

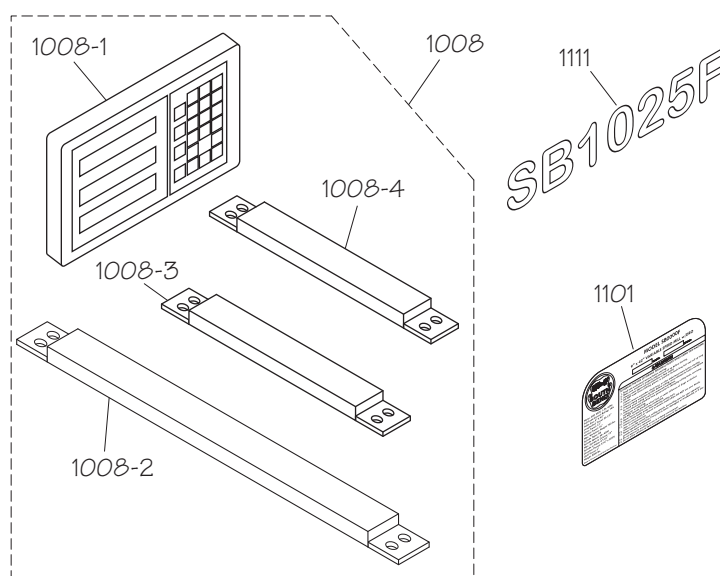
The Model SB1025F Milling Machine is the same machine as the Model SB1025 except for the following:

- Added a 3-Axis Fagor Digital Readout (DRO).
- Longitudinal table travel reduced to 23½" due to DRO installation.

Except for the differences noted in this insert, all other content in the Model SB1025 Owner's Manual applies to this machine. Before operating your new milling machine, you **MUST** read and understand this insert, the entire Model SB1025 Owner's Manual, and the Fagor DRO Owner's Manual to reduce the risk of injury when using this machine.

If you have any further questions about this manual insert or the differences between the Model SB1025F and the Model SB1025, contact our Technical Support at (360) 734-1639 or email sales@southbendlathe.com.

New & Changed Parts

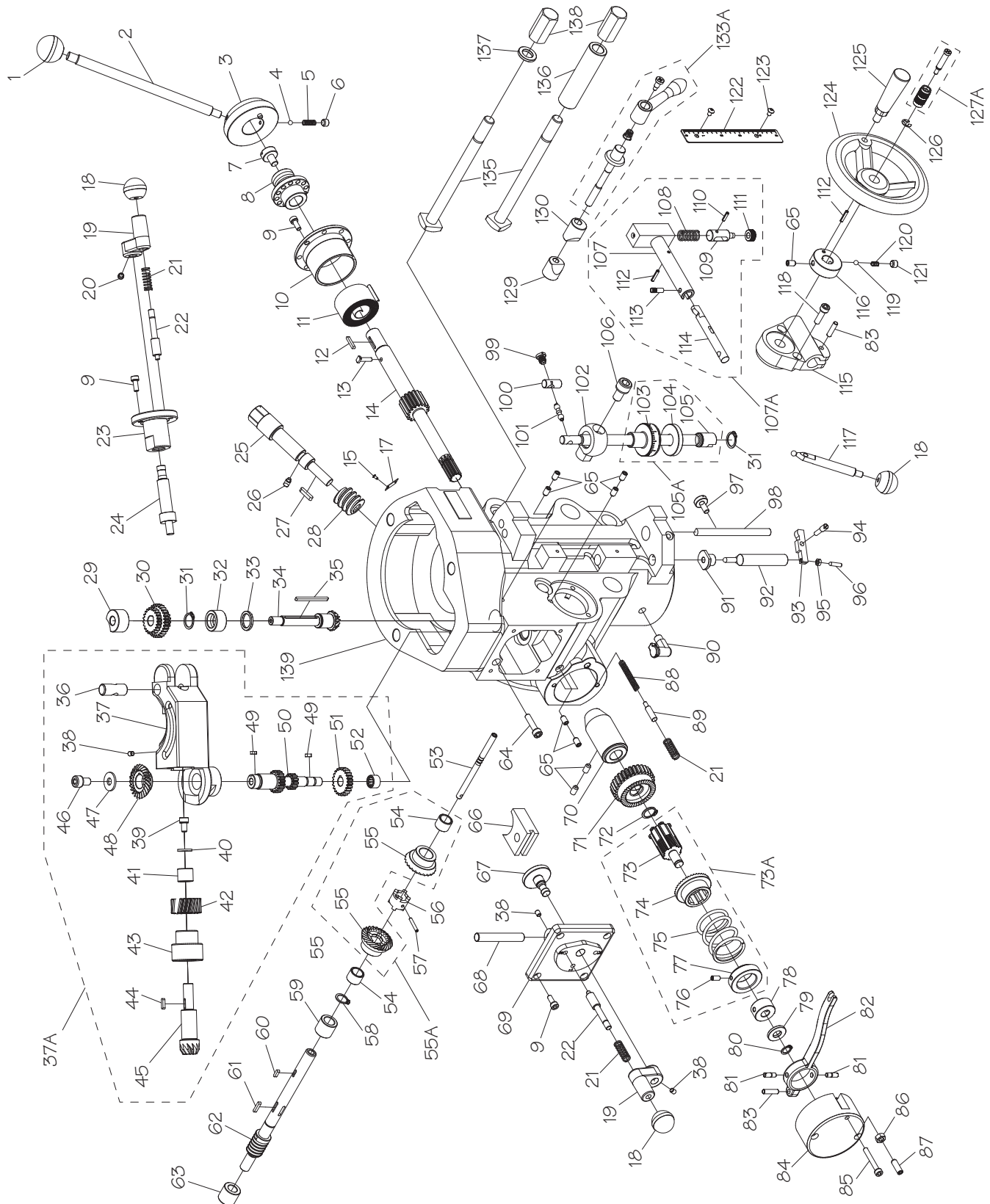


REF	PART #	DESCRIPTION
1008	PSB1026F1008	DRO ASSEMBLY FAGOR 3-AXIS
1008-1	PSB1026F1008-1	DRO DISPLAY FAGOR 30iM
1008-2	PSB1026F1008-2	DRO X-AXIS SCALE FAGOR MKT-77
1008-3	PSB1026F1008-3	DRO Y-AXIS SCALE FAGOR MKT-37

REF	PART #	DESCRIPTION
1008-4	PSB1026F1008-4	DRO Z-AXIS SCALE FAGOR MKT-47
1101	PSB1025F1101	MACHINE ID LABEL
1111	PSB1025F1111	MODEL NUMBER LABEL

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Headstock



Headstock Parts List

REF	PART #	DESCRIPTION
1	PSB10240449	ROUND KNOB 3/8-16
2	PSB10240002	PINION SHAFT LEVER
3	PSB10240003	PINION SHAFT HUB
4	PSTB004	STEEL BALL 3/16
5	PSB10240005	COMPRESSION SPRING
6	PSS05	SET SCREW 5/16-18 X 1/4
7	PSB10240007	HUB RETAINER
8	PSB10240008	PINION SHAFT HUB SLEEVE
9	PCAP33M	CAP SCREW M5-.8 X 12
10	PSB10240010	RETURN SPRING COVER
11	PSB10240011	FLAT COIL SPRING
12	PK155M	KEY 3 X 3 X 18
13	PSB10240013	RETURN SPRING STUD
14	PSB10240014	QUILL PINION SHAFT 10T/16T
15	PRIV001M	FLUTED RIVET 2 X 5MM STEEL
17	PSB10240017	ZERO SCALE
18	PSB10240018	ROUND KNOB 1/4-20
19	PSB10240019	SHIFT CRANK
20	PSS11	SET SCREW 1/4-20 X 1/4
21	PSB10240021	COMPRESSION SPRING 9 X 1 X 24MM
22	PSB10240022	GEAR SHIFT PLUNGER
23	PSB10240023	SHIFT SLEEVE
24	PSB10240024	WORM GEAR CRADLE THROW-OUT
25	PSB10240025	WORM SHAFT
26	PSS01M	SET SCREW M6-1 X 10
27	PK102M	KEY 4 X 4 X 18
28	PSB10240028	WORM GEAR
29	PSB10240029	CLUSTER GEAR RETAINER
30	PSB10240030	FEED CLUSTER GEAR 17T/28T/22T
31	PRO6M	EXT RETAINING RING 16MM
32	PSB10240032	BEVEL GEAR BUSHING
33	PSB10240033	BEVEL GEAR THRUST SPACER
34	PSB10240034	FEED REVERSE BEVEL PINION
35	PK53M	KEY 3 X 3 X 45
36	PSB10240037A	FEED ENGAGE PIN
37A	PSB10240037A	WORM GEAR CRADLE ASSEMBLY
37	PSB10240037A	WORM GEAR CRADLE
38	PSS26M	SET SCREW M5-.8 X 6
39	PCAP04M	CAP SCREW M6-1 X 10
40	PW03M	FLAT WASHER 6MM
41	PSB10240037A	WORM GEAR SPACER
42	PSB10240037A	FEED DRIVE WORM GEAR 20T
43	PSB10240037A	WORM CRADLE BUSHING
44	PK103M	KEY 3 X 3 X 12
45	PSB10240037A	FEED REVERSE BEVEL PINION
46	PCAP30	CAP SCREW 5/16-18 X 1/2
47	PSB10240037A	BEVEL GEAR FLAT WASHER 8MM
48	PSB10240037A	FEED BEVEL GEAR 24T
49	PK03M	KEY 3 X 3 X 8

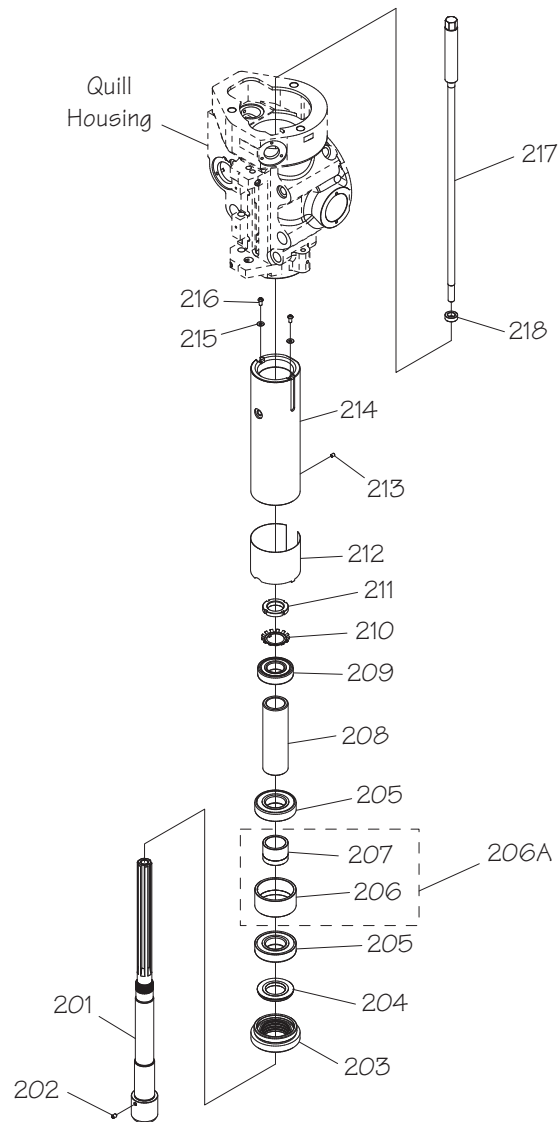
REF	PART #	DESCRIPTION
50	PSB10240037A	CLUSTER GEAR SHAFT 18T/12T
51	PSB10240037A	FEED DRIVE CLUSTER GEAR 23T
52	PSB10240037A	NEEDLE BEARING BZ66Z TIMKEN
53	PSB10240053	REVERSE CLUTCH ROD
54	PSB10240055A	FEED REVERSE BUSHING
55A	PSB10240055A	FEED REVERSE BEVEL GEAR ASSY
55	PSB10240055A	FEED REVERSE BEVEL GEAR
56	PSB10240056	FEED REVERSE CLUTCH
57	PRP42M	ROLL PIN 3 X 20
58	PRO3M	EXT RETAINING RING 12MM
59	PSB10240059	FEED WORM SHAFT BUSHING
60	PK39M	KEY 3 X 3 X 10
61	PK52M	KEY 3 X 3 X 15
62	PSB10240062	WORM
63	PSB10240063	BUSHING
64	PCAP06M	CAP SCREW M6-1 X 25
65	PSS01M	SET SCREW M6-1 X 10
66	PSB10240066	FEED GEAR SHIFTER FORK
67	PSB10240067	CLUSTER GEAR SHIFT CRANK
68	PSB10240068	FEED SHIFT ROD
69	PSB10240069	CLUSTER GEAR COVER
70	PSB10240070	QUILL PINION SHAFT BUSHING
71	PSB10240071	OVERLOAD CLUTCH WORM GEAR 30T
72	PRO5M	EXT RETAINING RING 15MM
73	PSB10240073A	PINION OVERLOAD CLUTCH SHAFT
73A	PSB10240073A	PINION OVERLOAD CLUTCH ASSY
74	PSB10240073A	OVERLOAD CLUTCH
75	PSB10240073A	COMPRESSION SPRING 40 X 46 X 3.5MM
76	PSS05M	SET SCREW M5-.8 X 10
77	PSB10240073A	PINION OVERLOAD CLUTCH COLLAR
78	PSB10240078	CLUTCH RING
79	PSB10240079	FLAT WASHER 10 X 22 X 3MM
80	PRO1M	EXT RETAINING RING 10MM
81	PSB10240081	CLUTCH RING SCREW M5-.8 X 16
82	PSB10240082	OVERLOAD CLUTCH TRIP LEVER
83	PRP03M	ROLL PIN 5 X 20
84	PSB10240084	CLUTCH ARM COVER
85	PCAP79M	CAP SCREW M5-.8 X 35
86	PN05	HEX NUT 1/4-20
87	PSS06	SET SCREW 1/4-20 X 3/4
88	PSB10240088	COMPRESSION SPRING 1.2 X 6.6 X 42MM
89	PSB10240089	OVERLOAD CLUTCH PLUNGER
90	PSB10240090	OIL CUP 1/8"
91	PSB10240091	TRIP PLUNGER BUSHING
92	PSB10240092	FEED TRIP PLUNGER
93	PSB10240093	FEED TRIP LEVER
94	PSB10240094	TRIP LEVER SCREW M6-1 X 22.5
95	PN04M	HEX NUT M4-.7
96	PSS49M	SET SCREW M4-.7 X 16

Headstock Parts List

REF	PART #	DESCRIPTION
97	PSB10240097	KNURLED KNOB SCREW M6-1 X 15
98	PSB10240098	SCRIBING LEVER
99	PSB10240099	REVERSE TRIP BALL LEVER SCREW
100	PSB10240100	FEED REVERSE TRIP PLUNGER
101	PSB10240101	REVERSE TRIP BALL LEVER
102	PSB10240102	QUILL STOP KNOB
103	PSB10240105A	UPPER QUILL MICRO STOP
104	PSB10240105A	LOWER QUILL MICRO STOP
105A	PSB10240105A	QUILL MICRO STOP ASSEMBLY
105	PSB10240105A	QUILL MICRO STOP SHAFT
106	PCAP105	CAP SCREW 3/8-16 X 5/8
107A	PSB10240107A	STOP TRIP BAR ASSEMBLY
107	PSB10240107A	STOP SHAFT TRIP BAR
108	PSB10240107A	COMPRESSION SPRING
109	PSB10240107A	STOP SHAFT TRIP SHAFT
110	PRP61M	ROLL PIN 3 X 12
111	PSB10240107A	STOP SHAFT END CAP
112	PRP02M	ROLL PIN 3 X 16
113	PSB10240107A	TRIP BAR SET SCREW
114	PSB10240107A	STOP SHAFT PLUNGER
115	PSB10240115	FEED TRIP BRACKET

REF	PART #	DESCRIPTION
116	PCAP02M	CAP SCREW M6-1 X 20
117	PSB10240117	STOP SHAFT TRIP LEVER
118	PSB10240118	HANDWHEEL CLUTCH
119	PSTB004M	STEEL BALL 5MM
120	PSB10240120	COMPRESSION SPRING
121	PS617M	SET SCREW M8-1.25 X 6
122	PSB10240122	QUILL DEPTH SCALE
123	PS17M	PHLP HD SCR M4-.7 X 6
124	PSB10240124	FINE DOWNFEED HANDWHEEL
125	PSB10240125	HANDWHEEL HANDLE
126	PEC13M	E-CLIP 5MM
127A	PSB10240127A	KNURLED SLEEVE ASSEMBLY
129	PSB10240129	QUILL LOCK NUT M18-2.5
130	PSB10240130	QUILL LOCK SLEEVE
133A	PSB10240133A	LOCK HANDLE ASSEMBLY
135	PSB10240135	HEAD ROTATION LOCK BOLT 1/2-13 X 6-1/4
136	PSB10240136	LOWER CLAMPING BOLT SPACER
137	PSB10240137	LOCK BOLT FLAT WASHER
138	PSB10240138	LOCK BOLT HEX NUT 1/2-13
139	PSB10240139	QUILL HOUSING

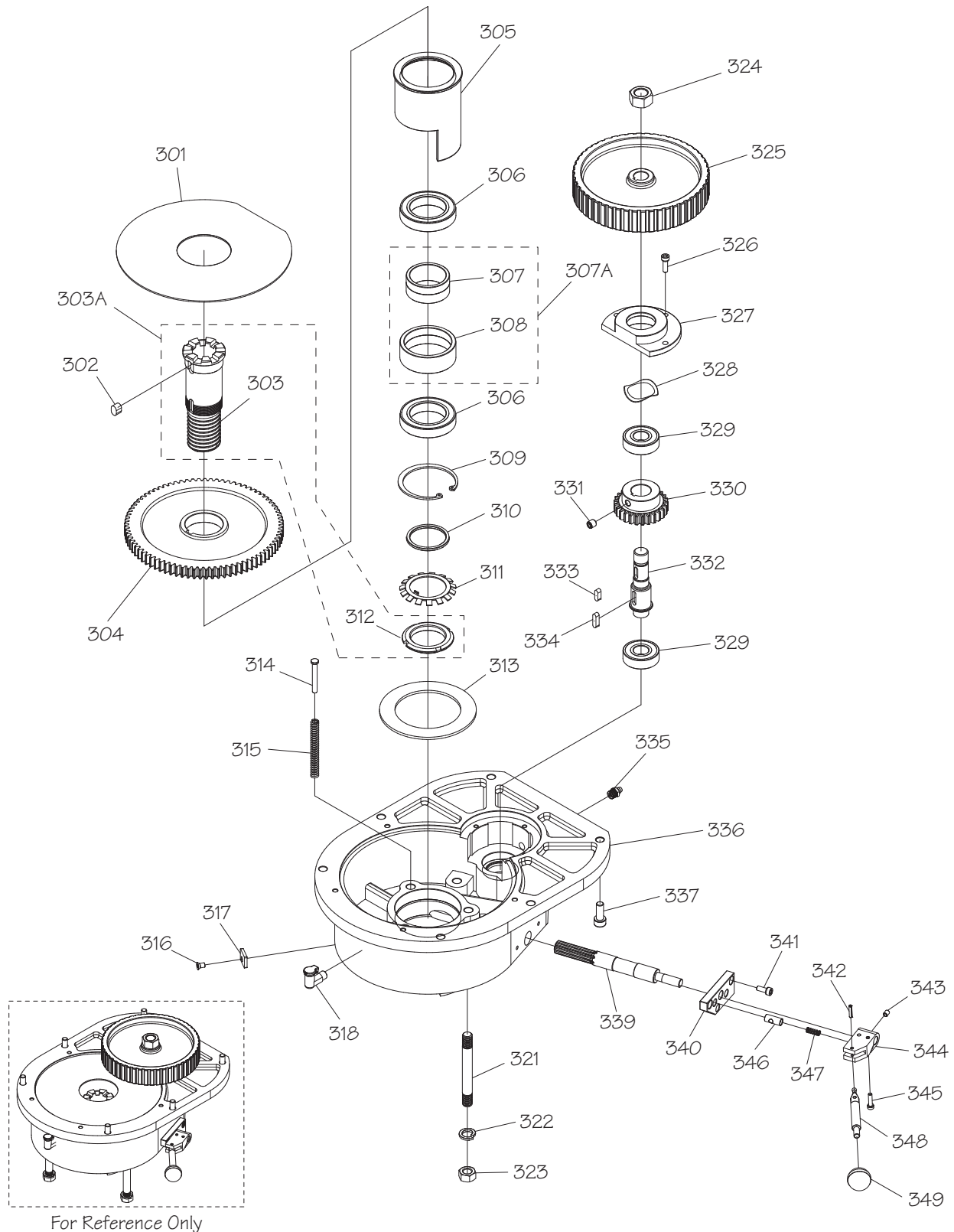
Quill



REF	PART #	DESCRIPTION
201	PSB10240201	SPINDLE R8
202	PS503M	SET SCREW M6-1 X 8
203	PSB10240203	QUILL END CAP
204	PSB10240204	QUILL SEAL
205	PSB10240205	ANGULAR CONTACT BEARING 7207 P4
206A	PSB10240206A	BEARING SPACER ASSEMBLY
206	PSB10240206A	BEARING SPACER
207	PSB10240206A	BEARING SPACER
208	PSB10240208	SLEEVE
209	P6206ZZ	BALL BEARING 6206ZZ

REF	PART #	DESCRIPTION
210	PSB10240210	SPANNER LOCK WASHER
211	PSB10240211	SPANNER NUT
212	PSB10240212	QUILL SKIRT
213	PS526M	SET SCREW M5-.8 X 6
214	PSB10240214	QUILL
215	PW02M	FLAT WASHER 5MM
216	PS09M	PHLP HD SCR M5-.8 X 10
217	PSB10240217	DRAWBAR 7/16-20 X 18-1/2
218	PSB10240218	DRAWBAR WASHER

SB1024 Gearbox

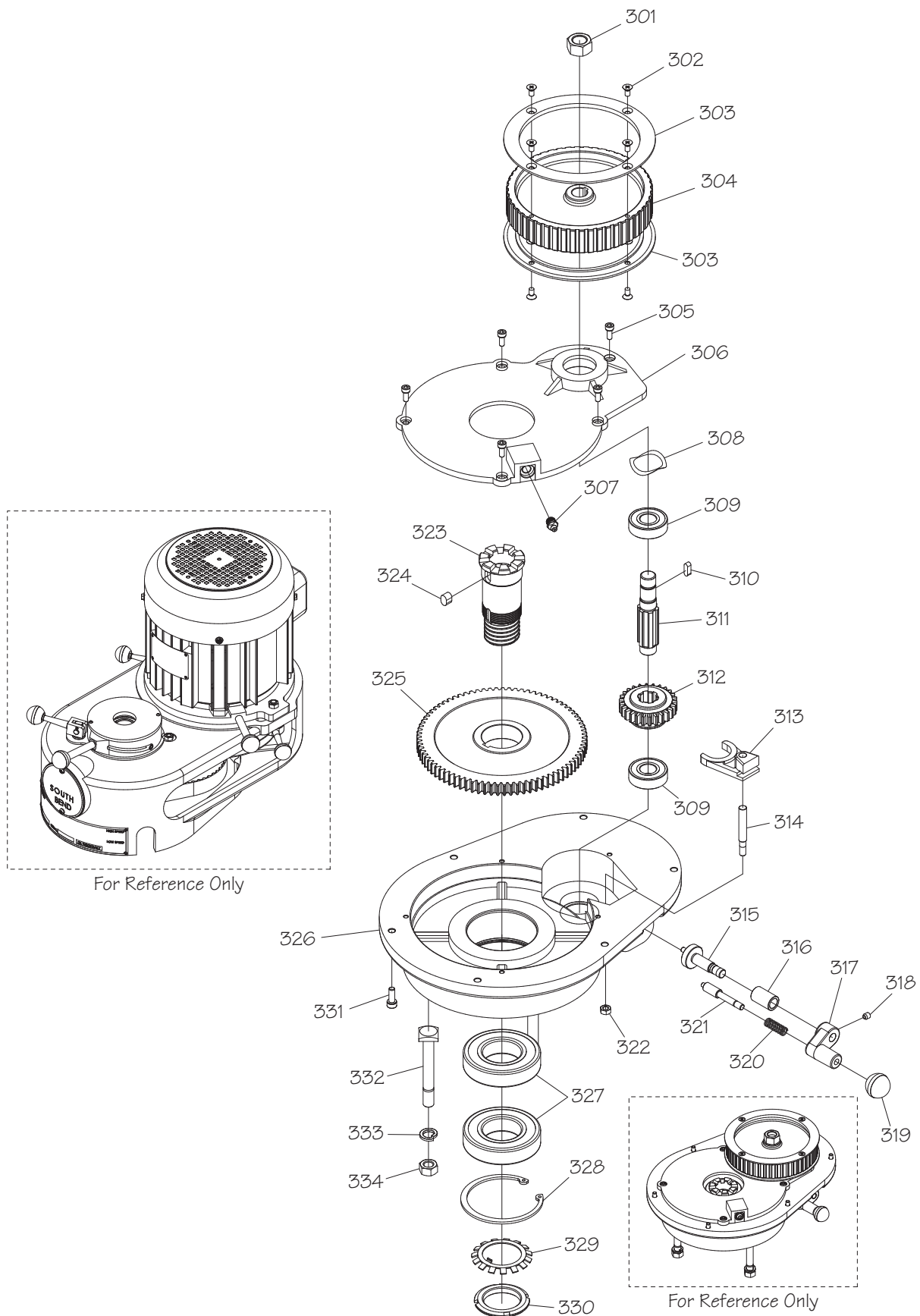


SB1024 Gearbox Parts List

REF	PART #	DESCRIPTION
301	PSB10240301	GEARBOX PLATE
302	PK70M	KEY 8 X 8 X 12
303A	PSB10240303A	SPINDLE GEAR HUB ASSEMBLY
303	PSB10240303A	SPINDLE GEAR HUB
304	PSB10240304	SPINDLE BULL GEAR
305	PSB10240305	BEARING SLEAVE
306	P6908VV-N	DEEP GROOVE BALL BEARING 6908VV NSK
307A	PSB10240307A	BEARING SPACER ASSEMBLY
307	PSB10240307A	BULL GEAR BEARING SPACER
308	PSB10240307A	BULL GEAR BEARING SPACER
309	PR38M	INT RETAINING RING 62MM
310	PSB10240310	WAVY SPRING WASHER
311	PSB10240311	SPANNER LOCK WASHER
312	PSB10240303A	SPANNER NUT
313	PSB10240313	BEARING SLEAVE WASHER
314	PSB10240314	STEP PIN
315	PSB10240315	COMPRESSION SPRING
316	PFH71M	FLAT HD CAP SCR M5-.8 X 8
317	PSB10240317	INSERT
318	PSB10240090	OIL CUP 1/8"
321	PSB10240321	DOUBLE END HOUSING STUD
322	PLW05	LOCK WASHER 7/16
323	PN19	HEX NUT 7/16-14
324	PNO9	HEX NUT 5/8-18

REF	PART #	DESCRIPTION
325	PSB10240325	BELT PULLEY GEAR
326	PCAP24M	CAP SCREW M5-.8 X 16
327	PSB10240327	BULL GEAR PINION BEARING CAP
328	PSB10240328	WAVY SPRING WASHER
329	P6203VV-N	DEEP GROOVE BALL BEARING 6203VV NSK
330	PSB10240330	PINION GEAR 30T
331	PS620M	SET SCREW M8-1.25 X 8
332	PSB10240332	PINION GEAR SHAFT
333	PK19M	KEY 5 X 5 X 14
334	PK14M	KEY 5 X 5 X 18
335	PSB10240335	STRAIGHT GREASE FITTING 1/8 PT
336	PSB10240336	GEARBOX HOUSING
337	PCAP14M	CAP SCREW M8-1.25 X 20
339	PSB10240339	BULL GEAR SHIFT PINION
340	PSB10240340	HI-LOW DETENT PLATE
341	PCAP33M	CAP SCREW M5-.8 X 12
342	PRP02M	ROLL PIN 3 X 16
343	PS626M	SET SCREW M5-.8 X 6
344	PSB10240344	HI-LOW PINION BLOCK
345	PCAP16M	CAP SCREW M4-.7 X 16
346	PSB10240346	HI-LOW DETENT PLUNGER
347	PSB10240347	COMPRESSION SPRING
348	PSB10240348	HI-LOW LEVER
349	PSB10240349	ROUND KNOB 1/4-20

SB1025/SB1026 Gearbox

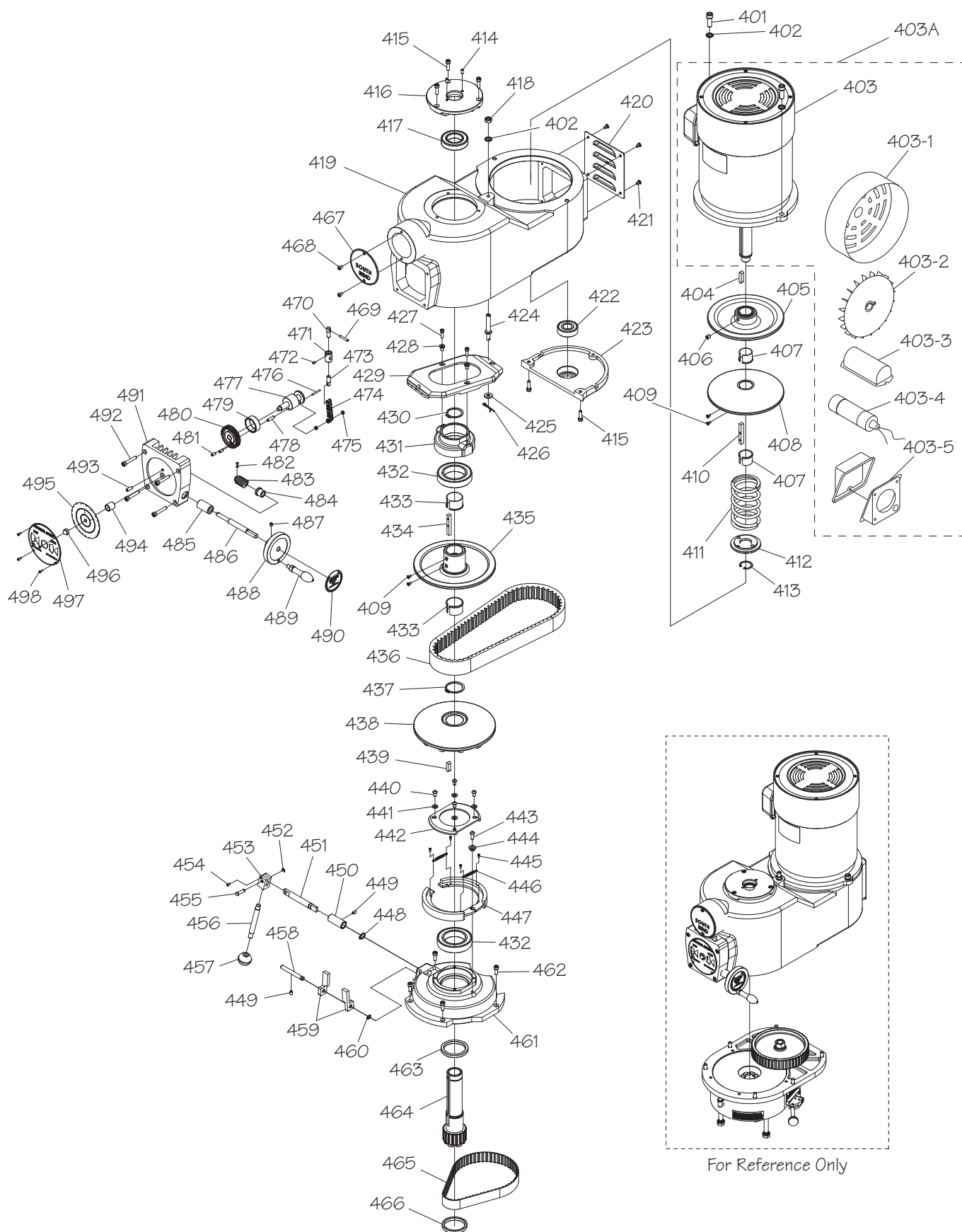


SB1025/SB1026 Gearbox Parts List

REF	PART #	DESCRIPTION
301	PNO4	HEX NUT 5/8-11
302	PFH07M	FLAT HD SCR M5-.8 X 10
303	PSB10250303	PULLEY FLANGE
304	PSB10250304	TIMING BELT PULLEY
305	PCAP33M	CAP SCREW M5-.8 X 12
306	PSB10250306	GEARBOX COVER
307A	PSB10240307A	BEARING SPACER ASSEMBLY
307	PSB10240307A	GREASE FITTING 1/8
308	PSB10240307A	WAVE SPRING WASHER
309	P6203VV-N	DEEP GROOVE BALL BEARING 6203VV NSK
310	PK20M	KEY 5 X 5 X 15
311	PSB10250311	PINION GEAR SHAFT
312	PSB10250312	PINION GEAR 26T
313	PSB10250313	BACK GEAR SHIFTER FORK
314	PSB10250314	STEPPED PIN
315	PSB10250315	BACK GEAR SHIFT CRANK
316	PSB10250316	BACK GEAR SHIFT BUSHING
317	PSB10250317	SHIFT CRANK

REF	PART #	DESCRIPTION
318	PSS02M	SET SCREW M6-1 X 6
319	PSB10240018	ROUND KNOB 1/4-20
320	PSB10250320	COMPRESSION SPRING
321	PSB10250321	GEAR SHIFT PLUNGER
322	PSB10250322	SPECIAL HARDENED HEX NUT 1/4-20
323	PSB10250323	SPLINE GEAR HUB
324	PK70M	KEY 8 X 8 X 12
325	PSB10250325	SPINDLE BULL GEAR
326	PSB10250326	GEARBOX HOUSING
327	P6908VV-N	DEEP GROOVE BALL BEARING 6908VV NSK
328	PSB10250328	INT RETAINING RING
329	PSB10250329	SPANNER LOCK WASHER
330	PSB10250330	SPANNER NUT
331	PCAP01M	CAP SCREW M6-1 X 16
332	PSB10250332	T-BOLT
333	PLW05	LOCK WASHER 7/16
334	PN19	HEX NUT 7/16-14

SB1024 Belt Housing

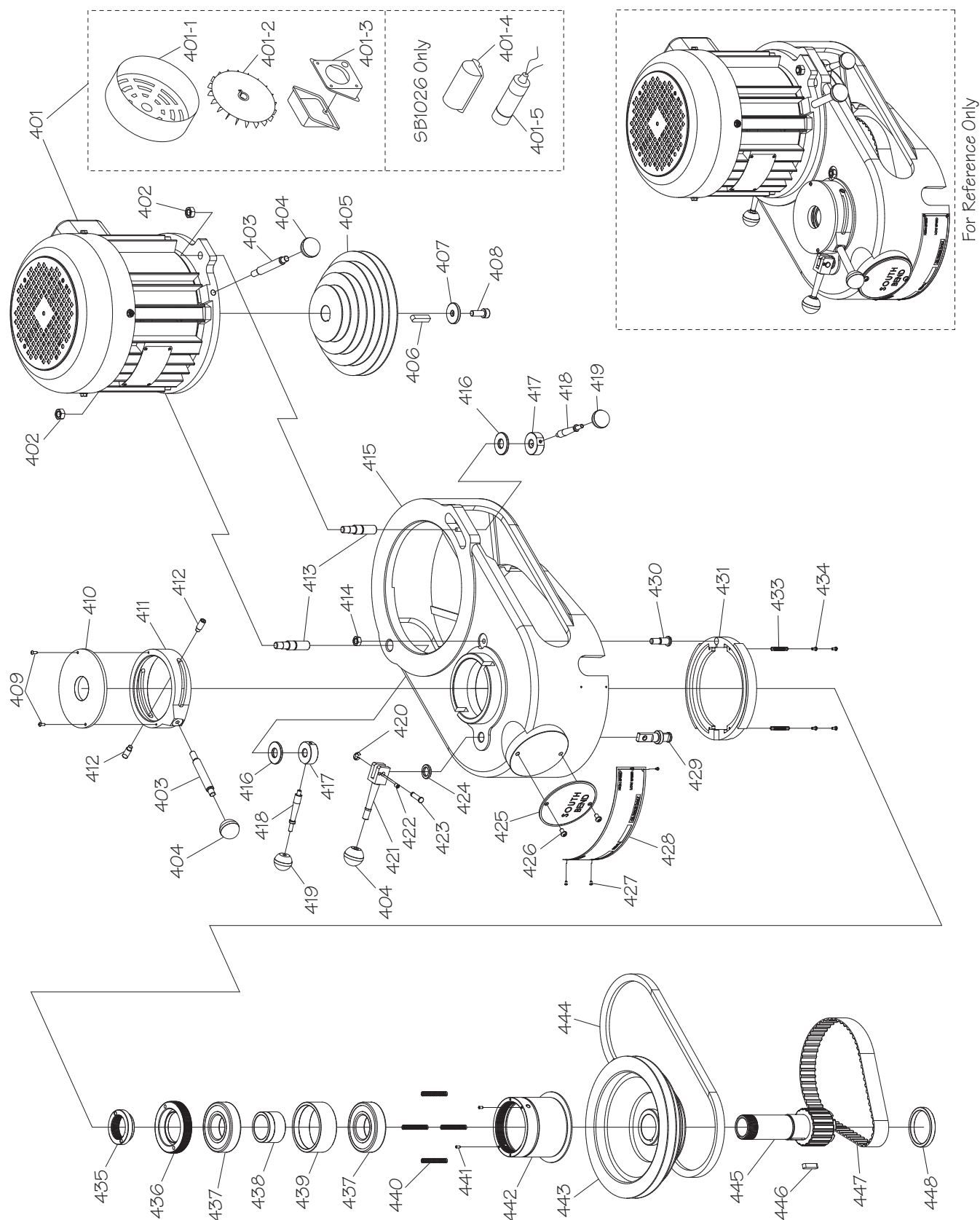


SB1024 Belt Housing Parts List

REF	PART #	DESCRIPTION
401	PCAP14	CAP SCREW 3/8-16 X 1
402	PLW06M	LOCK WASHER 10MM
403A	PSB10240403A	MOTOR ASSEMBLY
403	PSB10240403A	MOTOR 2HP 220V 1PH
403-1	PSB10240403A	MOTOR FAN COVER
403-2	PSB10240403A	MOTOR FAN
403-3	PSB10240403A	CAPACITOR COVER
403-4	PSB10240403A	5 CAPACITOR 600M 125V 2 X 3-1/2
403-5	PSB10240403A	MOTOR JUNCTION BOX
404	PK28M	KEY 7 X 7 X 30
405	PSB10240405	UPPER MOTOR PULLEY PLATE
406	PSS20M	SET SCREW M8-1.25 X 8
407	PSB10240407	MOTOR PULLEY PLASTIC RING
408	PSB10240408	LOWER MOTOR PULLEY PLATE
409	PFH31M	FLAT HD SCR M4-.7 X 8
410	PSB10240410	MOTOR PULLEY ALIGNMENT KEY
411	PSB10240411	MOTOR SHAFT COMPRESSION SPRING
412	PSB10240412	SPRING SEAT
413	PR20M	INT RETAINING RING 28MM
414	PSS05M	SET SCREW M5-.8 X 10
415	PCAP02M	CAP SCREW M6-1 X 20
416	PSB10240416	TOP BEARING COVER
417	P6007V-N	DEEP GROOVE BALL BEARING 6007V NSK
418	PNO8	HEX NUT 3/8-16
419	PSB10240419	BELT HOUSING
420	PSB10240420	REAR VENT COVER
421	PS05M	PHLP HD SCR M5-.8 X 8
422	P6204V-N	DEEP GROOVE BALL BEARING 6204V NSK
423	PSB10240423	MOTOR PULLEY COVER
424	PSB10240424	SPEED CHANGE PLATE PIVOT STUD
425	PWO1M	FLAT WASHER 8MM
426	PSB10240426	COTTER PIN 1/8
427	PCAP24M	CAP SCREW M5-.8 X 16
428	PSB10240428	PIVOT SLEET
429	PSB10240429	SPEED CHANGE PLATE
430	PR12M	EXT RETAINING RING 35MM
431	PSB10240431	SLIDE HOUSING
432	P6010V-N	DEEP GROOVE BALL BEARING 6010V NSK
433	PSB10240433	SPINDLE PULLEY PLASTIC RING
434	PSB10240434	SPINDLE PULLEY ALIGNMENT KEY
435	PSB10240435	UPPER SPINDLE PULLEY PLATE
436	PSB10240436	RIBBED DRIVE BELT 38-12-890
437	PR68M	EXT RETAINING RING 40MM
438	PSB10240438	LOWER SPINDLE PULLEY PLATE
439	PK27M	KEY 7 X 7 X 25
440	PS68M	PHLP HD SCR M6-1 X 10
441	PWO3M	FLAT WASHER 6MM
442	PSB10240442	BRAKE BEARING CAP
443	PS11M	PHLP HD SCR M6-1 X 16
444	PSB10240444	BRAKE SHOE PIVOT SLEEVE
445	PS12M	PHLP HD SCR M3-.5 X 6
446	PSB10240446	BRAKE SHOE SPRING

REF	PART #	DESCRIPTION
447	PSB10240447	BRAKE SHOE SET
448	PR47M	EXT RETAINING RING 13MM
449	PSS03M	SET SCREW M6-1 X 8
450	PSB10240450	BRAKE SHAFT SLEEVE
451	PSB10240451	BRAKE SHAFT
452	PECO2M	E-CLIP 4MM
453	PSB10240453	BRAKE LEVER BRACKET
454	PSS26M	SET SCREW M5-.8 X 6
455	PSB10240455	GROOVED PIN
456	PSB10240456	BRAKE LEVER
457	PSB10240449	ROUND KNOB 3/8-16
458	PSB10240458	BRAKE OPERATING FINGER
459	PSB10240459	BRAKE FINGER PIVOT STUD
460	PR36M	EXT RETAINING RING 7MM
461	PSB10240461	BRAKE SEAT
462	PCAP01M	CAP SCREW M6-1 X 16
463	PSB10240463	SPINDLE PULLEY SPACER
464	PSB10240464	SPINDLE PULLEY HUB
465	PSB10240465	TIMING BELT 225L-100
466	PSB10240466	TIMING PULLEY CLUTCH SLEEVE
467	SB1319	SOUTH BEND NAMEPLATE 90MM
468	PS05M	PHLP HD SCR M5-.8 X 8
469	PRP56M	ROLL PIN 4 X 25
470	PSB10240470	UPPER SPEED CHANGE STUD
471	PSB10240471	SPEED CHANGE STUD SLEEVE
472	PSS45M	SET SCREW M3-.5 X 6
473	PSB10240473	LOWER SPEED CHANGE STUD
474	PSB10240474	SPEED CHANGE CHAIN
475	PNO4M	HEX NUT M4-.7
476	PRP16M	ROLL PIN 3 X 25
477	PSB10240477	SPEED CHANGE CHAIN DRUM
478	PRP03M	ROLL PIN 5 X 20
479	PSB10240479	BUSHING
480	PSB10240480	SPEED CHANGE WORM GEAR
481	PRP35M	ROLL PIN 5 X 10
482	PRP61M	ROLL PIN 3 X 12
483	PSB10240483	WORM
484	PSB10240484	BRONZE SLEEVE BEARING
485	PSB10240485	BUSHING
486	PSB10240486	SPEED CONTROL SHAFT
487	PSS02M	SET SCREW M6-1 X 6
488	PSB10240488	SPEED CHANGE HANDWHEEL
489	PSB10240489	HANDWHEEL HANDLE
490	PSB10240490	SPEED CHANGE WARNING PLATE
491	PSB10240491	SPEED CHANGE HOUSING
492	PCAP48M	CAP SCREW M6-1 X 35
493	PSS11M	SET SCREW M6-1 X 16
494	PSB10240494	BRONZE SLEEVE BEARING
495	PSB10240495	VARIABLE SPEED DIAL
496	PNO2	HEX NUT 5/16-18
497	PSB10240497	VARIABLE SPEED DIAL PLATE
498	PS79M	PHLP HD SCR M3-.5 X 8

SB1025/SB1026 Belt Housing

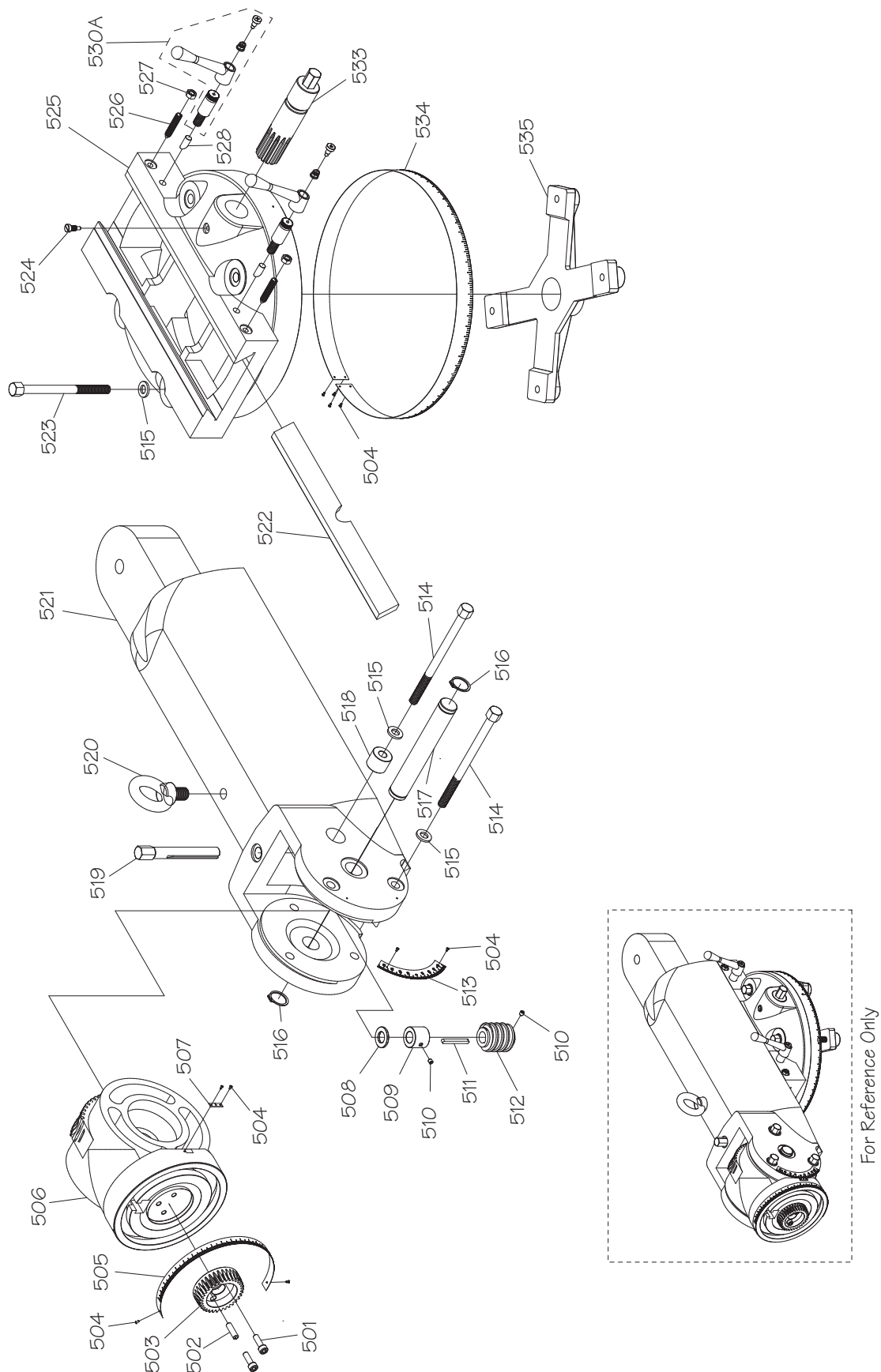


SB1025/SB1026 Belt Housing Parts List

REF	PART #	DESCRIPTION
401	PSB10250401	MOTOR 2HP 220V 3PH (SB1025)
401	PSB10260401	MOTOR 2HP 220V 1PH (SB1026)
401-1	PSB10250401-1	MOTOR FAN COVER (SB1025)
401-1	PSB10260401-1	MOTOR FAN COVER (SB1026)
401-2	PSB10250401-2	MOTOR FAN (SB1025)
401-2	PSB10260401-2	MOTOR FAN (SB1026)
401-3	PSB10250401-3	MOTOR JUNCTION BOX (SB1025)
401-3	PSB10260401-3	MOTOR JUNCTION BOX (SB1026)
401-4	PSB10260401-4	CONTACTOR COVER (SB1026)
401-5	PSB10260401-5	5 CAPACITOR 600M 125V (SB1026)
402	PN11	HEX NUT 3/8-24
403	PSB10250403	BELT TENSION ADJUSTMENT LEVER
404	PSB10250407	KNOB 5/16-18
405	PSB10250405	MOTOR PULLEY
406	PK28M	KEY 7 X 7 X 30
407	PW01M	FLAT WASHER 8MM
408	PCAP14M	CAP SCREW M8-1.25 X 20
409	PS79M	PHLP HD SCR M3-.5 X 8
410	PSB10250410	CAM RING COVER
411	PSB10250411	CAM RING
412	PSB10250412	CAM RING SCREW M6-1 X 8
413	PSB10250413	MOTOR MOUNTING STUD 1/2-13 X 2-3/16
414	PN02	HEX NUT 5/16-18
415	PSB10250415	BELT HOUSING
416	PSB10250416	MOTOR MOUNTING WASHER 21 X 13 X 3MM
417	PSB10250417	MOTOR LOCK NUT
418	PSB10250418	MOTOR LOCK LEVER
419	PSB10250419	KNOB 1/4-20

REF	PART #	DESCRIPTION
420	PEC13M	E-CLIP 5MM
421	PSB10250421	BRAKE HANDLE
422	PS526M	SET SCREW M5-.8 X 6
423	PSB10250423	GROOVED PIN
424	PSB10250424	BRAKE HANDLE PIVOT RING
425	SB1319	SOUTH BEND NAMEPLATE 90MM
426	PS05M	PHLP HD SCR M5-.8 X 8
427	PRIV001M	FLUTED RIVET 2 X 5MM STEEL
428	PSB10250428	SPINDLE SPEED PLATE
429	PSB10250429	BRAKE STUD
430	PSB10250430	BRAKE RING SCREW
431	PSB10250431	BRAKE SHOE SET
433	PSB10250433	COMPRESSION SPRING
434	PS12M	PHLP HD SCR M3-.5 X 6
435	PSB10250435	INNER BEARING RETAINING RING
436	PSB10250436	OUTER BEARING RETAINING RING
437	P6207VV-N	DEEP GROOVE BALL BEARING 6207VV NSK
438	PSB10250438	BEARING SPACER
439	PSB10250439	BEARING SPACER
440	PSB10250440	COMPRESSION SPRING
441	PS545M	SET SCREW M3-.5 X 6
442	PSB10250442	BEARING SEAT
443	PSB10250443	SPINDLE PULLEY
444	PVA33	V-BELT A33
445	PSB10250445	SPINDLE PULLEY SPLINE
446	PK143M	KEY 6 X 6 X 25
447	PSB10250447	TIMING BELT 225L-100
448	PSB10250448	TIMING PULLEY CLUTCH SLEEVE

Ram

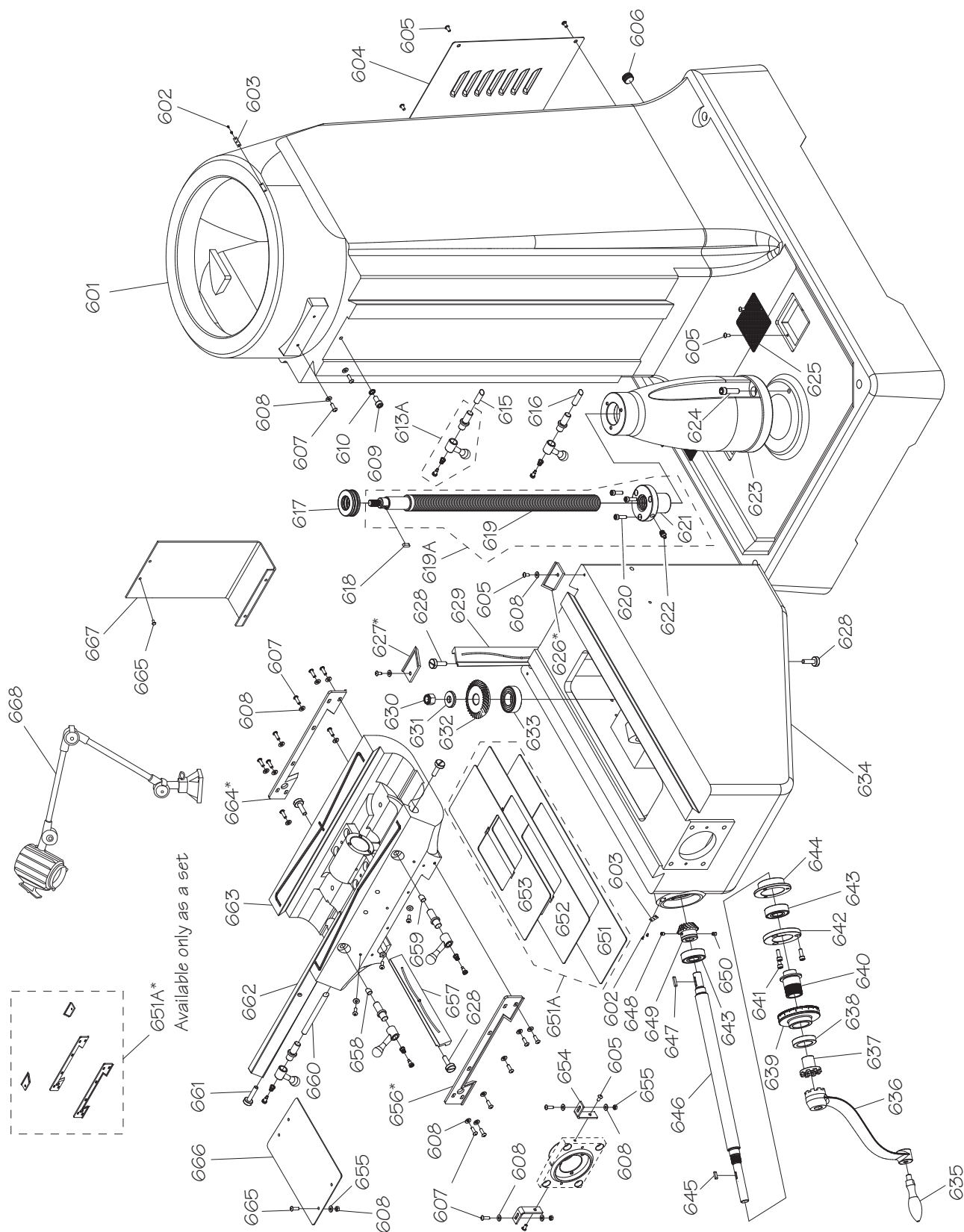


Ram Parts List

REF	PART #	DESCRIPTION
501	PCAP31M	CAP SCREW M8-1.25 X 25
502	PRP90M	ROLL PIN 8 X 30
503	PSB10240503	GEAR 33T
504	PRIV001M	FLUTED RIVET 2 X 5MM STEEL
505	PSB10240505	HEAD ROTATION SCALE
506	PSB10240506	RAM ADAPTER
507	PSB10240507	INDICATOR PLATE
508	PSB10240508	WORM THRUST WASHER
509	PSB10240509	LOCK COLLAR
510	PS502M	SET SCREW M6-1 X 6
511	PK36M	KEY 5 X 5 X 50
512	PSB10240512	HEAD TILT WORM
513	PSB10240513	HEAD TILT SCALE
514	PSB10240514	TILT LOCK BOLT
515	PW10M	FLAT WASHER 14MM
516	PR19M	EXT RETAINING RING 28MM

REF	PART #	DESCRIPTION
517	PSB10240517	TILT PIVOT STUD
518	PSB10240518	TILT LOCK BOLT BUSHING
519	PSB10240519	HEAD TILT WORM SHAFT
520	PSB10240520	LIFTING EYE BOLT 3/4-10
521	PSB10240521	RAM
522	PSB10240522	RAM GIB
523	PSB10240523	TURRET CLAMP BOLT
524	PSB10240524	RAM PINION SCREW
525	PSB10240525	TURRET
526	PSB10240526	RAM GIB ADJUSTMENT SCREW
527	PNO8	HEX NUT 3/8-16
528	PSB10240528	RAM LOCK PLUNGER
530A	PSB10240530A	LOCK LEVER ASSEMBLY
533	PSB10240533	RAM PINION
534	PSB10240534	RAM ROTATION SCALE
535	PSB10240535	TURRET BRACKET

Column, Knee, & Saddle



Column, Knee, & Saddle Parts List

REF	PART #	DESCRIPTION
601	PSB10240601	COLUMN
602	PRIV001M	FLUTED RIVET 2 X 5MM STEEL
603	PSB10240603	INDICATOR PLATE
604	PSB10240604	REAR COLUMN COVER
605	PS09M	PHLP HD SCR M5-.8 X 10
606	PSB10240606	PIPE PLUG 1/2 PT
607	PS40M	PHLP HD SCR M5-.8 X 16
608	PW02M	FLAT WASHER 5MM
609	PCAP11M	CAP SCREW M8-1.25 X 16
610	PLW04M	LOCK WASHER 8MM
613A	PSB10240613A	KNEE LOCK LEVER ASSEMBLY
615	PSB10240615	UPPER KNEE LOCK PLUNGER
616	PSB10240616	LOWER KNEE LOCK PLUNGER
617	P51305	THRUST BEARING 51305
618	PK20M	KEY 5 X 5 X 15
619A	PSB10240619A	VERTCAL LEADSCREW W/NUT ASSY
619	PSB10240619A	VERTICAL LEADSCREW INCH
620	PCAP02M	CAP SCREW M6-1 X 20
621	PSB10240619A	VERTICAL LEADSCREW BEVEL NUT INCH
622	PZERK005	GREASE FITTING ST 1/8 PT
623	PSB10240623	VERTICAL LEADSCREW HOUSING
624	PCAP19	CAP SCREW 3/8-16 X 1-1/4
625	PSB10240625	COOLANT SCREEN
626A	PSB10240626A	KNEE/SADDLE WIPER ASSEMBLY
626	PSB10240626A	RIGHT KNEE WIPER
627	PSB10240626A	LEFT KNEE WIPER
628	PSB10240628	GIB SCREW
629	PSB10240629	KNEE GIB
630	PNO1	HEX NUT 1/2-20
631	PSB10240631	BEVEL GEAR FLAT WASHER 1/2
632	PSB10240632	BEVEL GEAR
633	P6205ZZ	BALL BEARING 6205ZZ
634	PSB10240634	KNEE
635	PSB10240635	CRANK HANDLE

REF	PART #	DESCRIPTION
636	PSB10240636	VERTICAL CRANK
637	PSB10240637	CRANK CLUTCH
638	PSB10240638	FRONT DIAL RETAINER
639	PSB10240639	VERTICAL DIAL INCH
640	PSB10240640	REAR DIAL RETAINER
641	PCAP01M	CAP SCREW M6-1 X 16
642	PSB10240642	BEARING RETAINER
643	P6204ZZ	BALL BEARING 6204ZZ
644	PSB10240644	BEARING SEAT
645	PK47M	KEY 4 X 4 X 15
646	PSB10240646	VERTICAL CRANK SHAFT
647	PK48M	KEY 4 X 4 X 20
648	PS502M	SET SCREW M6-1 X 6
649	PSB10240649	BEVEL PINION
650	PS503M	SET SCREW M6-1 X 8
651A	PSB10240651A	CHIP GUARD SET
651	PSB10240651A	OUTER CHIP GUARD
652	PSB10240651A	MIDDLE CHIP GUARD
653	PSB10240651A	INNER CHIP GUARD
654	PSB10240654	WAY COVER SUPPORT
655	PNO6M	HEX NUT M5-.8
656	PSB10240626A	FRONT SADDLE WIPER
657	PSB10240657	SADDLE GIB
658	PSB10240658	LEFT TABLE LOCK PLUNGER
659	PSB10240659	RIGHT TABLE LOCK PLUNGER
660	PSB10240660	SADDLE LOCK PLUNGER
661	PSB10240661	TABLE GIB SCREW
662	PSB10240662	TABLE GIB
663	PSB10240663	SADDLE
664	PSB10240626A	REAR SADDLE WIPER
665	PBHS13M	BUTTON HD CAP SCR M5-.8 X 18
666	PSB10240666	FRONT WAY COVER
667	PSB10240667	REAR WAY COVER
668	PSB10240668	HALOGEN WORK LAMP ASSY 24V

Table

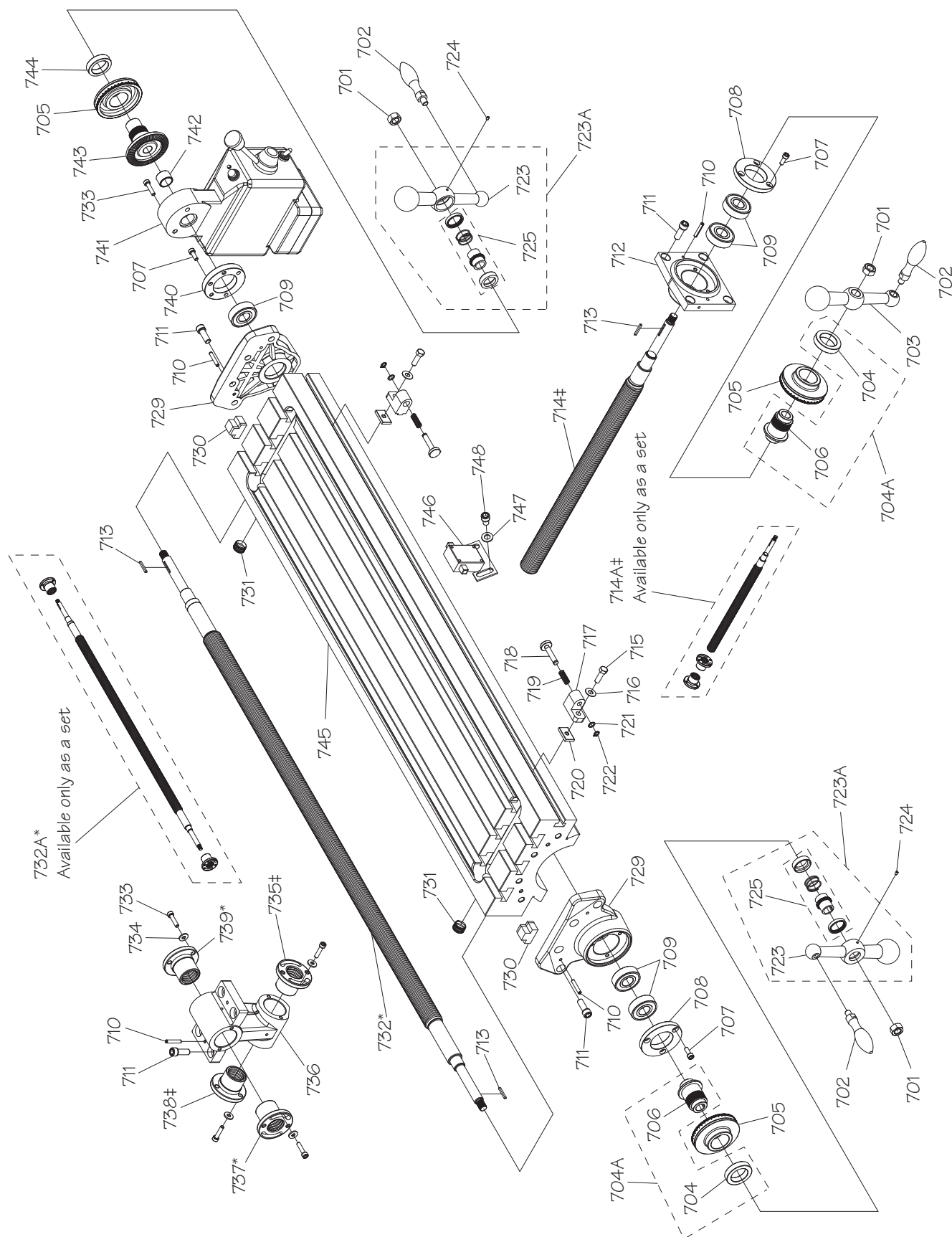
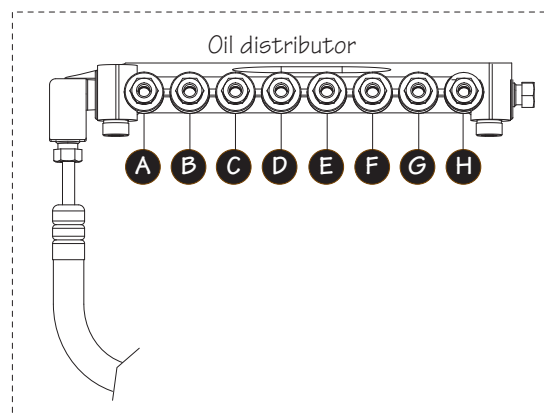
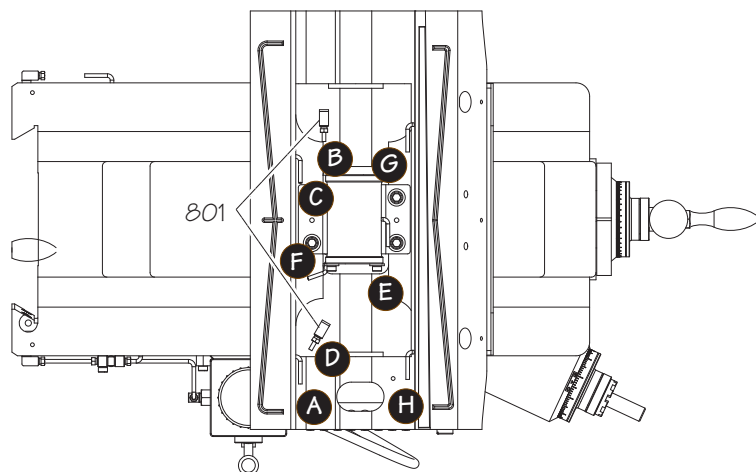
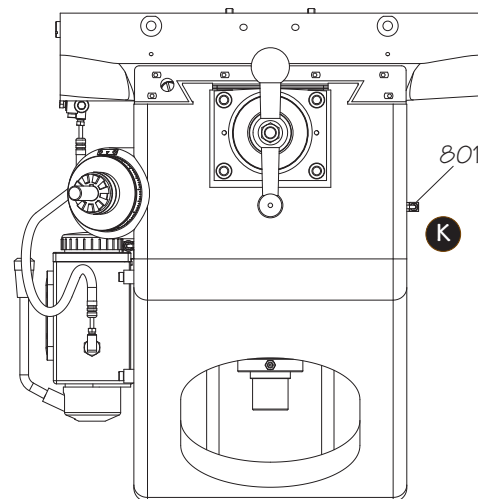
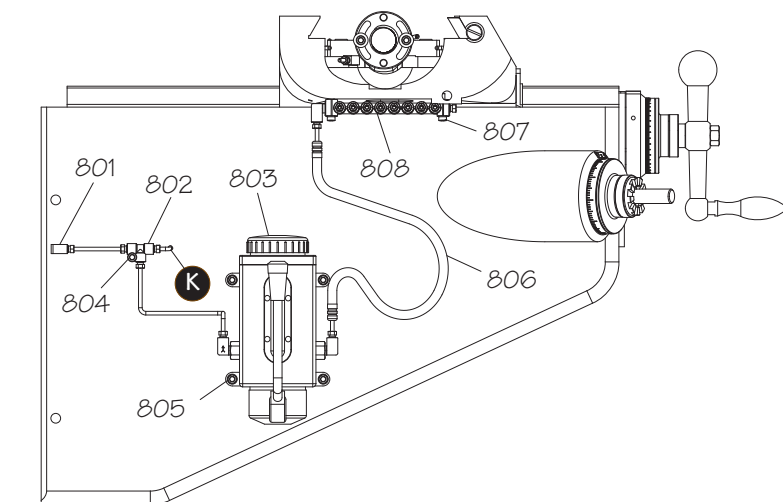


Table Parts List

REF	PART #	DESCRIPTION
701	PN01	HEX NUT 1/2-20
702	PSB10240702	HANDLE
703	PSB10240703	CROSS FEED BALL HANDLE
704A	PSB10240704A	DIAL HOLDER ASSEMBLY
704	PSB10240704A	OUTER DIAL HOLDER
705	PSB10240705	TABLE DIAL INCH
706	PSB10240704A	INNER DIAL HOLDER
707	PCAP01M	CAP SCREW M6-1 X 16
708	PSB10240708	BEARING RETAINER RING
709	P6204ZZ	BALL BEARING 6204ZZ
710	PRP05M	ROLL PIN 5 X 30
711	PCAP14	CAP SCREW 3/8-16 X 1
712	PSB10240712	CROSS FEED BEARING BRACKET
713	PK92M	KEY 3 X 3 X 25
714A	PSB10240714A	CROSS FEED LEADSCREW W/NUTS ASSY
714	PSB10240714A	CROSS FEED LEADSCREW
715	PSS01	SET SCREW 5/16-18 X 1
716	PW07	FLAT WASHER 5/16
717	PSB10240717	TRAVEL STOP
718	PSB10240718	TRAVEL STOP SHAFT
719	PSB10240719	COMPRESSION SPRING
720	PSB10240720	TRAVEL STOP T-NUT
721	PSB10240721	TRAVEL STOP FLAT WASHER 8MM
722	PR39M	EXT RETAINING RING 8MM

REF	PART #	DESCRIPTION
723A	PSB10240723A	LONGITUDINAL BALL HANDLE ASSY
723	PSB10240723A	LONGITUDINAL BALL HANDLE
724	PSS08M	SET SCREW M4-.7 X 5
725	PSB10240723A	TABLE BALL HANDLE CLUTCH ASSY
729	PSB10240729	TABLE BEARING BRACKET
730	PSB10240730	RUBBER TABLE T-SLOT PLUG
731	PSB10240606	PIPE PLUG 1/2 PT
732	PSB10240732	LONGITUDINAL LEADSCREW INCH
733	PCAP06M	CAP SCREW M6-1 X 25
734	PW03M	FLAT WASHER 6MM
735	PSB10240714A	FRONT CROSS LEADSCREW NUT
736	PSB10240736	LEADSCREW NUT BRACKET
737	PSB10240737	LEFT LONGITUDINAL LEADSCREW NUT
738	PSB10240714A	REAR CROSS FEED LEADSCREW NUT
739	PSB10240739	RIGHT LONGITUDINAL LEADSCREW NUT
740	PSB10240740	BEARING RETAINING RING
741	PSB10240741	POWER FEED ASSEMBLY
742	PSB10240742	BEVEL GEAR BUSHING
743	PSB10240743	POWER FEED BEVEL GEAR
744	PSB10240744	BEVEL GEAR NUT
745	PSB10240745	TABLE 9 X 42"
746	PSB10240746	LONGITUDINAL LIMIT SWITCH ASSEMBLY
747	PW02	FLAT WASHER 3/8
748	PCAP100	CAP SCREW 3/8-16 X 1/2

One-Shot Oiler

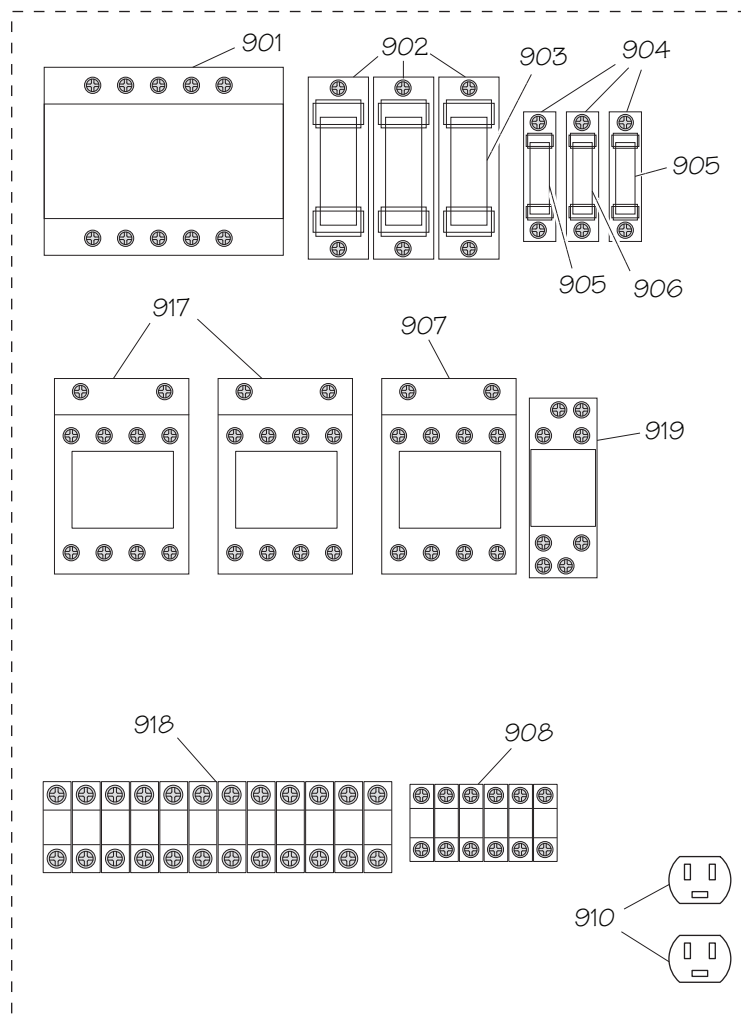


REF	PART #	DESCRIPTION
801	PSB10240801	ELBOW JOINT M4 X 1/8 PT
802	PSB10240802	T-JOINT
803	PSB10240803	ONE SHOT OILER ASSEMBLY
804	PCAP02M	CAP SCREW M6-1 X 20

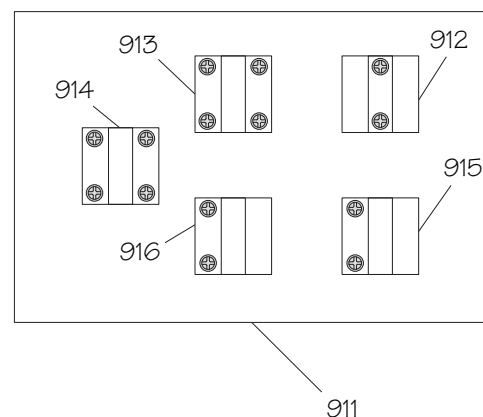
REF	PART #	DESCRIPTION
805	PCAP01M	CAP SCREW M6-1 X 16
806	PSB10240806	FLEXIBLE STEEL TUBE 4 X 500MM
807	PCAP38M	CAP SCREW M5-.8 X 25
808	PSB10240808	OIL DISTRIBUTOR 8-PORT

SB1024/SB1026 Electrical Box & Control Panel

Electrical Box



Control Panel

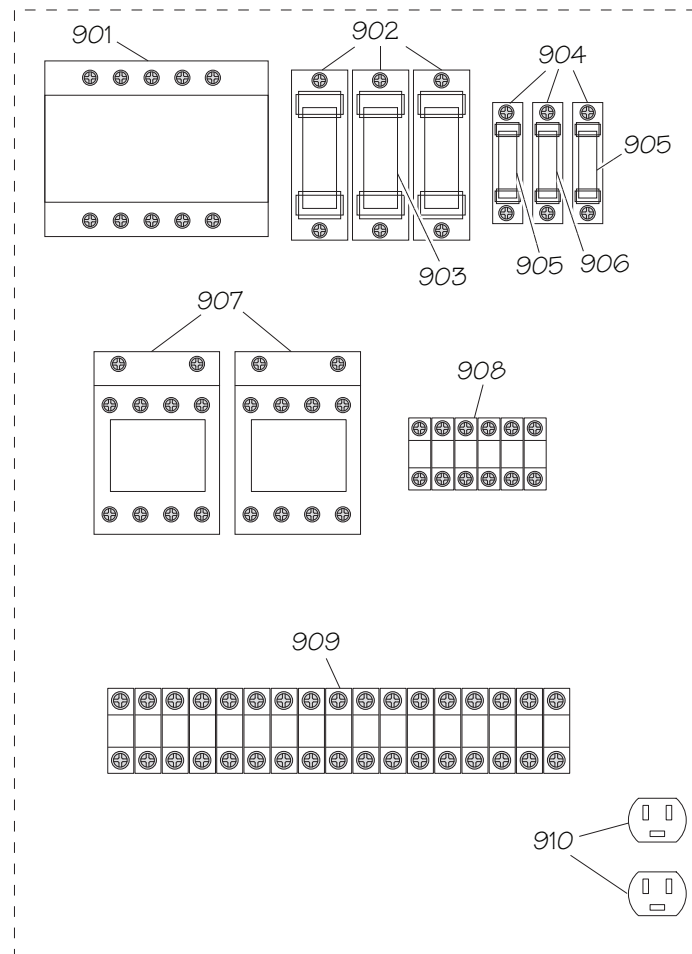


REF	PART #	DESCRIPTION
901	PSB10240901	TRANSFORMER 24-440V YJ A009-0383
902	PSB10240902	FUSE HOLDER 30A
903	PSB10240903	FUSE 30A
904	PSB10240904	FUSE HOLDER 2-5A
905	PSB10240905	FUSE 5A
906	PSB10240906	FUSE 2A
907	PSB10240907	CONTACTOR AB C09-400 220V
908	PSB10240908	TERMINAL BAR 6-POST
910	PSB10240910	POWER RECEPTACLE 100V

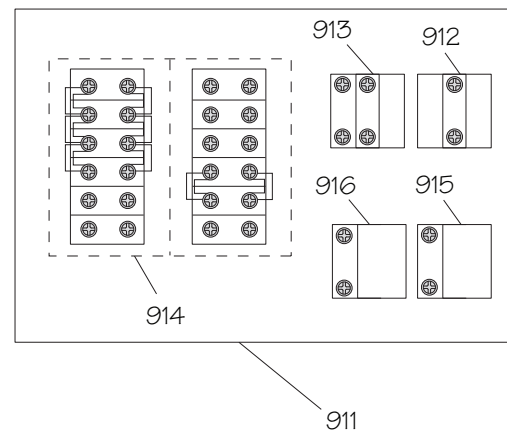
REF	PART #	DESCRIPTION
911	PSB10240911	CONTROL PANEL
912	PSB10240912	POWER INDICATOR ASSEMBLY
913	PSB10240913	SPINDLE START BUTTON ASSEMBLY
914	PSB10240914	SPINDLE DIRECTION SWITCH ASSEMBLY
915	PSB10240915	EMERGENCY STOP BUTTON ASSEMBLY
916	PSB10240916	SPINDLE STOP BUTTON ASSEMBLY
917	PSB10240917	CONTACTOR AB C16-01 220V
918	PSB10240918	TERMINAL BAR 12-POST
919	PSB10240919	RELAY OMERON MY2J 24V

SB1025 Electrical Box & Control Panel

Electrical Box



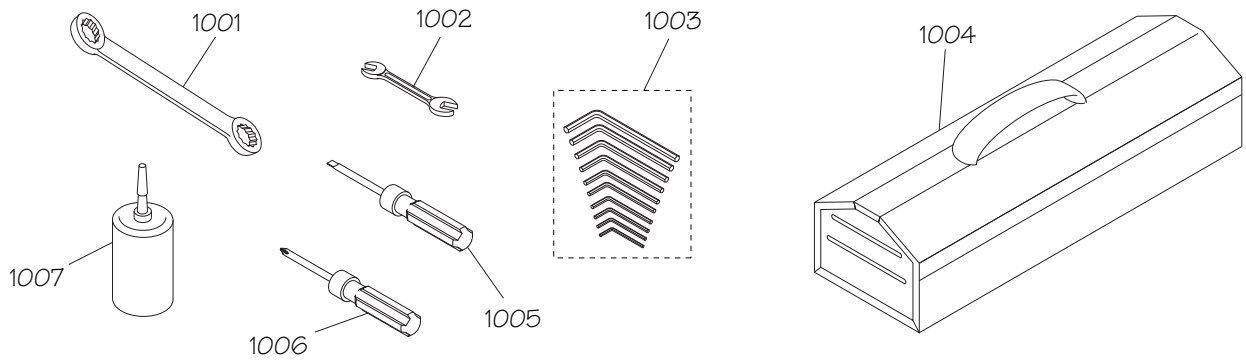
Control Panel



REF	PART #	DESCRIPTION
901	PSB10240901	TRANSFORMER 24-440V YJ A009-0383
902	PSB10240902	FUSE HOLDER 30A
903	PSB10240903	FUSE 30A
904	PSB10240904	FUSE HOLDER 2-5A
905	PSB10240905	FUSE 5A
906	PSB10240906	FUSE 2A
907	PSB10240907	CONTACTOR AB C09-400 220V
908	PSB10240908	TERMINAL BAR 6-POST

REF	PART #	DESCRIPTION
909	PSB10250909	TERMINAL BAR 17-POST
910	PSB10240910	POWER RECEPTACLE 100V
911	PSB10250911	CONTROL PANEL
912	PSB10240912	POWER INDICATOR ASSEMBLY
913	PSB10240913	SPINDLE START BUTTON ASSEMBLY
914	PSB10250914	SPINDLE DIRECTION SWITCH ASSEMBLY
915	PSB10240915	EMERGENCY STOP BUTTON ASSEMBLY
916	PSB10240916	SPINDLE STOP BUTTON ASSEMBLY

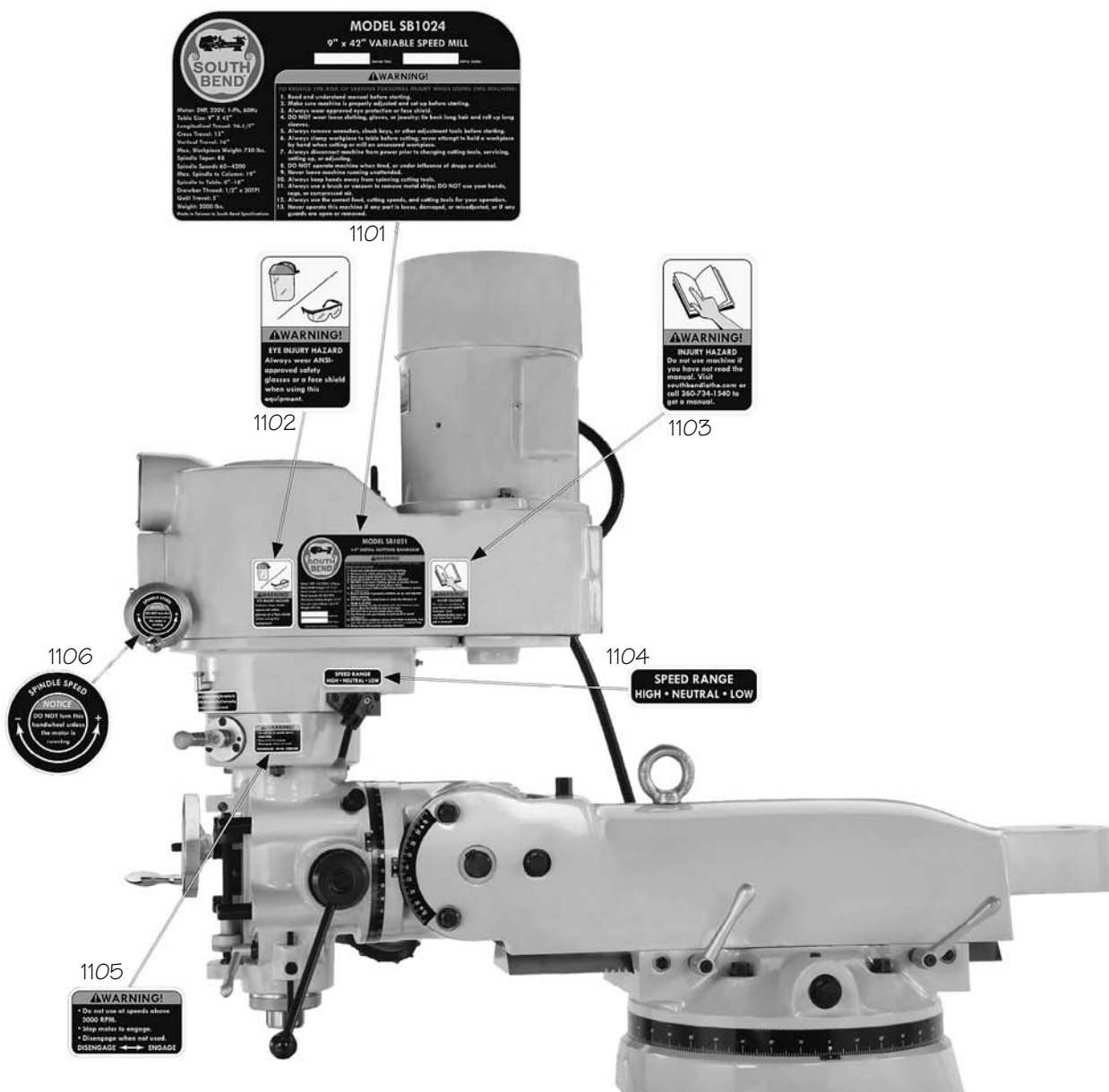
Accessories



REF	PART #	DESCRIPTION
1001	PWR1921C	CLOSED END WRENCH 19/21MM
1002	PWR1214	WRENCH 12/14MM
1003	PAW1510M	HEX WRENCH SET 10PC 1.5-10 MM
1004	PSB10241004	TOOL BOX

REF	PART #	DESCRIPTION
1005	PSDF2	FLAT SCREWDRIVER #2
1006	PSDP2	PHILLIPS SCREWDRIVER #2
1007	PSB10241007	OIL BOTTLE

SB1024 Head Machine Labels



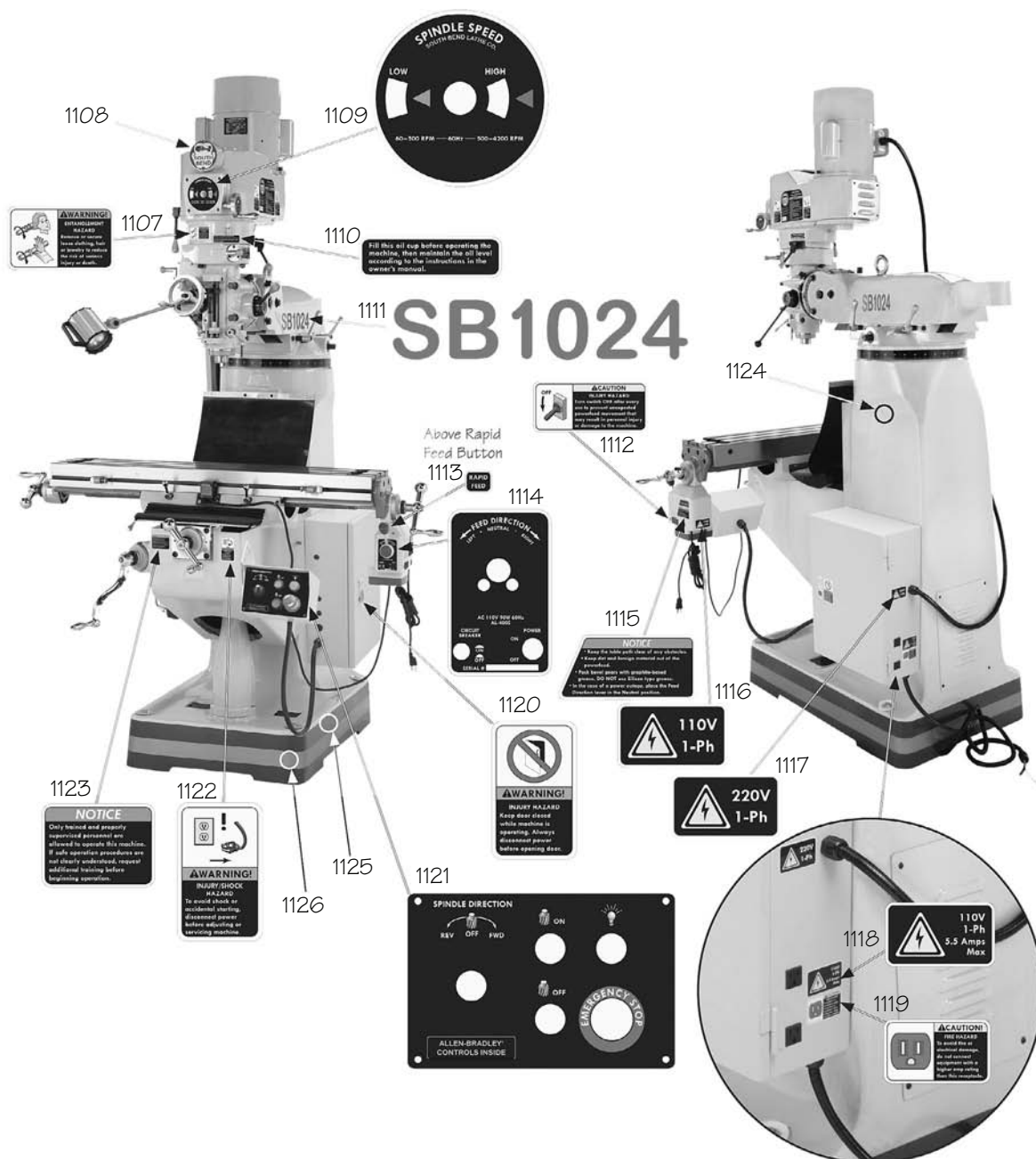
REF	PART #	DESCRIPTION
1101	PSB10241101	MACHINE ID LABEL
1102	PSBLABELO7VL	EYE INJURY HAZARD LABEL
1103	PSBLABELO1VL	READ MANUAL LABEL

REF	PART #	DESCRIPTION
1104	PSB10241104	SPEED RANGE LABEL
1105	PSB10241105	DOWNFEED WARNING LABEL
1106	PSB10241106	VARIABLE SPINDLE SPEED LABEL

⚠ WARNING

The safety labels provided with your machine are used to make the operator aware of the machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of these safety labels. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact South Bend Lathe Co. at (360) 734-1540 or www.southbendlathe.com to order new labels.

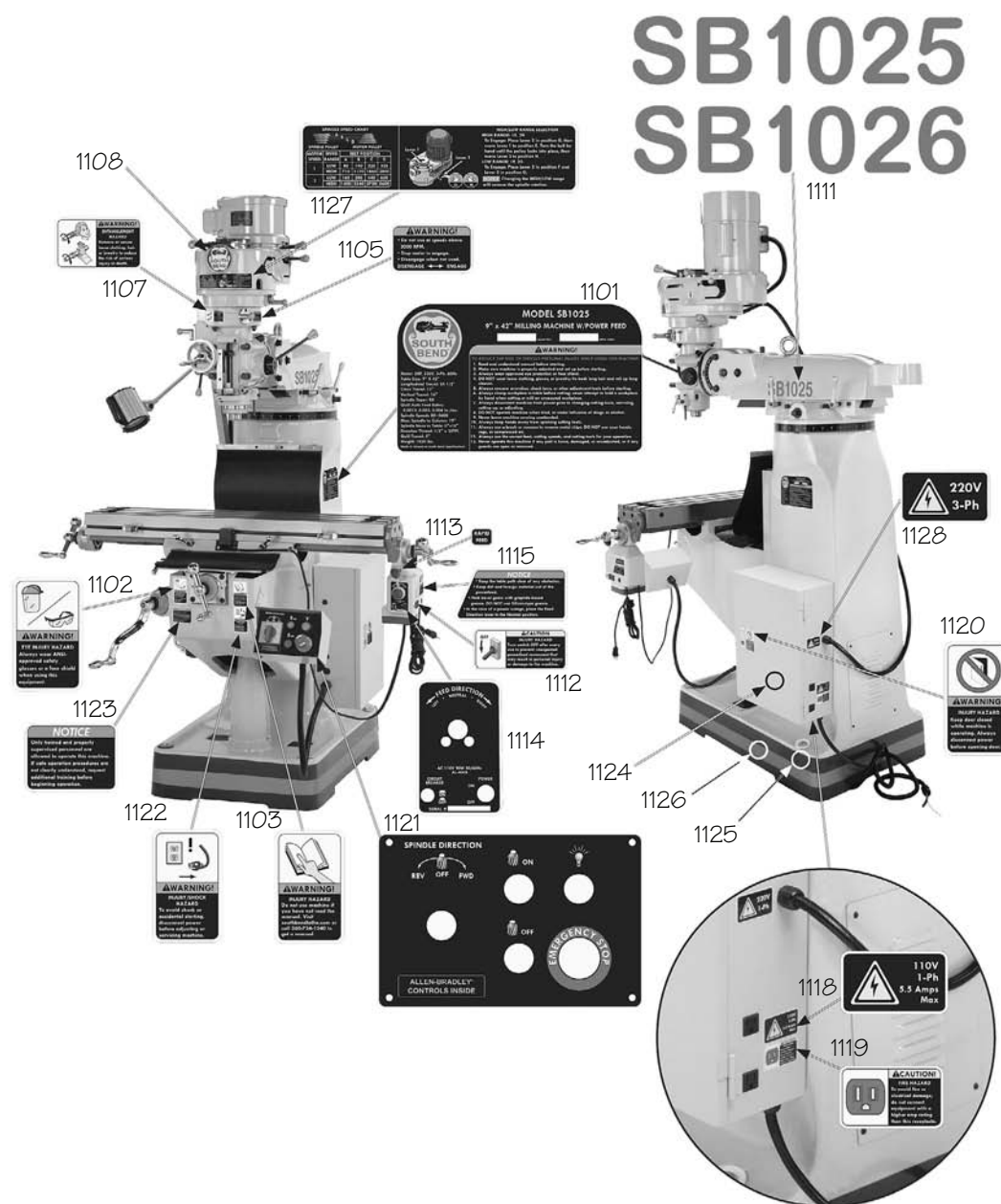
SB1024 Main Machine Labels



REF	PART #	DESCRIPTION
1107	PSBLABEL08VL	ENTANGLEMENT HAZARD LABEL
1108	SB1319	SOUTH BEND NAMEPLATE 90MM
1109	PSB10241109	SPINDLE SPEED DISPLAY LABEL
1110	PSB10241110	HEAD LUBRICATION LABEL
1111	PSB10241111	MODEL NUMBER LABEL
1112	PSB10241112	POWER FEED WARNING LABEL
1113	PSB10241113	POWER FEED RAPID FEED LABEL
1114	PSB10241114	POWER FEED CONTROL LABEL
1115	PSB10241115	POWER FEED NOTICE LABEL
1116	PSB10241116	110V 1PH LABEL

REF	PART #	DESCRIPTION
1117	PSB10241117	220V 1PH LABEL
1118	PSB10241118	110V 1PH 5.5A LABEL
1119	PSB10241119	PLUG RECEPTACLE FIRE HAZARD LABEL
1120	PSB10241120	ELECTRICAL BOX WARNING LABEL
1121	PSB10241121	CONTROL PANEL LABEL
1122	PSBLABEL02VL	DISCONNECT POWER LABEL
1123	PSB10241123	QUALIFIED PERSONNEL NOTICE LABEL
1124	PSBPAINT01	SB GRAY TOUCH-UP PAINT
1125	PSBPAINT02	SB LIGHT BLUE TOUCH-UP PAINT
1126	PSBPAINT03	SB DARK BLUE TOUCH-UP PAINT

SB1025/SB1026 Machine Labels



REF	PART #	DESCRIPTION
1101	PSB10251101	MACHINE ID LABEL (SB1025)
1101	PSB10261101	MACHINE ID LABEL (SB1026)
1102	PSBLABEL07VL	EYE INJURY HAZARD LABEL
1103	PSBLABEL01VL	READ MANUAL LABEL
1105	PSB10241105	DOWNFEED WARNING LABEL
1107	PSBLABEL08VL	ENTANGLEMENT HAZARD LABEL
1108	SB1319	SOUTH BEND NAMEPLATE 90MM
1111	PSB10251111	MODEL NUMBER LABEL (SB1025)
1111	PSB10261111	MODEL NUMBER LABEL (SB1026)
1112	PSB10241112	POWER FEED WARNING LABEL
1113	PSB10241113	POWER FEED RAPID FEED LABEL
1114	PSB10241114	POWER FEED CONTROL LABEL

REF	PART #	DESCRIPTION
1115	PSB10241115	POWER FEED NOTICE LABEL
1118	PSB10241118	110V 1PH 5.5A LABEL
1119	PSB10241119	PLUG RECEPTACLE FIRE HAZARD LABEL
1120	PSB10241120	ELECTRICAL BOX WARNING LABEL
1121	PSB10241121	CONTROL PANEL LABEL
1122	PSBLABEL02VL	DISCONNECT POWER LABEL
1123	PSB10241123	QUALIFIED PERSONNEL NOTICE LABEL
1124	PSBPAINTO1	SB GRAY TOUCH-UP PAINT
1125	PSBPAINTO2	SB LIGHT BLUE TOUCH-UP PAINT
1126	PSBPAINTO3	SB DARK BLUE TOUCH-UP PAINT
1127	PSB10251127	SPINDLE SPEED CHART LABEL
1128	PSB10251128	220V 3PH LABEL