

# LeBlond

**World's Largest Builder**

**of a Complete Line of Lathes**

**Madison and Edwards Roads**

**Cincinnati 8, Ohio**



BULLETIN C-58





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Throughout industry in America and abroad—in production, maintenance and toolroom work—you'll find LeBlond lathes doing a great job. For there's virtually no turning problem that can't be solved with utmost satisfaction on one of LeBlond's complete line of lathes.

Sound engineering with ingenuity is largely responsible for the superiority of LeBlond lathes. Among the advancements developed or pioneered by LeBlond are these: Free-running spur gear headstock design with the lowest no-load horsepower in the industry. Four-way Power Rapid Traverse. Hardened and ground replaceable steel bedways fitted to the compensating veeway principle for better distribution of cutting forces. Thrust-lock tailstock with full-length spindle support and convenient off-angle handwheel. Combined gear and belt-drive headstock for rugged low speeds and super-smooth high speeds. Double-wall, one-piece apron casting for precision under extreme loads. And many more refinements that add to the value and long trouble-free life of all LeBlond products.

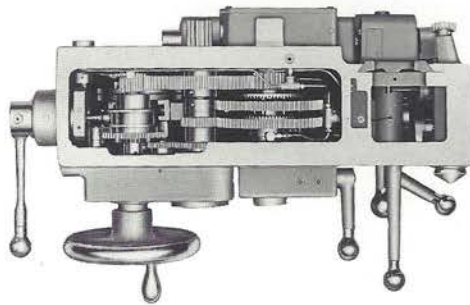
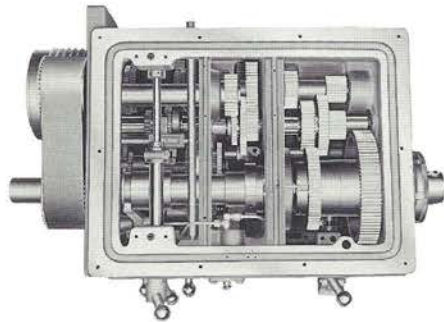
Seventy years of experience in designing and building lathes. Eleven acre plant that is one of the most modern in the industry. Research and engineering facilities to solve the toughest turning problems. A complete line of precision lathes. These are the reasons we can confidently say—with LeBlond, you can cut with confidence!

4-9	HEAVY DUTY ENGINE LATHES
10	ROLL TURNING LATHES
11	HYDRA-TRACE
12-13	RT TOOLROOM LATHE
14-15	STANDARD DUTY LATHES
16-17	SLIDING BED GAP LATHES
18-19	HOLLOW SPINDLE LATHES
20-21	RAPID PRODUCTION LATHES
22	CRANKSHAFT LATHES
23	LEBLOND-CARLSTEDT RAPID BORER
24-25	DUAL DRIVE LATHES
26-28	REGAL LATHES
29	REGAL PLAIN AND SLIDING BED GAP LATHES
30	DISTRIBUTORS

13", 16"

# Heavy Duty

Lathes



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## HEADSTOCK

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Combination gear-belt drive provides wide speed range; from low roughing range to high finishing speeds. Three spindle bearings—center bearing has adaptor to relieve high-speed potential excessive preload. Short heavy shafts minimize deflection, mounted on anti-friction bearings. Automatic forced feed lubricated.

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## ONE-PIECE APRON

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Apron construction assures accurate alignment under heavy strain. Four directional power rapid traverse and a positive-jaw feed clutch with a single lever for cross and length feed are incorporated. All bearings in the apron, cross slide and ways are lubricated by an automatic system. Chasing dial built integral with apron.

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## BED

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The bed is of heavy construction to provide the best lathe foundation for heavy duty jobs. The girths are scientifically designed to withstand extreme stress and strain. Cutting generates a greater downward force than outward force on the bedways. To compensate for the greater downward thrust, the front way is at a 20° angle to the carriage and has a greater width than thickness. This puts the bearing surface where it is needed most. As a result, bedways retain precision, have far better wearing qualities.

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## STANDARD EQUIPMENT

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Hardened and ground replaceable steel bed ways; Hardened and ground crossfeed screw with compensating nut; four directional power rapid traverse; Two cabinet legs; Small face plate; Compound rest with hinged dirt guard; No. 1 tool post assembly; Chasing dial; Single automatic length stop; Two speed tailstock; Drill sleeve with tang driver; Shear wipers; Centers and necessary wrenches; Arranged for motor drive.

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## EXTRA EQUIPMENT

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Hydra-Trace duplicating attachment; Taper attachment; Chip pan; Steady rest; Follow rest; Large face plate; Turret tool block; Pump, piping and tank; Connected rests; Plain block rests; Positive and automatic length stops; Single or multiple positive cross stops; Metric transposing gears.

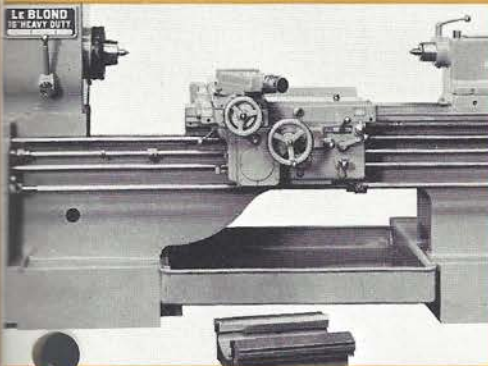
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## HEAVY DUTY GAP LATHES

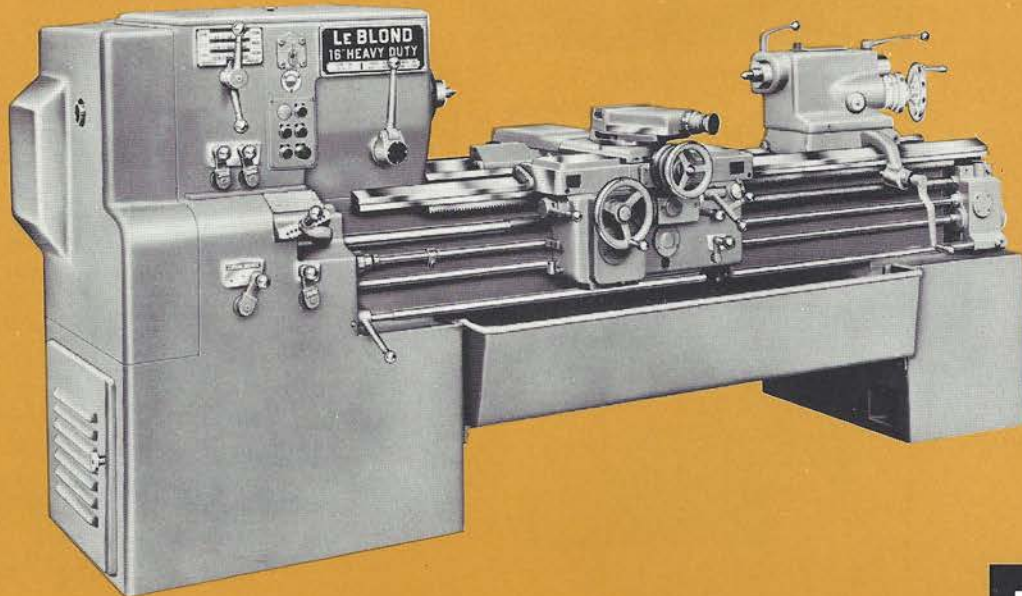
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LeBlond Gap Lathes are built in 12", 14", 16", 20", 25" and 32" sizes. With removable gap block, capacity may be greatly increased, work with unusual proportions or large diameter flanges accommodated easily.

73" H. D.  
NOT AVAILABLE  
AT PRESENT TIME



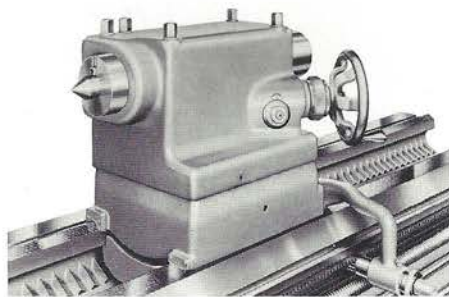
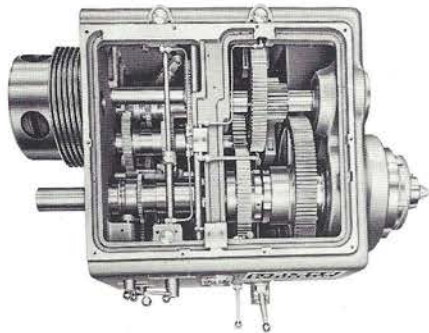
	13"	16"
<b>CAPACITY</b>		
Swing over bed and carriage wings	16"	20½"
Swing over compound rest	10"	12¾"
Distance between centers, base	30"	30"
Center distance increases in increments of	24"	24"
Size of forged tool	⅝" x 1¼"	⅝" x 1¼"
<b>HEADSTOCK</b>		
Spindle speeds, number	27	27
Spindle speeds, range	18 to 2250	16 to 2000
Spindle, size of center, Morse No.	4	4
Spindle nose, American Standard taper key	L-1	L-1
<b>BED</b>		
Length, base	7' 6"	7' 6"
Width across ways	15¾"	16¼"
Depth	13½"	14¾"
<b>CARRIAGE</b>		
Bearing surface, square inches	111	128
Bridge width	8"	9"
Cross slide travel	9¾"	11⅝"
<b>FEEDS—THREADS</b>		
Feed and thread changes	60	60
Feed, range	.0011 to .205	.0011 to .205
Threads per inch, range	2 to 120	2 to 120
Leadscrew diameter, threads per inch	1⅞", 4	1⅞", 4
<b>TAILSTOCK</b>		
Center, Morse No.	4	4
Spindle travel and set-over, right or left	10", 1"	11", 1"
<b>MOTOR RECOMMENDED</b>		
Maximum	15 hp 1800 rpm	20 hp 1800 rpm
Frame Size, N.E.M.A.	284U	286U
<b>WEIGHT</b>		
Net weight, lbs.	7000	7500
Floor space required	104" x 40"	109" x 47½"



20", 25", 32"

# Heavy Duty

Lathes



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## HEADSTOCK

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The headstock design of LeBlond Heavy Duty Lathes incorporates the free-running principle with hardened and ground steel gears in geometric progression. This means that fewer gears are in mesh at any given spindle speed to minimize no-load friction horsepower. You get more smooth power for your production work, longer life from your LeBlond Lathe.

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## TAILSTOCK

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LeBlond's unique tailstock design incorporates a rack and worm construction with positive lock against end thrust. The hand-wheel is convenient to the operator. Exceptionally long travel and full spindle support is provided even when completely extended. Other features include: two speed spindle travel; one-shot lubrication; tailstock mover; positive spindle clamping.

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## HARDENED AND GROUND STEEL BED WAYS

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Ways are hardened to 62-66 Rockwell C (600 Brinell) and contain lubricant in the form of free graphite to reduce friction and wear. They are fitted to conform to LeBlond's time-proven "compensating vee-way" principle. Design of tailstock locking rack prevents chip-clogging.

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## SPINDLE

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The spindle on the 20", 25" and 32" Heavy Duties is supported by five anti-friction bearings in three places; it maintains many times the rigidity of a two-bearing spindle. Weight drag is reduced, cutting pressure and wear decreased.

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## STANDARD EQUIPMENT

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Hardened and ground replaceable steel bed ways; 4-directional power rapid traverse; two-speed tailstock with mover; Small face plate; Compound rest; No. 2 tool post assembly; Chasing dial; Drill sleeve with tang driver; Centers and necessary wrenches; Machine arranged for motor drive.

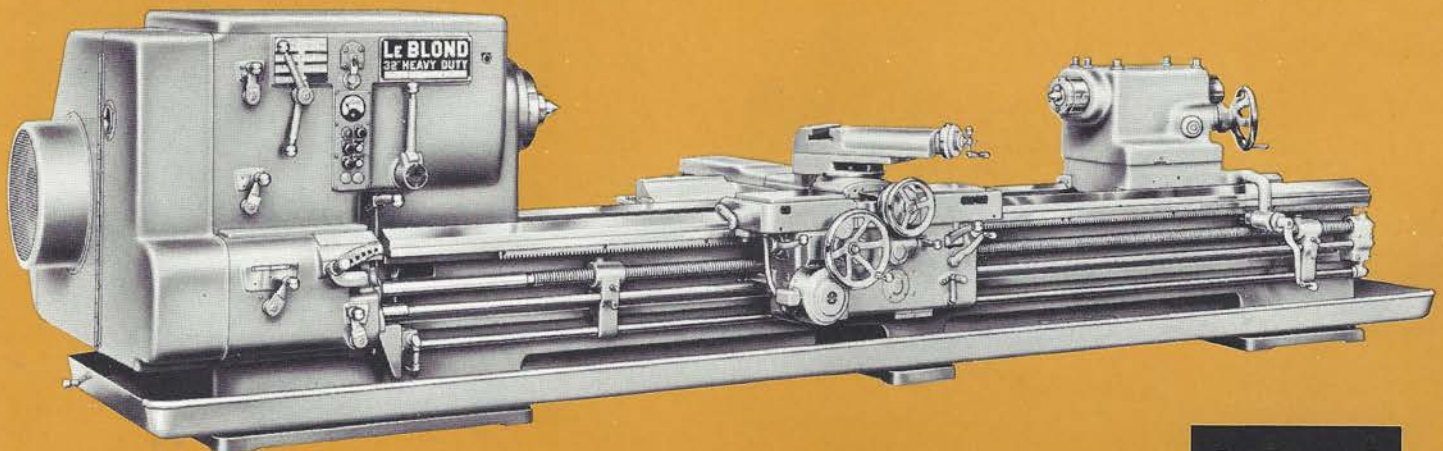
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## EXTRA EQUIPMENT

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Hydra-Trace hydraulic duplicating attachment; Taper attachment; Chip pan; Steady rests; Follow rest; Face plates; Turret tool post; Coolant system; Connected rests; Plain block rest; Positive and automatic length stops; Single or multiple positive cross stops; Profiling attachment; Coarse threading attachment; metric transposing gears; Anti-friction tailstock spindles; and many others.

	20"	25"	32"
<b>CAPACITY</b>			
Swing over bed and carriage wings	25"	30½"	34½"
Swing over compound rest	16"	19½"	23½"
Distance between centers, base	48"	48"	60"
Center distance increases in increments of	24"	24"	24"
Size of forged tool	¾" x 1½"	7⁄8" x 1¾"	1" x 2"
<b>HEADSTOCK</b>			
Spindle speeds, number	36	36	36
Spindle speeds, range	10 to 1300	5.5 to 625	4.5 to 500
Spindle, size of center, Morse No.	5	6	6
Spindle nose, American Standard taper key	L-2	L-3	L-3
<b>BED</b>			
Length, base	10' 3"	10' 9"	12' 7"
Width across ways	22¾"	267⁄8"	31"
Depth	17"	17½"	25¾"
<b>CARRIAGE</b>			
Bearing surface, square inches	227	335	415
Bridge width	10⅞"	12"	12⅞"
Cross slide travel	14"	17"	20½"
<b>FEEDS—THREADS</b>			
Feed and thread changes	60	48	48
Feed, range	.0047 to .2816	.004" to .250"	.004" to .250"
Threads per inch	1 to 60	¾ to 46	¾ to 46
Leadscrew diameter, threads per inch	1⅝", 2	2⅜", 2	2⅜", 2
<b>TAILSTOCK</b>			
Center, Morse No.	5	6	6
Spindle travel and set-over, right or left	13", 1"	15", ½"	17", ½"
<b>MOTOR RECOMMENDED</b>			
Maximum	40 hp, 1800 rpm	50 hp, 1800 rpm	60 hp, 1800 rpm
Frame Size, N.E.M.A.		405	405
<b>WEIGHT*</b>			
Net weight, lbs.	13,000*	17,900	22,700
Floor space required	140" x 57"	150" x 80¾"	150" x 87"
*Weight estimated			



**LeBlond**

40", 50"

# Heavy Duty

Lathes



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## HEADSTOCK

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A wide range of 27 spindle speeds are provided, including 18 which are periphery-driven. This makes possible a remarkably smooth, powerful drive. All gears are hardened and mounted on short, rugged splined shafts. All shafts run on tapered roller bearings; the spindle is mounted on four anti-friction bearings. Automatic lubrication system provides an abundance of oil to all moving parts.

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## QUICK-CHANGE BOX

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The oil-tight casting encloses all the gears in this automatically lubricated feed box. Provides 54 thread and feed changes in two ranges, easily and quickly set from a direct-reading index plate. All gears in box are steel, quadrant gear and all shafts mounted on anti-friction bearings. Leadscrew disengaging mechanism integral with box.

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## ONE-PIECE APRON WITH POWER RAPID TRAVERSE

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This apron is a double-wall, one-piece casting providing solid support of internal shafts. Built in chasing dial. Automatic lubrication to apron, carriage, cross slide, compound rest and bed ways. Cross and length feed interlocked with leadscrew to prevent simultaneous engagement. Apron handwheel is automatically disengaged when power rapid traverse is used. Six-way Power Rapid Traverse enables operator to move the apron and carriage easily for length travel, cross travel, in either direction simply by moving a single lever. Cross traverse may be diverted to the compound rest by a slip gear arrangement thus providing traverse to compound rest in either direction.

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## STANDARD EQUIPMENT

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Six-way power rapid traverse; Hardened and ground replaceable steel bed ways; Large face plate driven from center and periphery; Compound rest with power angular feed; No. 4 tool post assembly; Chasing dial; Drill sleeve; Two speed tailstock; Tailstock mover; Leadscrew supports; Shear wipers; Centers and necessary wrenches.

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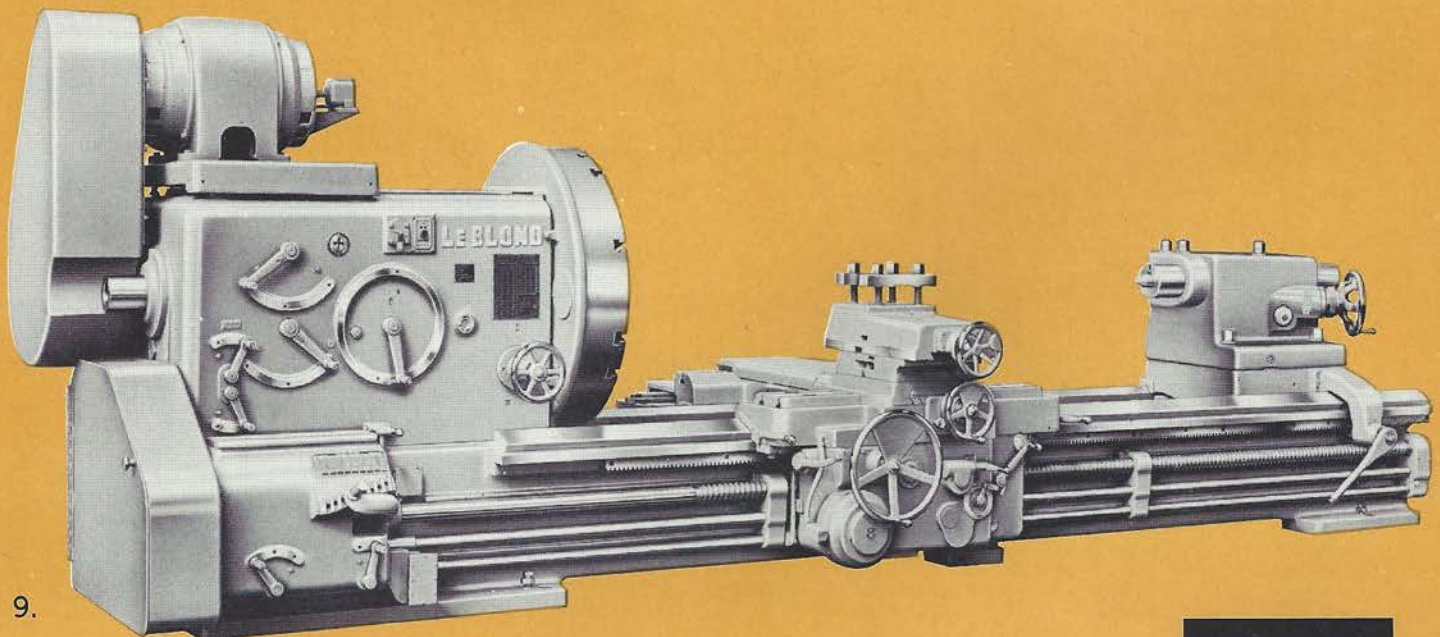
## EXTRA EQUIPMENT

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Taper attachment (regular or geared); Chip pan; Steady rests; Follow rests; Turret Tool post; Coolant system; Connected rests; Plain block rest; Positive and automatic length stops; Single or multiple positive cross stops; Coarse threading attachment, Metric transposing gears.



	40"	50"
<b>CAPACITY</b>		
Swing over bed and carriage wings	45"	52½"
Swing over compound rest	28½"	35½"
Distance between centers, base	60"	60"
Center distance increases in increments of	24"	24"
Size of forged tool	1¼" x 2¼"	1¼" x 2¼"
<b>HEADSTOCK</b>		
Spindle speeds, number	27	27
Spindle speeds, range	1.5 to 165	1.5 to 165
Range thru face plate periphery drive	1.5 to 32.8	1.5 to 32.8
Spindle, size of center, Morse No.	6	6
<b>BED</b>		
Length, base	14' 6"	14' 6"
Width across ways	42"	42"
Depth	23¼"	23¼"
<b>CARRIAGE</b>		
Bearing surface, square inches	575	575
Bridge width	18¾"	18¾"
Cross slide travel	27½"	27½"
<b>FEEDS—THREADS</b>		
Feed and thread changes	54	54
Feed, range	.005 to .308	.005 to .308
Threads per inch, range	½ to 30	½ to 30
Leadscrew diameter, threads per inch	2¾", 1	2¾", 1
<b>TAILSTOCK</b>		
Center, Morse No.	6	6
Spindle travel and set-over, right or left	20", 1"	20", 1"
<b>MOTOR RECOMMENDED</b>		
Maximum	50 hp 1800 rpm	50 hp 1800 rpm
<b>WEIGHT</b>		
Net weight, lbs.	42, 460	44, 460
Floor space required	200" x 85"	200" x 85"



25", 32", 40", 50"

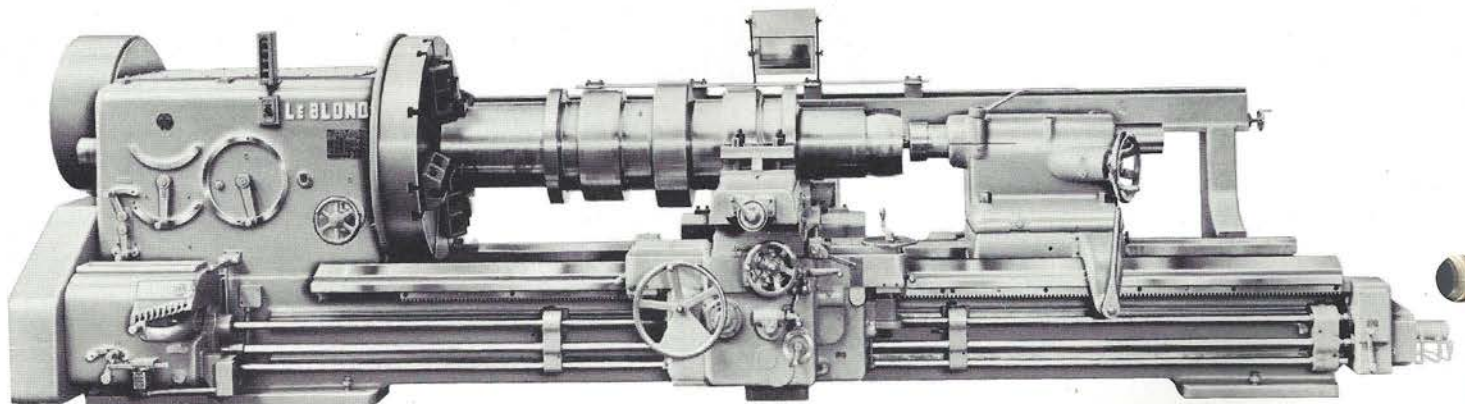
# Roll Turning

Lathes

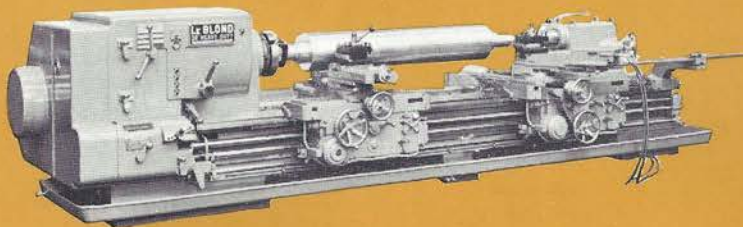
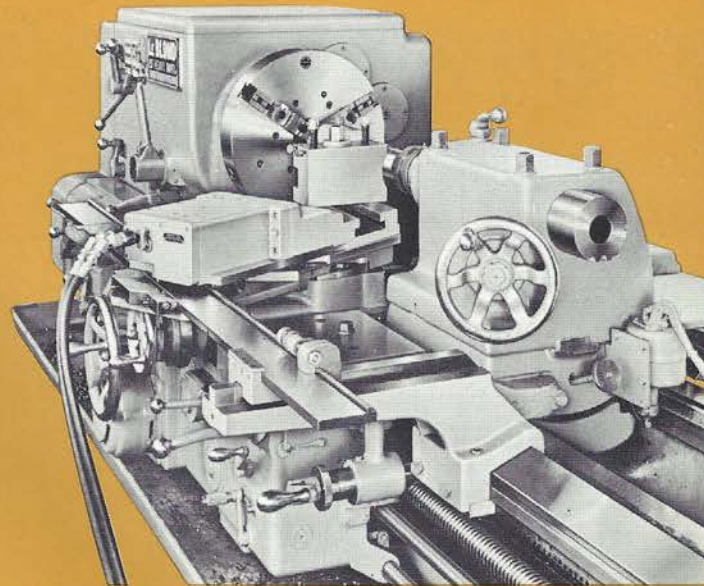


The LeBlond Roll Lathe is equipped with two-directional hydraulic tracing and is especially suited for contouring large rolls with complicated steep angle contours. Up to 80% operation time has been saved over the conventional methods of form turning. Four sizes are currently available which cover the broadest range for roll purposes. Tool motion, in both directions, is controlled hydraulically through a single valve actuated by a stylus following the contours of a flat template.

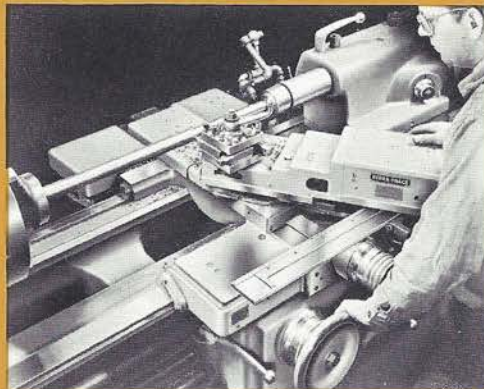
	25"	32"	40"	50"
Swing over the ways	30½"	34½"	44½"	52½"
Swing over the Compound Rest	18"	22"	28"	32"
Distance between centers (Minimum length)	48"	60"	60"	60"
Center distance increases in increments of	24"	24"	24"	24"
Bed Length Minimum	10' 7"	12' 7"	14' 6"	14' 6"



# Hydra-Trace



Printing roll journals are step machined by Hydra-Trace simultaneously with a second carriage straight turning the roll body. Production time for the journal roll operation is saved. This application of Hydra-Trace attachment in conjunction with a LeBlond 32" Heavy Duty Lathe demonstrates the production versatility available from LeBlond's complete line of lathes and lathe accessories.



Simply adding Hydra-Trace made a tracing lathe of this five-year-old 32" LeBlond Heavy Duty—at small cost. In this tracing-boring operation, bells for centrifugal pipe molds are machined internally with Hydra-Trace feeding 30° angle. Machining time 3 hours, one-third time required for hand-fed turning!

LeBlond Hydra-Trace duplicating attachment is a hydraulically operated tracing unit for turning contours on duplicate work pieces. Incorporating a hydraulic valve and cylinder-piston rod arrangement, the Hydra-Trace replaces the regular compound rest on your engine lathe. All controls and flat template are located in front for rigid set-up and convenient operation.

Because Hydra-Trace is an attachment, set-up is simple, quickly accomplished—creating more production time. Initial capital is small compared to special machines. In addition, you have the services and versatility of a regular engine lathe. When not in use, Hydra-Trace requires little storage space.

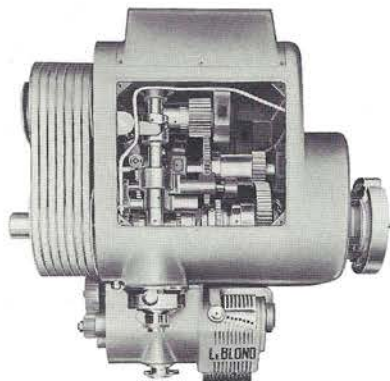
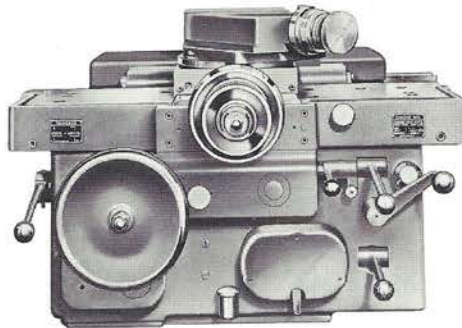
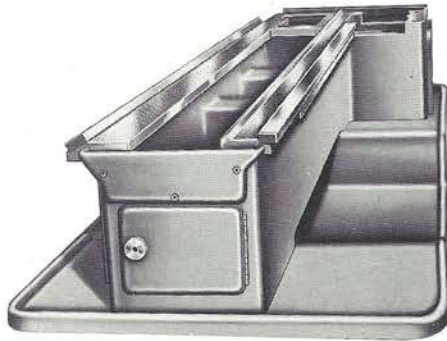
Available in three sizes, Hydra-Trace is applied successfully to hundreds of contour and step operations—from spherical joints to paper-roll journals; from spindles to axles. Its swiveling unit action increases the job variety tremendously. Wherever used, production has increased and turning costs have been minimized. Nearby there is a LeBlond representative who can save you money by applying a Hydra-Trace to your duplicating jobs.

Made of only five parts, the compact Hydra-Trace is easy to handle and convenient to mount on any Heavy Duty LeBlond engine lathe built since 1935—on all LeBlond engine lathes built since 1955.

16" RT

# Tool Room

Lathe



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## HARDENED STEEL BED WAYS

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The L-shaped bed supports the entire base of the headstock, and provides a firm foundation for carriage and tailstock. The bed ways are hardened and ground, test at 62-66 Rockwell C, retain lubricant and reduce friction, and are replaceable. Ways conform to the LeBlond compensating vee-way principle. Tool storage locker is contained in the tail end of the bed.

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## ONE-PIECE APRON

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This single-casting apron gives you rigidity for long-life precision turning. It encloses: 4-way power rapid traverse to length and cross slide; Positive jaw feed clutch for single-lever feed control; Spindle start, stop and reverse control; Graduated quick-set direct-reading dials on length and cross feed handwheels; Chasing dial integral with apron.

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## COMBINATION GEAR-BELT DRIVE HEADSTOCK

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The RT Toolroom lathe provides infinite speeds from 6 to 1500 rpm chosen by a single control unit. Speeds may be changed while cutting.

Spindle is mounted on two pair of preloading ballbearings. All other drive shafts mounted on ballbearings. Feed driving shafts run on anti-friction bearings. All main drive gears are hardened and ground.

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## STANDARD EQUIPMENT

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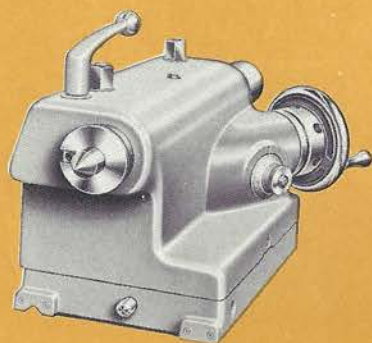
Four-way power rapid traverse; Hardened and ground replaceable steel bed ways; Chip pan; Cabinet legs; Small face plate; Graduated quick set dials; Compound rest; No. 1 tool post assembly; Single automatic length stop in both directions; Automatic chasing cross stop; Reverse to leadscrew at apron; Start-stop spindle control at apron; Universal quick-change box for American and diametral pitch threads, millimeter and module pitch leads and leads in inches, all listed on a drum-mounted plate; Drill sleeve with tang driver; Shear wipers; Centers and necessary wrenches; Machine arranged for motor drive but not including motor or control.

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## EXTRA EQUIPMENT

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Hydra-Trace hydraulic duplicating attachment; Plain and Geared taper equipment; Combined feed apron for cutting steep tapers; Steady rests; Follow rest; Large face plate; Turret tool post; Coolant system; Connected rests; Plain block rest; Multiple automatic length stops; Single or multiple positive cross stops. Spindle Reverse.



#### TAILSTOCK

LeBlond's unique tailstock design incorporates a rack and worm construction with positive safety lock against end thrust and puts the handwheel convenient to the operator. Exceptional long spindle travel and full support is provided even when completely extended. Brass shoes give positive spindle clamping. Two-speed arrangement for drilling is incorporated.

#### CAPACITY

Swing over bed and carriage wings	18½"
Swing over compound rest	11½"
Distance between centers, base	30"
Center distance increases in increments of	24"
Size of forged tool	⅝" x 1¼"

#### HEADSTOCK

Spindle speeds, number	Over 300
Spindle speeds, range	6 to 1500
Spindle, size of center, Morse No.	4
Spindle nose, American Standard taper key	L-1

#### BED

Length, base	7' 5"
Width across ways	17½"
Depth	13¼"

#### CARRIAGE

Bearing surface, square inches	110
Bridge width	8"
Cross slide travel	12½"

#### FEEDS-THREADS

Feed and thread changes	90
Feed, range	.0007" to 2.064"
Threads per inch, range	¼ to 120
Leadscrew diameter, threads per inch	1⅞", 4

#### TAILSTOCK

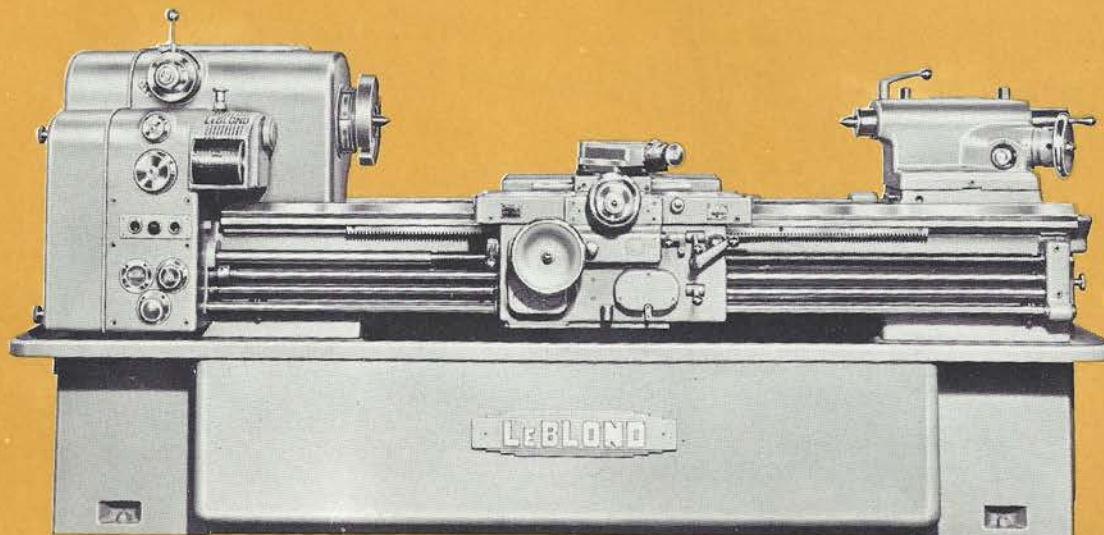
Center, Morse No.	4
Spindle travel and set-over, right or left	11", ½"

#### MOTOR RECOMMENDED

Maximum	7½ 690/2760 rpm
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#### WEIGHT

Net weight, lbs.	8400
Floor space required	96" x 48"



20", 25", 32", 40"

# Standard Duty

Lathes

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## STANDARD EQUIPMENT

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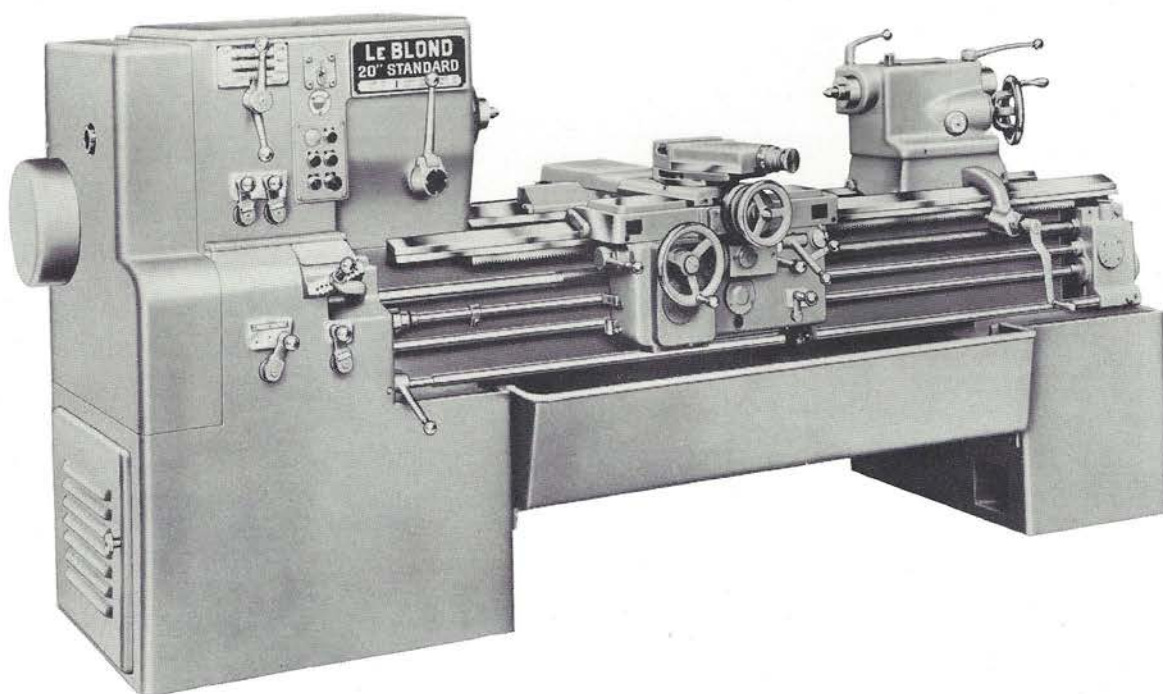
Hardened and ground replaceable steel bed ways, 4-directional power rapid traverse; Two speed tailstock with mover; Small face plate; Compound rest; Tool post assembly; Chasing Dial (built integral with apron); Drill sleeve with tang driver; Centers and necessary wrenches; Machine arranged for motor or electrical equipment.

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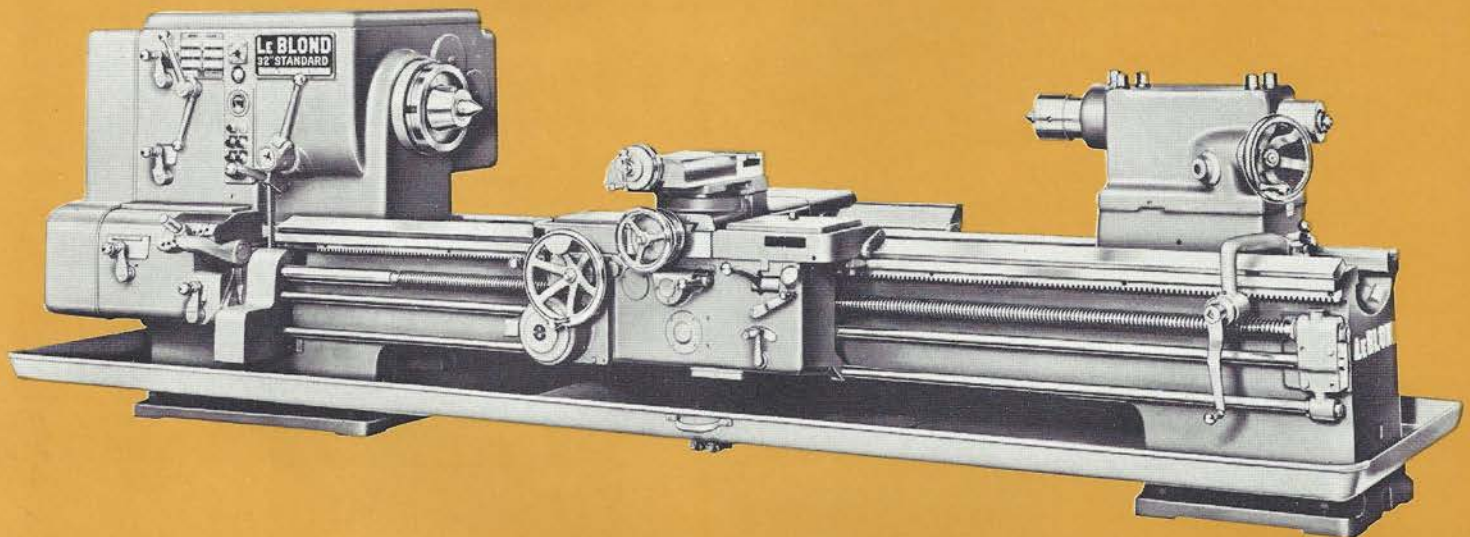
## EXTRA EQUIPMENT

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Hydra-Trace duplicating attachment; Taper attachment; Chip pan; Steady rest; Follow rest; Face plates; Turret tool post; Pump, piping and tank; Connected rests; Plain block rests; Positive and automatic length stops; Single or multiple positive cross stops; Metric transposing gears.



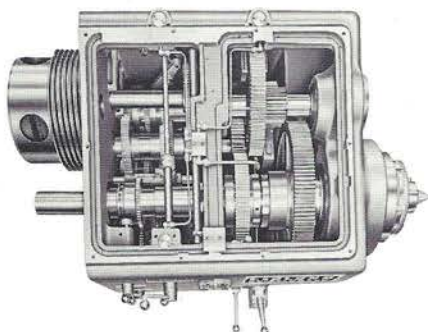
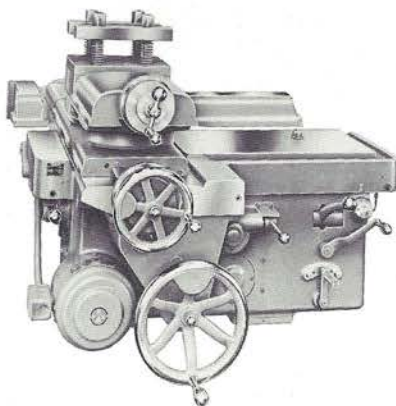
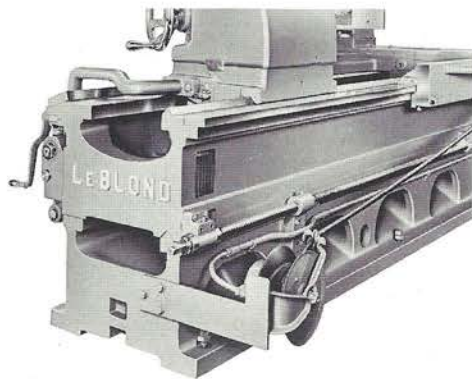
	20"	25"	32"	40"
<b>CAPACITY</b>				
Swing over bed and carriage wings	22½"	28¾"	33½"	40½"
Swing over compound rest	15¾"	20"	24"	29½"
Distance between centers, base	54"	48"	48"	60"
Center distance increases in increments of	24"	24"	24"	24"
Size of forged tool	⅝" x 1¼"	¾" x 1½"	⅞" x 1¾"	1" x 2"
<b>HEADSTOCK</b>				
Spindle speeds, number	27	36	36	36
Spindle speeds, range	16 to 2000 rpm	10 to 1300 rpm	5.5 to 625	4.5 to 500
Spindle, size of center, Morse No.	4	5	6	6
Spindle nose, American Standard taper key	L-2	L-2	L-3	L-3
<b>BED</b>				
Length, base	7' 6"	10' 3"	10' 9"	12' 7"
Width across ways	16½"	22¾"	26¾"	31"
Depth	14¾"	17"	17½"	25¾"
<b>CARRIAGE</b>				
Bearing surface, square inches	128	227	335	415
Bridge width	9"	10⅞"	12"	12⅞"
Cross slide travel	11⅞"	14"	14½"	18⅞"
<b>FEEDS—THREADS</b>				
Feed and thread changes	60	60	48	48
Feed, range	.0011 to .205	.0047 to .2816	.004 to .250	.004 to .250
Threads per inch, range	2 to 120	1 to 60	¼ to 46	¼ to 46
Leadscrew diameter, threads per inch	1⅞", 4	1⅞", 2	2⅜", 2	2⅜", 2
<b>TAILSTOCK</b>				
Center, Morse No.	4	5	6	6
Spindle travel and set-over, right or left	11", 1"	13", 1"	15", 1"	17", 1"
<b>MOTOR RECOMMENDED</b>				
Maximum	20 hp 1800 rpm	40 hp 1800 rpm	40 hp 1800 rpm	50 hp 1800 rpm
Frame Size, N.E.M.A.	286U	404	404	405
<b>WEIGHT</b>				
Net weight, lbs.	8650	11,500	18,500	26,000
Floor space required	133" x 47½"	140" x 57"	150" x 84⅞"	150" x 87"



16/38", 25/50", 32/60"

# Sliding Bed Gap

Lathes



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## SLIDING BED

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The two perfectly aligned sections of the sliding bed are of heavy construction, with scientifically designed girths. The top bed is movable by means of a heavy coarse pitch screw. The ways on the upper bed are replaceable, hardened and ground steel. The lower bed designed on the 25/50" and 32/60" with special chip chutes; a chip pan is provided on the 16/38".

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## APRON & CARRIAGE

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A special cross slide is provided to bring the cutting tool to the outer edge of the gap. The apron is of the one-piece, double wall type that maintains rigidity and accuracy indefinitely. The length handwheel shaft is extended to clear large work in the gap.

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## HEADSTOCK 25 & 32

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This headstock design incorporates the free-running principle with hardened and ground steel gears. This means that fewer gears are in mesh at any given spindle speed to minimize no-load friction horsepower. You get more smooth power for your production work, longer life from your LeBlond lathe. The spindle is mounted on four anti-friction bearings for maximum rigidity, accuracy. See page 4 for description of 16/38" headstock.

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## STANDARD EQUIPMENT

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Four-way rapid traverse; Hardened and ground steel bed-ways front and rear on upper bed; Large and small face plates; Compound rest; Two-speed tailstock; No. 4 tool post; Chasing dial; Screw support jacks; Centers and necessary wrenches.

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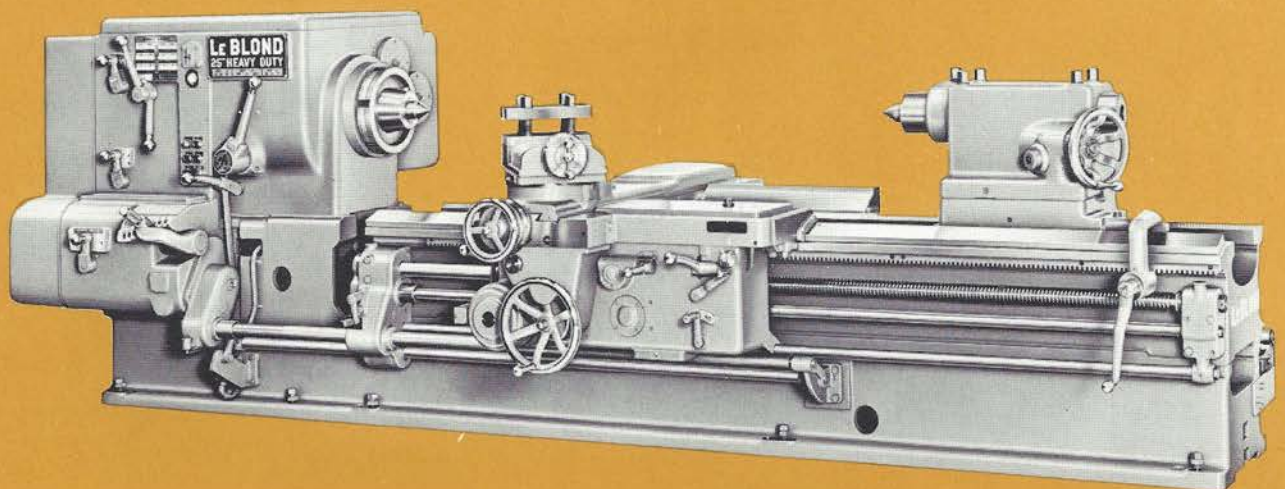
## EXTRA EQUIPMENT

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Taper attachment; Follow rest; Hydra-Trace; Steady rests; Face plate jaws; Chip pan; Pump and piping; Plain block rest; Connected rests; Positive and automatic length stops; Single positive cross stop; Metric transposing gears; Special extension rest and many others.



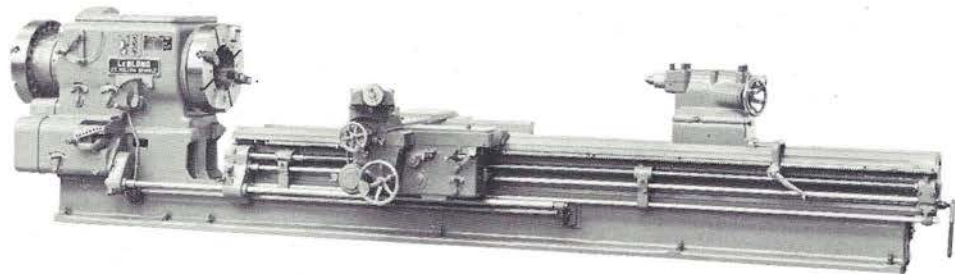
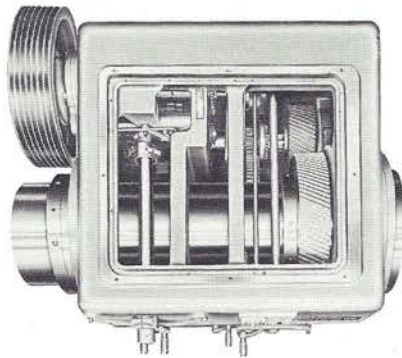
	16/38"	25/50"	32/60"
<b>CAPACITY</b>			
Swing over bed and carriage wings	20½"	30½"	34½"
Swing over compound rest	12⅞"	19½"	23½"
Swing over gap	46"	56"	61½"
Distance between centers, base, gap closed	72"	96"	84"
Distance between centers, base, gap open	120"	156"	144"
Center distance increases in increments of	24"	24"	24"
Size of forged tool	⅝" x 1¼"	⅞" x 1¾"	1" x 2"
<b>HEADSTOCK</b>			
Spindle speeds, number	27	36	36
Spindle speeds, range	16 to 2000	5.5 to 625	4.5 to 500
Spindle, size of center, Morse No.	4	6	6
Spindle nose, American Standard taper key	L-2	L-3	L-3
<b>BED</b>			
Length, base	10' 11"	14' 7"	14' 7"
Width across ways	16½⅞"	26⅞"	32"
Depth, top bed	14⅞"	14¼"	14¼"
<b>CARRIAGE</b>			
Bearing surface, square inches	140	335	415
Bridge width	9"	12⅞"	13⅞"
Cross slide travel	20"	26½"	30½"
<b>FEEDS—THREADS</b>			
Feed and thread changes	60	48	48
Feed, range.	.0011 to .205	.004 to .250	.004 to .250
Threads per inch, range	2 to 120	¼ to 46	¼ to 46
Leadscrew diameter, threads per inch	1⅞", 4	2⅞", 2	2⅞", 2
<b>TAILSTOCK</b>			
Center, Morse No.	4	6	6
Spindle travel and set-over, right or left	11", 1"	15", 1"	17", ½"
<b>MOTOR RECOMMENDED</b>			
Maximum	20 hp 1800 rpm	50 hp 1800 rpm	60 hp 1800 rpm
<b>WEIGHT</b>			
Net weight, lbs.	10,400	22,300	32,300
Floor space required, gap closed	6' 2" x 13'	7' 6" x 19' 6"	8' 5" x 19'
Floor space required, gap open	6' 2" x 17'	7' 6" x 24' 6"	8' 5" x 25'



16", 20", 27", 30"

# Hollow Spindle

Lathes



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## HOLLOW SPINDLE

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Used extensively in the oil country, in the steel industry and many others where a large opening in the spindle is required. Opening ranges in size from 5¼" for the 16" lathe to 12¾" for the 30" lathe.

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## HEADSTOCK

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Hollow spindle headstocks are designed to give rugged yet smooth service. An electric brake on the 16" and 20" stops the spindle smoothly in a matter of seconds, reducing time required to make adjustments. A mechanical clutch and brake are provided on the 27" and 30". All gears operate in filtered oil and slide on splined shafts mounted in anti-friction bearings. All high-speed gears are hardened and ground.

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## STANDARD EQUIPMENT

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Hardened and ground replaceable steel bed ways, front and rear; 4-directional power rapid traverse (extra on 20" lathes); Compound rest; No. 2 Tool post assembly; Chasing dial; Tailstock center; Shear wipers; Necessary wrenches; Machine arranged for motor drive but not including motor or electrical equipment.

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## EXTRA EQUIPMENT

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Chuck; Adapter and center; Hydra-Trace hydraulic duplicating attachment; Taper attachment; Follow rest; Steady rests; Chip pan; Coolant system; Turret tool post; Connected rests; Plain block rest; Positive and automatic length stops; Single or multiple positive cross stops; Coarse threading attachment; Metric transposing gears and many others. Carriage rapid traverse on 20" lathes.

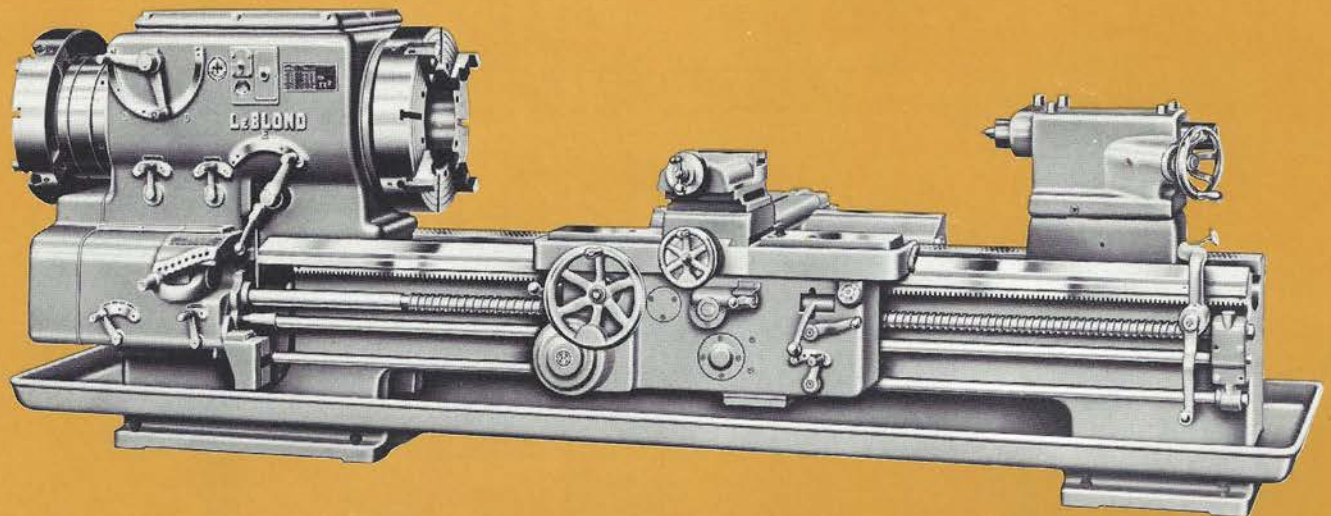
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## 27/50 SBG HOLLOW SPINDLE

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LeBlond also manufactures a 27/50 Sliding Bed Gap Hollow Spindle Lathe. This lathe is extremely versatile for turning all types of work. Write for complete information.

	16"	20"	27"	30"
<b>CAPACITY</b>				
Swing over bed and carriage wings	20½"	27"	33½"	38½"
Swing over compound rest	13½"	18¾"	23"	25½"
Distance between centers, base	30"	48"	48"	60"
Center distance increases in increments of	24"	24"	24"	24"
Size of forged tool	⅝" x 1¼"	¾" x 1½"	⅞" x 1¾"	1" x 2"
<b>HEADSTOCK</b>				
Spindle speeds, number	24	18	12	12
Spindle speeds, range	14 to 870	10 to 362	5 to 213	5 to 213
Spindle, size of center, Morse No.	4	5	6	
Spindle nose, flange type	8"	15"	17¾"	17¾"
Spindle, size of center	5¼"	9"	12⅝"	12⅝"
<b>BED</b>				
Length, base	7' 3"	9' 2"	10' 7"	12' 7"
Width across ways	17"	21¼"	26⅞"	31"
Depth	13"	15⅝"	22"	22⅝"
<b>CARRIAGE</b>				
Bearing surface, square inches	127	224	314	394
Bridge width	9"	9⅞"	12"	12⅞"
Cross slide travel	11⅞"	14½"	17¾"	18¼"
<b>FEEDS—THREADS</b>				
Feed and thread changes	60	60	48	48
Feed, range	.0011" to .205"	.004" to .250"	.004" to .250"	.004" to .250"
Threads per inch, range	2 to 120	1 to 60	¼ to 46	¼ to 46
Leadscrew diameter, threads per inch	1⅞", 4	1⅞", 2	2⅜", 2	2⅜", 2
<b>TAILSTOCK</b>				
Center, Morse No.	4	5	6	6
Spindle travel and set-over, right or left	11", 1"	12", 1"	12", ½"	17", ½"
<b>MOTOR RECOMMENDED</b>				
Maximum	10 hp 1200 rpm	20 hp 1200 rpm	25 hp 1800 rpm	30 hp 1800 rpm
Frame Size, N.E.M.A.	326	365	364	365
<b>WEIGHT</b>				
Net weight, lbs.	6900	8150	13,700	21,700
Floor space required	109" x 32¼"	130" x 67"	155½" x 86"	174⅞" x 98"



13", 17", 20"

# Rapid Production

Lathes

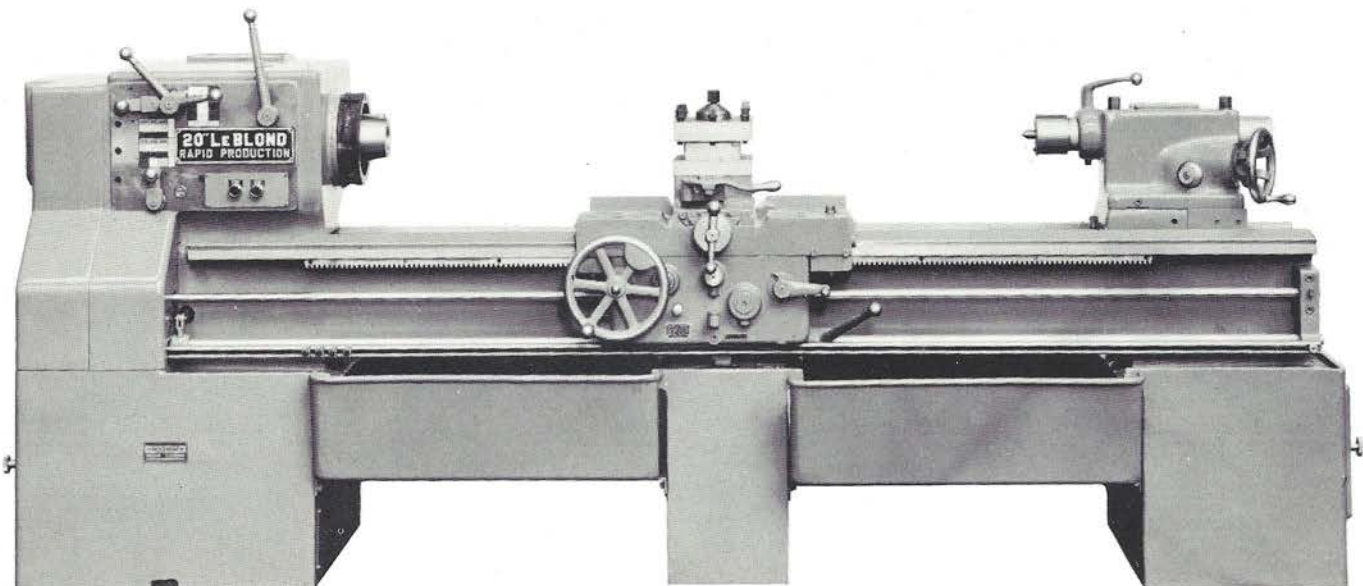
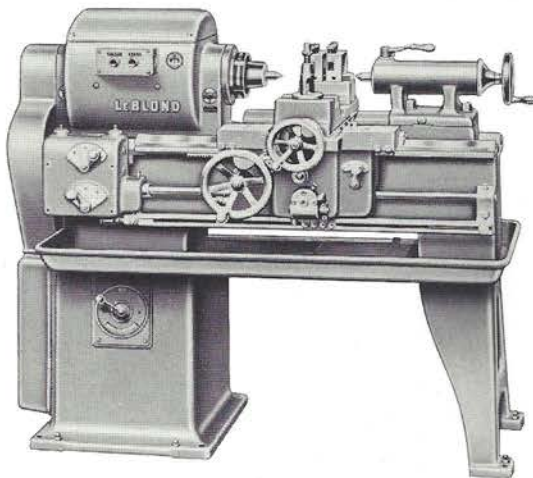
The LeBlond Rapid Lathe has been designed from the ground up specifically for manufacturing assignments. They are not stripped down engine lathes. They are fundamentally simple and rugged, and will perform dependably for many years. Design your own manufacturing lathes with the features and attachments you want. No extras to buy, only what you really need to do your job. These lathes give you your maximum production capacity per dollar invested.

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## RP FEATURES

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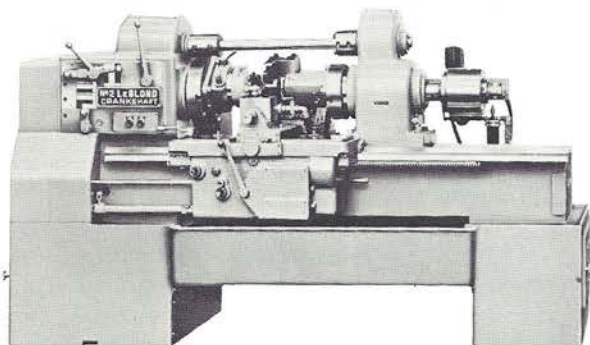
Hardened and ground steel bed ways.  
American Standard Taper spindle nose.  
Geared headstocks automatically lubricated.  
Feed box totally-enclosed, automatically lubricated.  
One-piece double wall apron; positive jaw clutch.  
Heavy duty carriage, maximum bearing surface rigidity.  
Standard equipment includes: Small face plate, plain block rest, No. 1 tool post assembly, multiple automatic length stops, centers and necessary wrenches.  
A complete range of useful attachments is available.



	13''	17''	20''
<b>CAPACITY</b>			
Swing over ways	14 $\frac{7}{8}$ ''	17 $\frac{1}{4}$ ''	20 $\frac{1}{4}$ ''
Swing over compound rest	8 $\frac{3}{8}$ ''	10 $\frac{1}{2}$ ''	12 $\frac{1}{8}$ ''
Distance between centers	12 $\frac{1}{2}$ ''	17''	27 $\frac{1}{2}$ ''
Size of tool	$\frac{1}{2}$ '' x 1''	$\frac{5}{8}$ '' x 1 $\frac{1}{4}$ ''	$\frac{3}{4}$ '' x 1 $\frac{1}{2}$ ''
<b>HEADSTOCK</b>			
Spindle speeds, No.	8	8	8
Spindle speeds, standard range, rpm	68 to 400	70 to 700	57 to 600
Spindle speeds, high range, rpm	102 to 600	105 to 1050	85 to 900
Motor headstock (13'' lathe only)			
Spindle speeds, selection, single speed, in hundreds	9, 18, or 36		
Spindle speeds, selection, two-speed, in hundreds	6, 12, or 9, 18 or 18, 36		
Spindle speeds, selection, four-speed, in hundreds	4.5, 9, 18, 36 or 6, 9, 12, 18		
Spindle, size of center, Morse No.	3	4	5
Spindle nose, new standard taper key drive, size	L-0	L-1	L-2
<b>BED</b>			
Length, base (5' 0'' with motor head 13'' only)	4' 0''	5' 0''	6' 7''
Width	11 $\frac{1}{2}$ ''	14 $\frac{3}{8}$ ''	17''
Depth	14 $\frac{3}{8}$ ''	11 $\frac{1}{4}$ ''	13''
<b>CARRIAGE</b>			
Bearing surface, square inches	54 $\frac{5}{8}$ ''	74''	101 $\frac{1}{2}$ ''
Bridge width	6''	7 $\frac{3}{8}$ ''	8 $\frac{1}{2}$ ''
Cross slide travel	8 $\frac{7}{8}$ ''	9 $\frac{1}{2}$ ''	11 $\frac{1}{2}$ ''
<b>FEEDS</b>			
Number, change gear and lever shift	9	18	18
Number, lever shift		9	9
Range, ipr:		.002 to .160	.004 to .240
Feeds, range, motor headstock (13'')	.001'' to .010'' or .002'' to .020''		
<b>TAILSTOCK</b>			
Spindle size of center, Morse No.	3	4	5
Spindle travel	4 $\frac{1}{2}$ ''	10''	11''
<b>MOTOR RECOMMENDED</b>			
Standard spindle speeds	3 or 5 hp 1800 rpm	10 hp, 1800 rpm	15 hp, 1800 rpm
High spindle speeds Motor headstocks (13'')	5 hp, 1800 rpm 5 hp	15 hp, 1800 rpm	20 hp, 1800 rpm
<b>WEIGHT*—FLOOR SPACE</b>			
Net, lbs.	1615	4200	5250
Net, lbs., motor head	1780		
Floor space required (w/o taper att.)			
13'' with motor head	77'' x 41''	88'' x 36''	93'' x 47''
*All weights estimated			

# Crankshaft

Lathes



## LEBLOND NO. 2 CRANKSHAFT LATHE

A combination Automatic lathe and Universal Crankshaft lathe all in one productive unit. Designed for pin turning on small cranks as used in air compressors, refrigerators, out-board motors, other small engines, etc. Complete automatic cycle for each pin. This lathe is a double-end drive crankshaft forming machine designed to handle crankshafts up to six throws.

## COMPLETELY MECHANIZED CRANKSHAFT LATHES

55 crankshafts per hour are now being turned out by the latest equipment developed. LeBlond Crankshaft Lathes with automatic loaders and modern conveying systems make it possible to obtain high rates of production at all times. Investigate the automatic equipment with push button control by calling your LeBlond Distributor.

LeBlond has pioneered the development of modern crank-turning since 1905. LeBlond manufactures lathes for roughing and finishing all elements of any crank—small air compressor types, automotive and aircraft crankshafts. LeBlond has the right machine for your job.



# Rapid Borer

## RAPID BORER

With the new LeBlond-Carlstedt Rapid Borer, you can bore, trepan, or counterbore holes 3 to 8 times faster than by the conventional D-bit method!

The Rapid Borer was developed expressly to accommodate revolutionary new tooling which cuts at very high speed with excellent accuracy and finish. Cutting oil is forced between the boring bar and hole wall forming a continuous bearing. It flushes back through a hole in the boring head and bar, carrying away the chips as it goes. Chip form is controlled both by tool angles and proper feed and speed combinations; thus tool faces are kept clean and chip passage clear. Cutter design produces balanced cutting pressures thereby controlling concentricity.

Basically, the Rapid Borer is suited to work that is symmetrical for balance in rotation—round, square, octagonal, tapered or stepped. A wide variety of hole diameters and depths as well as work sizes can be accommodated.

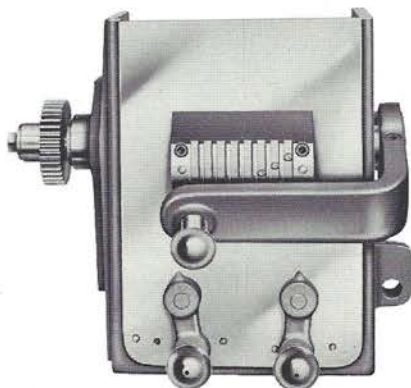
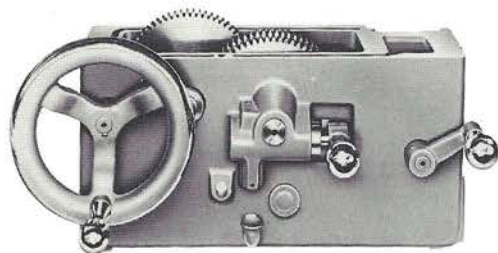
Tell us about the holes you'd like to produce faster. Large holes or small. If the Rapid Borer can handle the job, we'll show you how to produce them faster than ever before!

	No. 15	No. 30	No. 60
Main Drive Motor, hp	15	30	40-60
Number of Spindle Speeds	3, 4, 6 or 8	1 or Variable	1 or Variable
Spindle Speeds, Up To, rpm	5720	2500	2200
Boring Lengths	18"	18"	18"
	42"	42"	42"
	66"	66"	66"
<b>CAPACITIES</b>			
Solid Boring	5/16"-1"	1/2"-1 1/4"	5/8"-2 3/8"
Trepanning or Counter Boring	1 3/8"	2 3/8"	4 1/4"
Maximum Workpiece Clamping Diam.	6 1/2"	6 1/2"	9 3/4"



# Dual-Drive

Lathe



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## APRON

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A one-piece, double-walled casting project protects the positive-jaw clutch and gear train from dirt and misalignment. The cross and length feed clutch is operated by a single control which has a positive safety interlock.

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## TAILSTOCK

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LeBlond's unique tailstock design incorporates a rack and worm construction with positive safety lock against end thrust and puts the handwheel convenient to the operator. Exceptional long spindle travel and full support is provided even when completely extended. Brass shoes give positive spindle clamping.

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## QUICK-CHANGE BOX

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An oil-tight case encloses the gears of this automatically lubricated feed box. No operator attention is required. 48 feed and thread changes are available. All important gears are heat-treated.

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## STANDARD EQUIPMENT

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Hardened and ground replaceable steel bed ways; Small face plate; Graduated compound rest; No. 1 tool post assembly; Chasing dial; Adjustable thread cutting stop; Multiple automatic length stops; Cabinet legs; Chip pan; Centers and necessary wrenches; Lag screws and washers; Feed drive safety clutch; Apron spindle control; Machine arranged for motor drive, but not including motor or electrical equipment.

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## EXTRA EQUIPMENT

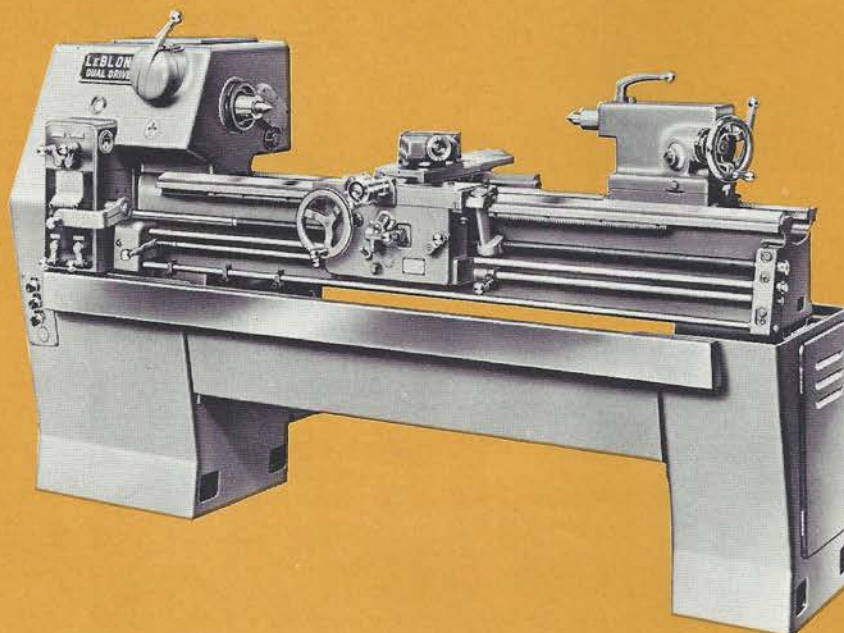
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Hydraulic duplicating attachment; Taper attachment; Steady rest; Follow rest; Grinding attachment; Coolant system; Milling and keyway cutting attachment; Micrometer carriage stops; Drill pad; Metric transposing gears; Turret tool post; Turret on bed; Chucks; Tools and many others.



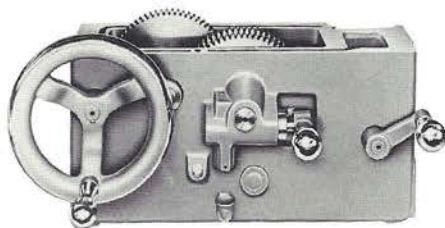
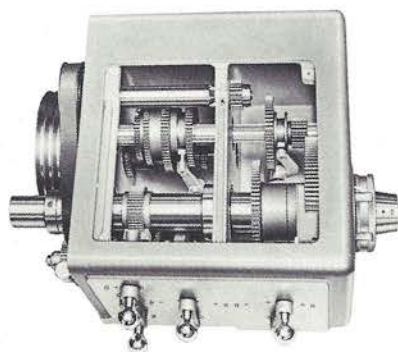
15"

<b>CAPACITY</b>	
Swing over bed and carriage wings	15"
Swing over compound rest	9½"
Distance between centers, base	30"
Center distance increases in increments of	12"
Size of forged tool	½" x 1"
<b>HEADSTOCK</b>	
Spindle speeds, number	16
Spindle speeds, range	31 to 2400
Spindle, size of center, Morse No.	4
Spindle nose, American Standard taper key	L-0
<b>BED</b>	
Length, base	5' 8½"
Width across ways	12¾"
Depth	10½"
<b>CARRIAGE</b>	
Bearing surface, square inches	62
Bridge width	6¼"
Cross slide travel	8⅞"
<b>FEEDS—THREADS</b>	
Feed and thread changes	48
Feed, range	.0021" to .120"
Threads per inch, range	4 to 224
Leadscrew diameter, threads per inch	1", 6
<b>TAILSTOCK</b>	
Center, Morse No.	4
Spindle travel and set-over, right or left	8", 1"
<b>MOTOR RECOMMENDED</b>	
Maximum	5 hp 1800 rpm
Frame Size, N.E.M.A.	215
<b>WEIGHT</b>	
Net weight, lbs.	2925
Floor space required	76¾" x 37"



# Regal

## Lathes



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### COMBINATION GEAR-BELT DRIVE HEADSTOCK

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The new Regal headstock design provides eight gear-driven spindle speeds and four belt-driven speeds for smooth power throughout the range. Low and high speed ranges are available for each model (see specifications).

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### APRON

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A one-piece, double-walled casting project protects the positive-jaw clutch and gear train from dirt and misalignment. The cross and length feed clutch is operated by a single control which has a positive safety interlock.

---

### TAILSTOCK

---

Positive clamping holds the spindle rigid. Longer bed bearing is provided to insure perfect alignment with the headstock. The tailstock spindle is graduated for easy reading of travel. Cross adjustment provides alignment and emergency taper turning.

The new Regal gives you big-lathe features for dependable production, maintenance and training. Designed and built like heavy duty lathes, the new LeBlond Regals will give you a long life of precision production, minimum maintenance and the kind of dependability you'd expect from a much higher-priced machine.

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### STANDARD EQUIPMENT

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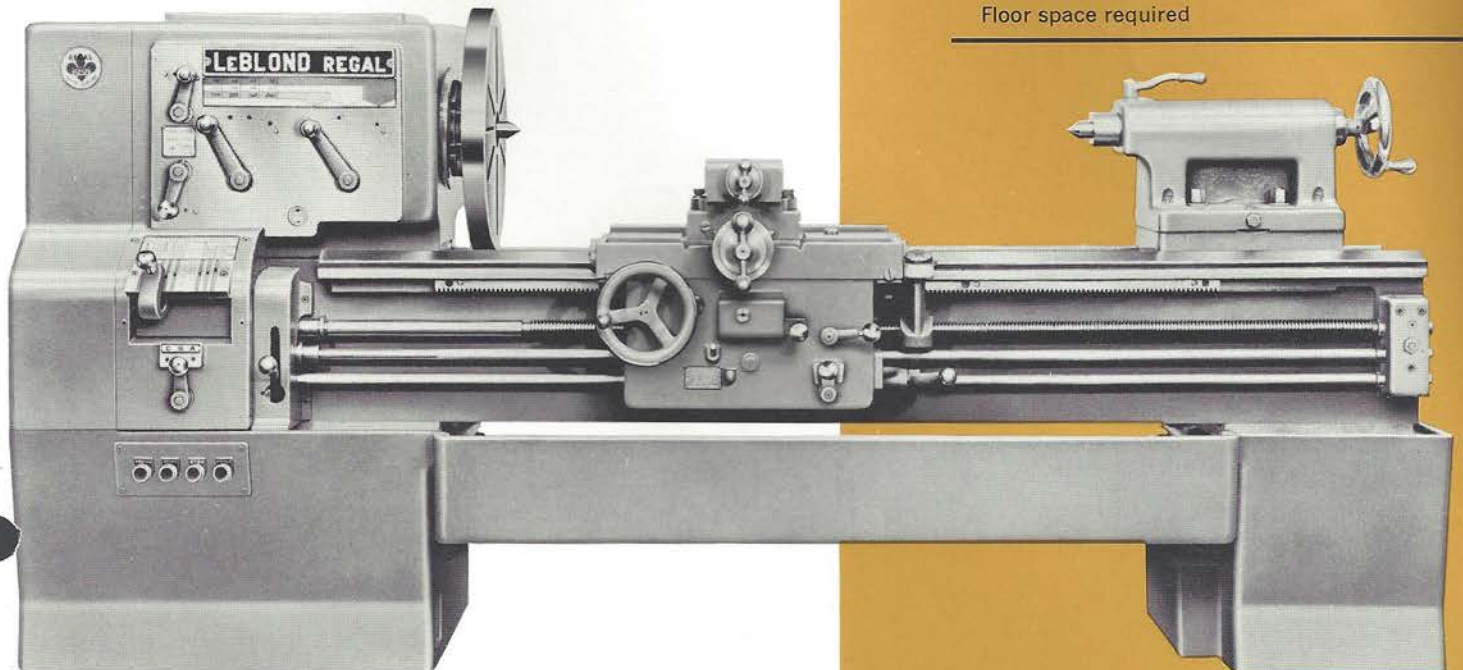
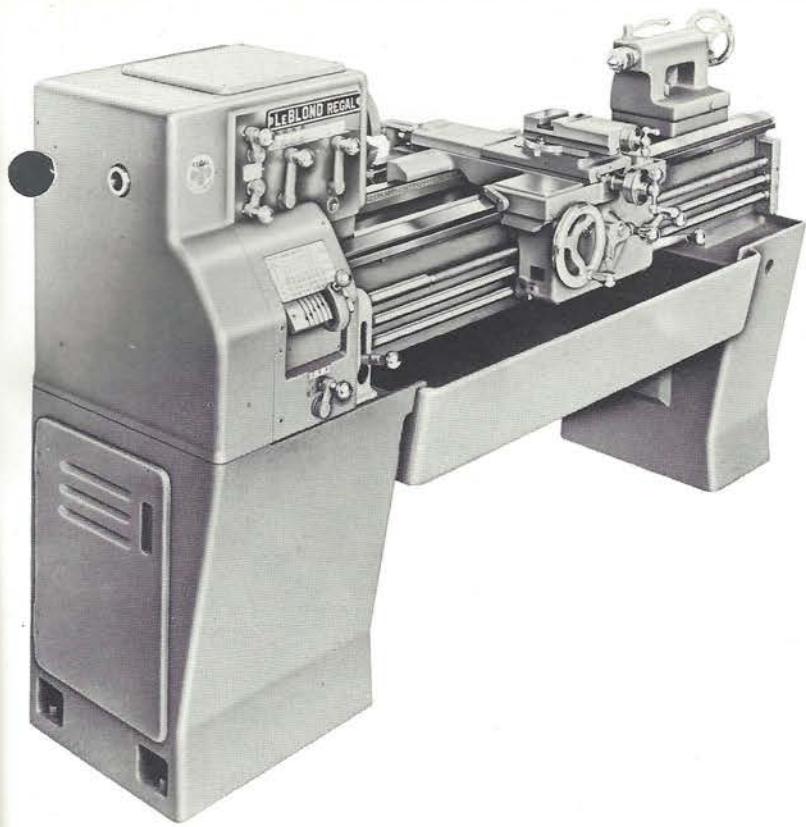
Hardened, ground steel bed ways; Small face plate; Graduated compound rest; No. 1 tool post; Chasing dial; Taper spindle sleeve; Adjustable thread cutting stop; Two cabinet legs; Chip pan; Feed drive safety clutch; Centers; Necessary wrenches; Apron spindle control; Machine arranged for multiple Vee belt motor drive but not including motor or electrical equipment.

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### EXTRA EQUIPMENT

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Turret tool post; Millerette converter; Taper attachment; Grinding Attachment; Milling and keyway cutting attachment; Large face plate; Connected rests; Steady rest; Follow rest; Metric Transposing gears; Chucks, tools and many others.




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#### CAPACITY

Swing over bed and carriage wings  
 Swing over compound rest  
 Distance between centers, base  
 Center distance increases in increments of  
 Size of forged tool

---

#### HEADSTOCK

Spindle speeds, number  
 Spindle speeds, range  $\begin{matrix} \text{Low} \\ \text{High} \end{matrix}$   
 Spindle, size of center, Morse No.  
 Spindle nose, American Standard taper key

---

#### BED

Length, base  
 Width across ways  
 Depth

---

#### CARRIAGE

Bearing surface, square inches  
 Bridge width  
 Cross slide travel

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#### FEEDS—THREADS

Feed and thread changes  
 Feed, range  
 Threads per inch, range  
 Leadscrew diameter, threads per inch

---

#### TAILSTOCK

Center, Morse No.  
 Spindle travel and set-over, right or left

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#### MOTOR RECOMMENDED

Maximum  
 Frame Size, N.E.M.A.

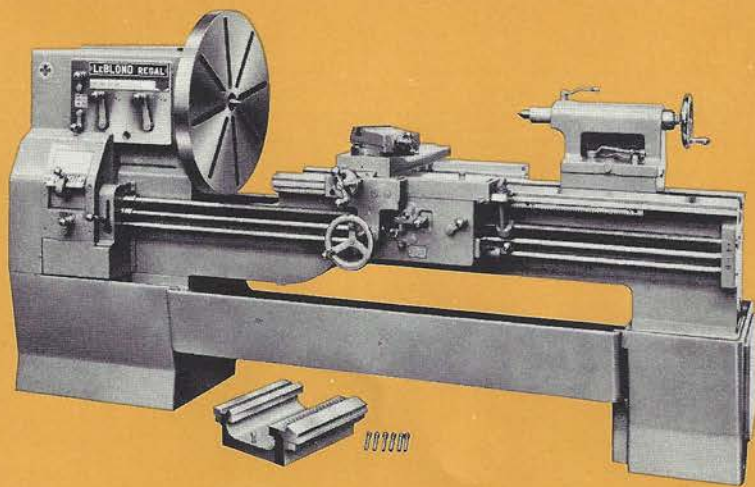
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#### WEIGHT

Net weight, lbs.  
 Floor space required

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	13''	15''	17''	19''	21''	24''
TS	14''	15½''	17¾''	19¼''	22¼''	26''
lements of	8''	9½''	10¾''	12¼''	14¼''	18¼''
	18''	18''	30''	30''	36''	36''
	12''	12''	12''	12''	12''	12''
	½'' x ¾''	½'' x 1''	⅝'' x 1¼''	⅝'' x 1¼''	¾'' x 1½''	¾'' x 1½''
aper key	12	12	12	12	12	12
	30 to 1200	30 to 1200	25 to 1000	25 to 1000	18 to 720	18 to 720
	45 to 1800	45 to 1800	38 to 1500	38 to 1500	27 to 1080	27 to 1080
	3	3	4	4	5	5
	L-00	L-00	L-0	L-0	L-2	L-2
	4' 6¼''	4' 6¼''	6' 3''	6' 3''	7' 6''	7' 6''
	12¾''	12¾''	14¾''	14¾''	16¾''	16¾''
	10¼''	10¼''	11½''	11½''	14¾''	14¾''
	62	62	79	79	107	107
	6¼''	6¼''	7⅞''	7⅞''	9''	9''
	8⅞''	8⅞''	11¼''	11¼''	13¼''	13¼''
inch	48	48	48	48	48	48
	.0018 to .106	.0018 to .106	.002 to .116	.002 to .116	.0036 to .205	.0036 to .205
	4 to 224	4 to 224	2 to 112	2 to 112	2 to 112	2 to 112
	1'', 6	1'', 6	1¾'', 4	1¾'', 4	1¾'', 4	1¾'', 4
or left	3	3	4	4	5	5
	5'', 1''	5'', 1''	7'', 1''	7'', 1''	8'', 1''	8'', 1''
	3 hp 1800 rpm	3 hp 1800 rpm	5 hp 1800 rpm	5 hp 1800 rpm	10 hp 1800 rpm	10 hp 1800 rpm
	213	213	215	215	256U	256U
	2000	2100	3100	3350	4810	4950
	60½'' x 31½''	60½'' x 31½''	83'' x 36''	83'' x 36''	108'' x 60''	108'' x 60''



**REGAL PLAIN & SLIDING  
BED GAP LATHES**

The Regal Sliding and Plain Bed Gap Lathes create a turning department out of a single lathe. They have the same specifications as the regular engine lathe with the exception of capacity for the irregular work with unusual projections or wide flanges. With the Regal Gap Lathes you can increase your production potential. This lathe also has a special carriage which permits the tool to work close to the gap.

**Plain Bed Gap Lathes**

17"

19"

21"

24"

**CAPACITY**

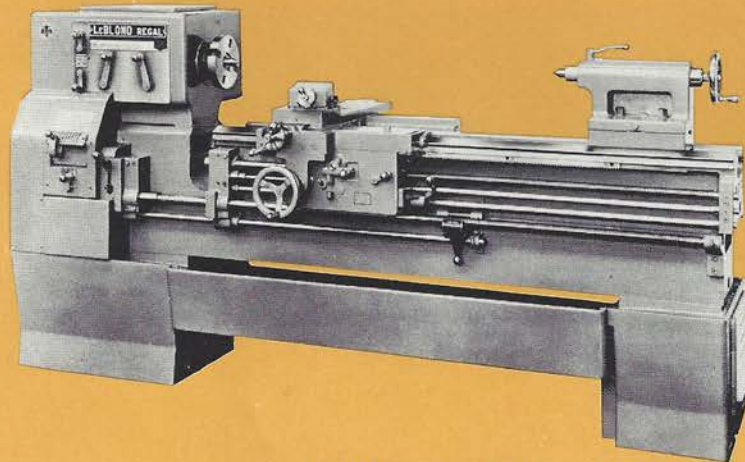
Swing over gap	26"	27½"	33"	37"
Distance spindle nose to end of gap	10⅞"	10⅞"	12¼"	12¼"
Distance face plate to end of gap	10¾"	10¾"	12"	12"

**CARRIAGE**

Length on ways	22"	22"	27"	27"
Bearing surface, square inches	82¼"	82¼"	111¼"	111¼"
Cross slide travel	15½"	15½"	21½"	21½"

**WEIGHT\***

Net weight, lbs., base length	3675	3925	5300	5450
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**Sliding Bed Gap Lathes**

17/28"

19/28"

**CAPACITY**

Swing over gap	35"	36½"
Center distance, bed closed	30"	30"
Center distance, bed extended	50"	50"

**CARRIAGE**

Length on ways	22"	22"
Bearing surface, square inches	82¼"	82¼"
Cross slide travel	15½"	15½"

**WEIGHT\***

Net weight, lbs., base length	4220	4375
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\*All weights estimated

## Distributors for Complete Line

### **New York Office**

Raymond-Commerce Bldg., Newark 2, New Jersey

### **Toledo Office**

Fine Bldg., Toledo 2, Ohio

### **Detroit Office**

New Center Bldg., Detroit 2, Michigan

### **C. A. Broad**

4751 N. Woodburn Ave., Milwaukee 11, Wisconsin

### **Chicago Office**

6429 West North Ave., Oak Park, Illinois

### **E. P. Rohrbach**

147 Oakland Drive, E. Lansing Michigan

### **Atlanta, Georgia**

J. R. Carlson Co., 3224 Peachtree Rd., N. E.

### **Birmingham 2, Alabama**

Moore-Handley Hardware Co., Inc., 27 S. 20th St.

### **Boston 15, Massachusetts**

Stedfast & Roulston, Inc., 11 Deerfield St.

### **Buffalo 13, New York**

Buffalo Machinery Co., 833-841 Grant Street

### **Charlotte, N. C.**

J. H. Elliott Co., Southern Div., Inc., Johnston Bldg.

### **Chattanooga 4, Tenn.**

Moore-Handley Hardware Co., Inc., 232 E. 11th St.

### **Cincinnati 19, Ohio**

Technical Equipment Sales Co., 411 Oak St.

### **Cleveland 29, Ohio**

J. C. Whitney Machinery Co., P.O. Box 7267

### **Dallas 1, Texas**

C. J. Harter & Son, Mchry., P.O. Box 35323, Airlawn Stat.

### **Denver, Colorado**

R. E. Duboc Associates, 2353 S. Broadway

### **Des Moines 14, Iowa**

Machine Tools, Inc., 1701 2nd Ave.

### **Grand Rapids 2, Mich.**

Wing & Jabaay, 511 Fulton

### **Houston 3, Texas**

C. J. Harter & Son, Mchry., 3838 Navigation Blvd.

### **Indianapolis 20, Indiana**

Technical Equipment Sales Co., 6216 Carrollton Ave.

### **Jacksonville, Florida**

Farquhar Machinery Co., Box 3275, Station F

### **Kansas City 8, Missouri**

Eichman Machinery Co., Inc., 1701 Locust St.

### **Los Angeles 54, Calif.**

Hoffman & Heartt, P.O. Box 2403, Terminal Annex

### **Minneapolis 4, Minn.**

The Satterlee Company, 2200 E. Franklin Ave.

### **Mobile 16, Alabama**

Moore-Handley Hardware Co., Inc., 401 N. Water St.

### **Nashville, Tennessee**

Moore-Handley Hardware Co., Inc., 492 Craighead St.

### **Natchez, Mississippi**

Peerless Supply Co., Inc., 200 State St.

### **New Orleans 12, La.**

Patrick H. Dillon, 524 Howard Ave.

### **Oklahoma City, Okla.**

Marshall Supply & Equipment Co., 1241 W. Main St.

### **Omaha, Nebraska**

The Balbach Co., 1201 California St.

### **(Philadelphia) Willow Grove, Pa.**

Delaware Valley Mch, Inc., 2323 Maplewood Ave.

### **Phoenix, Arizona**

J. L. Black, 716 E. Desert Park Lane

### **Pittsburgh 20, Pa.**

Barney Machinery Co., 1002 Greentree Rd.

### **Portland 12, Oregon**

Harry M. Euler Co., 2811 N. E. Glisan St.

### **Rapid City, S. Dakota**

The Balbach Co., Highway 79 & St. Anne

### **Rochester 4, New York**

Macaulay Machinery Co., Sibley Tower Bldg.

### **Salt Lake City, Utah**

J. M. Grisley Machine Tools, 334 W. 17th, South

### **San Francisco 7, Calif.**

Bulotti Machinery Co., 475 Fourth St.

### **Seattle, Washington**

Buckner-Weatherby Co., 1745 First Ave., South

### **Shreveport, La.**

Peerless Supply Co., Inc., 701 Spring St.

### **St. Louis, Missouri**

McDonald Machinery Co., 1531 N. Broadway

### **Syracuse 1, New York**

J. F. Owens Machinery Co., P.O. Box 1144