

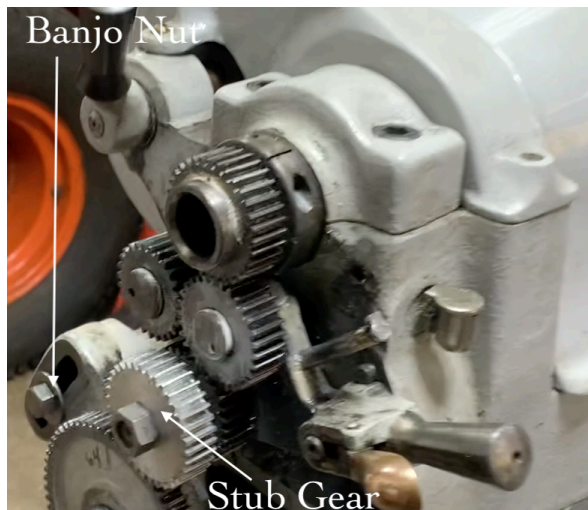
## South Bend Metric Conversion Stub Gear

Thank you for purchasing our metric conversion stub gear for Southbend Lathes: 13, 14 1/2 and 16 equipped with a 1 lever change gear box. \*\*\* **Note:** This gear does not work on 2 lever change gear box lathes. They have different diametral pitch requirements.

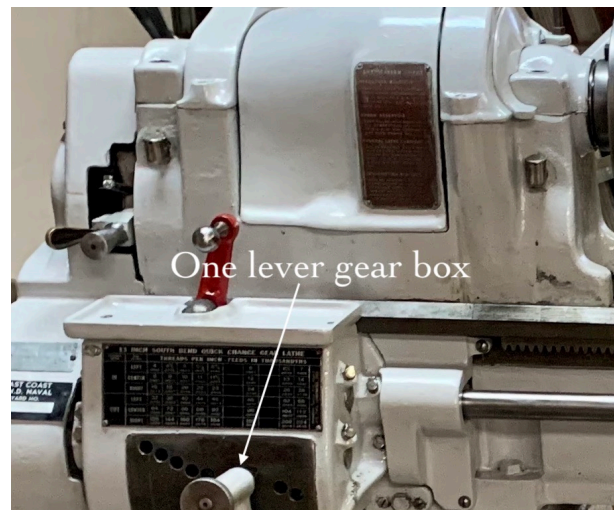
### **CAUTION:**

To use your new gear, **disconnect your lathe from main power**, loosen the banjo, replace the original stub gear and ensure that everything is reassembled and adequately tightened in accordance with manufacturer specifications.

Below is a chart showing the various metric treads you are now able to cut. By choosing a tread per inch selection on your lathe's change gear box which corresponds to a metric pitch of your choice on this chart you can now cut metric treads. This gear although not perfectly exact will achieve results that are accurate within 0.05%.



Caption



Caption

## South Bend Metric Conversion Stub Gear

Thread per inch	Threads in millimetres
4	12
6	8
8	6
12	4
16	3
24	2
32	1.5
48	1
64	0.75
96	0.5
192	0.25