



# Model SB1354 Cast Iron Workbench Legs INSTRUCTION SHEET



P.O. Box 2027, Bellingham, WA 98227 U.S.A.  
PHONE: (360) 734-1540 • www.southbendlathe.com

Designed with smooth flowing lines reminiscent of industrial designs from the early 1900s, these heavy Cast Iron Legs provide plenty of support and stability for shop-made workbenches or machine stands. Just add your own bench top and bottom shelf to suit your particular needs.



**Figure 1. SB1354**  
(Bench top and shelf not included).

## Specifications

Material ..... Cast Iron  
Finish ..... Powder Coat  
Weight ..... 110 Lbs. Per Leg  
Dimensions ..... See **Page 4**  
Capacity ..... See Warning Below

### **!WARNING**

Although each leg is capable of supporting up to 2000 lbs., the actual capacity of the completed workbench is dependent on many factors, including (but not limited to) material type, quality, and dimensions of the bench top and shelf; the method and materials used for cross bracing; the size and quality of the hardware used; and any forces that may be applied to the workbench during its use.

## Inventory

Cast Iron Legs w/Brass Nameplate ..... 2

## Things You'll Need

During the assembly process you'll need the following (not included):

### For Assembly

- Two additional people
- Bench Top
- Lower Shelf
- Cross-brace
- Bench Mounting:
  - Lag Screws  $\frac{5}{16}$ " Dia. x Length (Bench Thickness +  $\frac{1}{4}$ " ) ..... 8
  - Flat Washers  $\frac{5}{16}$ " ..... 8
  - Drill Bit  $\frac{1}{4}$ " (pilot hole) ..... 1
- Lower Shelf Mounting:
  - Lag Screws  $\frac{1}{4}$ " Dia. Length (Shelf Thickness) ..... 4
  - Flat Washers  $\frac{1}{4}$ " ..... 4
  - Drill Bit  $\frac{7}{32}$ " (pilot hole) ..... 1
- Cross-Brace Mounting:
  - Dependent on cross-bracing used
- Tools needed for tightening selected hardware
- Cardboard (or other protective material for assembly process) larger than bench top dimensions

### Optional

- Leveling Feet  $\frac{3}{8}$ "-16 thread pitch
- Precision Level
- Shim Stock (as needed)
- Floor Mounting Hardware (x4)

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## Assembly

The procedure that follows describes the general steps required for assembly. Since the bench top and shelf are not included, individual assembly steps will vary.

### To assemble the workbench:

1. Place a piece of cardboard or other protective material on a flat, level, hard floor, then place your bench face-down on it.

### **!WARNING**

The legs included in this kit weigh over 100 lbs. each. In the steps that follow, make sure the legs are constantly stabilized to prevent them from falling until they are secured to the bench top in Step 4. Failure to do so could allow the legs to fall, resulting in crushing injuries, laceration injuries, or death.

2. With the help of one or two additional people, place one of the legs upside-down onto the inverted bench top, making sure the cross-brace mounting tab points toward the middle of the bench as shown in **Figure 3**.

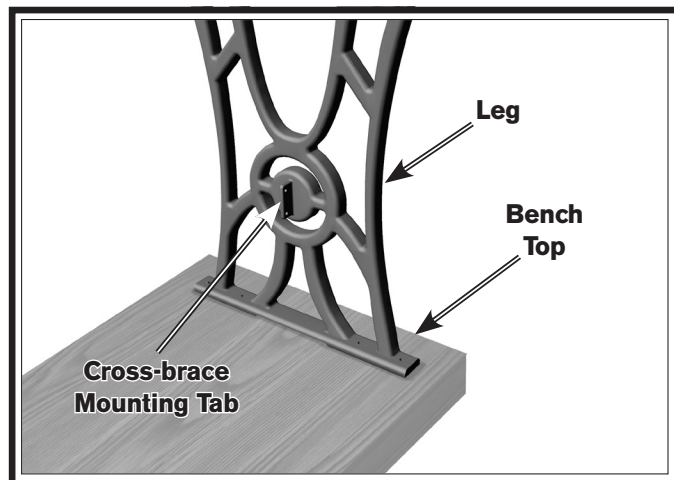


Figure 3. Leg placement.

### **NOTICE**

Never attempt to weld onto the cast iron legs or drill into them. Doing so can compromise their strength and will void the warranty.

3. Place the leg in the desired position, then mark and pre-drill holes for the mounting hardware you have chosen. Unless you intend to do so, take care to avoid drilling all the way through the bench top.
4. Use your chosen hardware to secure the leg to the bench top, as shown in **Figure 4**.

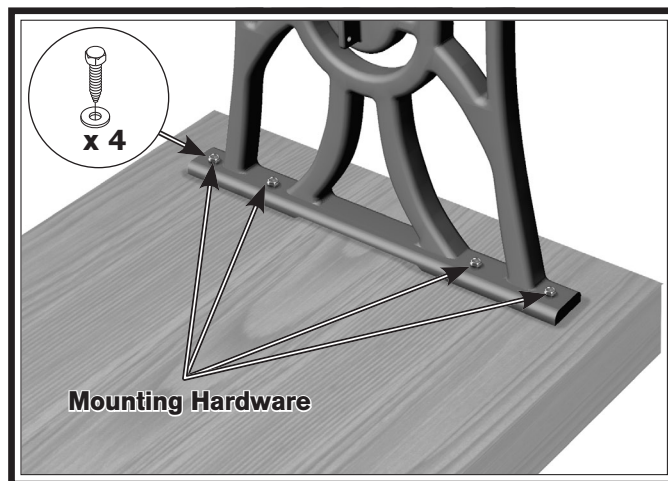


Figure 4. Securing leg to bench top.

5. Repeat **Steps 2–4** for the second leg.
6. With additional people to help, carefully turn the bench over.
7. Place your shelf onto the shelf brackets, as shown in **Figure 5**, then mark drill holes through the holes on the shelf brackets.

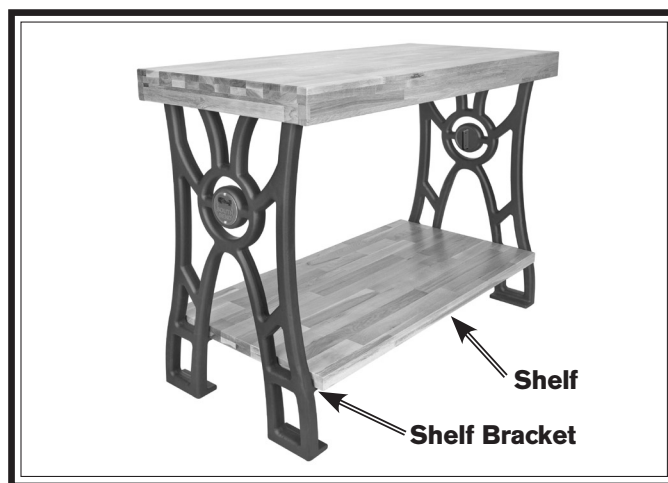


Figure 5. Shelf placement.

8. Remove the shelf, then pre-drill holes for the mounting hardware you have chosen. Unless you intend to do so, take care to avoid drilling all the way through the shelf.
9. Place your shelf back onto the shelf brackets, taking care to line up the holes you drilled in the previous step with the holes in the shelf brackets.
10. Use your chosen hardware to secure the shelf to the shelf brackets.
11. Install cross-bracing to provide additional stabilization between the legs, or between the legs and bench top. Two possible methods are shown in **Figures 6–7**

## ⚠ WARNING

Failure to properly cross-brace the Model SB1354 will result in a significantly reduced maximum weight capacity and could cause the bench to collapse under heavy vertical or lateral loading. Collapse can result in crushing injuries and/or property damage.

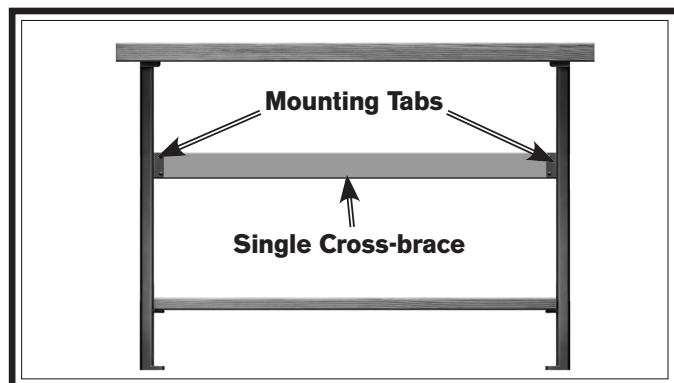


Figure 6. Single cross brace.

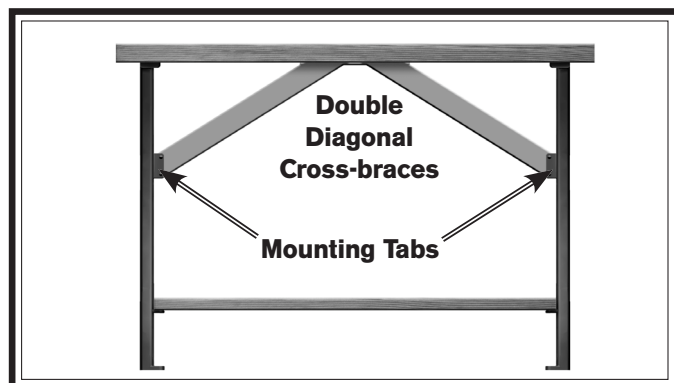


Figure 7. Double triangle cross brace.

## Leveling

Though leveling is not required, the Model SB1354 legs have  $\frac{3}{8}$ "-16 pitch threaded holes at the base to allow for the installation of leveling feet.

## Securing to Concrete Floors

### NOTICE

**DO NOT use impact tools to secure the legs to the floor. The impact associated with these tools could crack the cast iron. Tighten all floor mounting hardware by hand.**

Though securing the bench to the floor is not required, the holes at the base of the legs can be used for this purpose (to avoid interference with the existing threads, use  $\frac{5}{16}$ " or smaller hardware). Before securing the bench to the floor, use a precision level to check the bench for level in all directions. Place shims under the legs as necessary until the bench is level and all four feet are planted firmly on the floor. Then, use mounting hardware to mount the bench to the floor.

Lag screws and anchors, or anchor studs (**below**), are two popular methods for securing machinery to a concrete floor. We suggest you research the many options and methods for securing your machine and choose the best one for your specific application.

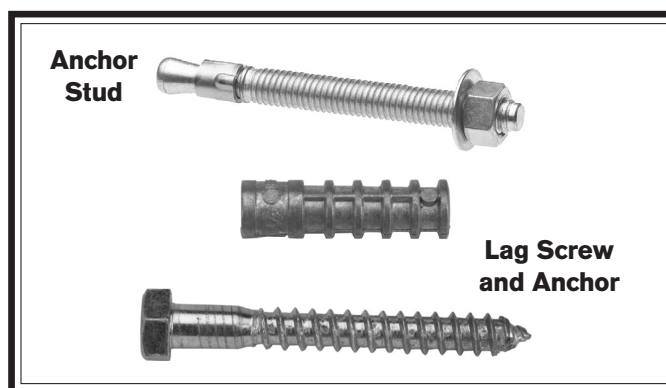
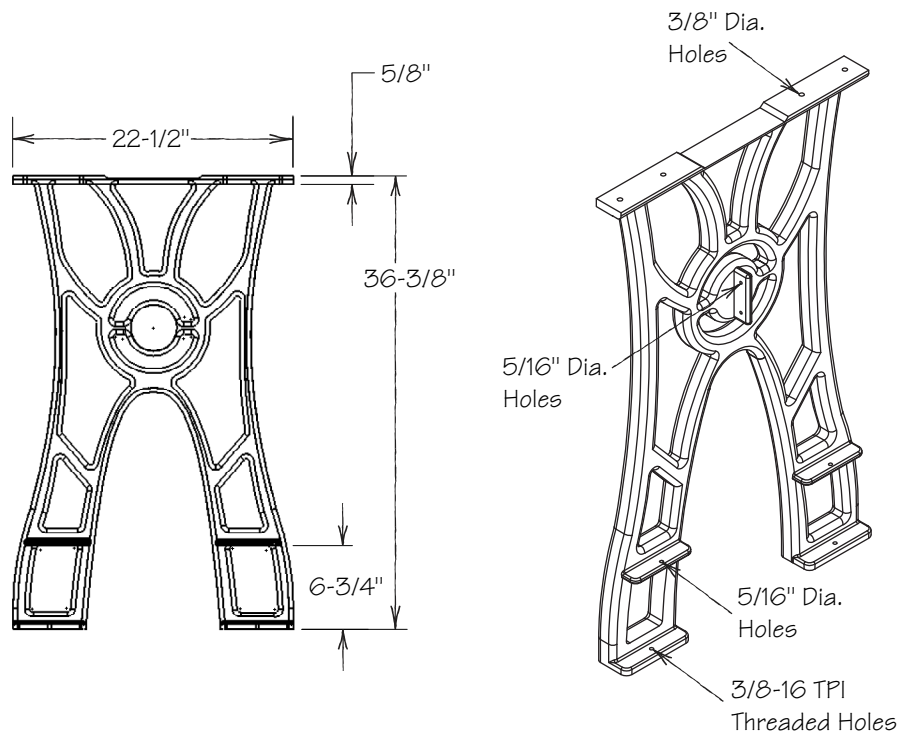
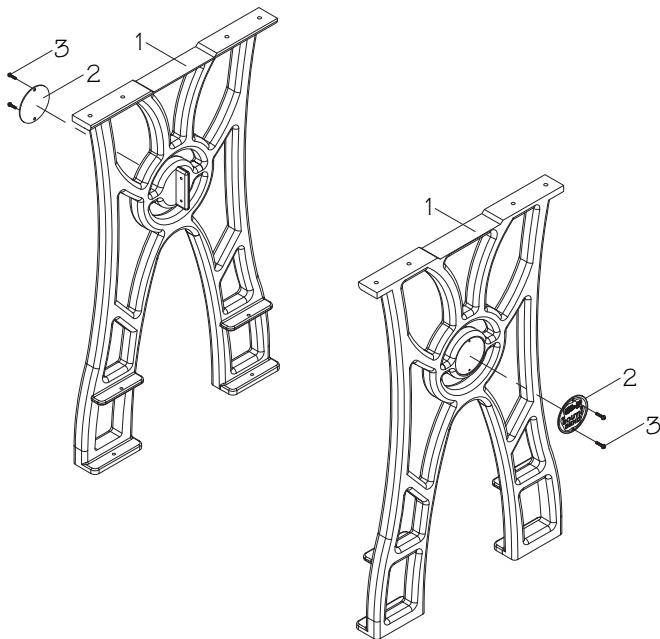


Figure 8. Common types of fasteners for securing machinery to concrete floors.

# Dimensions



# Parts\*



REF	PART #	DESCRIPTION
1	PSB1354001	CAST IRON LEG
2	SB1319	SOUTH BEND NAMEPLATE
3	PS06	PHLP HD SCR 10-24 X 3/8

\* Breakdown is for illustration purposes. Not all parts may be available for purchase.