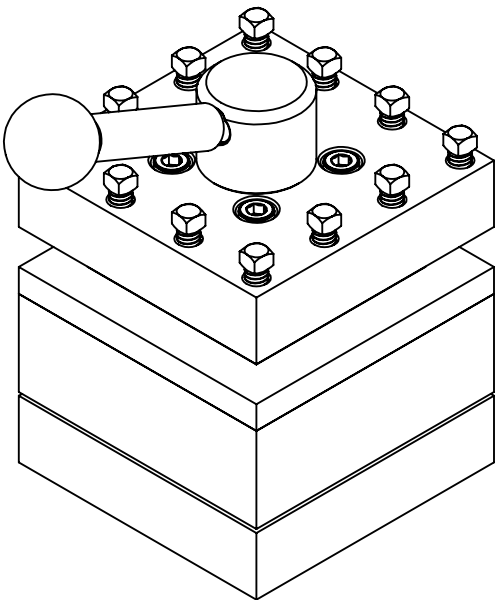
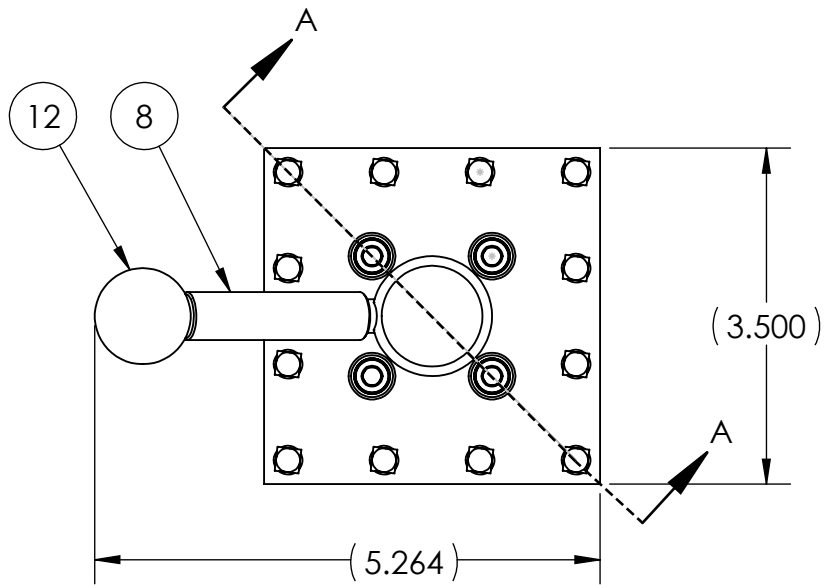


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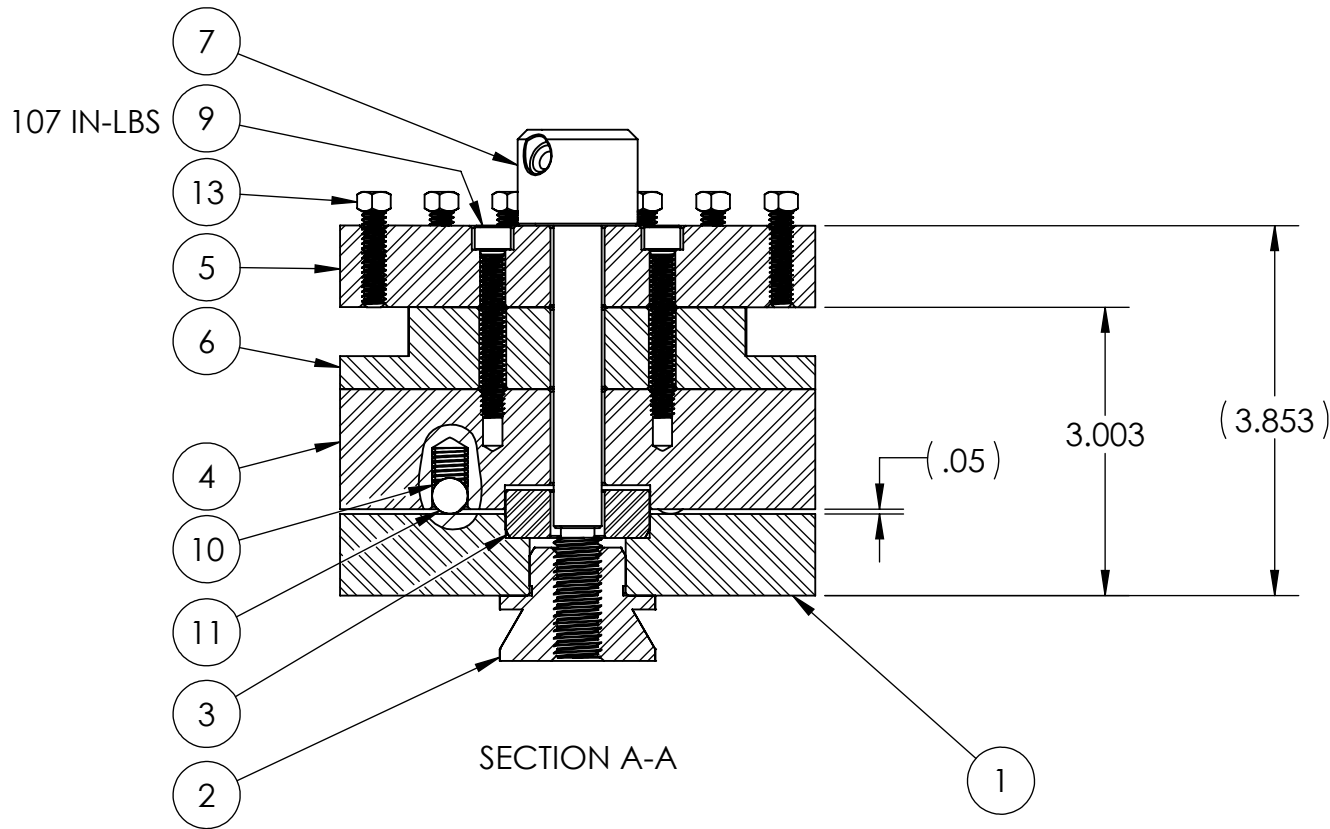
2

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- NOTES:
- 1. UOS, MATERIAL:
A. FABRICATED PARTS: AISI 1045 CR STEEL PER ASTM A108
B. PURCHASED COMPONENTS: PER MANUFACTURER'S SPECIFICATION
 - 2. UOS BREAK ALL EDGES .02 X 45°
 - 3. ALL THREADED FASTENER TORQUES ARE BASED ON LUBRICATED THREADS

COMPONENTS LISTED ARE SPECIFIED FROM MCMASTER-CARR



13	12	91416A125	SET SCREW, EXT SQ, 1/4-20 UNC X 1.00 LG
12	1	6045K35	KNOB, BALL, 1/4-20 UNC X .50 DP
11	6	96455K54	BALL, STL, Ø.375±.005
10	6	9657K306	SPRING, COMP, 1.00 LG, .375 OD, .305" ID
9	4	90044A124	SHCS: 1/4-20 UNC X 1.75 LG, ALLOY STEEL
8	1	108-TP-SB10	HANDLE, CLAMPING, TOOL POST
7	1	107-TP-SB10	SCREW, CLAMPING, TOOL POST
6	1	106-TP-SB10	PLATE, SPACER, TOOL POST
5	1	105-TP-SB10	BODY, UPPER, TOOL POST
4	1	104-TP-SB10	BODY, LOWER, TOOL POST
3	1	103-TP-SB10	CENTERING PUCK, TOOL POST
2	1	102-TP-SB10	LOCKING PUCK, TOOL POST
1	1	101-TP-SB10	BASE PLATE, TOOL POST
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION

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		TOLERANCES:		CHECKED			
		FRACTIONAL ±1/32		ENG APPR.			
		ANGULAR: MACH ±.5° BEND ±1°		MFG APPR.			
		TWO PLACE DECIMAL ±.03		Q.A.			
		THREE PLACE DECIMAL ±.010		COMMENTS:			
		INTERPRET GEOMETRIC TOLERANCING PER ASME 14.5-2018					
		MATERIAL					
		FINISH					
NEXT ASSY		USED ON					
APPLICATION		DO NOT SCALE DRAWING					

LAKE WORTH
FLORIDA 33462

TITLE:
**TOOL POST,
SOUTHBEND 10-INCH
LATHE**

SIZE	DWG. NO.	REV
B	100-TP-SB10	

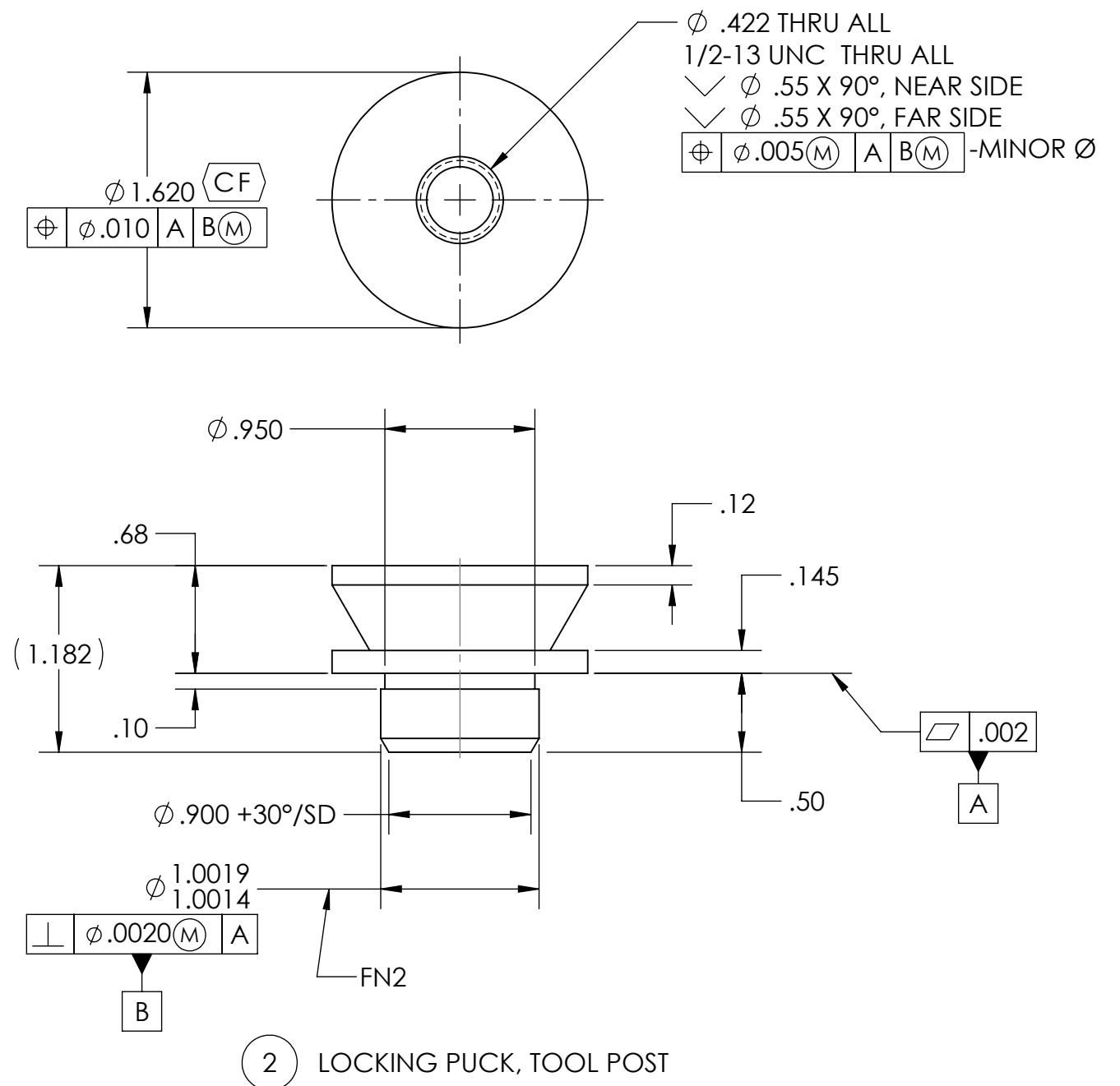
SCALE: 1:2 WEIGHT: 13.0422 SHEET 1 OF 7

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2 LOCKING PUCK, TOOL POST

1 BASE PLATE, TOOL POST

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		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL $\pm 1/32$ ANGULAR: MACH $\pm .5^\circ$ BEND $\pm 1^\circ$ TWO PLACE DECIMAL $\pm .03$ THREE PLACE DECIMAL $\pm .010$	DRAWN	R.PAPLOW	6/19/2026	TITLE: TOOL POST, SOUTHBEND 10-INCH LATHE	
			CHECKED	R.PAPLOW			
			ENG APPR.				
			MFG APPR.	R.PAPLO			
		INTERPRET GEOMETRIC TOLERANCING PER ASME 14.5-2018	Q.A.	R.PAPLOW		SIZE DWG. NO. REV B 100-TP-SB10 -	
		MATERIAL N/A	COMMENTS:				
		FINISH ✓					
	NEXT ASSY	USED ON					
	APPLICATION						

SCALE: 1:1 WEIGHT: 13.0422 SHEET 2 OF 7

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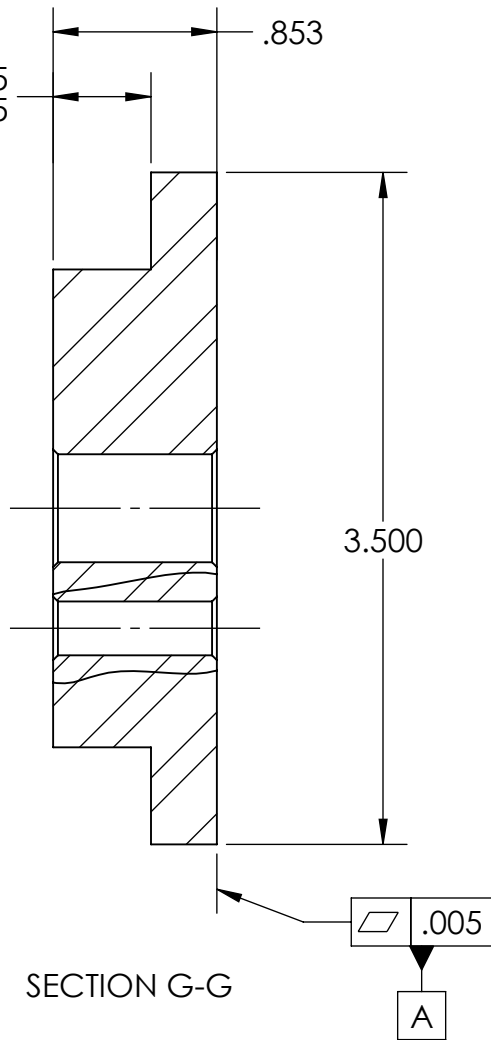


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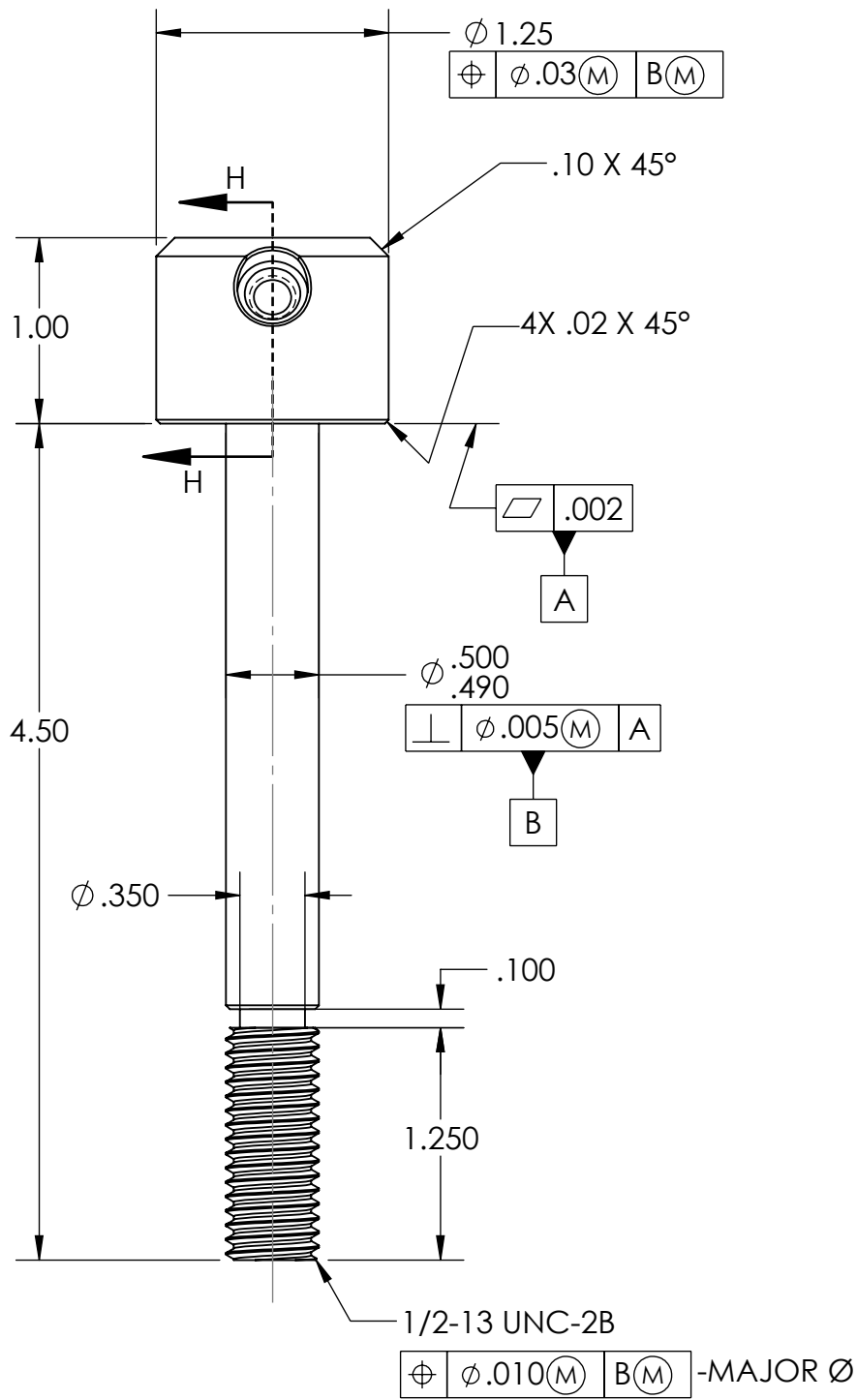


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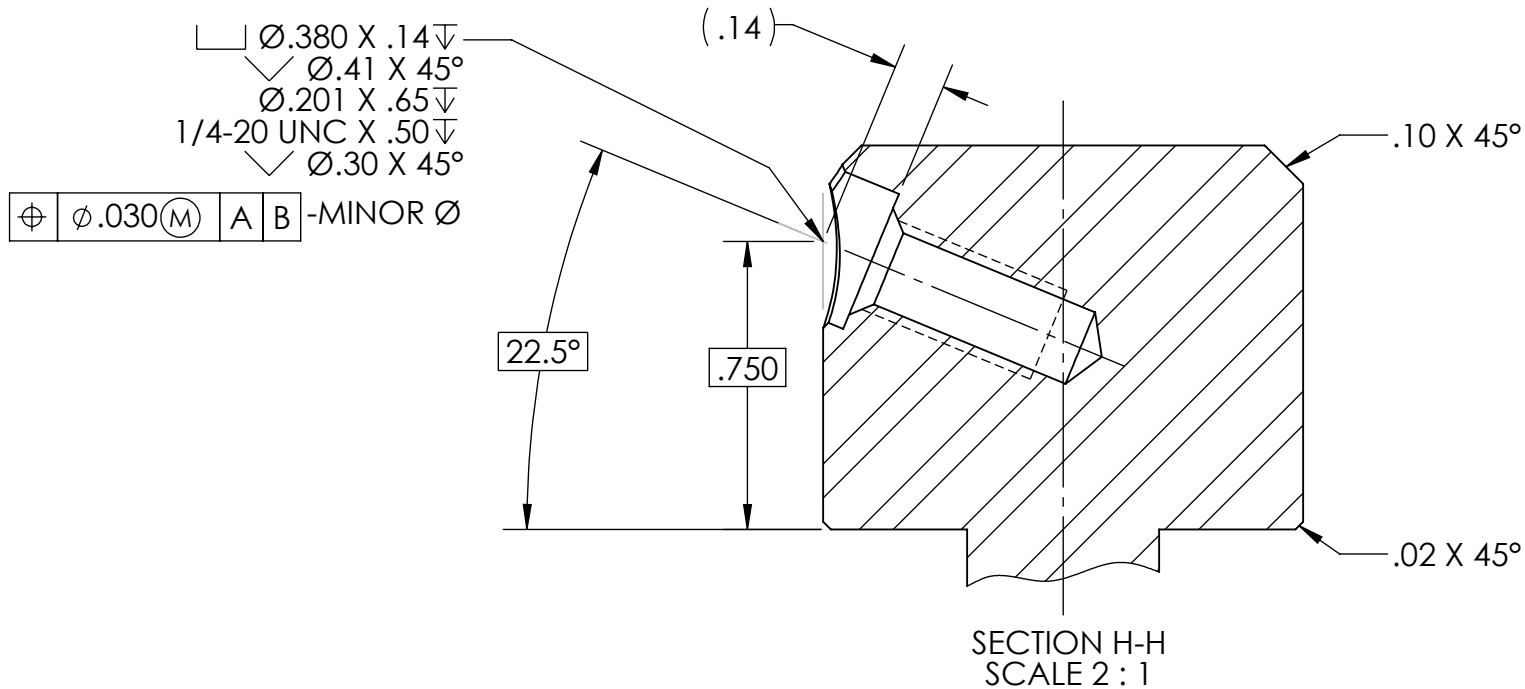
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		DIMENSIONS ARE IN INCHES		DRAWN	R.PAPLOW	6/19/2026	TITLE: TOOL POST, SOUTHBEND 10-INCH LATHE		
		TOLERANCES:		CHECKED	R.PAPLOW				
		FRACTIONAL ± 1/32		ENG APPR.					
		ANGULAR: MACH ± .5° BEND ± 1°		MFG APPR.	R.PAPO				
		TWO PLACE DECIMAL ± .03		Q.A.	R.PAPLOW				
		THREE PLACE DECIMAL ± .010							
		INTERPRET GEOMETRIC TOLERANCING PER ASME 14.5-2018		COMMENTS:					
		MATERIAL	N/A						
		FINISH							
	NEXT ASSY	USED ON					SIZE	DWG. NO.	REV
APPLICATION							B	100-TP-SB10	-
							SCALE: 1:1 WEIGHT: 13.0422 SHEET 5 OF 7		

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7 SCREW, CLAMPING, TOOL POST



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		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/32 ANGULAR: MACH ± .5° BEND ± 1° TWO PLACE DECIMAL ±.03 THREE PLACE DECIMAL ±.010	DRAWN	R.PAPLOW	6/19/2026	TITLE: TOOL POST, SOUTHBEND 10-INCH LATHE	
			CHECKED	R.PAPLOW			
			ENG APPR.				
			MFG APPR.	R.PAPLO			
			Q.A.	R.PAPLOW			
		INTERPRET GEOMETRIC TOLERANCING PER ASME 14.5-2018	COMMENTS:				
		MATERIAL N/A					
		FINISH 					
NEXT ASSY	USED ON						
APPLICATION			SCALE: 1:1 WEIGHT: 13.0422 SHEET 6 OF 7				
			SIZE DWG. NO. REV B100-TP-SB10-				

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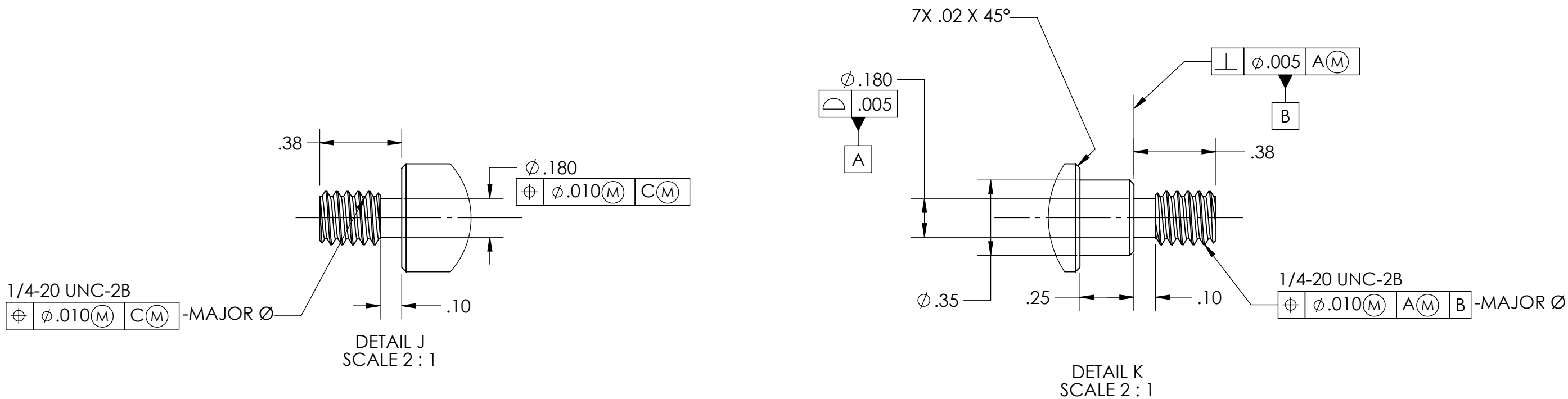
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			CHECKED	R.PAPLOW				
			ENG APPR.					
			MFG APPR.	R.PAPLO				
			Q.A.	R.PAPLOW				
		INTERPRET GEOMETRIC TOLERANCING PER ASME 14.5-2018	COMMENTS:			SIZE DWG. NO. REV B 100-TP-SB10 -		
		MATERIAL						
		N/A						
NEXT ASSY	USED ON	FINISH					SCALE: 1:1 WEIGHT: 13.0422 SHEET 7 OF 7	
APPLICATION								

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