RIVETT 608 PRECISION BACK GEARED SCREW CUTTING LATHES

ATTACHMENTS — MOUNTINGS — DRIVES

RIVETT LATHE & GRINDER INC.
BRIGHTON, BOSTON, MASS., U. S. A.

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Prices include packing for domestic shipment, f. o. b. Brighton, Boston, Mass., U. S. A.

LATHE ASSEMBLIES

	Fig. No. Bulletin 608E	*Code Word for Item*	*Price*
608-PC Precision Back Geared Screw Cutting Lathe: 8½" swing, 1" collet capacity, 40" bed, jack pedestals, pedestal bolts, lead screw, feed rod, safety interlock, carriage, carriage wipers, carriage stop, quick change gear box, cone pulley headstock for flat belt drive, center and center chuck, screw draw-in spindle, driving plate, set-over graduated spindle tailstock with center, compound slide rest with Rivett eccentric tool holder and set of ½" dia. carbon steel slide rest tools, or slide rest with rocker tool post and set of four tool holders — specify selection	1	GASAT	$1600.00
608-PV — Same as above except Semi-enclosed Headstock for V-belt drive	60	HASAT	1700.00

COMPLETE MOUNTING AND DRIVING ASSEMBLIES

Bench with Overhead Countershaft Drive — for details see mounting assembly No. 1 and driving assembly No. 5 below (for 608-PC Lathe)	51	RASAF	315.00
with **Horizontal Safety Drive** — for details see mounting assembly No. 1 and driving assembly No. 6 below (for 608-PC Lathe)	45	RASAG	315.00
with **Speed Box Motor Drive** — for details see mounting assembly No. 1 and driving assembly No. 7 below (for 608-PC Lathe)	49	RASAH	365.00
with **Motor Jackshaft Drive** — for details see mounting assembly No. 1 and driving assembly No. 8 below (for 608-PV Lathe)	—	RASAI	400.00
Oak Cabinet with Overhead Countershaft Drive — for details see mounting assembly No. 2 and driving assembly No. 5 below (for 608-PC Lathe)	—	RASAJ	430.00
with **Horizontal Safety Drive** — for details see mounting assembly No. 2 and driving assembly No. 6 below (for 608-PC Lathe)	44	RASAK	430.00
with **Speed Box Motor Drive** — for details see mounting assembly No. 2 and driving assembly No. 7 below (for 608-PC Lathe)	48	RASAL	495.00
Steel Cabinet with Motor Jackshaft Drive — for details see mounting assembly No. 3 and driving assembly No. 8 below (for 608-PV Lathe)	60	RASAM	~~735.00~~ 700
Oil Pan with Speed Box Motor Drive — for details see mounting assembly No. 4 and driving assembly No. 7 below (for 608-PC Lathe)	47	RASAO	375.00

MOUNTING ASSEMBLIES

No. 1 Bench Assembly: 72" x 26" x 2¼" 5-ply laminated hardwood top with back and end boards, cast iron legs with cross bracing, single drawer with tool tray, collet board, lock and key	51
No. 2 Oak Cabinet Assembly: 57" x 24" quartered stock oak cabinet with 5-ply laminated top with back board, two drawers, one with collet board, and two compartments for attachments and drive, all with locks and keys	48
No. 3 Steel Cabinet Assembly: 53" x 26" welded steel cabinet with oil pan top, 53" x 20½" with 1¾" rim, two drawers, one with collet board and one with slide, storage compartment for attachments and ventilated motor compartment having end door for easy access to controller, all with locks and keys	60
No. 4 Oil Pan Assembly: 48" x 12" cast iron oil pan with sump and strainer mounted on heavy cast iron legs	47

DRIVING ASSEMBLIES

No. 5 Overhead Countershaft Drive Assembly: ball bearing countershaft, support, ball bearing jackshaft, latch treadles or hand belt shifters (specify selection with bench, cabinet uses hand belt shifters), set of 4 belts, ¾ h.p., 220, 440 or 550 volt, 3 phase, 60 cycle motor and switch assembled and wired to produce 12 spindle speeds, see speed table, fig. 52	51

DRIVING ASSEMBLIES — Continued

	Fig. No. Bulletin 608E	Code Word for Item	Price
No. 6 Horizontal Safety Drive Assembly:—ball bearing countershaft, hinged bracket, belt guard and cover (all compactly mounted on bench or cabinet top back of lathe), ball bearing jackshaft, latch treadles or hand belt shifters (specify selection with bench, cabinet uses hand belt shifters), set of 4 belts, ¾ h.p., 220, 440 or 550 volt, 3 phase, 60 cycle motor and switch assembled and wired to produce 12 spindle speeds, see speed table, fig. 46	45		
No. 7 Speed Box Motor Drive Assembly:—speed box, latch treadles or hand lever (specify selection with bench or oil pan, cabinet uses hand lever), U guard, automatic brake, all belting, ¾ h.p., 220, 440 or 550 volt, 3 phase, 60 cycle motor and drum type reversing switch, assembled and wired to produce 12 spindle speeds, see speed table, fig. 50	47		
No. 8 Motor Jackshaft Drive Assembly:—welded frame mounted on bench motor plank or cabinet floor, motor cradle, lever belt tension release, ball bearing jackshaft, sheaves, vee belts, ¾ h.p., 220, 440 or 550 volt, 60 cycle, 3 phase, 600/1200 r.p.m. motor, four-way reversing switch and disconnect line switch assembled and wired to produce twelve spindle speeds 25 to 1500 r.p.m.	60		
Magnetic Controller with any one of above assemblies			**Price on application**
Fused Disconnect Line Switch — wired to motor control for 220 volt, extra, net	—	**RASAP**	**$ 10.00**
Same for 440 or 550 volt, extra, net	—	**RASAQ**	**20.00**
Boxing any of above lathe assemblies for ocean shipment, one box, net	—	**RASAR**	**12.00**
Boxing any of above lathe assemblies with mounting and drive for ocean shipment, two boxes, net	—	**RASAS**	**30.00**

Approx. net weights — lathe and standard attachments 350 lbs., lathe and standard attachments complete with bench and drive 775 lbs., with oak cabinet and drive 900 lbs., with steel cabinet and drive 1050 lbs., with oil pan and drive 850 lbs.

Approx. shipping weights — lathe and standard attachments, two cases, domestic add 100 lbs., boxed for ocean shipment add 175 lbs. total; lathe, standard attachments, mounting and drive, two cases, domestic add 200 lbs., boxed for ocean shipment add 350 lbs., total.

Approx. cubic feet — boxed for ocean shipment, lathe and standard attachments 16, with bench 100, with oak or steel cabinet 52, with oil pan 32.

ATTACHMENTS

Angle Iron — for face plate, rocker tool post slide rest and carriage milling attachment	40	**RBSBA**	**$ 20.00**
Belting — flat endless for speed box to lathe spindle	47	**RBSBC**	**3.50**
flat endless, set of 4, for horizontal safety drive	45	**RBSBD**	**13.00**
flat endless, set of 4, for overhead countershaft drive	51	**RBSBE**	**20.00**
vee belts for jackshaft to lathe spindle, set of two	60	**RBSBX**	**5.00**
vee for motor to jackshaft or speed box	51	**RBSBF**	**2.50**
Center — soft male	42	**RBSBG**	**2.50**
soft male with center chuck	42	**RBSBH**	**9.00**
hard male	42	**RBSBI**	**3.50**
blank	42	**RBSBJ**	**2.25**
large male, hard	42	**RBSBK**	**5.25**
half male, hard	42	**RBSBL**	**3.75**
female, hard	42	**RBSBM**	**3.75**
solid V	42	**RBSBN**	**6.00**
revolvable V	42	**RBSBO**	**10.00**
spur	42	**RBSBP**	**7.50**
adjustable off-center	42	**RBSBQ**	**27.00**
Chuck — center chuck for headstock center	42	**RBSBR**	**7.00**
drill chuck on straight or taper shank. Capacity: ¼"	43	**RBSBT**	**10.00**
⅜"	43	**RBSBU**	**11.00**
½"	43	**RBSBV**	**15.00**
drill chuck on taper shank to fit internal grinding attachment — capacity ⅛"	—	**RBSBW**	**11.00**
5" — 3 jaw geared scroll universal chuck, two sets of jaws, mounted	43	**RBSBY**	**54.00**
6" — 4 jaw independent chuck with reversible jaws, mounted	43	**RBSCA**	**51.00**
6" — 4 jaw geared scroll combination chuck, reversible jaws, mounted	43	**RBSCB**	**98.00**
step chuck, forged steel, split, blanks: 2"	43	**RBSCE**	**10.00**
3"	43	**RBSCF**	**12.00**
4"	43	**RBSCG**	**14.00**
5"	43	**RBSCH**	**16.00**
6"	43	**RBSCI**	**18.00**
step chuck, stepped to above prices add for steps bored to customers' specifications (aggregate of steps not to exceed four, each 3/32" deep or equivalent, smallest step not less than 9/16" dia., largest step not exceeding capacity of blank), one step $3.00, two steps $5.00, three steps $6.50, 4 steps $7.50	43		
step chuck closing ring for 3" and 4" step chucks	43	**RBSCK**	**13.00**
step chuck closing ring for 5" and 6" step chucks	43	**RBSCL**	**15.00**
Closer — lever chuck closer	4	**RBSHE**	**123.00**
lever chuck closer, in place of screw draw-in spindle (with new machine)	4	**RBSCD**	**100.00**

ATTACHMENTS — Continued

	Fig. No. Bulletin 608E	Code Word for Item	Price
Collet, Draw-in Type — blanks, not hardened, drilled or sawed	43	RBSCO	$ 4.00
round fractional size 1/16" to 1" x 64ths	43	RBSCP	4.75
round fractional undersize, less than 1/16"	43	RBSCQ	5.25
round fractional oversize, up to 1/16" above capacity	43	RBSCR	5.25
square fractional size 1/8" to 23/32"	43	RBSCS	7.75
hex. fractional size, 1/8" to 7/8"	43	RBSCT	7.75
square fractional undersize — less than 1/8"	43	RBSCU	8.75
hex. fractional undersize — less than 1/8"	43	RBSCV	8.75
round decimal, metric or odd size, above 1/16"	43	RBSCW	5.00
round decimal, metric or odd undersize, less than 1/16"	43	RBSCX	5.50
step or pot	43	RBSHC	5.75
taper hole, unsplit, hardened and ground	43	RBSHD	9.75
Collet Board — swinging collet board for oil pan assembly	—	RBSCY	12.00
Countershaft — 3 speed, ball bearing, with cone driving pulley, only (for lineshaft drive)		RBSCZ	55.00
same with three latch treadles and turnbuckles		RBSDB	70.00
Cutting-Off and Forming Slide — with front circular tool holder with blank and rear tool block with cutting-off tool	38	RBSDE	125.00
Cutting-Off and Turning Slide — with front and rear steel faced tool blocks and tool posts, front tool block having lever traverse for straight turning	39	RBSDF	170.00
Dial — threading dial for lathe carriage	5	RBSDG	30.00
Dog — clamp dog	40	RBSDH	3.00
Gears — translating gears for metric threads	—	RBSDJ	36.00
Grinding Attachment — unit motor drive, rocker tool post only, with ball bearing spindle for internal and external work, with cord and switch — 110–115 volt, complete with case	16 & 17	RBSDL	80.00
external for rocker tool post, with adj. height, for overhead drive	21	RBSDM	40.00
internal for rocker tool post, with adj. height, for overhead drive	20	RBSDN	45.00
external for eccentric tool holder, with adj. height, for overhead drive	19	RBSDO	58.00
internal for eccentric tool holder, with adj. height, for overhead drive	18	RBSDP	64.00
arbors for internal wheels, each	22	RBSDQ	3.00
for traverse miller (see milling) requires overhead drive	34	RBSDR	40.00
Indexing Attachment — with mounting bracket and finger	29	RBSDW	50.00
index plates, 45, 56, 60, 64, 72, 80, 84 and 100 divisions, each	25	RBSDX	8.00
Knurling Attachment — for tailstock, with screw adjustment	14	RBSDY	33.00
Milling Attachment — carriage type with 8 standard index plates	26-28	RBSDZ	450.00
for eccentric tool holder slide rest with 8 standard index plates (requires 4 N. S. collets)	25	RBSEB	225.00
index plates, 45, 56, 60, 64, 72, 80, 84 and 100 divisions, each	25	RBSEC	8.00
index plates with special divisions, each	25	Prices on application	
cutter arbors 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", 5/8", 11/16", 3/4", 13/16", 7/8", 1", each	25	RBSED	10.00
traverse miller (requires overhead drive)	31	RBSEF	390.00
thread milling attachment for traverse miller	32	RBSEG	175.00
Overhead Drive — auxiliary countershaft for horizontal safety drive (for grinding attachments, etc.)	45	RBSDS	60.00
auxiliary countershaft for overhead countershaft drive (for grinding attachments, etc.)	51	RBSDT	45.00
auxiliary motor drive 3-speed, with 1/4 h. p. motor (for grinding attachments, etc.)	47	RBSDU	75.00
Pan — chip pan	—	RBSEH	10.00
Plate — drill plate: 2"	41	RBSEI	5.00
3"	41	RBSEJ	6.00
4"	41	RBSEK	7.00
5"	41	RBSEL	8.00
driving plate	41	RBSEM	10.00
emery face plate — for use of emery discs	41	RBSEN	17.00
plain face plate 4 1/4" diameter	41	RBSEO	13.00
plain face plate 5 1/8" diameter	41	RBSEP	14.00
slotted face plate 8" dia. with four plain and four T slots	41	RBSEQ	23.00
slotted and tapped face plate 8" dia.	41	RBSER	30.00
tapped face plate 7" dia., with forty-nine 5/16" — 18 tapped holes	41	RBSES	23.00

ATTACHMENTS — Continued

	Fig. No. Bulletin 608E	Code Word for Item	Price
Pump — oil pump and piping for steel cabinet or oil pan	—	RBSEV	$55.00
Relieving Attachment — plain (requires overhead drive)	—	RBSEW	250.00
universal (requires overhead drive)	—	RBSEY	500.00
Rest — ball turning rest with screw adjustment for centering	23	RBSEZ	145.00
follower rest, 3″ dia. capacity	40	RBSFA	20.00
L rest, to mount in T rest base	40	RBSFB	12.00
saw table, to mount in T rest base	40	RBSFC	6.00
steady rest (back rest) 4″ dia. capacity, hinged, with screw adjustment	40	RBSFE	40.00
T rest, plain, with 3″ tee, base to mount on carriage angle	40	RBSFG	15.00
T rest, hinged, with 3″ tee, base to mount on carriage angle	40	RBSFH	25.00
6″ tee, for use in T rest base	40	RBSFI	6.00
triangle rest to mount in T rest	40	RBSFJ	6.00
slide rest, compound precision, Rivett eccentric tool holder	6	RBSFK	170.00
same with metric screws and dials, extra	6	RBSFL	10.00
slide rest, compound precision, rocker tool post	8	RBSFM	170.00
same with metric screws and dials, extra	8	RBSFN	10.00
SLIDE REST TOOLS — eccentric slide rest bar holder for 5/16″ square tool bits	7	RBSFO	9.00
eccentric slide rest eccentric tool holder with sleeve for 5/16″ square tool bits	7	RBSFP	24.00
eccentric slide rest eccentric tool holder for 1/2″ round tools	7	RBSFQ	12.00
eccentric slide rest tool holders with 3/16″ bits, set of four	—	RBSFR	24.00
eccentric slide rest knurling tool holder with three knurls	7	RBSFS	12.00
eccentric slide rest internal threading tool holder	7	RBSFT	7.00
eccentric slide rest 1/2″ diameter round tools, set of six, carbon steel	7	RBSFU	18.00
eccentric slide rest 1/2″ diameter round tools, set of six, high speed steel	7	RBSFV	30.00
rocker slide rest tool holders with 3/16″ bits, set of four	9	RBSFW	15.00
rocker slide rest knurling tool holder with three knurls	9	RBSFX	12.00
Slotting Attachment — complete with base	29	RBSFY	150.00
Slotting and Milling Fixture — mounts on carriage angle	40	RBSFZ	45.00
Spindle — screw draw-in spindle with knob	2	RBSGB	30.00
Spiral Attachment — with driving countershaft	33	RBSGC	450.00
Stop — carriage micrometer stop	6	RBSGA	35.00
carriage micrometer stop, in place of standard stop (with new machine)	6	RBSGD	20.00
Tailstock — set-over offset, graduated spindle, with center	11	RBSGE	125.00
lever attachment, extra	13	RBSGF	25.00
Taper Attachment — graduated in both degrees and inches per foot	15	RBSGH	135.00
Thread Tool — for generating threads in ten progressive cuts, with block to mount on carriage	24	RBSGI	65.00
cutter, ten tooth for 6 pitch and finer, high speed steel	24	RBSGJ	12.00
same, carbon steel	24	RBSGK	9.00
Turret Attachment — automatic indexing, six 3/4″ holes, independent auto. stops	36	RBSGL	300.00
for lever tailstock	12	RBSGM	55.00
Turret Tools — adjustable finishing hollow mill with four blades, 3/16″ to 1/2″ capacity	37	RBSGN	Prices on application
adjustable roughing hollow mill with three blades, 3/16″ to 1/2″ capacity	37	RBSGO	
adjustable knurl holder, 1/8″ to 9/16″ capacity	37	RBSGP	
box tool, 1/4″ dia. x 2″	37	RBSGQ	
centering and facing tool, 3/8″ drill capacity	37	RBSGR	
die holder, non-releasing, 3/8″ x 1 1/4″ thread capacity	37	RBSGS	
die holder, releasing, 3/8″ x 1″ thread capacity	37	RBSGT	
die cap, extra capacity to take dies 1/2″ x 1 1/2″	37	RBSGU	
die holder, "acorn" releasing, 1/4″ to 7/16″ x 1 1/2″ thread capacity	37	RBSGV	
drill holder, 5/8″ dia. drill capacity	37	RBSGW	
floating holder with blank bushing, 5/8″ dia. drill capacity	37	RBSGX	
tap holder, non-releasing, 5/8″ dia. tap capacity	37	RBSGY	
tap holder, releasing, 5/8″ dia. tap capacity	37	RBSGZ	
Vise — for mounting in slide rest eccentric tool holder, milling attachments and lathe spindle	41	RBSHA	65.00
for mounting on rocker tool post, slotted face plate, angle iron and carriage attachment	41	RBSHB	50.00