

LATHE BULLETIN 10L-6
Replaces Bulletin 10L-5

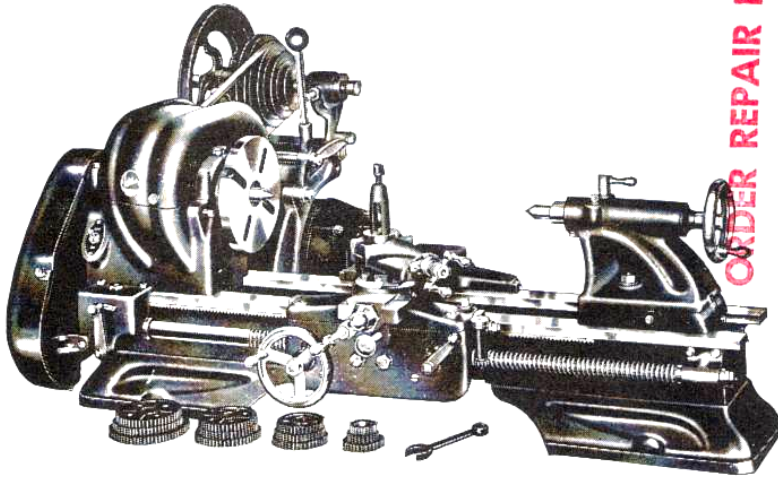
Atlas

PARTS LIST FOR SERIES ATLAS LATHES

FOR ATLAS TIMKEN BEARING LATHES:
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: TH36, TH42, TH48, TH54
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: TV36, TV42, TV48, TV54

FOR ATLAS BABBITT BEARING LATHES:
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: H36, H42, H48, H54
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: V36, V42, V48, V54

FOR ATLAS QUICK-CHANGE LATHES:
Cat. Nos.: QC42 and QC54



ORDER REPAIR PARTS
FROM

CLAUSING SERVICE CENTER
2306 EISENHOWER DRIVE
GOSHEN, INDIANA 46526

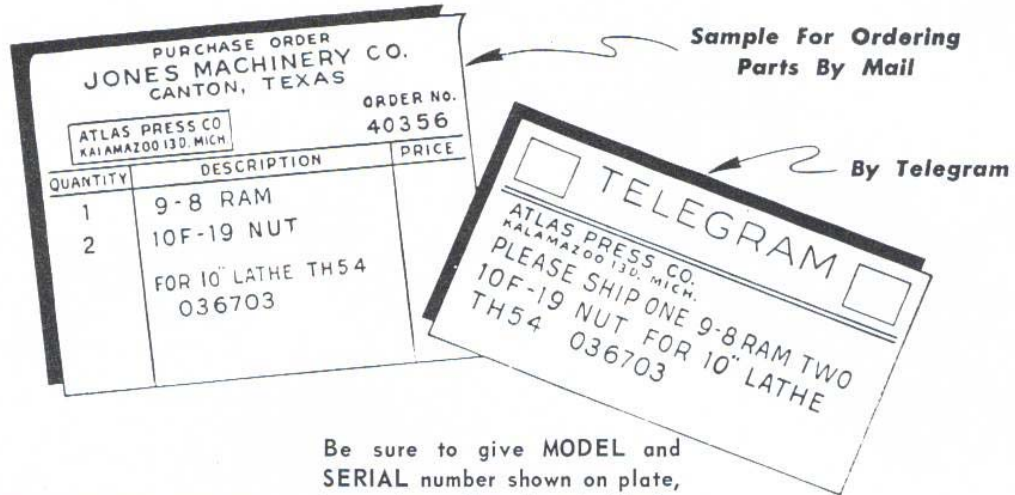
PRESS CO. • Kalamazoo, Mich., U.S.A. 49001

SINCE 1911, MANUFACTURERS OF PRECISION MACHINE TOOLS

PRINTED IN U.S.A.

IMPORTANT: The following information must be furnished on all repair part orders.

1. Quantity Required
2. PART NUMBER and Name of Part
3. Model and Serial Number of Lathe



Be sure to give MODEL and SERIAL number shown on plate, located at tailstock end of lathe bed.

NOTE: On Lathes without this plate, MODEL and SERIAL Number is found on top of FRONT BED-WAY.

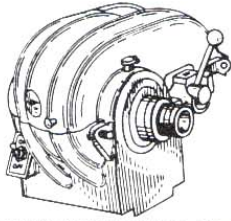


Parts shown without part numbers are standard parts and should be purchased locally.
 We reserve the right to make changes in design and specifications without notice.

INDEX FOR LATHE PARTS AND PRICES

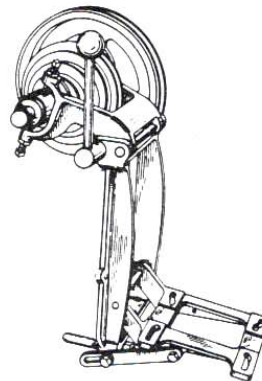
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Atlas 10" F-SERIES LATHE UNIT ASSEMBLIES

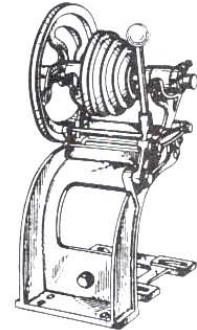


10A-2BXH TIMKEN BEARING HEADSTOCK ASSEMBLY
For Horizontal Countershaft Lathes

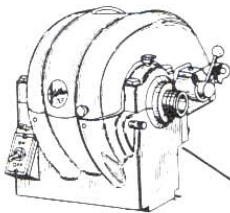
10A-2BXV TIMKEN BEARING HEADSTOCK ASSEMBLY
For Vertical Countershaft Lathes



9-20X VERTICAL COUNTERSHAFT ASSEMBLY

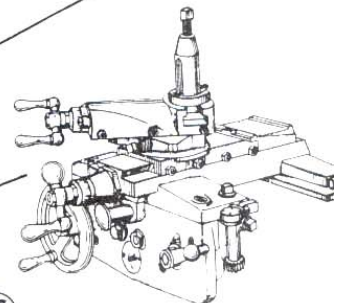


10-20X HORIZONTAL COUNTERSHAFT ASSEMBLY

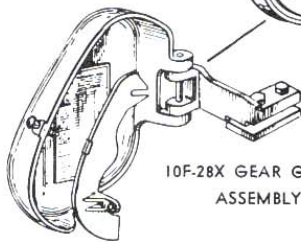


10A-2BXH TIMKEN BEARING HEADSTOCK ASSEMBLY
For Horizontal Countershaft Lathes
Replaces 10D-2BXH Babbitt Bearing Headstock Assembly

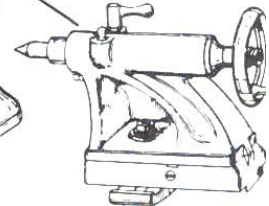
10A-2BXV TIMKEN BEARING HEADSTOCK ASSEMBLY
For Vertical Countershaft Lathes
Replaces 10D-2BXV Babbitt Bearing Headstock Assembly



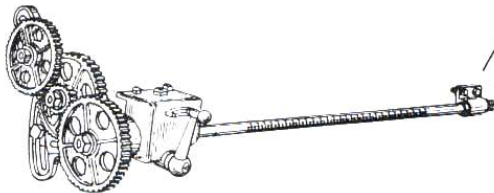
10F-9XY CARRIAGE ASSEMBLY



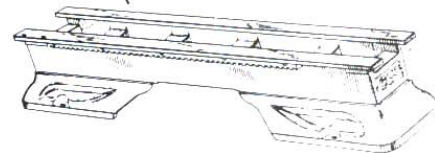
10F-28X GEAR GUARD ASSEMBLY



10D-5X TAILSTOCK ASSEMBLY



LEAD SCREW AND FEED GEAR ASSEMBLY



BED, LEGS AND RACK ASSEMBLY

10L - 6

10F-35-36X 36" MODEL LATHE
10F-35-42X 42" MODEL LATHE
10F-35-48X 48" MODEL LATHE
10F-35-54X 54" MODEL LATHE

3

9-1 BX 36" MODEL LATHE Not Available
942BX 42" MODEL LATHE
948BX 48" MODEL LATHE Not Available
954BX 54" MODEL LATHE

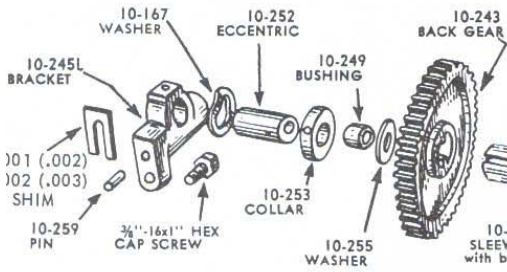
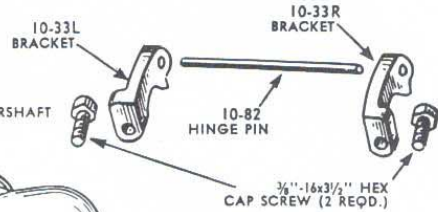
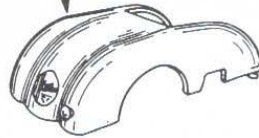


Not Available
10D-246
GEAR GUARD (RIGHT)
FOR VERTICAL CTRSHAFT
LATHES ONLY

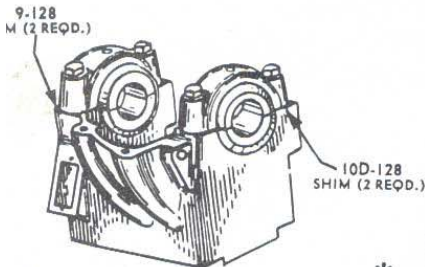


Not Available
10D-247
GEAR GUARD (LEFT)
FOR VERTICAL CTRSHAFT
LATHES ONLY

10-18
GEAR GUARD
FOR HORIZONTAL CTRSHAFT
LATHES ONLY



10-250X BACK GEAR ASSEMBLY

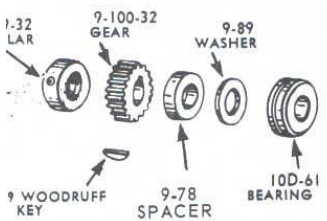
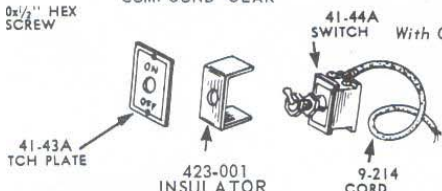


10D-2BA TIMKEN BEARING HEADSTOCK
laces 10D-2BA Babbitt Bearing Headstock



10A-2BXH HEADSTOCK ASSEMBLY
With Gear Guard - for Horizontal Countershaft Lathe
Replaces 10D-2BXH

10A-2BXY HEADSTOCK ASSEMBLY
for Vertical Countershaft Lathe
Replaces 10D-2BXY

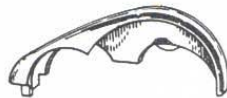


10-31X SPINDLE ASSEMBLY

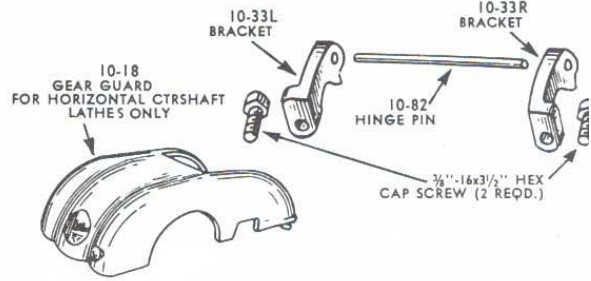
Replacement babbitt bearings not available. Order X10D-2BA conversion unit - includes headstock, spindle, Timken bearings, bearing shields and thrust collar.



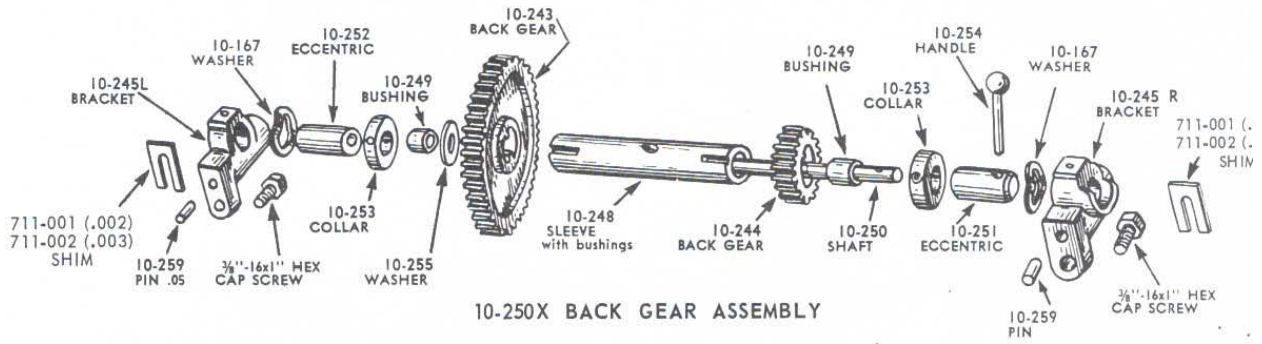
NOT AVAILABLE
10D-246
GEAR GUARD (RIGHT)
FOR VERTICAL CTRSHAFT
LATHES ONLY



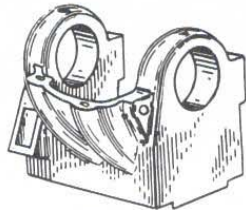
NOT AVAILABLE
10D-247
GEAR GUARD (LEFT)
FOR VERTICAL CTRSHAFT
LATHES ONLY



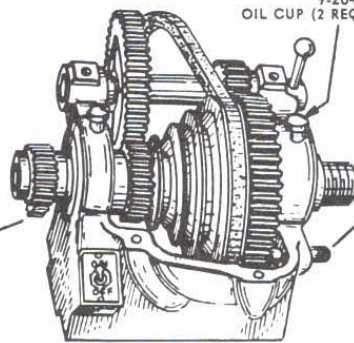
10-18
GEAR GUARD
FOR HORIZONTAL CTRSHAFT
LATHES ONLY



10-250X BACK GEAR ASSEMBLY

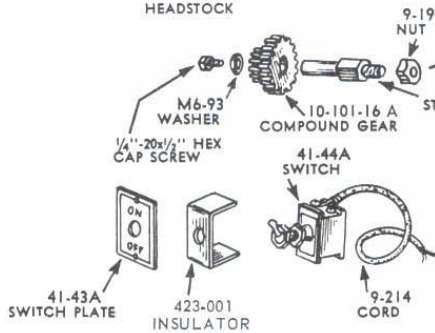


10A-2B
HEADSTOCK

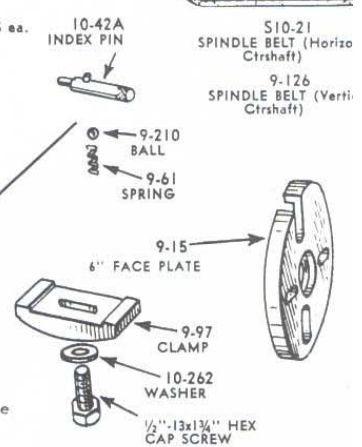


10A-2BXH HEADSTOCK ASSEMBLY
With Gear Guard - for Horizontal Countershaft Lathe

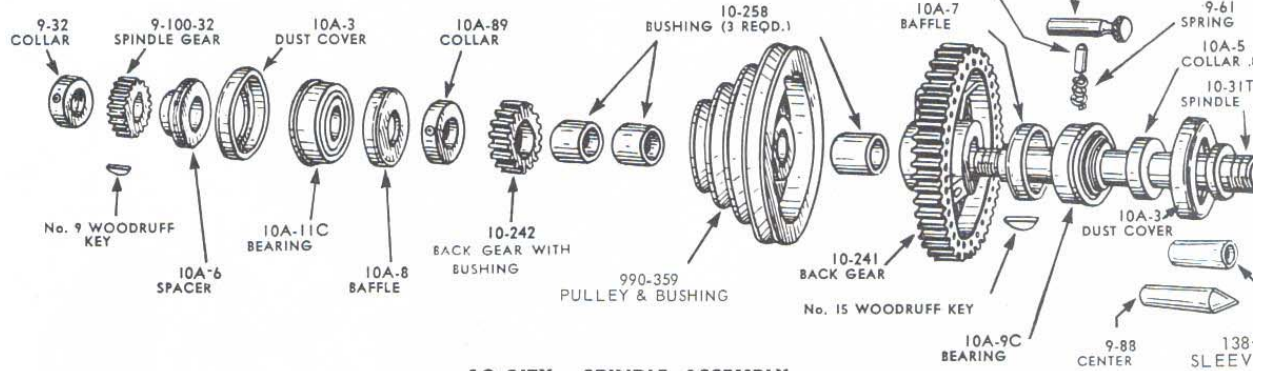
10A-2BXV HEADSTOCK ASSEMBLY
for Vertical Countershaft Lathe



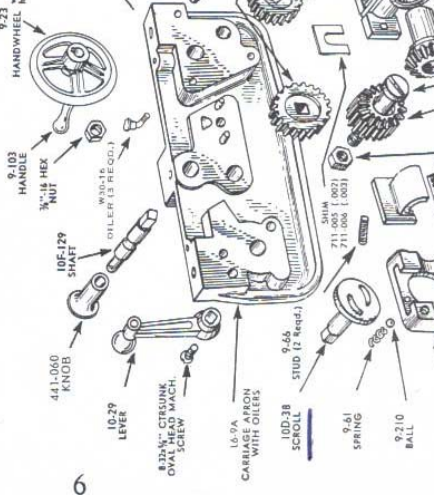
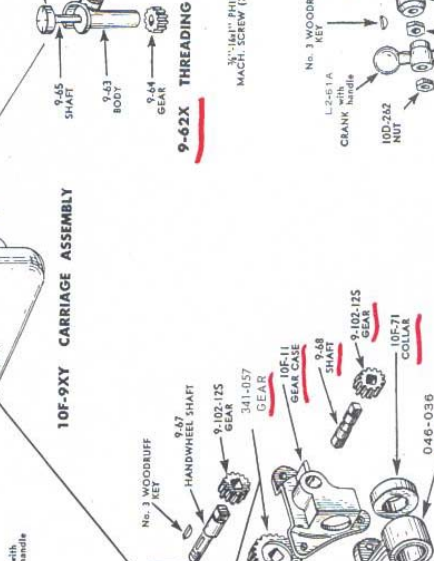
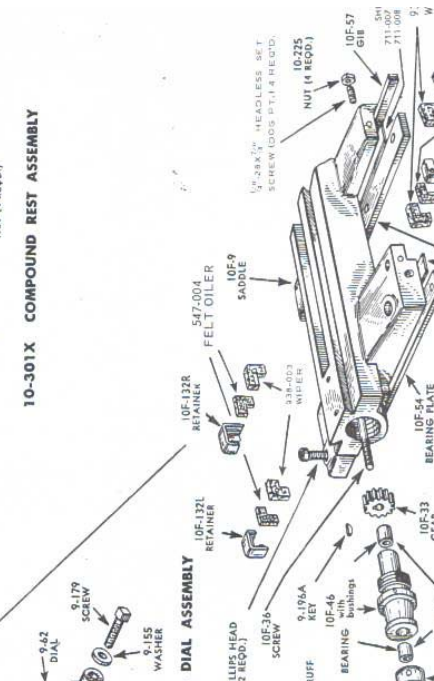
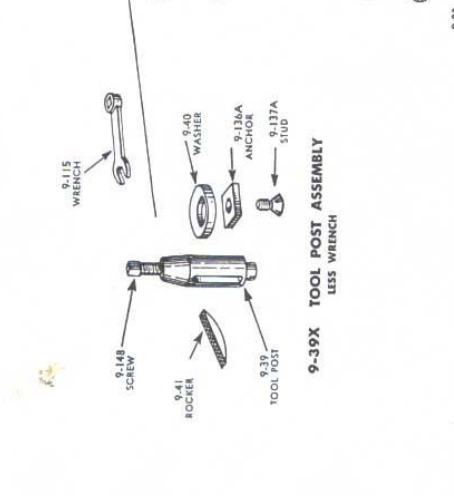
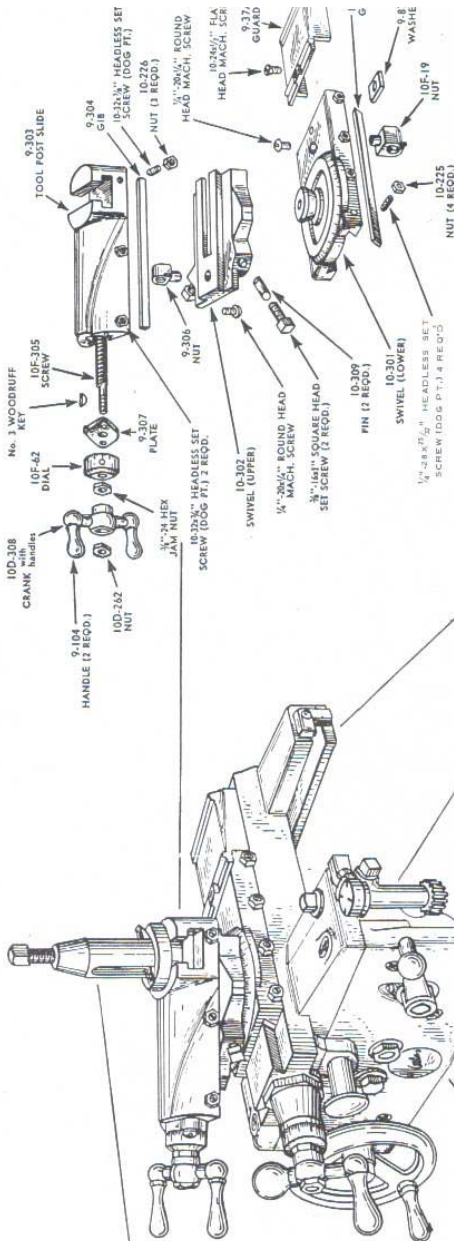
41-43A SWITCH PLATE
423-001 INSULATOR
9-214 CORD

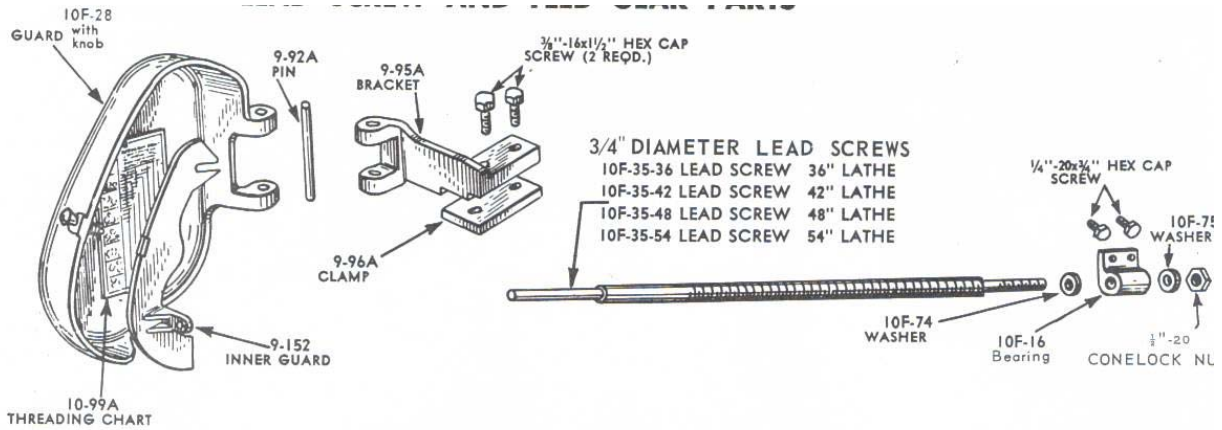


9-204 OIL CUP (2 REQD.) .25 ea.
10-42A INDEX PIN
9-210 BALL
9-61 SPRING
9-15 6" FACE PLATE
9-97 CLAMP
10-262 WASHER
1/2" 13x1 3/4" HEX CAP SCREW

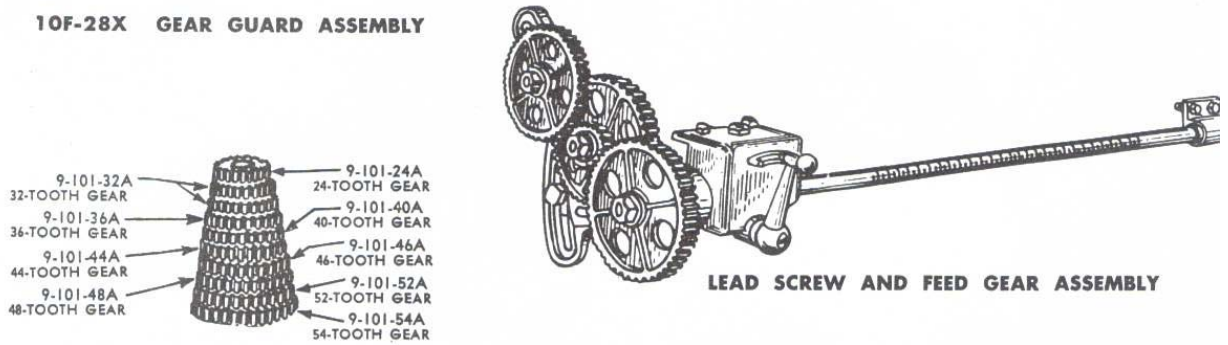


10-31TX SPINDLE ASSEMBLY



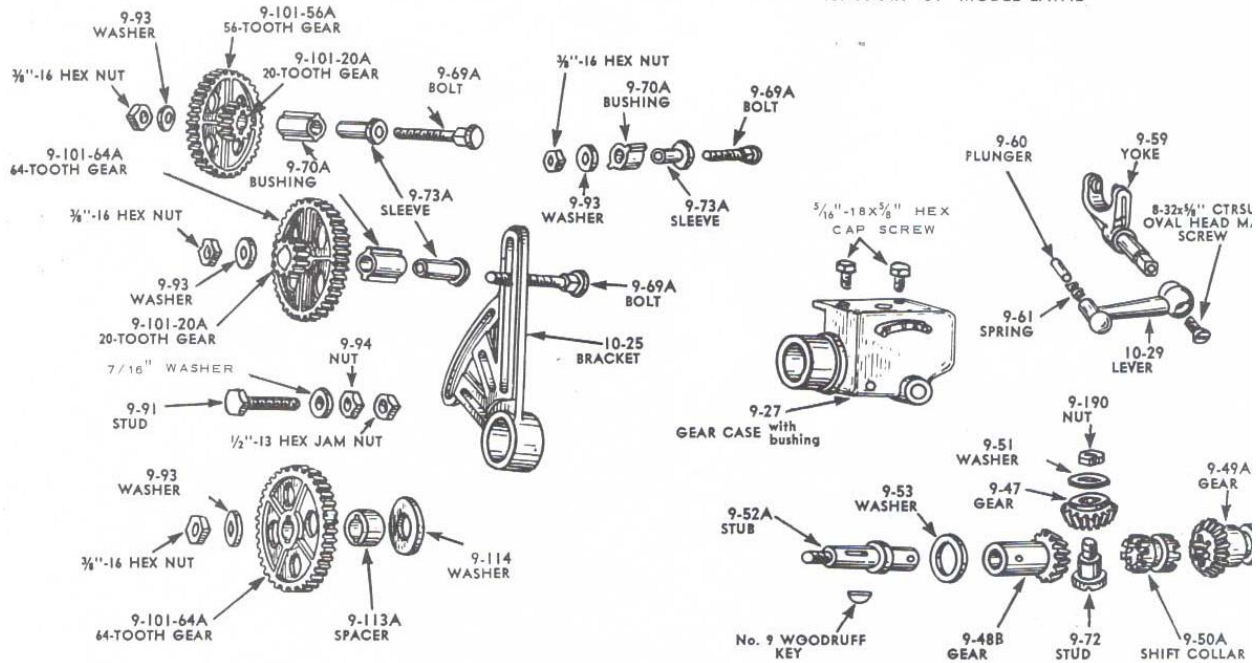


10F-28X GEAR GUARD ASSEMBLY



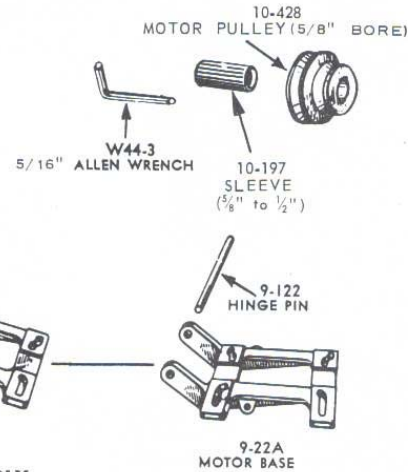
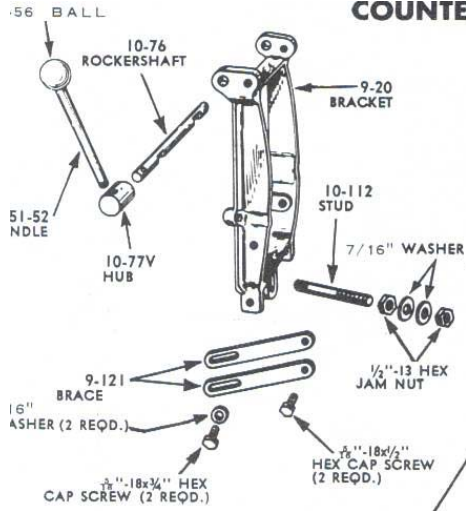
9-101A CHANGE GEAR ASSEMBLY

- 10F-35-36X 36" MODEL LATHE
- 10F-35-42X 42" MODEL LATHE
- 10F-35-48X 48" MODEL LATHE
- 10F-35-54X 54" MODEL LATHE

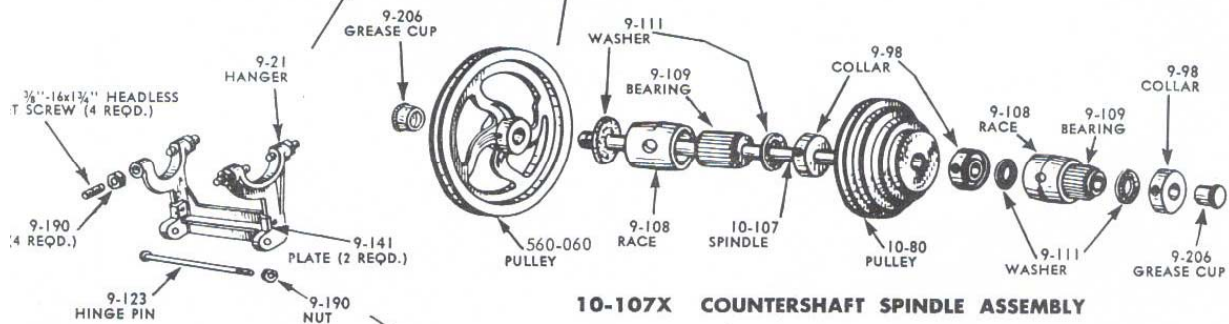


9-101A CHANGE GEAR ASSEMBLY

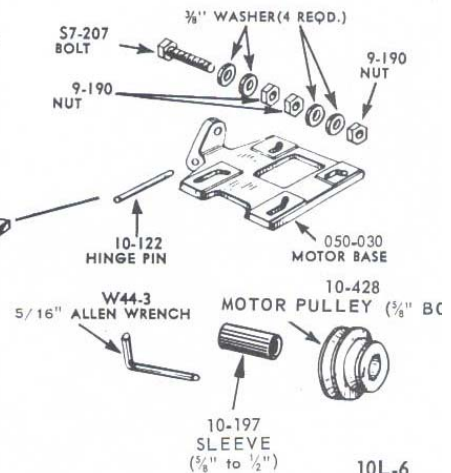
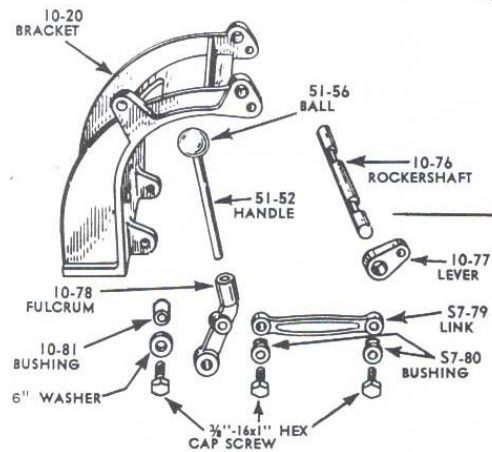
COUNTERSHAFT PARTS



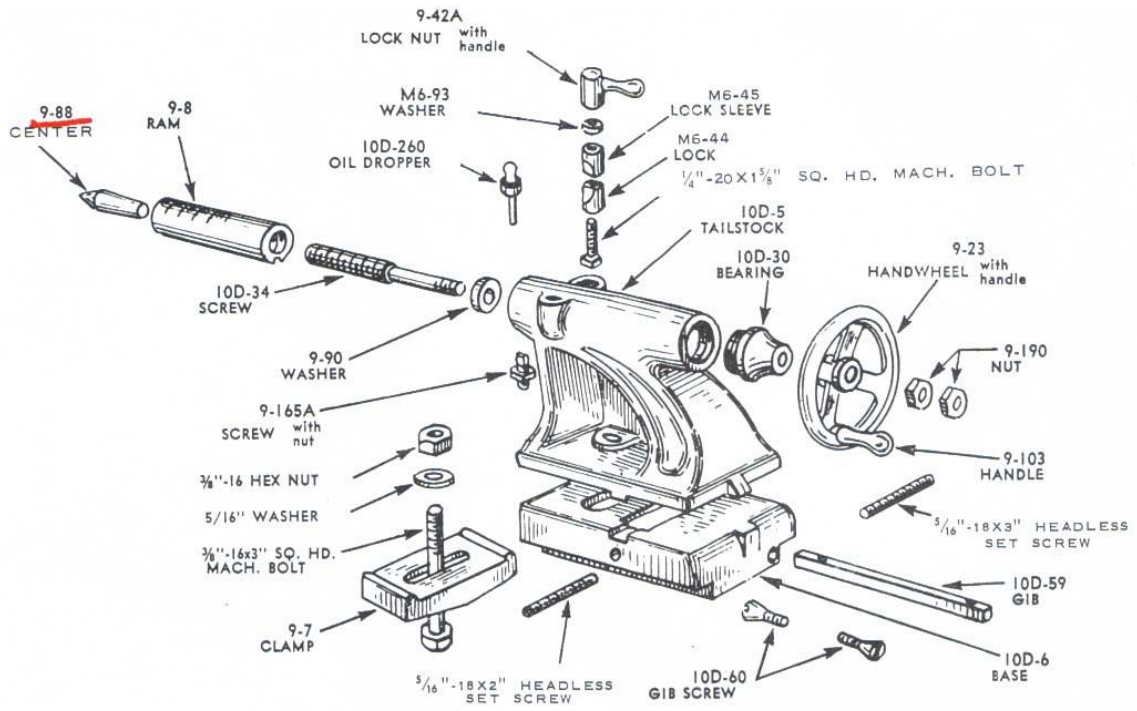
9-20X VERTICAL COUNTERSHAFT ASSEMBLY WITH MOTOR BELT AND PULLEY



10-107X COUNTERSHAFT SPINDLE ASSEMBLY

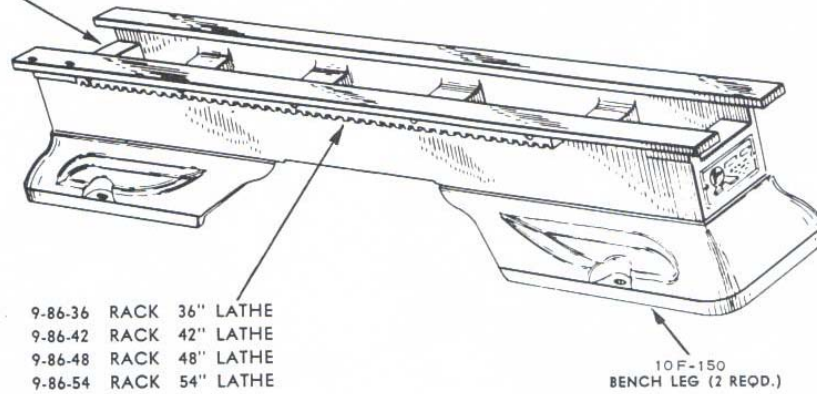


10-20X HORIZONTAL COUNTERSHAFT ASSEMBLY WITH MOTOR BELT AND PULLEY



10D-5X TAILSTOCK ASSEMBLY

942 B 42" LATHE BED ONLY
 954 B 54" LATHE BED ONLY



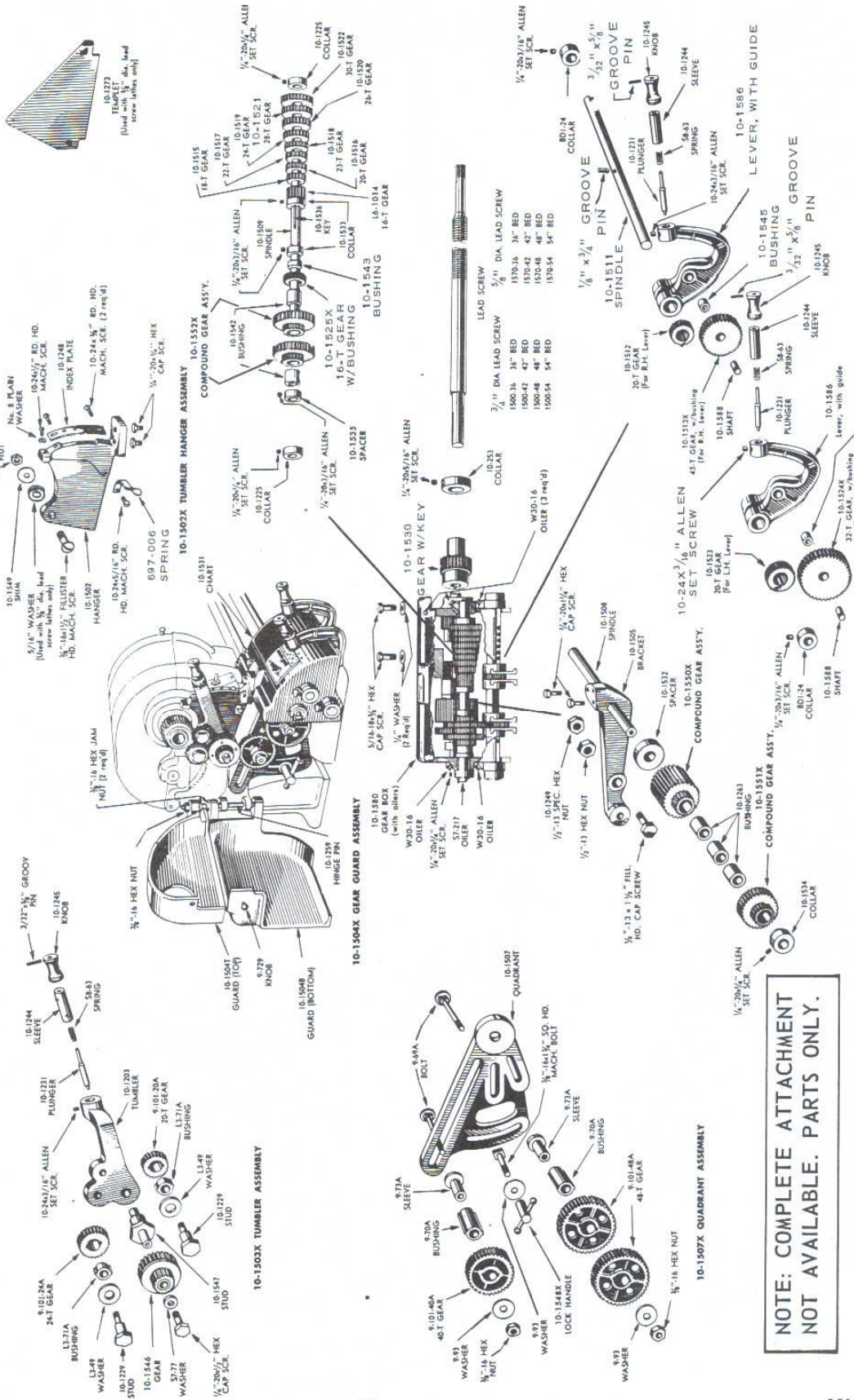
BED, LEGS, AND RACK ASSEMBLY

942BX 42" MODEL LATHE
 954BX 54" MODEL LATHE

bracket - use this page for ordering parts.



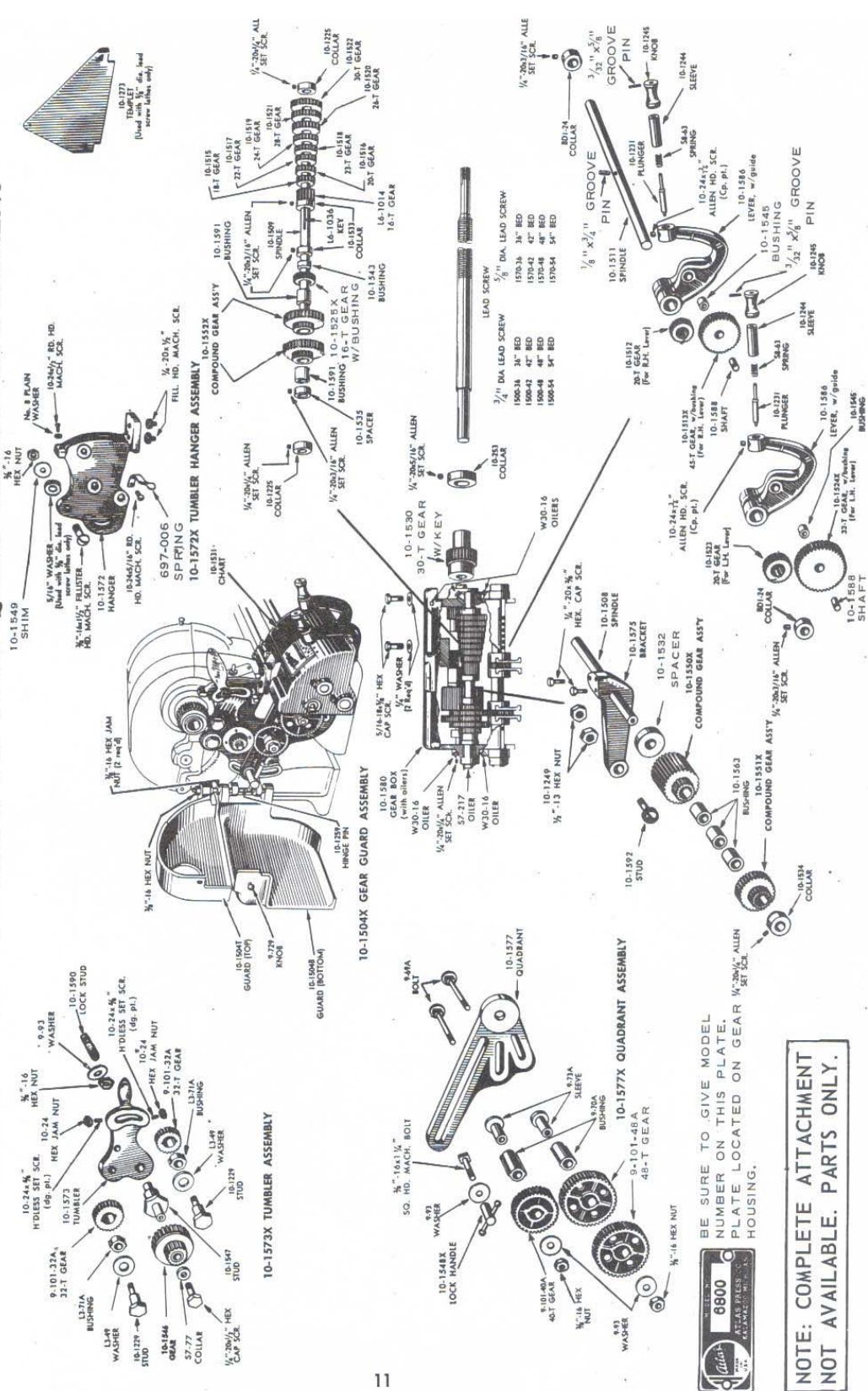
REPAIR PARTS FOR ATLAS Nos. 1500 and 1570 QUICK-CHANGE ATTACHMENT



NOTE: COMPLETE ATTACHMENT NOT AVAILABLE. PARTS ONLY.

If your lathe has a Quick-Change attachment with this tumbler gear bracket - use this page for ordering parts.

REPAIR PARTS FOR ATLAS No. 6800 QUICK-CHANGE ATTACHMENT



BE SURE TO GIVE MODEL NUMBER ON THIS PLATE. PLATE LOCATED ON GEAR HOUSING.

NOTE: COMPLETE ATTACHMENT NOT AVAILABLE. PARTS ONLY.

INSTRUCTIONS and PARTS



ATLAS PRESS COMPANY
KALAMAZOO, MICHIGAN 49001

THREADING CHART

for
10F-series 10" ATLAS LATHES
with 3/4" diameter lead screw

DECEMBER, 1966 FILE NO. 10-99A

FIG. 1		THREADING CHART											
SPINDLE		A-B-C-D ARE GEAR STUD POSITIONS B = BACK POSITION (TOWARD HEADSTOCK) F = FRONT POSITION (AWAY FROM HEADSTOCK) I = IDLER GEAR S = SPACER — = BLANK X = 24 TOOTH GEAR IN BACK POSITION (SS) = DOUBLE KEYWAY SPACER											
THREDS PER INCH	SCREW	POSITION D	POSITION C	POSITION B	POSITION A	SPINDLE STUD GEAR	FIG.						
4	32F			24	48	64I 20S	32	1					
4.5	36F			32	64	64I 20S	32	1					
5	40F			32	64	64I 20S	32	1					
5.5	44F			32	64	64I 20S	32	1					
6	48F			32	64	64I 20S	32	1					
6.5	52F			32	64	64I 20S	32	1					
7	56F			32	64	64I 20S	32	1					
8	32B			48I 20S	46I 24S		32	2					
9	36B			32I 20S	64I 24S		32	2					
10	40B			32I 20S	64I 24S		32	2					
11	44B			32I 20S	64I 24S		32	2					
11.5	46B			32I 20S	64I 24S		32	2					
12	48B			32I 20S	64I 24S		32	2					
13	52B			32I 20S	64I 24S		32	2					
14	56B			32I 20S	64I 24S		32	2					
16	64B			32I 20S	64I 24S		32	2					
18	36F			20S 64I	64	32	32	3					
20	40F			20S 64I	64	32	32	3					
22	44F			20S 64I	64	32	32	3					
23	46F			20S 64I	64	32	32	3					
24	48F			20S 64I	64	32	32	3					
26	52F			20S 64I	64	32	32	3					
27	54F			20S 64I	64	32	32	3					
28	56F			20S 64I	64	32	32	3					
32	64F			20S 56I	48	24	32	3					
36	36B			64I 20S	24	48	16	4					
40	40B			64I 20S	32	64	16	4					
44	44B			64I 20S	32	64	16	4					
48	48B			64I 20S	32	64	16	4					
56	56B			64I 20S	32	64	16	4					
64	64B			64I 20S	24	48	16	4					
72	36F	20S 64I		64	32	24	48	16	5				
80	40F	20S 64I		64	32	24	48	16	5				
96	48F	40 20		64I 24S	32	64	16	6					
FEED PER REVOLUTION OF SPINDLE													
FEED	SCREW	POSITION D	POSITION C	POSITION B	POSITION A	STUD	FIG.						
.001877	64B		20 64	52 20	24 48	16	—						
.0035	64F			64 20	20 56	16	7						
.005	64F X	52 20		54I (SS)	20 48	16	—						
.006	64F	52 20		54I (SS)	24 48	16	—						
.007	64B			20 64	56 20	32	—						
.0087	64F	56 20		36 46	20S 64I	16	—						
METRIC THREADING CHART													
PITCH IN MILLIMETERS	GEAR ON SCREW	POSITION D	POSITION C	POSITION B	POSITION A	SPINDLE STUD GEAR	FIG.						
.5	48F	40 44		52I (SS)	24 56	16	8						
.75	64F	40 32		52 44	20S 56I	16	—						
1.00	44F	40 32		52 48	20S 64I	16	—						
1.25	44B			52 48	20S 64I	16	—						
1.50	44B			52 40	20S 64I	16	—						
1.75	44F	48 52		56 40	20S 64I	16	—						
2.00	40F	44 48		52 36	20S 64I	16	—						
2.5	44B			52 24	20S 64I	16	—						
3.0	44B			52 20	24S 64I	16	—						
3.5	44F	48 56		52 20	24S 64I	16	—						
4.0	20F	44 48		52 36	24S 64I	16	9						
4.5	20F	44 54		52 36	20S 64I	16	—						
5.0	24F	44 52		40 20	20S 64I	16	—						
5.5	20F			48 52	64I 24S	32	—						
6.0	20F	44 52		48 24	32S 64I	16	—						
7.0	48B	52 44		20 56	64I 24S	32	—						