



# SOUTH BEND LATHE WORKS

(AN INDIANA CORPORATION)

SOUTH BEND 22, INDIANA, U.S.A.



MARCH  
1956

## THERE ARE STAR PERFORMERS IN EVERY FIELD...

those who "Stand Out" from all the others and can always be depended on to do the job.

Such star performances are the rule, when a South Bend Turret Lathe takes over. Whether our big 16" 2-H, the New 13" or the 10" model, Ease in Setting Up - Dependable Precision - Speed in Production - All are built-in to SOUTH BEND TURRET LATHES.

To return a profit on invested capital, a Turret Lathe must fit the job, do it right, then take on another job without loss of time and effort.

We're sending along this folder illustrating South Bend Turret Lathes with specifications, so that you can see

HOW SOLIDLY BUILT...for the rough, tough handling that day after day production gives a Turret Lathe.

HOW WELL DESIGNED...by practical men who understand the problems involved in quantity production of machined parts.

HOW WE'VE BUILT FOR EASY HANDLING...conveniently arranging controls, open and accessible to speed every operation.

HOW WE'VE MADE SOUTH BEND TURRET LATHES A BIGGER VALUE FOR YOUR DOLLARS!

Producing dependable tools that will do the job has been our business for the last FIFTY years. We've learned a lot about making good machine tools in those years, and you can bet that all we've learned has been put to use in building SOUTH BEND Machine Tools.

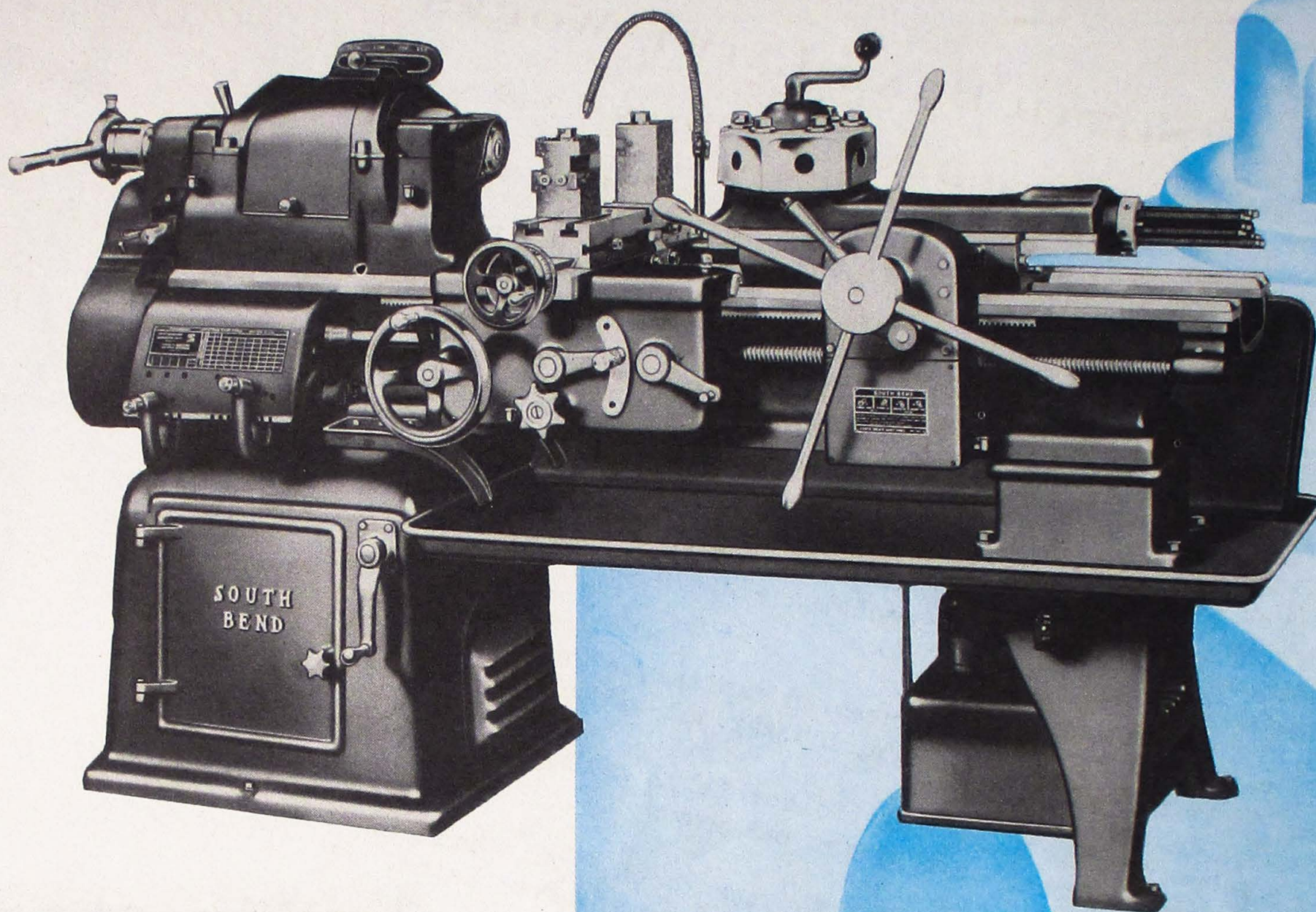
We have a GOLDEN ANNIVERSARY Catalog ready to send to you, describing our complete line of Machine Tools and Accessories. A postcard or a letter and your copy will be mailed right away. In the meantime, our distributor near you will be pleased to stop by and discuss your problems.

Very truly yours,  
SOUTH BEND LATHE WORKS

*J. A. Johnson*



# No. 2-H Precision Turret Lathe



## SPECIFICATIONS

### CAPACITY OF LATHE

Hole through spindle.....	1 1/8"
Swing over double tool cross slide.....	6 7/8"
Swing over bed and saddle wings.....	16 1/4"
Width of lathe bed.....	11 5/8"
Spindle nose diameter and threads per inch.....	2 3/8"-6
Maximum collet capacity through handlever collet chuck.....	1"

### SPINDLE SPEEDS (Standard spindle speeds with two-speed motor, approximate, not exact)

High spindle speeds	
r.p.m. of spindle, direct belt drive.....	945, 550, 300
r.p.m. of spindle, back-gear drive.....	118, 70, 32
Low spindle speeds (Not available with 1-speed motor)	
r.p.m. of spindle, direct belt drive.....	475, 278, 150
r.p.m. of spindle, back-gear drive.....	60, 33, 20

### TURRET

Diameter of holes in turret faces.....	1 1/2"
Center of turret hole to top of turret slide.....	2 1/2"
Effective feed of turret slide.....	5 7/8"
Distance between opposite flats.....	9 3/8"
Maximum distance between spindle nose and turret face at beginning of indexing movement.....	6 ft. bed 28 1/4", 7 ft. bed 40 1/4"

### UNIVERSAL CARRIAGE

Thread cutting range.....	4 to 224 per inch
Power longitudinal feeds.....	.0015" to .0841"
Maximum longitudinal travel.....	6 ft. bed 22 1/2" 7 ft. bed 34 1/2"
Power cross-feeds, 48.....	.0006" to .0315"
Cross travel of cross slide.....	9 3/4"
Tool block openings for cutter bits.....	5/8" x 5/8"

### MOTOR

For operating on	
3-phase A.C. 2-speed, 1800-900 r.p.m., 2 h.p.-1 h.p.	
For operating on	
1-phase A.C. or D.C. 1-speed, 1800 r.p.m., 1 1/2 h.p.	

Note—These lathes can be supplied with hand feed only for the turret if desired. Write for information.

Designed for the efficient production of duplicate parts, the South Bend No. 2-H Turret Lathe has the precision for exacting close-tolerance operations, smooth power for producing a fine finish, and versatility that reduces set-up time to a minimum.

The universal carriage has 48 power cross-feeds, 48 power longitudinal feeds, and 48 thread cutting feeds ranging from 4 to 224 per inch. All changes are made through the quick change box at the headstock end of the lathe. Front and back tool blocks are supplied on the screw feed cross slide and a 4-way turret tool block is available to order. The large diameter micrometer graduated collar on the cross slide handwheel permits adjusting the cutting tools with extreme accuracy.

The ram-type turret has both power feed and hand feed, with an adjustable feed trip and stop for each of the six turret faces. The turret head indexes automatically on the return stroke of the turret slide. The quick change box provides 48 changes for power turret feeds. Change gears in the turret apron provide an additional change for turret power feed, independent of the universal carriage feeds in both rate of feed and direction of feed. Turret ram lock is provided.

Full advantage may be taken of the higher cutting speeds of tungsten carbide tools as the result of the wide range of speeds and feeds available. The use of a two-speed motor permits quick change from high speeds to low speeds for reaming and tapping operations.

Equipment included in the price of lathe consists of: universal carriage with screw feed double tool slide having front and rear square tool blocks; power feed ram-type turret; quick change box; oil pan; coolant return assembly; wrenches; and installation plan. Electrical equipment, handlever collet attachment, collet splash guard, coolant reservoir, coolant pump, splash pan, and piping are not included in price of lathe.

No. 2-H Turret Lathes with Power Feed Carriage and Turret

Catalog Number	Bed Length Feet	Cubic Feet Boxed	Boxed Weight Pounds	Crated Weight Pounds	Factory Price
CL2CT	6	115	3175	2810	\$3350
CL2DT	7	130	3300	2900	3413

Collet attachment, electrical equipment, splash pan, coolant reservoir, and pump shown in illustration are not included in price of lathe.



## here's an example of WELL PLANNED TOOLING

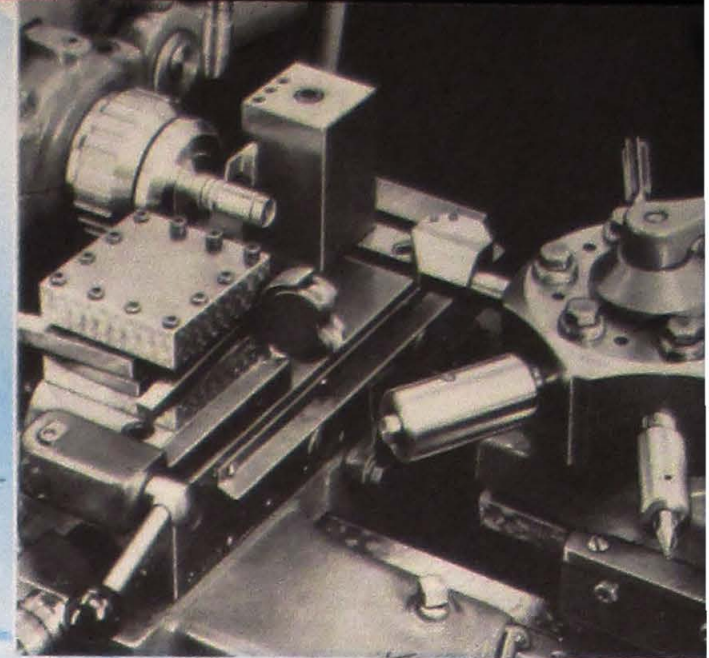
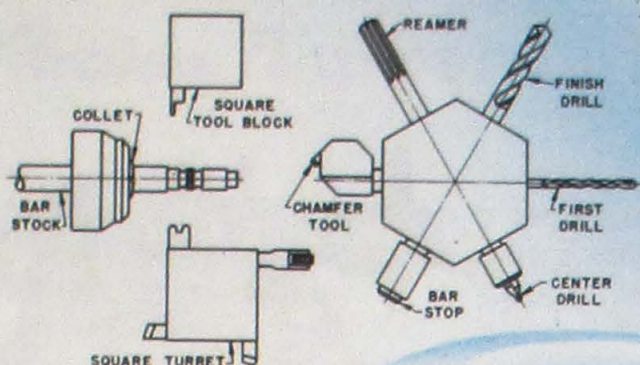


Illustrated  
ACTUAL SIZE

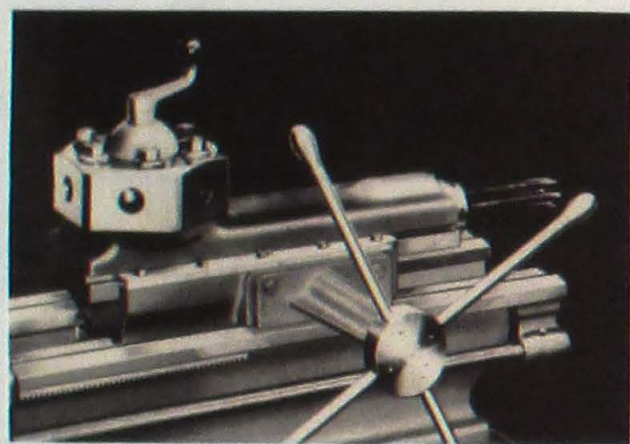
The problem was to produce a two-piece cigarette lighter case holding close tolerances to insure smooth wring fit of cap on base. Smooth finish was required all over. Illustrations show how a 10" South Bend Turret Lathe was used to solve the problem.

These attractive precision made pocket lighters were produced complete in less than two minutes per case including all operations on both upper and lower parts.

Produced primarily as a Turret Lathe demonstration item, we have samples of this lighter available for 50¢ each. On request we will furnish tooling information with each lighter. Send coin or stamps to: South Bend Lathe Works, Dept. 8, South Bend 22, Indiana.



**NEED EASY PAY  
PLAN?—Write for  
details on our 3 1/4%  
TIME PAYMENT PLAN**

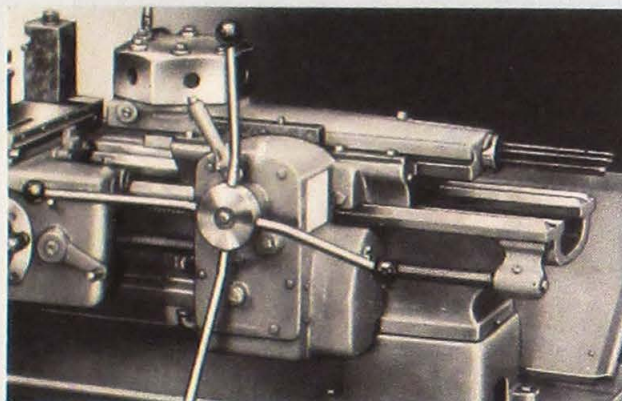


### Bed Turret for 16" Lathe

Mount on lathe bed in place of tailstock. Indexes automatically on return stroke of ram within plus or minus .0005" measured 4" from turret face. Has automatic feed stops for each turret face.

**CL1917H** Hand Feed Turnstile Bed Turret for 16" Lathe. Turret Tool Holes 1 1/2" diameter. Shipping Weight 505 lbs.

F.O.B. Price ..... **\$683**



### Bed Turrets for 13" Lathe

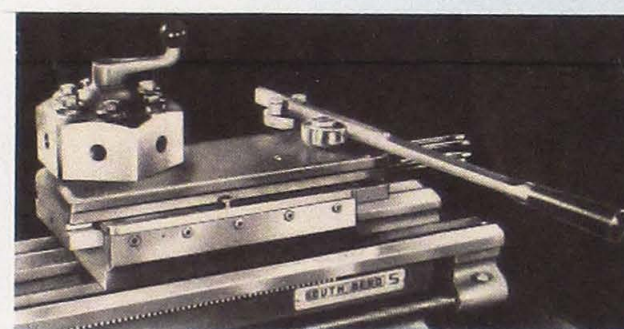
Choice of power and handfeed or turnstile handfeed only. Has feed trip and stop for each turret position. Effective feed of turret slide is 6 1/2". Turret head revolves on precision ball bearings and has 1" tool holes. Power feed model has 144 power turret feeds. Direction of feed can be reversed by changing gears in turret apron.

**CL1917T** Hand Feed Turnstile Bed Turret for 13" South Bend Lathe. Approx. Shipping Weight. 346 lbs.

F.O.B. Price ..... **\$495**

**CL2620T** Power Feed Turnstile Bed Turret for 13" South Bend Lathe. Approx. Shipping Weight 414 lbs.

F.O.B. Price ..... **\$698**

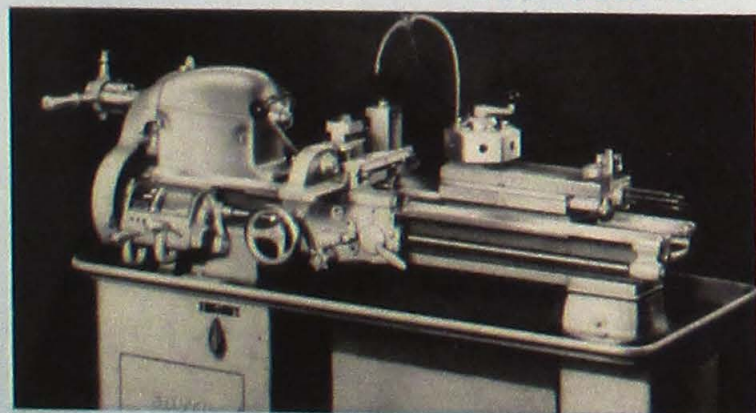


### Handlever Bed Turrets

These Handlever Bed Turrets mount on lathe in place of tailstock. Index automatically on return stroke within plus or minus .0005" measured 4" from turret face. Have effective slide feed of 4" with automatic feed stops for each turret position. Tool holes may be bored either 5/8" or 3/4".

F.O.B. Price for 9" Lathe —  
as low as ..... **\$273**

## Turret Lathe Conversion Units for All 9" and Light Ten South Bend Lathes



Any South Bend 9" or Light Ten Lathe can be supplied as a Turret Lathe with handlever bed turret and combination handlever or screw feed double tool cross slide in place of the regular tailstock and compound rest assemblies. Turret lathe conversion units must be specified *when the lathe is ordered*.

Conversion unit consists of handlever bed turret which mounts on inside bedways in place of tailstock and combination handlever and screw feed double tool cross slide mounted on the saddle cross slide dovetail in place of the compound rest assembly. Write for prices.



# New!

## South Bend 13" Precision Turret Lathe

### SPECIFICATIONS

#### CAPACITY OF LATHE

Hole through spindle.....1 3/8"  
Swing over double tool cross slide.....3 1/16"  
Swing over bed and saddle wings.....13 1/8"  
Spindle nose diameter and threads per inch.....2 1/4"-8  
Maximum collet capacity through handlever collet chuck.....1"

#### SPINDLE SPEEDS (standard spindle speeds with two-speed motor, approximate, not exact)

High spindle speeds  
r.p.m. of spindle, direct belt drive....940, 497, 270  
r.p.m. of spindle, back-gear drive....135, 71, 40  
Low spindle speeds (not available with 1-speed motor)  
r.p.m. of spindle, direct belt drive....470, 248, 135  
r.p.m. of spindle, back-gear drive....67, 35, 20

#### TURRET

Diameter of holes in turret faces.....1"  
Center of turret hole to top of turret slide.....1 1/2"  
Effective feed of turret slide.....6 1/2"  
Distance between opposite flats.....8"  
Maximum distance between spindle nose and turret face at beginning of indexing movement....6 ft. bed 35 5/8"

#### UNIVERSAL CARRIAGE

Thread cutting range.....4 to 224 per inch  
Power longitudinal feeds......0015" to .0841"  
Maximum longitudinal travel.....6 ft. bed 31 3/4"  
Power cross-feeds, 48......0006" to .0315"  
Cross travel of cross slide.....9 3/8"  
Tool block openings for cutter bits.....1 1/16" x 1/16"

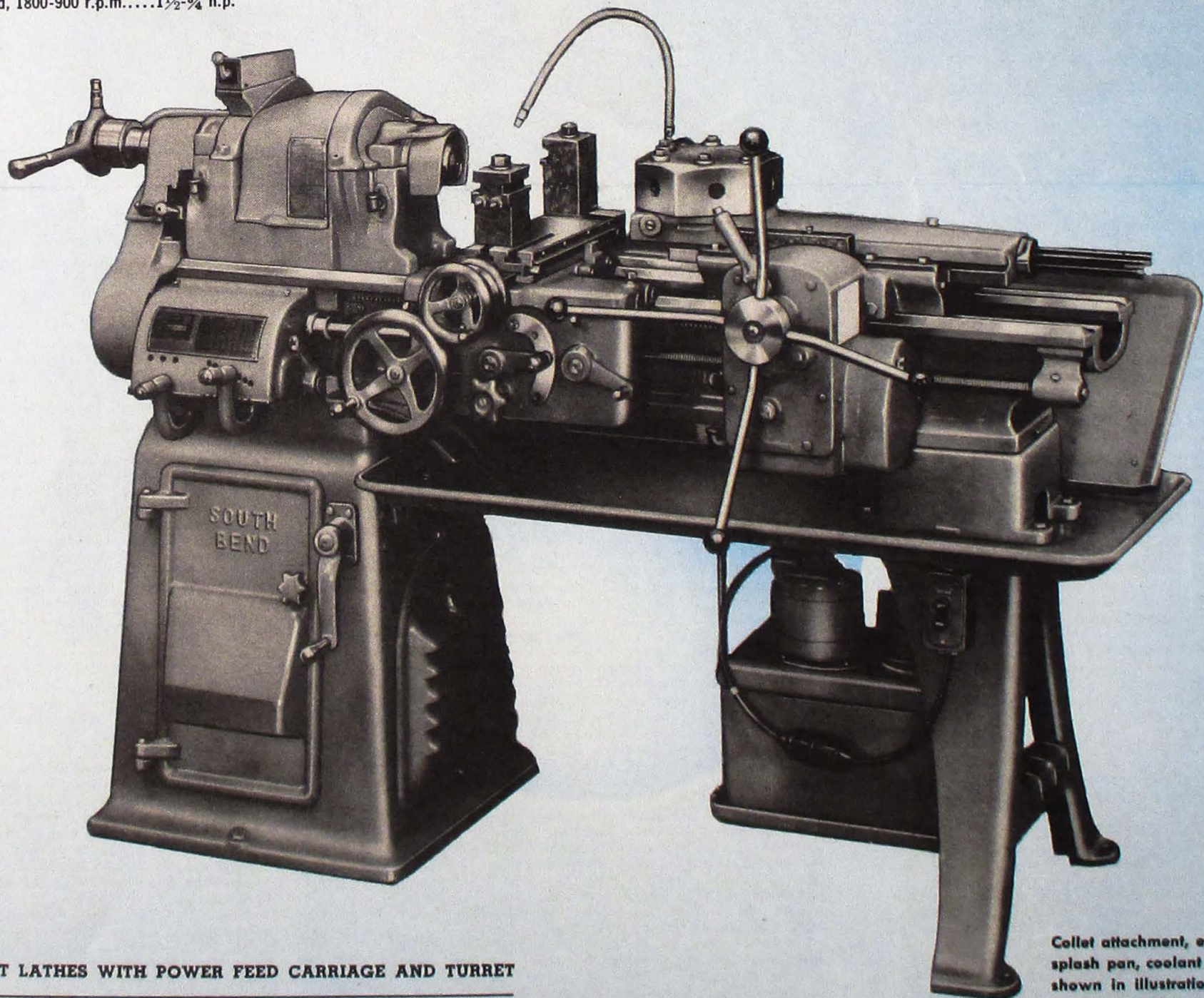
#### MOTOR

For operating on  
1-phase A.C. or D.C.—1-speed, 1800 r.p.m.....1 h.p.  
For operating on  
3-ph. A.C.—2-speed, 1800-900 r.p.m.....1 1/2-3/4 h.p.

The South Bend 13" Turret Lathe is a dependable tool for the manufacture of duplicate parts. It has the stamina for exacting close-tolerance work, ample power for smooth performance, and rigidity for producing a fine finish.

The turret head indexes and locks automatically when the turret slide is returned to the starting position. An individual feed trip and stop for each face of the turret accurately regulates the length of the cut with either the power feed or the hand feed. The turret head may be back-indexed or spun when it is desired to skip tool positions. Turret slide has tapered gibs on both sides which provide adjustment for wear and alignment. Power feeds for the turret slide are driven by lever operated friction clutch, permitting instant engagement and disengagement. Lever shift gears in turret apron provide three changes for fast, slow and intermediate feeds. The power feed is reversible to permit feeding the turret toward the headstock regardless of direction of universal carriage feed. A large turnstile operates the hand feed. Turret ram lock is provided.

Equipment includes: universal carriage; double tool slide; front and rear tool blocks; power feed turret; quick change box; oil pan; coolant return assembly; wrenches; and installation plan. Electrical equipment, handlever collet attachment, collet splash guard, coolant reservoir; coolant pump; splash pan and piping are not included in price.



Collet attachment, electrical equipment, splash pan, coolant reservoir and pump shown in illustration are not included in price of lathe.

13" TURRET LATHES WITH POWER FEED CARRIAGE AND TURRET

Catalog Number	Bed Length Feet	Cubic Feet Boxed	Boxed Weight Pounds	Crated Weight Pounds	Factory Price
CL1BT	5	88	1875	1570	\$2344
CL1CT	6	103	1950	1620	2397
CL1DT	7	117	2025	1670	2450

Note: These lathes can be supplied with hand feed turret if desired. Write for information.



## SPECIFICATIONS

### CAPACITY OF LATHE

Hole through spindle.....	1 1/2"
Swing over bed and saddle wings.....	10 1/2"
Width of lathe bed.....	7 1/2"
Spindle nose diameter and threads per inch.....	2 1/4"-8
Maximum collet capacity through handlever collet chuck.....	1"
Maximum capacity through universal lathe chuck.....	1 3/8"

### TURRET

Diameter of holes in turret faces.....	5/8"
Center of turret hole to top of turret slide.....	1 1/2"
Effective feed of turret slide.....	4"
Distance between opposite flats.....	4 1/2"
Maximum distance between spindle nose and turret face at beginning of indexing movement.....	19 1/2"

### SPINDLE SPEEDS (approximate, not exact)

	Direct Drive	Back-Geared
With one-speed motor		
High speeds, r.p.m.....	1400, 898, 585	250, 160, 105
Low speeds, r.p.m.....	740, 470, 304	130, 85, 55
With two-speed motor		
High speeds, r.p.m.....	1400, 898, 585	250, 160, 105
Low speeds, r.p.m.....	740, 470, 304	130, 85, 55
	700, 449, 292	125, 80, 52
	350, 224, 146	62, 40, 28

### UNIVERSAL CARRIAGE

Thread cutting range.....	4 to 224 per inch
Power longitudinal feeds.....	.0015" to .0836"
Maximum longitudinal travel of universal carriage, hand or power feed.....	16"

### DOUBLE TOOL CROSS SLIDE

Swing over double tool cross slide.....	3 1/2"
Cross travel of cross slide.....	3 1/2"
Maximum size cutter bit tool block opening will take.....	1/2" x 1/2"
Power cross-feeds.....	.0006" to .0303"

### COMPOUND REST CROSS SLIDE

Swing over compound cross slide.....	5 7/8"
Cross slide will travel.....	8 1/4"
Angular hand feed of top slide.....	2"
Size of tool holder shank for tool post.....	5/8" x 1 1/2"
Size of cutter bits tool holder takes.....	1/4" x 1/4"
Power cross-feeds.....	.0006" to .0303"

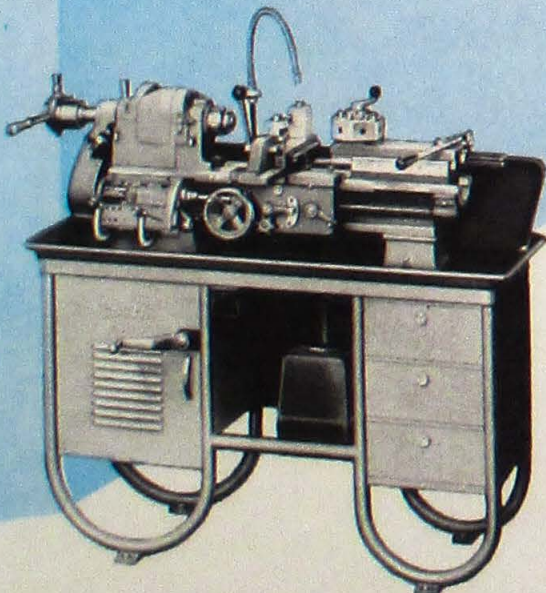
### MOTOR (Standard size)

One-speed.....	3/4 h.p.
Two-speed.....	1 1/2 h.p.

\*Can be supplied to order with 1/4" holes in turret head. No extra charge.

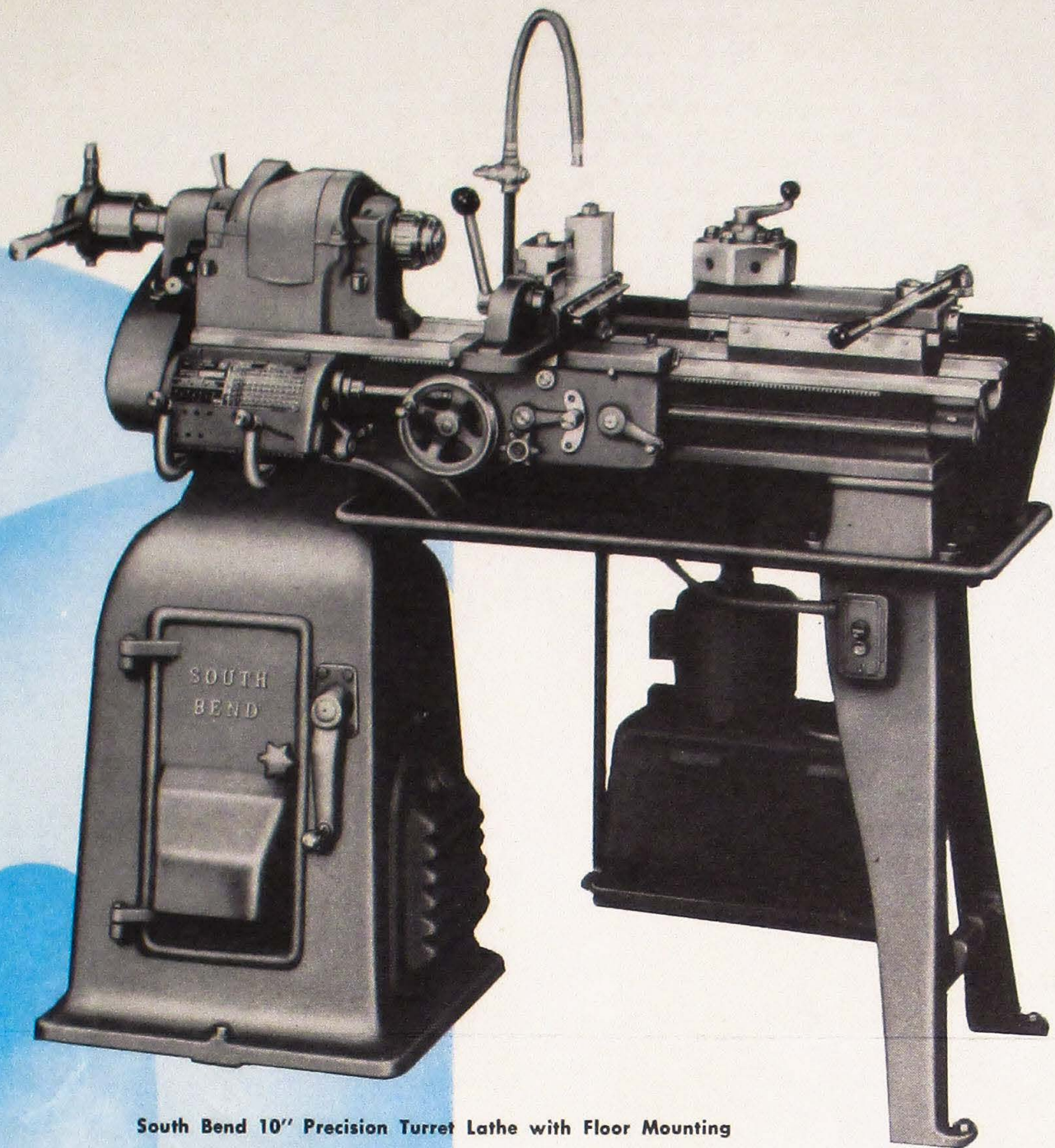
NOTE: Splash pan, tailstock, compound rest, centers, spindle sleeve, face plates, draw-in collet chuck attachment, lathe chuck, thread cutting stop, coolant equipment, and electrical equipment are not included in price of lathe.

South Bend 10" Turret Lathes are made with 3 1/2' bed length and with either bench or floor mounting, as illustrated. They are precision tools capable of fast, efficient production and are easily adaptable to a wide variety of work. There is no excessive weight in moving parts to slow down operation and cause fatigue. These lathes can be equipped with a one-speed motor or a two-speed motor to provide twelve or twenty-four spindle speeds as listed in the specifications.



South Bend 10" Bench Turret Lathe

## South Bend 10" Precision Turret Lathes



South Bend 10" Precision Turret Lathe with Floor Mounting

The turret is mounted on the inside bed ways and can be locked in position at any point along the length of the bed. The turret base can be placed close to the headstock to eliminate excessive overhang of the work or the turret tools. Turret head indexes automatically when the lever is moved to the extreme right, and has individual stops for each of the six turret faces. The turret head will index within plus or minus .0005", measured 4" from turret face and it may be back indexed or spun to skip tool positions. Turret ram slide can be locked for mounting work between centers if desired.

Equipped with front and rear tool blocks the handlever cross slide has adjustable stops which limit the movement of the cross-feed in either direction, in or out. The handlever can be removed and the cross-feed screw attached, permitting use of all power cross-feeds and longitudinal feeds with the double tool cross slide.

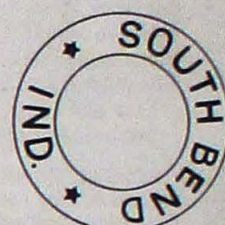
Equipment included in the price of turret lathe consists of: underneath motor drive unit (patented); universal carriage with combination handlever and screw feed double tool slide having front and rear square tool blocks; handlever bed turret; quick change box, oil pan; coolant return assembly; splash guards; wrenches; and installation plan. Bench turret lathes also include rigid tubular steel bench with 3 roomy drawers.

### SOUTH BEND 10" TURRET LATHES

Catalog Number	Type of Mounting	Cubic Feet Boxed	Boxed Weight Pounds	Crated Weight Pounds	Factory Price
CL1006Z	Floor	59	1350	1050	\$1601
CL1005Z	Bench	56	1250	950	1641



**SOUTH BEND LATHE WORKS**  
425 East Madison Street  
SOUTH BEND 22, INDIANA, U.S.A.



**BULK RATE**  
U.S. POSTAGE  
**PAID**  
Permit 176  
South Bend, Ind.

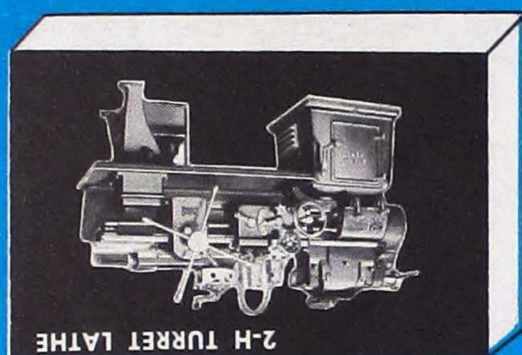
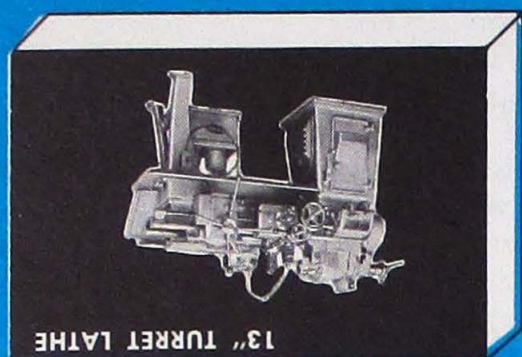
William F. Sievers Company  
160 Station  
Stoughton, Mass.

15

**BULLETIN 5624**

POSTMASTER: Form 3547 requested.

# Performers Star



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\*Columbus, Ohio, Reynolds Machinery Co.  
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\*Cumberland, Md., McKaig's—754  
\*Dallas, Tex., Nicholas & Parks Machinery Co.—RI 3246  
\*Danville, Ill., Danville Industrial Supply Co.—695  
\*Dayton, Ohio, C. H. Gosiger Machinery Co.—FU 5174  
\*Decatur, Ill., Miller Industrial Supply Company—8-3474  
\*Denver, Colo., M. L. Foss, Inc.—KE 5151  
\*Des Moines, Iowa, Iowa Machinery & Supply Co.—8-0123  
\*Detroit, Mich., Robt. F. Brown Machinery—Temple 2-3540  
\*Detroit, Mich., Lee Machinery Co.—LO 7-4257  
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Louisville, Ky., Neill-LaVielle Supply Co.—Calhoun 5401  
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Madeira Beach, Fla., Madeira Machine Co.—9-3901  
Memphis, Tenn., Lewis Supply Co.—5-6871  
\*Menominee, Mich., Christensen Machinery—5256  
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Milwaukee, Wis., W. A. Voell Machinery—GR 6-0990  
Mitchell, S. D., Mitchell Iron & Supply Company—2447  
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Montreal, Que., Can., Can. Fairbanks-Morse—UN 6-1451  
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Phoenix, Ariz., Wilson Machinery Corp.—AL 4-1711  
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\*Plainville, Conn., Ideal Machinery & Supply—SH 7-1651  
\*Portland, Ore., Star Machinery Co.—CA 8-7395  
\*Poughkeepsie, N. Y., Electra Supply Co.—2-3000  
\*Providence, R. I., Reynolds, Inc.—ST 1-3010  
Quebec, Que., Can., Canadian Fairbanks-Morse—2-1548  
\*Raleigh, N. C., Dillon Supply Co.—7-771  
\*Redwood City, Cal., Riley Precision Tool—Emerson 8-4184  
Regina, Sask., Can., Canadian Fairbanks-Morse—9-5491  
\*Richmond, Ind., Richmond Industrial Supply Co.—2-3013  
\*Richmond, Va., Smith-Courtney Co.—82-4581  
\*Roanoke, Va., Graves-Humphreys Hardware Co.—5551  
\*Rochester, N. Y., Ogden R. Adams, Inc.—Baker 6570  
\*Rockford, Ill., Factory Supplies Co.—4-6731  
\*Rocky Mount, N. C., Dillon Supply Co.—2-2163  
\*Saginaw, Mich., Saginaw Supply Corp.—5-3447  
\*St. John, N. B., Can., Canadian Fairbanks-Morse—3-3291  
\*St. Louis, Mo., Mill Supply & Machinery—Franklin 1-6810  
\*St. Paul, Minn., Anderson Machine Tool Co.—Prior 5831  
\*Salt Lake City, Utah., Salt Lake Hardware Co.—3-5771  
\*San Antonio, Tex., Alamo Iron Works—8-36161  
\*San Diego, Calif., Gould Hdwe. & Mch.—BEL 2-6174  
\*San Francisco, Calif., Riley Precision Tool  
Saskatoon, Sask., Can., Canadian Fairbanks-Morse—6195  
Savannah, Ga., Georgia Supply Co.—2-7131  
\*Scottsbluff, Neb., Herber Machinery Supply Co.—2306  
\*Scranton, Pa., The Charles B. Scott Co.—2-8221  
\*Seattle, Wash., Star Machinery Co.—Elliott 0760  
\*Sioux City, Iowa, Smith Elec. & Indus. Supply—8-0681  
\*South Bend, Ind., South Bend Lathe Works—CE 2-3311  
\*Spokane, Wash., Star Machinery Co.—RI 6121  
\*Springfield, Ill., Schlitt Supply Co.—8-4338  
\*Springfield, Mo., Industrial Equipment Corp.—4-1575  
\*Syacuse, N. Y., R. C. Neal Co.—75-9911  
Toronto, Ont., Can., Can. Fairbanks-Morse—EM 8-8321  
Toledo, Ohio, Reynolds Machinery Co.—LA 6043  
\*Tulsa, Okla., Krisman Industrial Supply Co.—DI 3-6213  
Tyler, Tex., Mason Machinery Co.—2-0911  
Utica, N. Y., Charles Millar & Son Co.—2-5121  
Vancouver, B. C., Can., Can. Fairbanks-Morse—Tatlow 0211  
Victoria, B. C., Can. Fairbanks-Morse—Garden 4171  
\*Washington, D. C., Carey Mch. & Sup.—DuPont 7-2204  
Waterloo, Iowa, Newkirk Sales Company—Adams 3-3549  
Watertown, N. Y., Thos. H. Bradley, Inc.—5400  
Wichita, Kan., Watkins, Inc.—Hobart 4-7301  
\*Williamsport, Pa., Lowry Electric Co.—2-7841  
\*Wilmington, Del., Holloway Brothers—3-5768  
Wilmington, N. C., Mill & Contractors Supply—7757  
Windsor, Ont., Can. Fairbanks-Morse—Clearwater 3-5293  
Winnipeg, Man., Can. Fairbanks-Morse—926-544  
\*Winston-Salem, N. C., Kester Machinery Co.—6181  
\*Wytheville, Va., R. P. Johnson Sons—670  
\*York, Pa., York Machinery & Supply Co.—29-531