacity 1/2” drill to 1”. Key-type wrench furnished. 2 1/2 lb.

No. 1897 JACOBS CHUCK, capacity 1/2” drill to 3/4”. Key-type wrench furnished. 3 1/2 lb.

No. 1898 ARBOR to adapt Nos. 1896 and 1897 chucks to No. 3 Morse taper drill press spindles. 13 oz.

**FOOT LEVER FEED CONTROL FOR 18” FLOOR DRILLS**

The Clauing Foot Lever Feed Control speeds up repetitive operations. Twelve combinations of feed rate and leverage, plus exclusive offset pedal that bypasses drill base, enable operator to work with maximum productivity and minimum fatigue, standing or sitting. 20” sleeve on connecting rod permits wide range of drill head positions. Return-spring tension is readily adjusted. Easily installed — no holes to drill or tap. Takes but one minute to disengage for hand feed.

No. 1804 FOOT FEED ATTACHMENT for Clauing 18” drill presses. 40 lb.

**POWER FEED ATTACHMENT FOR 18” DRILLS**

Steps up output by converting any Clauing drill into a power feed drill press. Power feed spindle is driven by V-belt from the drill press spindle, and speed is reduced by a drive gear, four sets of change gears plus a worm and worm gear. Rate of feed is selected by turning knurled dial. Ruggedly built for heavy duty service. Has overload-protection clutch, oil bath lubrication. See page 33 for complete information.

No. 1891 POWER FEED ATTACHMENT, with feed handles, pulley, V-belt and wrenches. Give serial number of drill press head when ordering. 50 lb.

www.OzarkToolManuals.com
Clausing lathes, drills and mills are broadly employed in solving countless and widely varied machining problems in plants and shops the world over.

More than 50 years of "know how" is built into Clausing machine tools - the experience of users quoted on this page suggests the quality of performance you can expect and get when you put them to work in your plant. You can depend on them for cost-saving results.

Your Clausing dealer will be glad to have you inspect his display, and he is equipped to recommend the machines best suited to your requirements.

Clausing machine tools are guaranteed to equal or exceed the standards of accuracy as represented.

They are guaranteed against defects in material and workmanship for a period of one year, subject to standard warranty procedure. Design and construction are subject to modification and improvement without notice.

Division, Atlas Press Co.
Kalamazoo, Mich., U.S.A.
NUMERICAL PRICE LIST FOR

LATHES AND ACCESSORIES

PRICE LIST 6582-5       JUNE, 1959

We reserve the right to make changes in price, design and specifications without notice, and those in effect at date of shipment will apply. Lathe prices include two-speed motor (***) and Allen-Bradley Electric Motor Control Kits. Prices marked (*) are F.O.B. factory; all others are F.O.B. nearest port accepting or open to ocean traffic.

CLAUSING DIVISION • ATLAS PRESS CO. • KALAMAZOO, MICHIGAN • U.S.A.

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<td>6” Universal Chuck with 2 sets of solid jaws</td>
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<td>6” 6-Jaw Griptur Chuck with 2 sets of solid jaws</td>
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** Specify voltage desired when ordering — 220 or 440V.

Clausing-Colchester lathes are also available with one-speed motors — price on request.
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**ACCESSORIES FOR 15" LATHES**

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<td>13-403</td>
<td>21&quot; Face Plate for Gap Bed Lathe, ASA—L-1 nose</td>
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<td>8&quot; Universal Chuck with 2 sets of solid jaws</td>
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**ACCESSORIES FOR 17" LATHES**

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<td>17-502</td>
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<td>17-503</td>
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