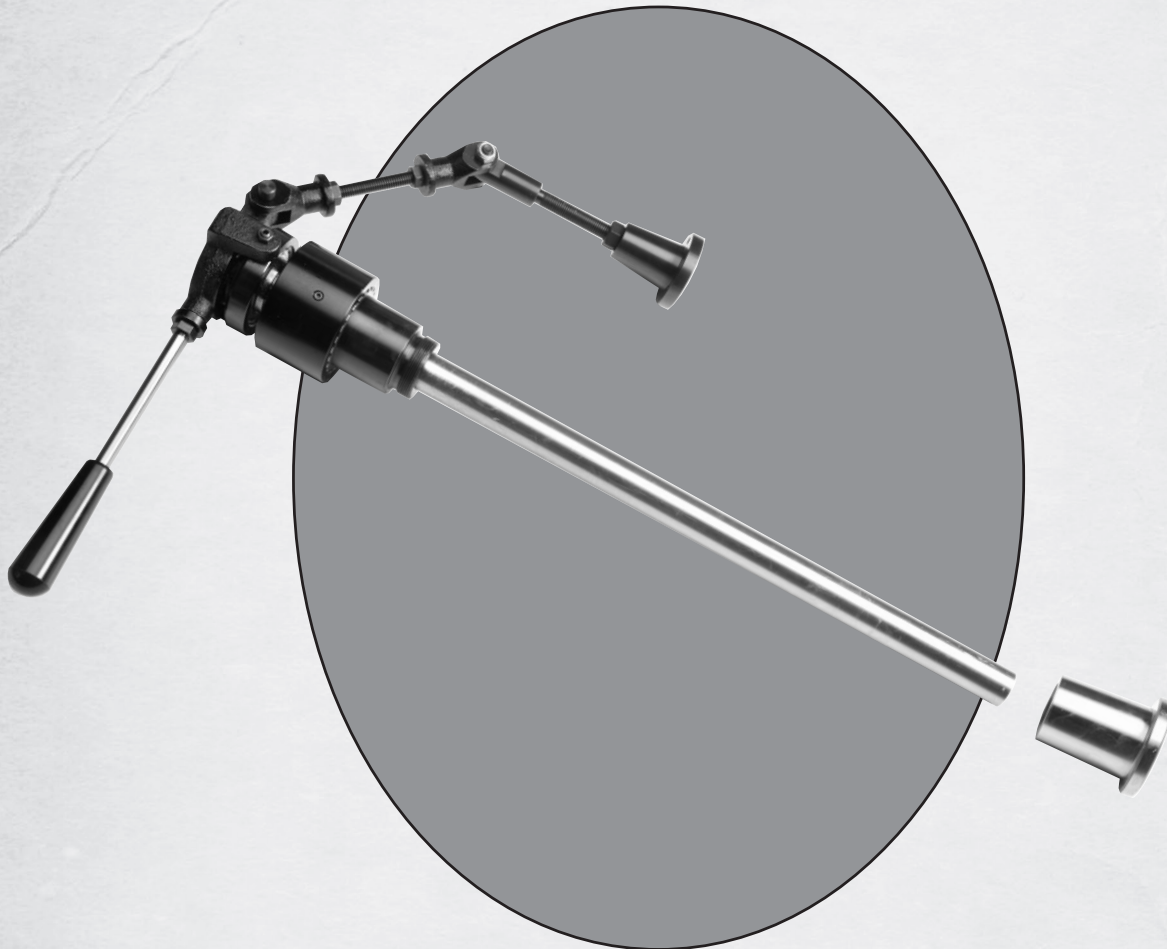




# MODEL SB1272 COLLET ATTACHMENT

FOR LATHE MODELS: SB1016 & SB1036



**OWNER'S MANUAL**

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## South Bend Lathe Co.<sup>TM</sup>

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*Hundreds of Thousands of Lathes Sold With a Tradition of Quality Since 1906!*



# Scope of Manual

This manual helps the reader understand the machine, how to prepare it for operation, how to control it during operation, and how to keep it in good working condition. We assume the reader has a basic understanding of how to operate this type of machine, but that the reader is not familiar with the controls and adjustments of this specific model. As with all machinery of this nature, learning the nuances of operation is a process that happens through training and experience. If you are not an experienced operator of this type of machinery, read through this entire manual, then learn more from an experienced operator, schooling, or research before attempting operations. Following this advice will help you avoid serious personal injury and get the best results from your work.

## Manual Feedback

We've made every effort to be accurate when documenting this machine. However, errors sometimes happen or the machine design changes after the documentation process—so the manual may not exactly match your machine. If a difference between the manual and machine leaves you in doubt, contact our customer service for clarification.

We highly value customer feedback on our manuals. If you have a moment, please share your experience using this manual. What did you like about it? Is there anything you would change to make it better? Did it meet your expectations for clarity, professionalism, and ease-of-use?

**South Bend Lathe, Inc.**  
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## Updates

For your convenience, any updates to this manual will be available to download free of charge through our website at:

**[www.southbendlathe.com](http://www.southbendlathe.com)**

## Customer Service

We stand behind our machines. If you have any service questions, parts requests or general questions about your purchase, feel free to contact us.

**South Bend Lathe Co.**  
**P.O. Box 2027**  
**Bellingham, WA 98227**  
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# About This Collet Attachment

## Capabilities

If many workpieces of the same diameter are to be turned or threaded on the lathe, and productivity is dependent on the ease of loading and unloading workpieces, this collet attachment provides the capability of increased productivity. This collet attachment accepts 5-C collets and is easily installed and removed from the lathe. The Model SB1272 Collet Attachment fits the Model SB1016 and SB1036 South Bend Lathes.

## Specifications

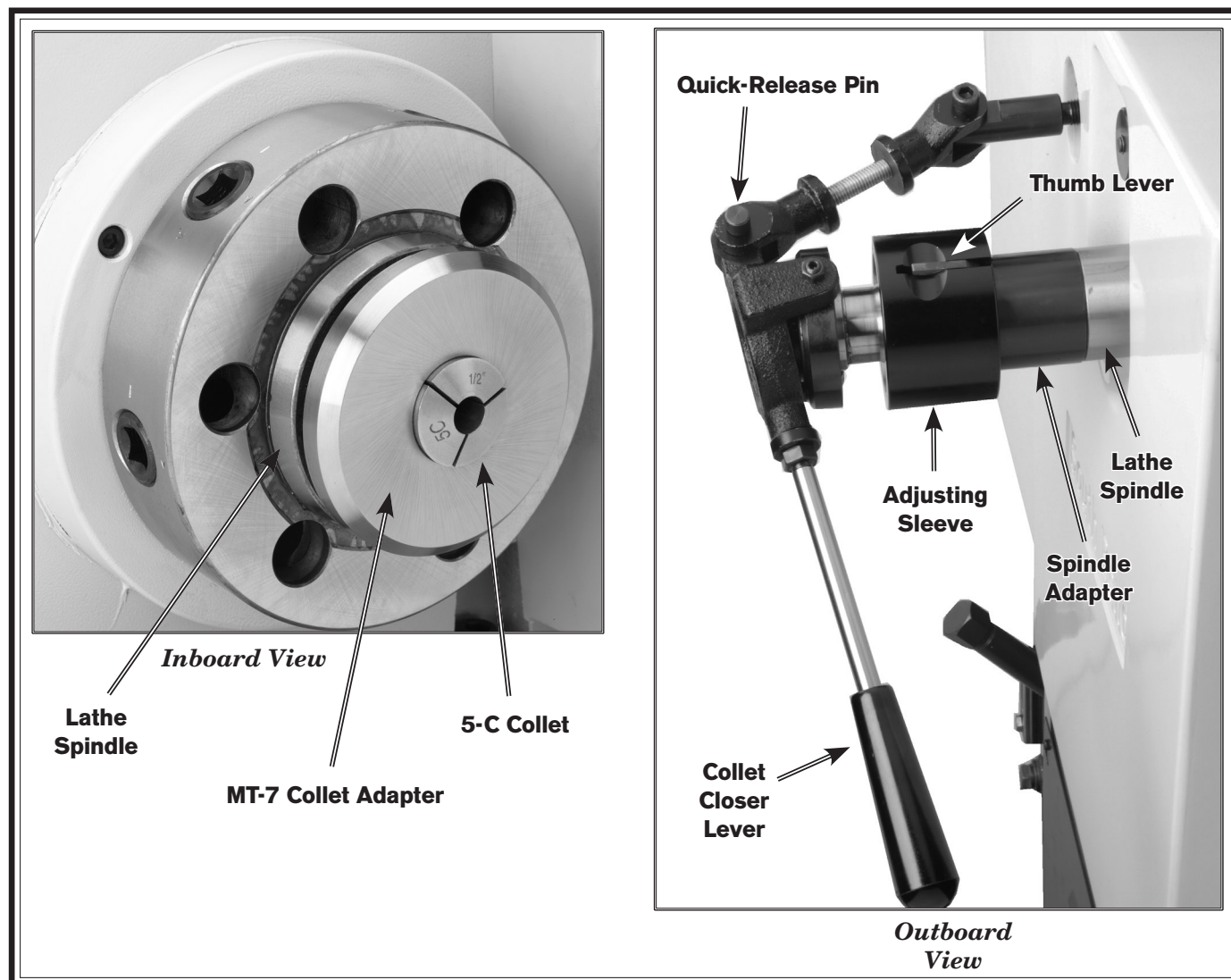
- Collet Size.....5-C Collets
- Quick Removal Design..... Yes
- All Metal Construction ..... Yes
- Collet Adapter ..... MT-7 to 5-C
- Installation Time ..... 45 Minutes
- Shipping Weight ..... 32 lbs.
- Origin..... Taiwan

## Features

This collet attachment takes advantage of the South Bend factory-made collet port in the lathe gear cover. This accessory installs easily on the listed South Bend Lathes without having to modify the gear cover. The Model SB1272 is capable of delivering years of trouble-free service. It is manufactured with the same high-quality workmanship, materials, and tolerances South Bend machinery is known for.

For ease of use, a collet attachment lever locks the 5-C collet and workpiece in place. To ensure accurate clamping pressure, a chuck sleeve with a thumb operated lock lever allows the length of the draw tube to be lengthened or shortened in fine increments. For speedy installation and removal of the entire collet attachment assembly, this unit is designed with a quick-release clevis and pin that has an overall slide-out design.

# Identification



## ⚠ WARNING

Serious personal injury could occur if you connect the lathe to power before completing the collet adapter setup process. **DO NOT** connect power until instructed to do so later in this manual.

## ⚠ WARNING

Untrained users have an increased risk of seriously injuring themselves with this tooling. Do not operate the lathe or collet adapter until you have understood this entire manual and received proper training.



# Understanding Risks of Machinery

Operating all machinery and machining equipment can be dangerous or relatively safe depending on how it is installed and maintained, and the operator's experience, common sense, risk awareness, working conditions, and use of personal protective equipment (safety glasses, respirators, etc.).

The owner of this machinery or equipment is ultimately responsible for its safe use. This responsibility includes proper installation in a safe environment, personnel training and usage authorization, regular inspection and maintenance, manual availability and comprehension, application of safety devices, integrity of cutting tools or accessories, and the usage of approved personal protective equipment by all operators and bystanders.

The manufacturer of this machinery or equipment will not be held liable for injury or property damage from negligence, improper training, machine modifications, or misuse. Failure to read, understand, and follow the manual and safety labels may result in serious personal injury, including amputation, broken bones, electrocution, or death.

The signals used in this manual to identify hazard levels are defined as follows:



*Death or catastrophic harm WILL occur.*



*Moderate injury or fire MAY occur.*



*Death or catastrophic harm COULD occur.*



*Machine or property damage may occur.*

## Basic Machine Safety

- 1. Owner's Manual:** All machinery and machining equipment presents serious injury hazards to untrained users. To reduce the risk of injury, anyone who uses THIS item MUST read and understand this entire manual before starting.
- 2. Personal Protective Equipment:** Operating or servicing this item may expose the user to flying debris, dust, smoke, dangerous chemicals, or loud noises. These hazards can result in eye injury, blindness, long-term respiratory damage, poisoning, cancer, reproductive harm or hearing loss. Reduce your risks from these hazards by wearing approved eye protection, respirator, gloves, or hearing protection.
- 3. Trained/Supervised Operators Only:** Untrained users can seriously injure themselves or bystanders. Only allow trained and properly supervised personnel to operate this item. Make sure safe operation instructions are clearly understood. If electrically powered, use padlocks and master switches, and remove start switch keys to prevent unauthorized use or accidental starting.
- 4. Guards/Covers:** Accidental contact with moving parts during operation may cause severe entanglement, impact, cutting, or crushing injuries. Reduce this risk by keeping any included guards/covers/doors installed, fully functional, and positioned for maximum protection.

- 5. Entanglement:** Loose clothing, gloves, neckties, jewelry or long hair may get caught in moving parts, causing entanglement, amputation, crushing, or strangulation. Reduce this risk by removing/securing these items so they cannot contact moving parts.
- 6. Mental Alertness:** Operating this item with reduced mental alertness increases the risk of accidental injury. Do not let a temporary influence or distraction lead to a permanent disability! Never operate when under the influence of drugs/alcohol, when tired, or otherwise distracted.
- 7. Safe Environment:** Operating electrically powered equipment in a wet environment may result in electrocution; operating near highly flammable materials may result in a fire or explosion. Only operate this item in a dry location that is free from flammable materials.
- 8. Electrical Connection:** With electrically powered equipment, improper connections to the power source may result in electrocution or fire. Always adhere to all electrical requirements and applicable codes when connecting to the power source. Have all work inspected by a qualified electrician to minimize risk.
- 9. Disconnect Power:** Adjusting or servicing electrically powered equipment while it is connected to the power source greatly increases the risk of injury from accidental startup. Always disconnect power **BEFORE** any service or adjustments, including changing blades or other tooling.
- 10. Secure Workpiece/Tooling:** Loose workpieces, cutting tools, or rotating spindles can become dangerous projectiles if not secured or if they hit another object during operation. Reduce the risk of this hazard by verifying that all fastening devices are properly secured and items attached to spindles have enough clearance to safely rotate.
- 11. Chuck Keys or Adjusting Tools:** Tools used to adjust spindles, chucks, or any moving/rotating parts will become dangerous projectiles if left in place when the machine is started. Reduce this risk by developing the habit of always removing these tools immediately after using them.
- 12. Work Area:** Clutter and dark shadows increase the risks of accidental injury. Only operate this item in a clean, non-glaring, and well-lighted work area.
- 13. Properly Functioning Equipment:** Poorly maintained, damaged, or malfunctioning equipment has higher risks of causing serious personal injury compared to those that are properly maintained. To reduce this risk, always maintain this item to the highest standards and promptly repair/service a damaged or malfunctioning component. Always follow the maintenance instructions included in this documentation.
- 14. Unattended Operation:** Electrically powered equipment that is left unattended while running cannot be controlled and is dangerous to bystanders. Always turn the power **OFF** before walking away.
- 15. Health Hazards:** Certain cutting fluids and lubricants, or dust/smoke created when cutting, may contain chemicals known to the State of California to cause cancer, respiratory problems, birth defects, or other reproductive harm. Minimize exposure to these chemicals by wearing approved personal protective equipment and operating in a well ventilated area.
- 16. Difficult Operations:** Attempting difficult operations with which you are unfamiliar increases the risk of injury. If you experience difficulties performing the intended operation, **STOP!** Seek an alternative method to accomplish the same task, ask a qualified expert how the operation should be performed, or contact our Technical Support for assistance.

## Additional Collet Attachment Safety

- 1. Tool Selection:** Cutting with an incorrect or dull tool increases the risk of accidental injury because extra force is required, which increases risk of breaking or dislodging components. Always select the right cutter for the job, and make sure it is sharp. A correct, sharp tool decreases strain and provides a better finish.
- 2. Securing the Workpiece:** Before starting the lathe, make sure the collet and workpiece are properly secured with the draw tube, and that the collet attachment lever is in the locked position. A thrown workpiece may cause severe injury or even death.
- 3. Long Stock Safety:** Long stock can whip violently if not properly supported, causing serious impact injury and damage to the lathe. Reduce this risk by supporting any stock that extends from the chuck/headstock more than three times its own diameter. Always turn long stock at slow speeds.
- 4. Speed Rates:** Operating the lathe at the wrong speed can cause nearby parts to break or the workpiece to come loose, which could result in them becoming dangerous projectiles. Large workpieces must be turned at slow speeds. Always use the appropriate feed and speed rates.
- 5. Stopping the Lathe by Hand:** Stopping the spindle by putting your hand on the workpiece creates an extreme risk of entanglement, impact, crushing, friction, or cutting hazards. Never attempt to slow or stop the lathe by using your hand. Allow the spindle to come to a stop on its own or use the brake (if equipped).
- 6. Projectile Hazard:** A camlock or chuck key left in the spindle or chuck can become a dangerous projectile if the lathe is started. And never walk away from the lathe leaving any of these tools in the spindle or chuck. Always remove all keys and tooling after use.
- 7. Crushing Hazard:** Chucks can be heavy and difficult to grasp, which can lead to crushed fingers or hands if mishandled. Get assistance when installing or removing chucks to reduce this risk. Protect your hands and the precision ground ways by using a chuck cradle or piece of plywood over the ways of the lathe when servicing chucks.
- 8. Avoiding Entanglement:** Disconnect the lathe from power before installing and removing the collet attachment, collets, and work pieces. Accidental lathe startup can cause severe injury or death.



## Things You'll Need

During the setup process, operation, and maintenance of your machine, you'll need the following items:

### For Assembly:

- Mineral Spirits
- Safety Glasses
- Shop Vacuum
- Another Person
- Oil Can with Way Oil
- Cotton Shop Rags
- Hex Wrench 5mm
- Hex Wrench 8mm
- Open-End Wrench 19mm
- Open-End Wrench 24mm
- Drill Bit 5mm or #9 (0.196")
- Drill Bit 1/8"
- Center Punch 1/4"
- Threading Tap M6-1
- Tube of Thread Sealant
- Electric Hand-Drill
- Hacksaw
- Bench-Mounted Vise

## Unpacking

This item was carefully packaged to prevent damage during transport. If you discover any damage, please immediately call Customer Service at (360) 734-1540 for advice. You may need to file a freight claim, so save the containers and all packing materials for possible inspection by the carrier or its agent.

## Inventory

If you can't find an item on this list, check the mounting location on the collet attachment or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Contents: (Figure 1)	Qty
A. Draw Tube.....	1
B. Collet Attachment Assembly .....	1
C. Spindle Adapter .....	1
D. Collet Adapter .....	1
E. Lock Lever .....	1
F. Mounting Arm Assembly.....	1
G. Cap Screws M6-1 x 20.....	3
H. Mounting Base .....	1

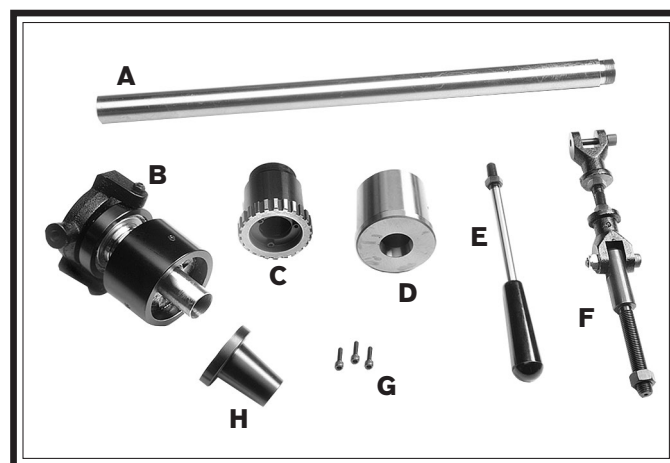


Figure 1. Inventory

## Cleaning & Protecting

The unpainted surfaces are coated at the factory with a heavy-duty rust preventative that prevents corrosion during shipment and storage. The benefit of this rust preventative is that it works very well. The downside is that it can be time-consuming to thoroughly remove.

Be patient and do a careful job when cleaning and removing the rust preventative. The time you spend doing this will reward you with smooth-sliding parts and a better appreciation for the proper care of the unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, we have cleaned thousands of machines and found the following process to be the best balance between efficiency and minimized exposure to toxic fumes or chemicals.

### Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (certain citrus-based degreasers work extremely well and they have non-toxic fumes)
- Safety glasses & disposable gloves

**Note:** Automotive degreasers, mineral spirits, or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of a painted area to make sure they will not damage it.



### ! WARNING

**Gasoline and petroleum products have low flash points and can explode or cause fire if used for cleaning. Avoid using these products to remove rust preventative.**



### ! CAUTION

**Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.**

## NOTICE

**Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.**

### Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.
2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner or degreaser and let them soak for a few minutes.
3. Wipe off the surfaces. If your cleaner or degreaser is effective, the rust preventative will wipe off easily.

**Note:** To clean off thick coats of rust preventative on flat surfaces, such as beds or tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or it may scratch the surface.)

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant or light oil to prevent rust.

# Installation

## To install the collet attachment:

1. DISCONNECT LATHE FROM POWER!
2. Remove the lathe chuck.
3. Looking through the hole in the gear cover, mark the center location of the hole on the headstock (**Figure 2**). The center location is where the center of the collet attachment base must be mounted.

**Note:** Depending on date of lathe manufacture, the mounting location shown in **Figure 3** may have been pre-drilled at the factory to mount the collet attachment base. If this is the case, remove the three fasteners that plug the holes and proceed to **Step 8**.

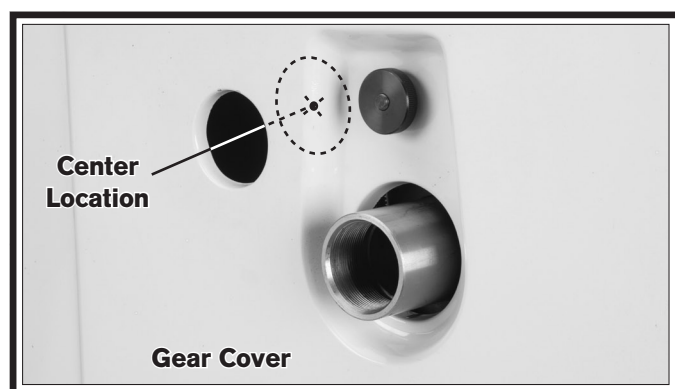


Figure 2. Base mounting location behind cover.

4. Put on your safety glasses, then using a 1/4" center punch and the base shown in **Figure 3** as a template, mark the three mounting bolt holes on the side of the headstock.

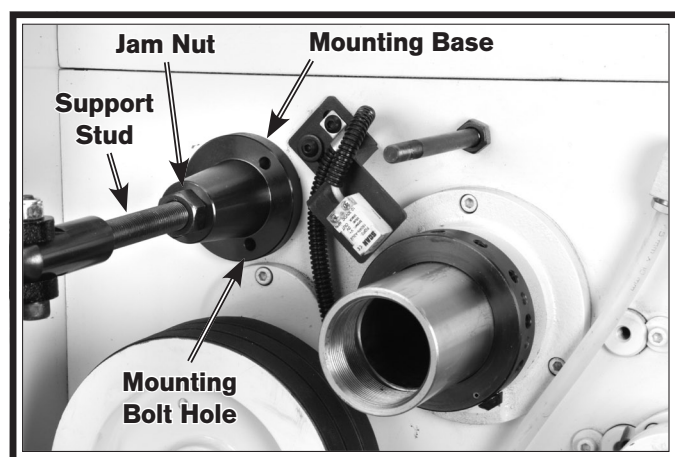


Figure 3. Base positioning on the headstock.

5. To reduce the risk of metal shavings contaminating the headstock gear case, have your assistant vacuum the filings while you drill and cut the threads into the headstock.
6. Carefully, so as not to run the drill bit too deep into the headstock gearbox, center-drill the three mounting holes with an 1/8" drill bit approximately 1/2" deep.
7. Using a 5mm or #9 drill bit and an M6-1 tap, drill and cut threads in the headstock case for the three mounting holes.
8. Apply a coat of thread sealant on the three M6-1 x 20 cap screws. Next, use a 5mm hex wrench to fasten the base to the headstock with the three cap screws.
9. Thread the support stud approximately 1" into the base. Then, using a 19mm wrench, tighten the jam nut shown in **Figure 3**.
10. Reinstall the gear cover.
11. Using a lightly oiled rag, wipe the inboard and outboard ends of the lathe spindle until they are clean.
12. Wipe the spindle adapter clean with the same rag. Next, thread the adapter onto the spindle in a counterclockwise direction until the adapter seats flush with the spindle as shown in **Figure 4**.

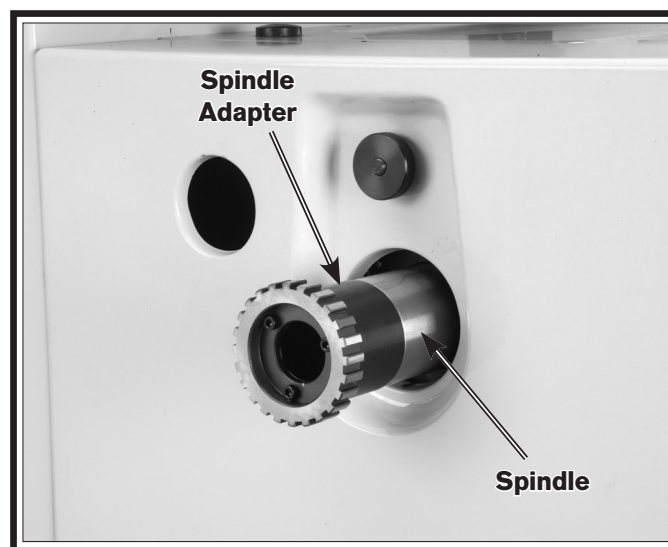
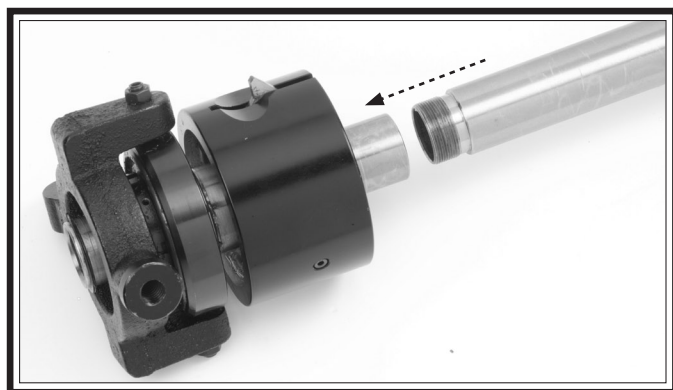


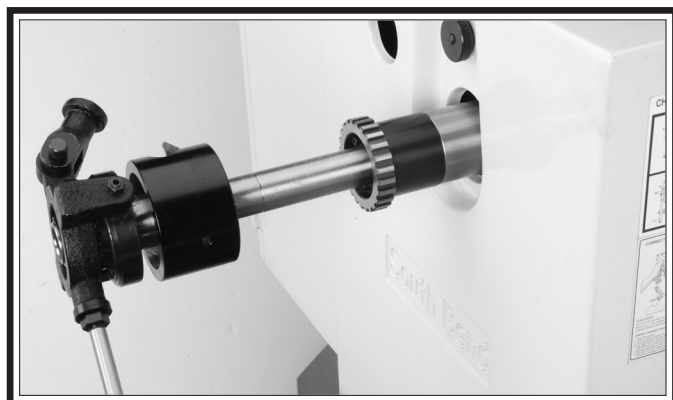
Figure 4. Spindle adapter installation.

- 13.** Thread the draw tube into the collet attachment assembly, as shown in **Figure 5**.



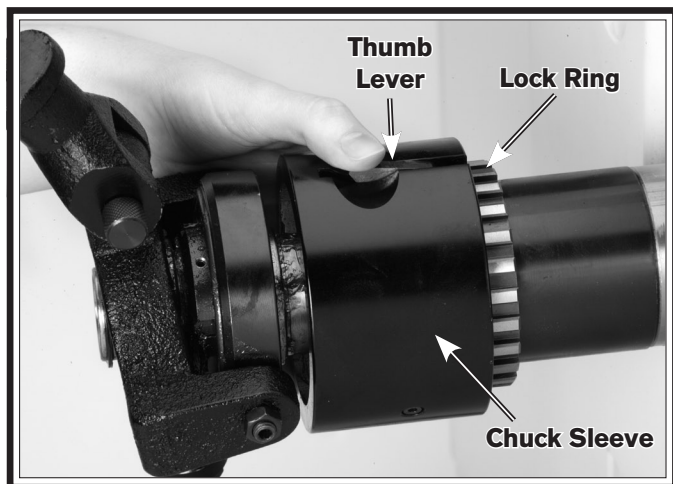
**Figure 5. Draw tube installation.**

- 14.** Carefully insert the collet attachment draw tube into the lathe spindle, as shown in **Figure 6**.



**Figure 6. Collet attachment installation.**

- 15.** When the chuck sleeve contacts the lock ring, press down on the thumb lever, as shown in **Figure 7**, and engage the lock ring with the chuck sleeve.

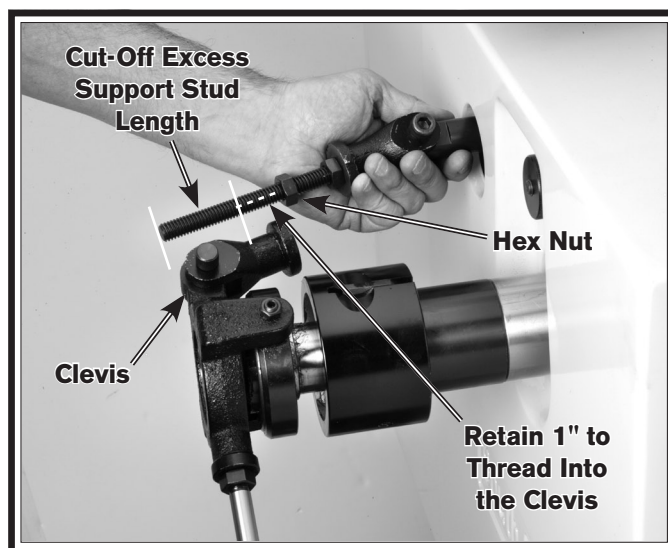


**Figure 7. Chuck sleeve installation.**

When fully installed, the lock ring will be hidden and the thumb lever will have dropped down into a lock ring slot.

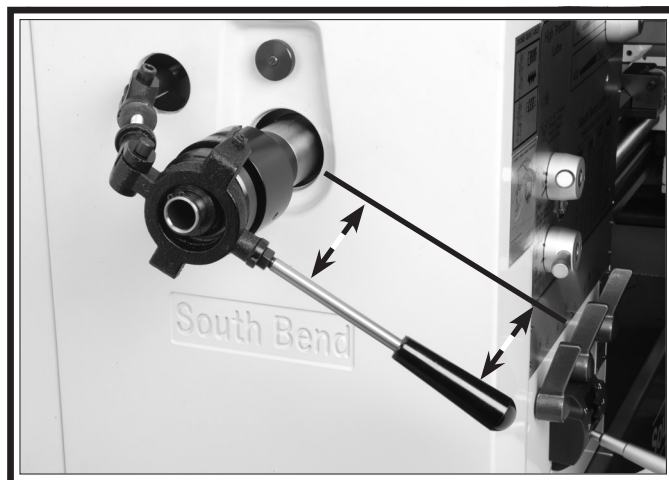
- 16.** Position the collet attachment lock lever so it is parallel with the gear cover, and mark how much of the support stud must be cut off (**Figure 8**) in order for the lever to be parallel with the cover surface. Next, cut off the excess support stud length.

**Note:** The amount to be cut-off is dependent on your desired lever position.



**Figure 8. Support stud sizing.**

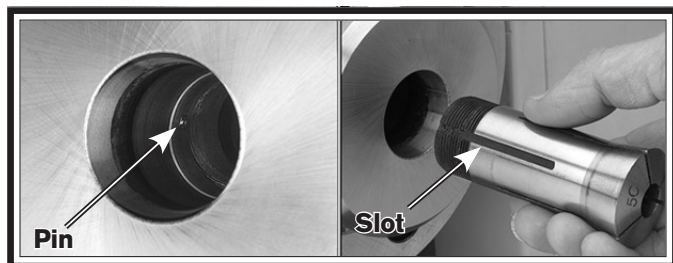
- 17.** Remove the clevis and thread it onto the support stud approximately 1". Adjust it so when the clevis is reinstalled onto the collet attachment, the lock lever is parallel with the gear cover, as shown in **Figure 9**.



**Figure 9. Clevis positioning so lock lever is parallel with gear cover.**



18. Tighten the hex nut on the support stud against the clevis (**Figure 8**).
19. Wipe the collet adapter clean and insert it into the lathe spindle.
20. Align the slot in the collet with the pin in the collet adapter, and install the collet, as shown in **Figure 10**.



**Figure 10. Collet alignment.**

21. While holding the collet against the collet adapter with your right hand, use your left hand to push down on the chuck-sleeve thumb lever (**Figure 7**) and rotate the chuck sleeve until the draw tube threads onto the collet.

**Note:** You may have to wiggle the collet attachment assembly, so the leading thread of the draw tube and collet catch one another.

The collet is seated properly when the chuck sleeve is snug, the collet is seated, and the workpiece or dowel slides into the collet with a slight drag, as shown in **Figure 11**.



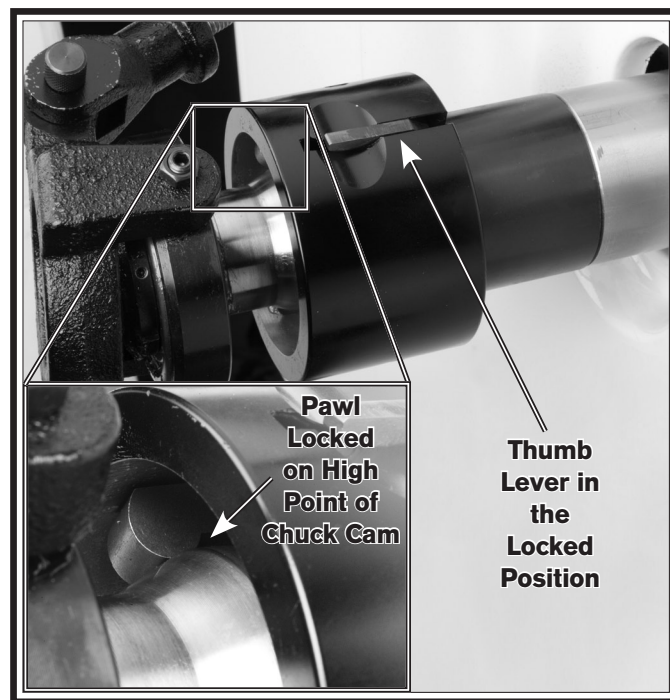
**Figure 11. Installing a workpiece.**

22. With the chuck sleeve unlocked, rotate it counterclockwise  $\frac{3}{4}$  – 1 turn. Then, pull the collet attachment lever outward.

— If the lever locks loosely or the workpiece slips in the collet, release the lever and tighten the chuck sleeve until the lever snaps to the locked position easily, and the workpiece is held tightened.

— If the lever does not move far enough to lock, loosen the chuck sleeve until the lever snaps to the locked position easily and the workpiece is held tightly. Do not force it into the locked position if over tightened.

**Note:** When the lever is locked, the pawls will be positioned on the highest point of the chuck cam, and there will be a gap of approximately 16mm exposing the pawls, as shown in **Figure 12**.



**Figure 12. Pawls in the locked position.**

23. Push the thumb lever back into its locked position (**Figures 13–14**), so it is horizontal with the chuck sleeve surface. You may have to rotate the chuck sleeve slightly to get the lever to drop back down into a lock ring slot.



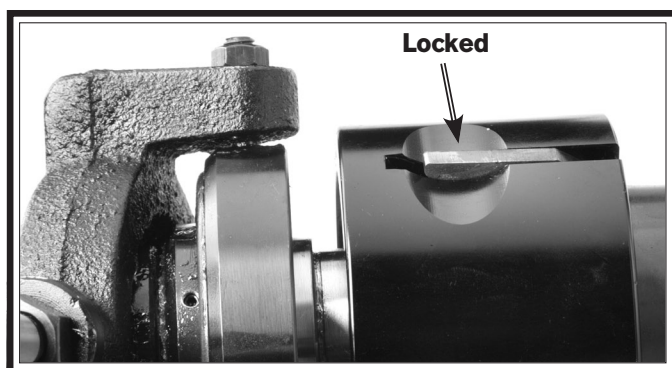


Figure 13. Chuck sleeve thumb lever locked.

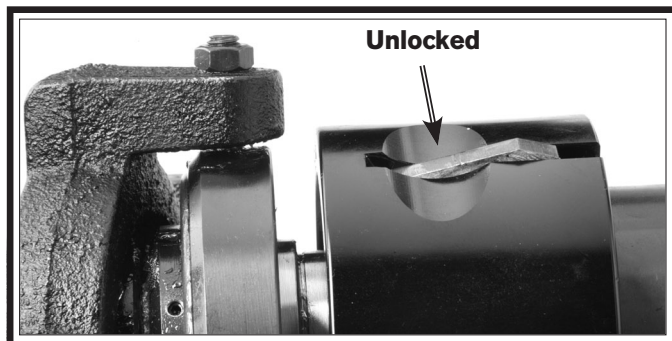


Figure 14. Chuck sleeve thumb lever unlocked.

24. At this point, the chuck sleeve and the collet attachment lever should be locked and positioned outward from the gear cover as shown in **Figure 15**. The workpiece or dowel must be held firmly without slippage when pulled by hand.

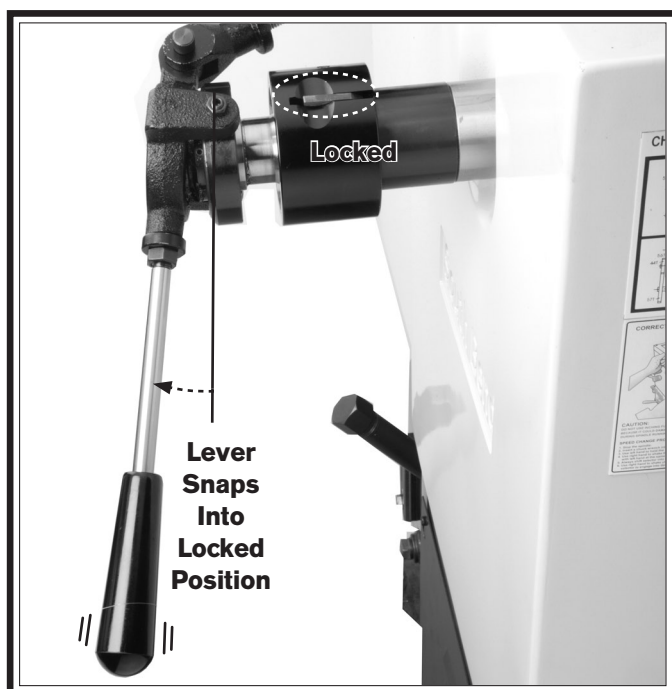


Figure 15. Collet attachment completely locked and ready for use.

## Test Run

Once the assembly is complete, test run your lathe with the collet attachment installed to make sure the unit is ready for regular operation. The test run consists of verifying the collet attachment is concentric with the lathe spindle and is free of vibration.

If, during the test run, you detect an unusual noise or vibration, stop using lathe immediately, and correct the problem.

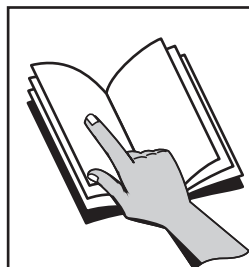
If you still cannot remedy a problem, contact our Tech Support at (360) 734-1540.

### To test run the collet attachment:

1. Make sure you have read the safety instructions at the beginning of the manual and that the collet attachment is setup properly.
2. Lock a small dowel or workpiece in the collet, and verify that the lathe spindle rotates freely by hand.
3. Make sure all tools and objects used during setup are cleared away from the collet attachment.
4. Set the lathe to a low spindle speed, and disengage any feed levers.
5. Put on safety glasses, connect the lathe to power, and turn the lathe **ON**.
6. Run the lathe through its full range of speeds.
  - When operating correctly, the collet attachment operates smoothly without vibration or rubbing noises.
  - Investigate and correct unusual noises or vibrations before operating the collet attachment further. Always disconnect the collet attachment from power when investigating or correcting potential problems.
7. Turn the lathe **OFF**.

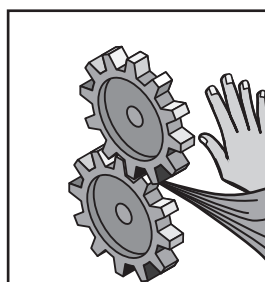
## Operation Overview

The purpose of the operation section is to familiarize you with the basic controls, terminology, capabilities, and adjustments that are necessary to use this collet attachment.



### **! WARNING**

**To reduce the risk of serious injury when using this collet attachment, read and understand this entire manual before beginning any operations.**



### **! WARNING**

**Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.**



### **! WARNING**

**During operation, small metal chips may become airborne, leading to serious eye injury. Wear safety glasses to reduce this risk.**

**To complete a typical operation, the operator does the following:**

1. Selects the correct-sized collet for the diameter of the workpiece.
2. Verifies that no burrs exist on the workpiece.
3. Aligns the slot in the collet with the pin in the collet adapter, and inserts the collet and workpiece into the adapter.
4. Threads the draw tube onto the collet by turning the chuck sleeve until the collet is seated and the clutch sleeve is snug.
5. Applies the collet attachment lever to close

the collet, and verifies the workpiece is clamped securely.

— If clamping is too loose or too tight, the operator releases the lock lever and rotates the chuck sleeve to attain lever locking and workpiece clamping.

6. Installs the required inboard and outboard workpiece support with stands, the steady rest, or the follow rest.
7. Installs the required tooling, puts on safety glasses, and begins lathe operations.

## Collet Attachment Removal

**To complete remove the collet attachment from the lathe:**

1. DISCONNECT LATHE FROM POWER!
2. Place a wooden board on the lathe ways to protect the ways.
3. Support the collet with your right hand. With your left hand, unlock the collet attachment lever and turn the chuck sleeve to un-thread the draw tube from the collet.
4. When the collet is free, remove the knurled pin, and slide the collet attachment assembly out of the spindle.
5. With your right hand, hold the spindle collet adapter to keep it from falling out of the lathe spindle, and with your left hand, insert a wooden dowel into the spindle from the outboard side and tap the spindle collet adapter free from the lathe spindle.

## Accessories

This section includes the most common accessories available for your lathe, which may be available through your local South Bend Lathe Co. dealer. If you do not have a dealer in your area, please call us at (360) 734-1540 or email us at [cs@southbendlathe.com](mailto:cs@southbendlathe.com).

### SB1271—Taper Attachment for SB1016 & SB1036 Lathes.

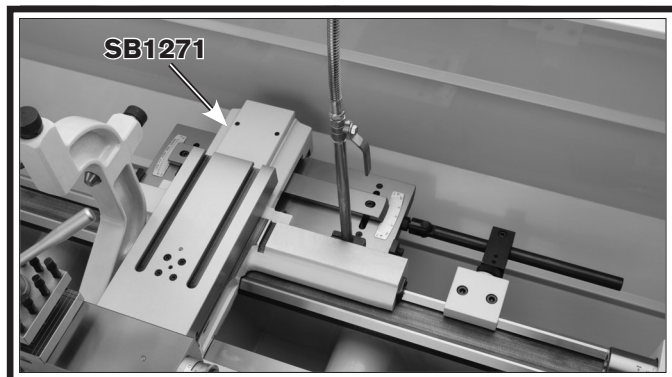


Figure 16. Taper attachment.

### SB1279—10 Pc. Precision 5-C Collet Set

Set of 10 collets sized from  $\frac{1}{8}$ " -  $\frac{3}{4}$ ". Same quality as the individual collets, only packaged in one convenient set.



Figure 17. Model SB1279 10 Pc. 5-C Collet Set.

### SB1239—MT#5 High Performance Live Center

South Bend® brand live centers are the best centers in the industry made with pride and uncompromising quality.

- Shafts are made of alloy steel and vacuum heat treated to  $HRC60 \pm 1$  for high rigidity and durability.
- Centers use a combination of roller bearings, thrust ball bearings and ball bearings.
- Applicable for CNC lathes and high speed turning.
- Waterproof design.
- 60° centers.

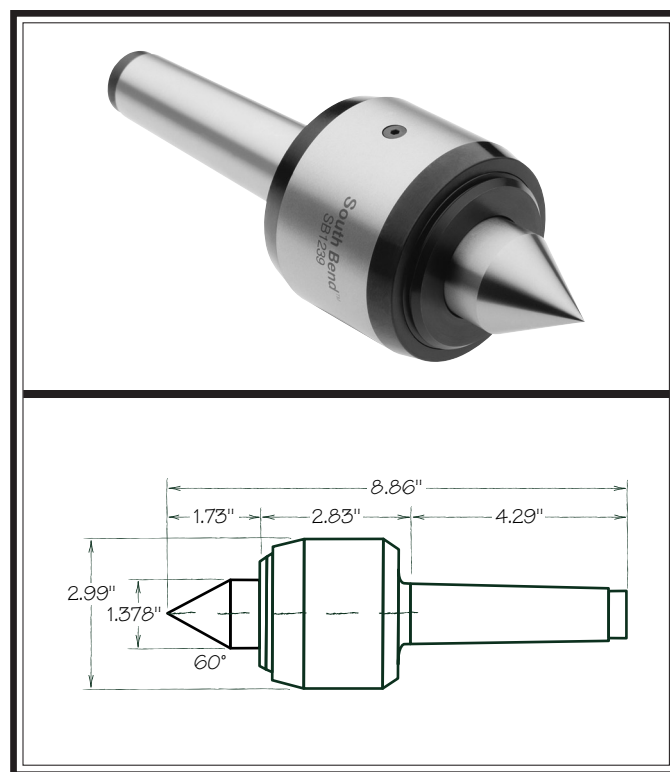
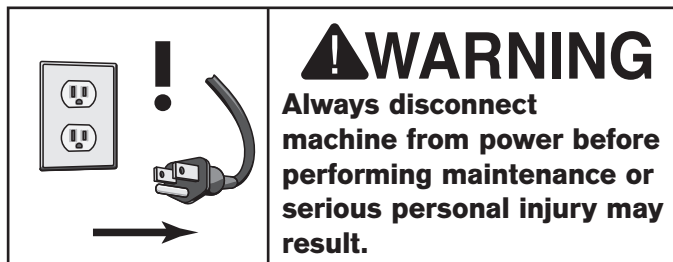


Figure 18. Model SB1239 High Performance Live Center.

# Maintenance Schedule



For optimum performance from your collet attachment, follow this maintenance schedule and refer to any specific instructions given in this section.

Cleaning your collet attachment is relatively easy. Vacuum excess metal chips away, and wipe off the remaining metal parts with a rag that is moistened with the machine oil you use to lubricate your lathe.

## Daily Check:

- Clean and inspect all tapered mating surfaces.
- Inspect for loose mounting cap screws.
- Inspect collet adapter for missing pin.
- Inspect for missing or cracked pins or loose set screws.
- Inspect for any other unsafe condition.

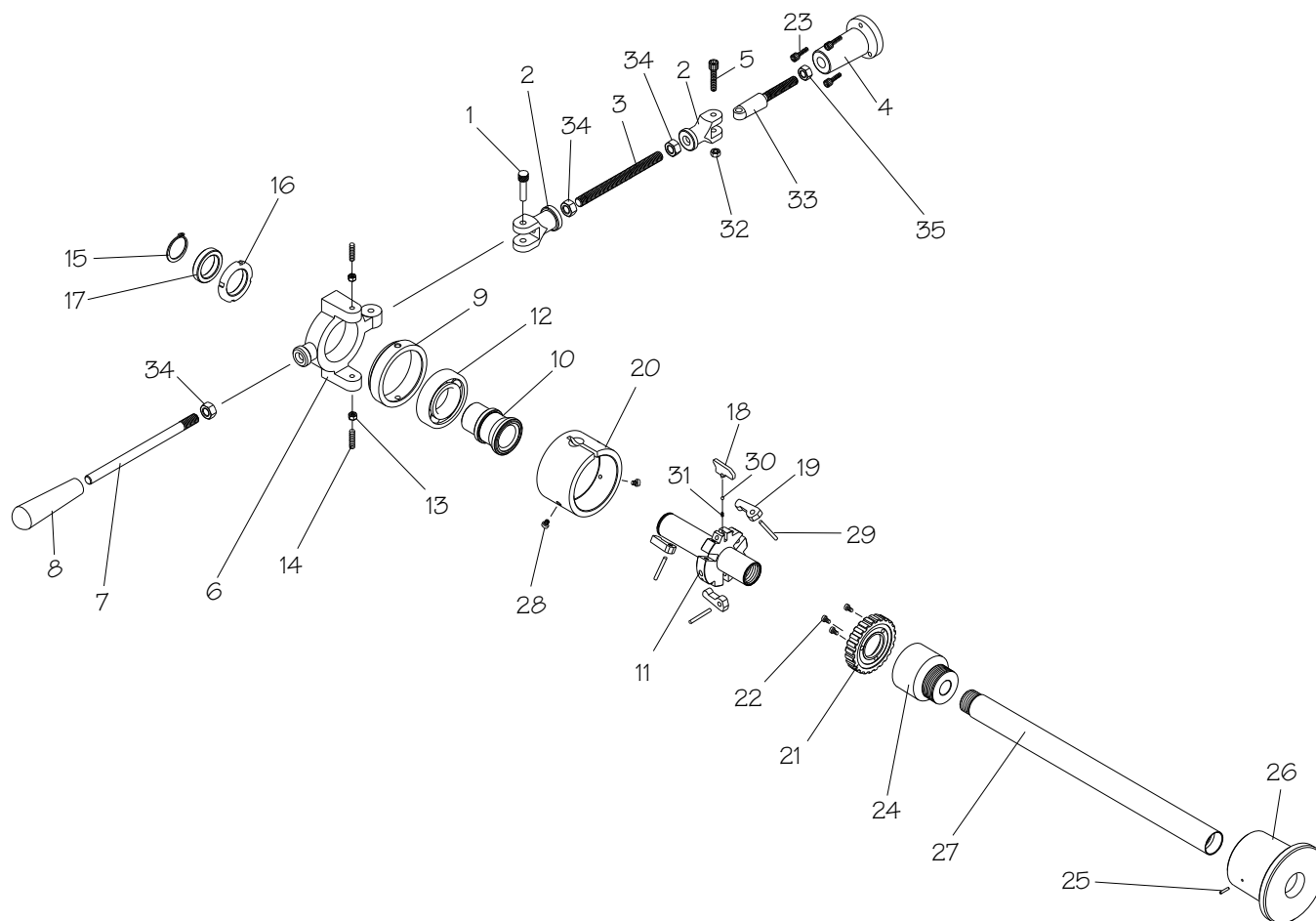
## Monthly Check:

- Clean and de-burr draw tube threads.
- Apply oil to all metal surfaces to prevent rust and maintain smooth operation.

## Storage:

- To prevent rust and corrosion, apply way oil to all metal surfaces, and store the collet attachment in a wooden box or cabinet that is dry and free of paints and chemicals.

# Parts Diagram



## Parts List

REF	PART #	DESCRIPTION
1	PSB1268001	KNURLED PIN
2	PSB1268002	CLEVIS
3	PSB1268003	THREADED STUD 1/2-20 x 6
4	PSB1268004	MOUNTING BASE
5	PCAP143M	CAP SCREW M10-1.5 X 50
6	PSB1268006	LOCK YOKE
7	PSB1268007	LEVER
8	PSB1268008	PLASTIC KNOB 1/2-20
9	PSB1268009	YOKE RING
10	PSB1268010	CHUCK RING
11	PSB1268011	CHUCK HOUSING
12	PSB1268012	BALL BEARING 6208ZZ KOYO
13	PN03M	HEX NUT M8-1.25
14	PSG74M	SET SCREW M8-1.25 X 35
15	PR37M	EXT RETAINING RING 32MM
16	PSB1268016	SPANNER NUT
17	PSB1268017	COLLAR
18	PSB1268018	THUMB LEVER

REF	PART #	DESCRIPTION
19	PSB1268019	LOCK PAWL
20	PSB1268020	ADJUSTMENT SLEEVE
21	PSB1268021	LOCK RING
22	PCAP33M	CAP SCREW M5-.8 X 12
23	PCAP02M	CAP SCREW M6-1 X 20
24	PSB1272024	SPINDLE ADAPTER 3.23"-16 UNC
25	PRP44M	ROLL PIN 3 X 10
26	PSB1272026	COLLET ADAPTER MT7/5C
27	PSB1272027	DRAW TUBE 27.2"
28	PCAP18M	CAP SCREW M4-.7 X 8
29	PSB1268029	PIVOT PIN
30	PSB1268030	LOCK BALL
31	PSB1268031	COMPRESSION SPRING
32	PLN05M	LOCK NUT M10-1.5
33	PSB1268033	CLEVIS STUD M16-2
34	PN01	HEX NUT 1/2-20
35	PN13M	HEX NUT M16-2



## Warranty

This quality product is warranted by South Bend Lathe Company to the original buyer for one year from the date of purchase. This warranty does not apply to consumable parts, or defects due to any kind of misuse, abuse, negligence, accidents, repairs, alterations or lack of maintenance. We do not reimburse for third party repairs. In no event shall we be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our products.

We do not warrant or represent that this machine complies with the provisions of any law, act, code, regulation, or standard of any domestic or foreign government, industry, or authority. In no event shall South Bend's liability under this warranty exceed the original purchase price paid for this machine. Any legal actions brought against South Bend Lathe Company shall be tried in the State of Washington, County of Whatcom.

This is the sole written warranty for this machine. Any and all warranties that may be implied by law, including any merchantability or fitness, for any purpose, are hereby limited to the duration of this warranty. To take advantage of this warranty, contact us by mail or phone to give us the details of the problem you are having.

Thank you for your business and continued support.



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