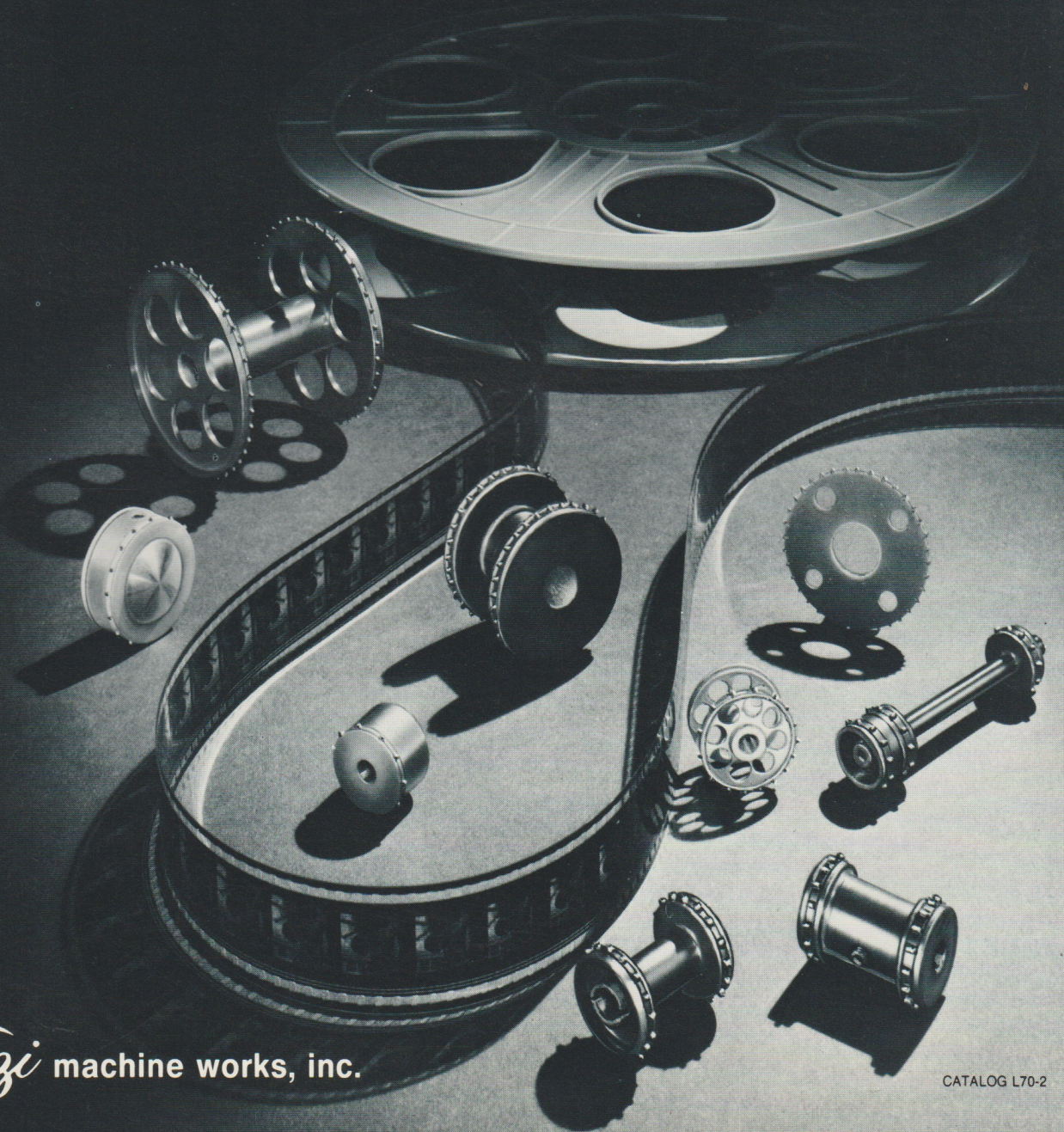


# PRECISION SPROCKETS FOR PERFORATED FILM

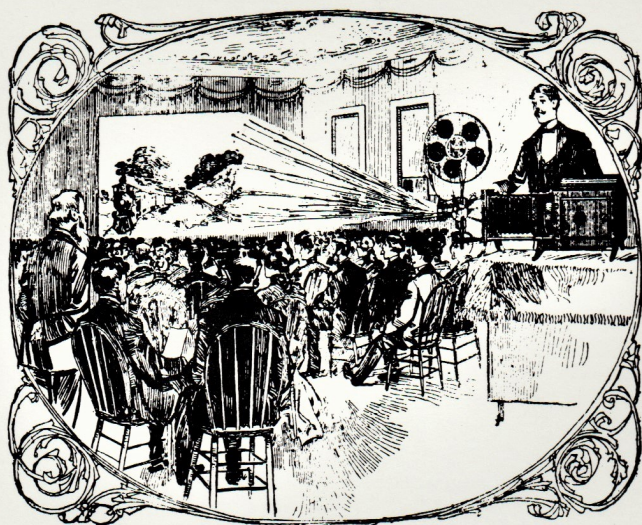




# LA VEZZI AND THE MOTION PICTURE INDUSTRY

During the infancy of the motion picture industry, LaVezzi Machine Works was founded and began manufacturing components—including a brass film sprocket—for hand-cranked motion picture projectors. Quality workmanship in sprockets was recognized as essential for good projection, and for proper care of the film.

Since that date in 1908, film sprockets have accounted for a major portion of LaVezzi production. The Company has placed the thrust of its engineering and production efforts into the manufacture of sprockets for motion picture film and tapes perforated according to the American National Standards Institute specifications, and to the manufacture of precision components for motion picture projectors and cameras.



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### QUALITY SPROCKETS FOR SIGHT AND SOUND

The quality of the picture and sound in a motion picture theatre is dependent to a large extent on the accuracy of sprockets controlling the film through the camera, the printer, processor, editor, synchronizer, recorder, projector and other pieces of equipment used in making the screen presentation possible. At LaVezzi, procedures have been established in engineering, production and quality control to produce sprockets that conform to the most rigid specifications and insure consistent quality in every type of film handling device. Particular attention is paid to machining each sprocket tooth to exact pitch and configuration. Maintaining exact tooth-to-tooth spacing provides for a smooth, even drive and longer wear life for the sprocket and the perforated film.

The film supporting surfaces are ground to assure close tolerances and concentricity, and to provide an abrasion-free surface to maintain the integrity of the film.

Many sprockets are manufactured with the exclusive LaVezzi Radi-Blend™ process that uniformly rounds all edges of the sprocket teeth, as well as other film-contacting surfaces. The Radi-Blend process incorporates a polishing, blending and smoothing operation to minimize film wear.

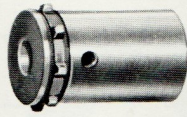
A series of sprockets are manufactured according to the LaVezzi Posi-Trol™ design. Described more thoroughly on pages 10 and 11, this line of positive control sprockets presents the latest concept in film control and careful film handling. These sprockets can be particularly useful in the simplification of projector design, too.

### CUSTOM SPROCKETS

While the sprockets in this catalog are available for off-shelf delivery, LaVezzi has developed special machinery and the technology to engineer and manufacture specialized sprockets to customer specifications. Virtually every type of high precision film sprockets imaginable has been produced for prototype and production quantities.

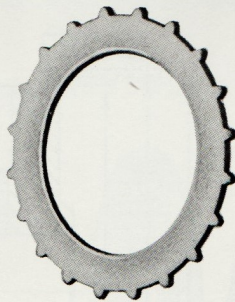
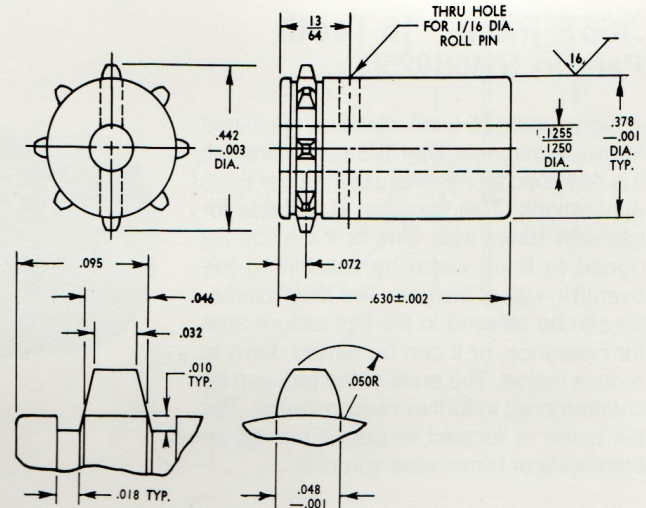
For sprockets manufactured to specification, LaVezzi will assist designers and engineers in the development of their product to determine the best sprocket specification for the application.





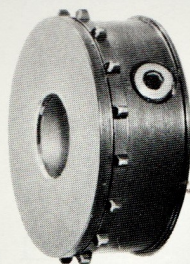
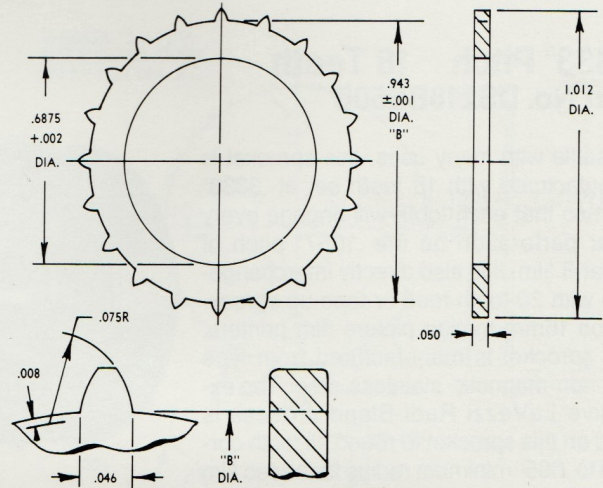
**.150" Pitch 8 Teeth**  
**Part No. 108B012D**

Used to drive tape and film perforated according to standards for 8mm film ANSI PH22.17, this 8-tooth sprocket is specifically designed to drive tape material that is dimensionally stable and not subject to shrinkage. The .378" diameter is intended for use with a tape having .004" thickness and is ground concentric with the center hole within .001" TIR. The .048" tooth width restricts backlash when the tape-driving direction is reversed. The sprocket is machined from type 303 non-magnetic stainless steel.



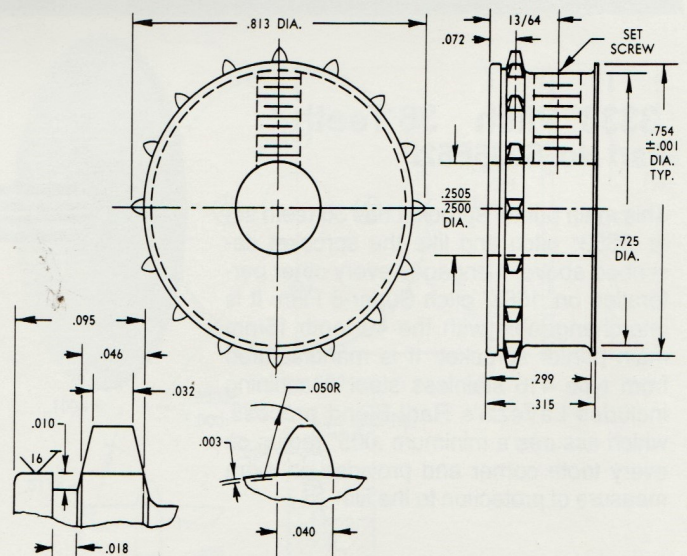
**.150" Pitch 20 Teeth**  
**Part No. 120A68J**

Machined from 2024-T4 aluminum, this economical 20-tooth sprocket is suitable for 8mm film or tape in applications where high precision is not a primary requirement. The wafer-type sprocket may be secured to a body, or other component of suitable material or design.



**.150" Pitch 16 Teeth**  
**Part No. 116B25D**

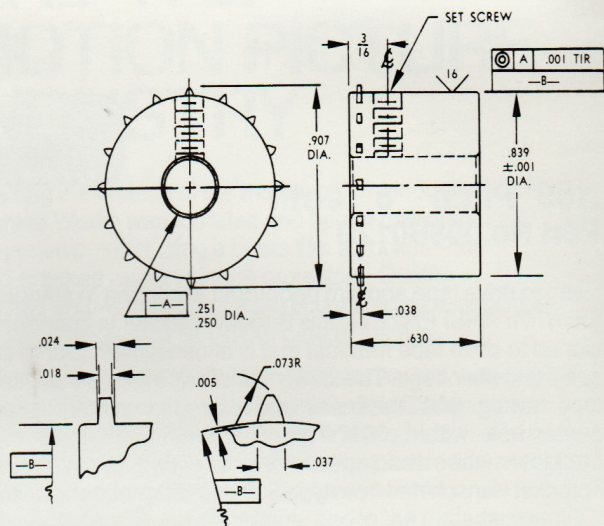
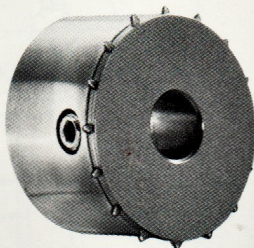
This high quality 16-tooth sprocket is used with 8mm film perforated according to ANSI PH22.17, and is designed for a variety of motion picture applications. Its non-magnetic type 303 stainless steel body makes it ideal for use with magnetic sound recording on film. It is manufactured according to standard practice for tooth-form, picture area clearance, etc. The .754" film diameters are ground concentric to the 1/4" bore within .001" TIR.





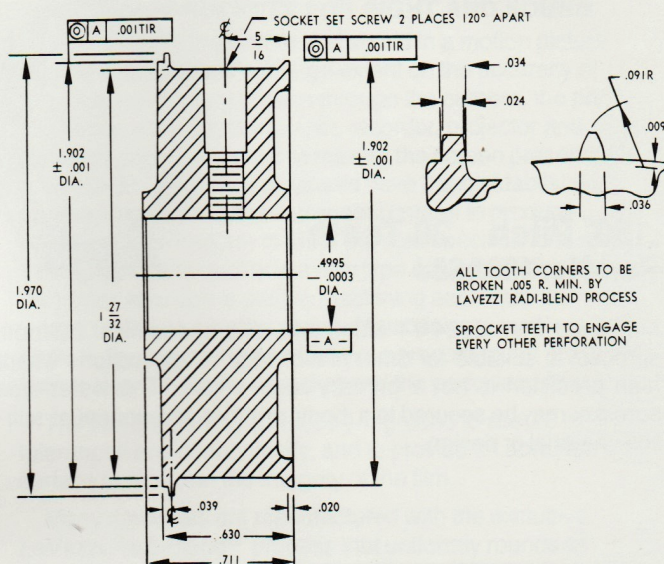
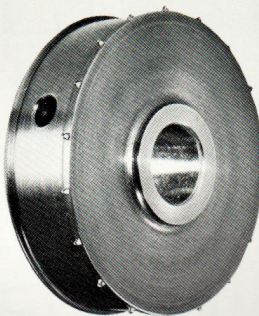
### .1667" Pitch 16 Teeth Part No. S116B025D

A high quality 16-tooth sprocket machined from non-magnetic type 303 stainless steel, it is designed for general use in Super 8mm applications. This sprocket is suitable for use with 16mm wide film, or it may be reduced to 8mm width by machining the overall length of the part. The .839" diameter can be relieved in the film picture area for clearance, or it can be turned down to reduce inertia. The ends of the part can be counterbored to further reduce inertia. The set screw is located to permit use as an 8mm wide or 16mm wide sprocket.



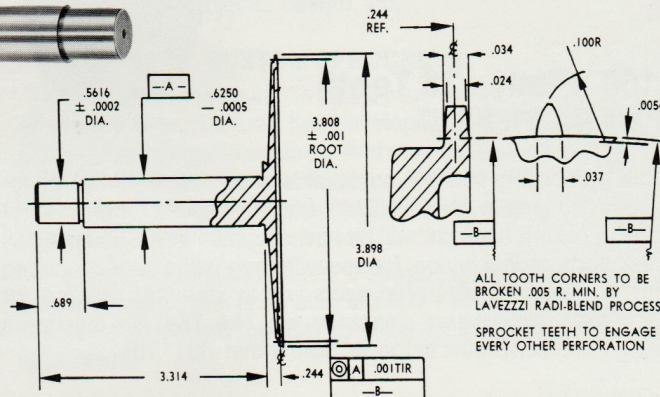
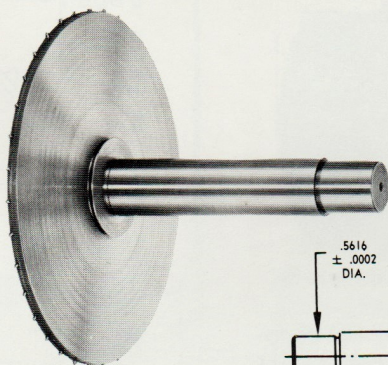
### .3333" Pitch 18 Teeth Part No. DS218BE50D

Versatile with many uses, this sprocket is manufactured with 18 teeth set at .3333" pitch so that each tooth will engage every other perforation on the .1667" pitch of Super-8 film. It is also directly interchangeable with 20-tooth feed or tape-up sprockets on 16mm motion picture film printers. The sprocket is manufactured from type 303 non-magnetic stainless steel. The exclusive LaVezzi Radi-Blend process is used on this sprocket to round all tooth corners to .005" minimum radius for added film protection.



### .3333" Pitch 36 Teeth Part No. S236E62F

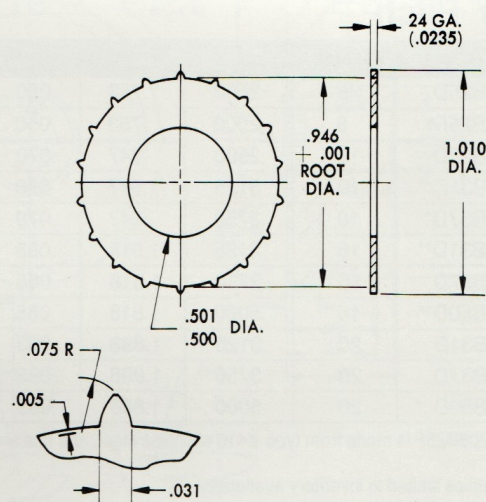
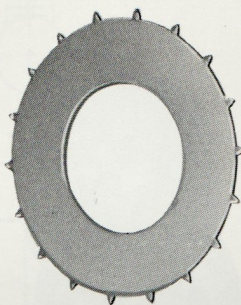
This main printer sprocket has 36 teeth set at .3333" pitch and like the sprocket described above, it engages every other perforation on .1667" pitch Super-8 Film. It is interchangeable with the 40-tooth 16mm main printer sprocket. It is manufactured from type 416 stainless steel. Machining includes LaVezzi's Radi-Blend process, which assures a minimum .005" radius on every tooth corner and provides an extra measure of protection to the film.





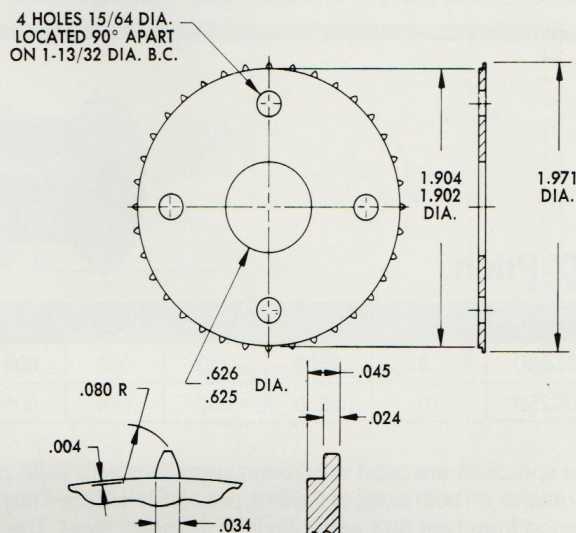
### .1667" Pitch 18 Teeth Part No. S118A50E

This 18-tooth, wafer-type sprocket is machined from type 316 non-magnetic stainless steel. It is suitable for film processing equipment applications, projectors, editors, viewers, etc., and is readily adaptable for equipment conversion. It has a root diameter equivalent to a 10-tooth 16mm, or a 16-tooth 35mm sprocket.



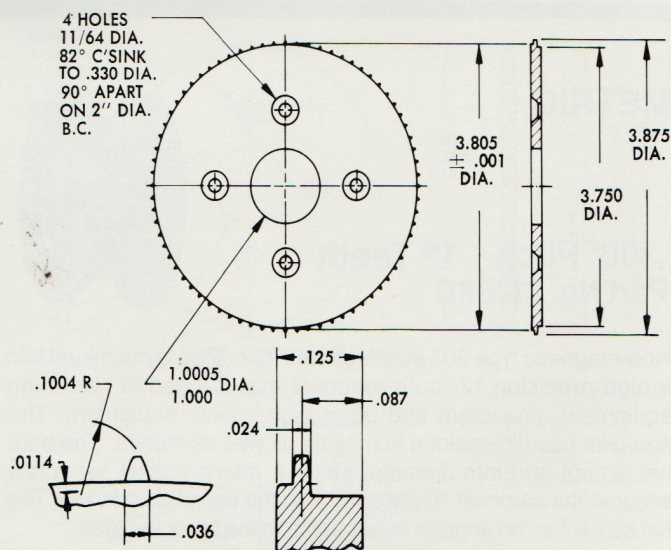
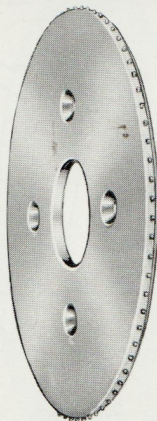
### .1667" Pitch 36 Teeth Part No. S136A62E

Manufactured from type 316 non-magnetic stainless steel, this wafer-type sprocket is applicable to film processing equipment, editors, etc. The sprocket includes a 1.904/1.902" film supporting diameter adjacent to the sprocket teeth. The diameter is equivalent to a 20-tooth 16mm sprocket, or a 32-tooth 35mm sprocket. The mounting holes have no relationship to the sprocket teeth.



### .1667" Pitch 72 Teeth Part No. S172A100J

This 72-tooth sprocket is manufactured from type 2024-T3 aluminum and is suitable for editors, synchronizers, measuring equipment, etc. The 3.805" diameter adjacent to the sprocket teeth is the film supporting diameter and is equivalent to a 40-tooth 16mm sprocket, or a 64-tooth 35mm sprocket, making conversion a relatively easy procedure. The four mounting holes are unrelated to the sprocket teeth.





## STANDARD SPROCKETS FOR FILM & TAPE

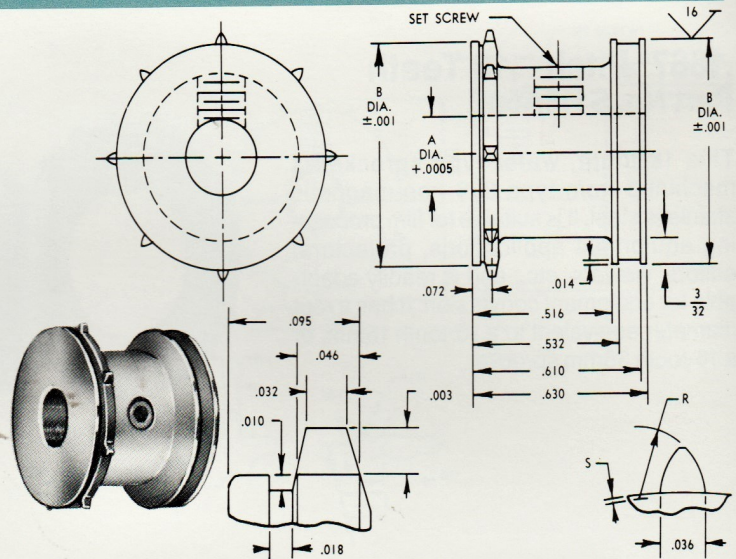
## .300" Pitch

Part No.	Teeth	“A”	“B”	“R”	“S”
208B25D	8	.2500	.753	.050	.003
208B25F*	8	.2500	.753	.050	.003
210B25D	10	.2500	.947	.070	.0055
210B31D**	10	.3125	.947	.070	.0055
210B37D**	10	.3750	.947	.070	.0055
216B31D**	16	.3125	1.518	.085	.009
216B37D	16	.3750	1.518	.085	.009
216B50D**	16	.5000	1.518	.085	.009
220B31D	20	.3125	1.898	.093	.011
220B37D	20	.3750	1.898	.093	.011
220B50D	20	.5000	1.898	.093	.011

\* Part 208B25F is made from type #416 stainless steel, and has two set screws at 90°.

\*\* Quantities limited to inventory availability.

These sprockets are used with 16mm sound film that have .300" pitch perforations on one side of the film only per ANSI PH22.12. The film supporting diameters—"B" in drawing—are ground concentric with the "A" center hole. These sprockets are

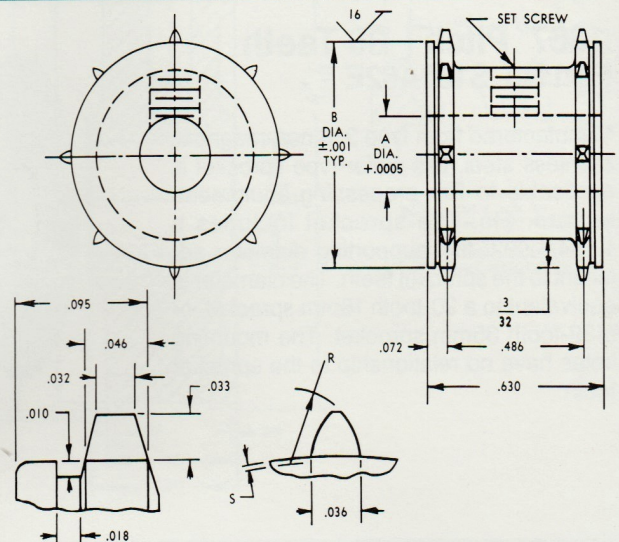
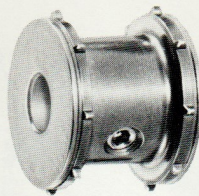


machined from type 303 non-magnetic stainless steel, except 208B25F which is machined from type 416 stainless steel. The 208B25F sprocket includes two set screws 90° from each other.

## .300" Pitch

Part No.	Teeth	"A"	"B"	"R"	"S"
208C25D	8	.2500	.753	.050	.003
210C25D	10	.2500	.947	.070	.0055

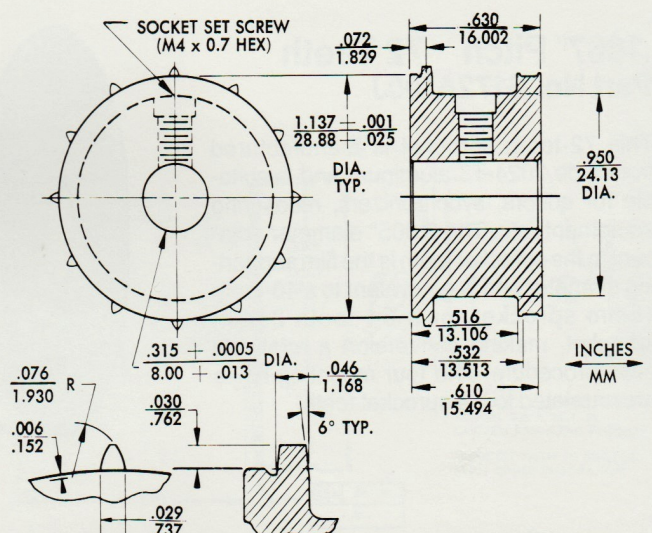
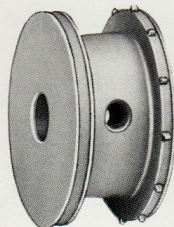
These sprockets are used with 16mm silent films with .300" pitch perforations on both sides of the film, per ANSI PH22.5. They are machined from type 303 non-magnetic stainless steel. The film supporting diameters are ground concentric with the center hole diameter.



## METRIC

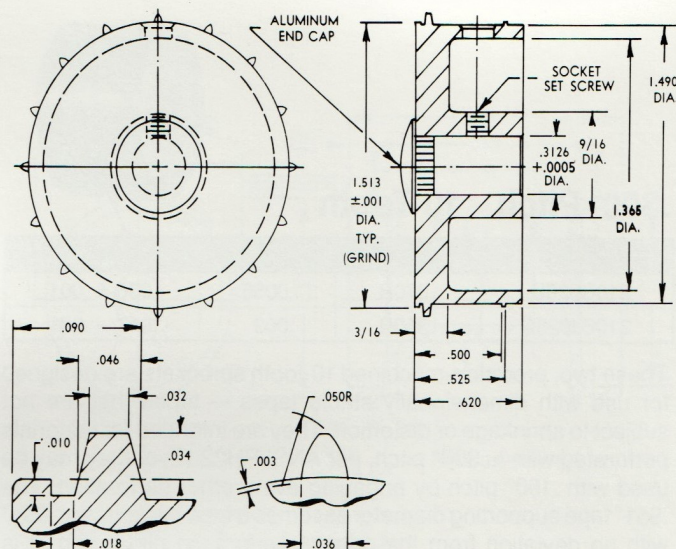
**.300" Pitch 12 Teeth**  
**Part No. 212B8D**

Non-magnetic type 303 stainless steel bar stock is machined into a high precision 12-tooth sprocket that is used in recording equipment, projectors and other high quality equipment. The sprocket has dimensions in metrics as well as inches. The bore will accept an 8mm diameter shaft. A metric socket set screw secures the sprocket to the shaft with the use of a 2mm key. The set screw has no angular relationship to the sprocket teeth.

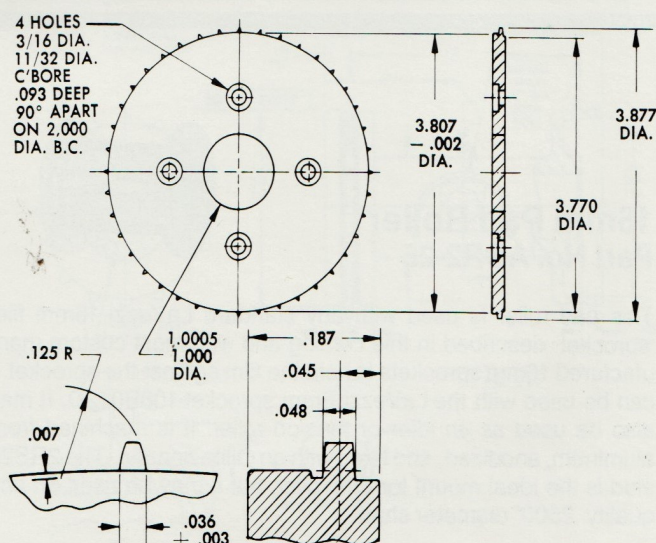
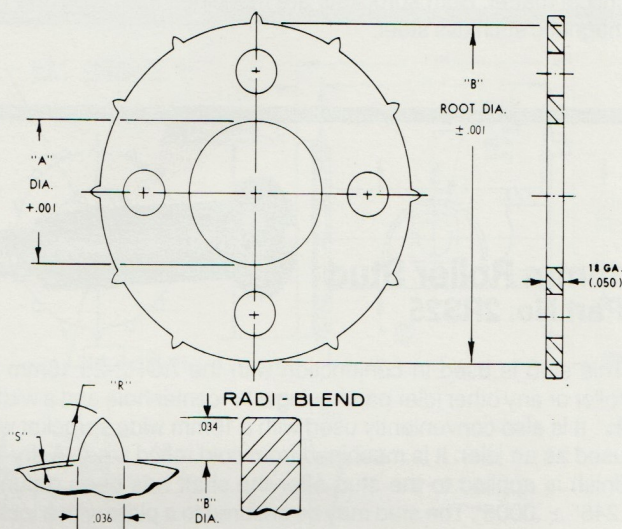




# 16 mm

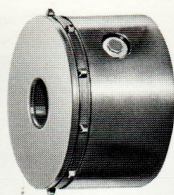


Part No.	Teeth	"A"	"B"	"R"	"S"
212A68E	12	.6875	1.133	.076R	.006
220A62E	20	.625	1.898	.093R	.011
220A75E	20	.750	1.898	.093R	.011
220A100E	20	1.000	1.898	.093R	.011





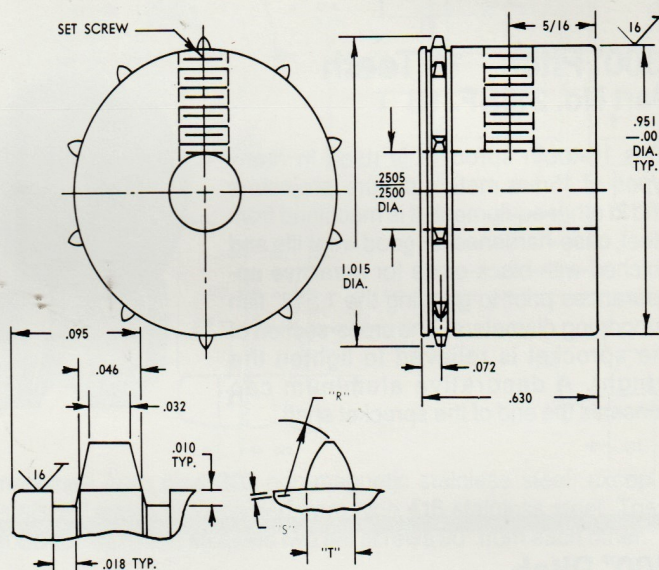
## STANDARD SPROCKETS AND PARTS FOR FILM & TAPES



**.300" Pitch 10 Teeth**

Part No.	"R"	"S"	"T"
210B025D	.070R	.0055	.036 ± .001
210BJ025D	.050R	.003	.047 – .001

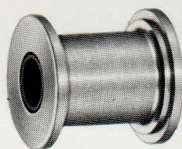
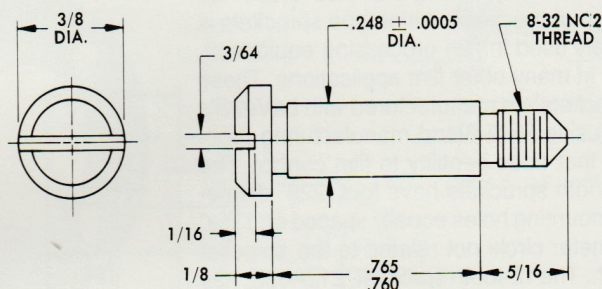
These two, precision-machined 10-tooth sprockets are designed for use with dimensionally stable tapes — tapes that are not subject to shrinkage or distortion. They are intended for materials perforated with a .300" pitch, per ANSI PH22.12; or they may be used with .150" pitch by engaging every other perforation. The .951" tape supporting diameter assumes a tape thickness of .004" with no deviation from the original perforating dimension. It is ground concentric with the center hole within .001" TIR. The tooth design of 210BJ025D restricts backlash at the reversal of the tape travel direction, while 210B025D is used where backlash is not a critical matter. Both sprockets are machined from type 303 non-magnetic stainless steel.



## 16mm Roller Stud

### Part No. 2RS25

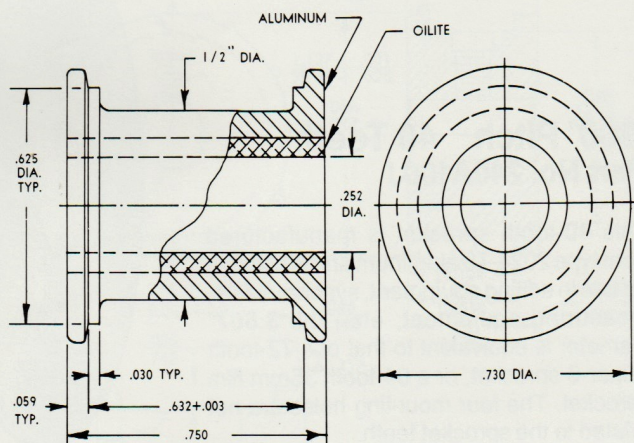
This stud is used in conjunction with the AOR2-25 16mm pad roller or any other idler part having a 1/4" center hole and a width of 3/4". It is also conveniently used with a 16mm wide sprocket when used as an idler. It is machined from cold rolled steel. A dry-lube finish is applied to the stud after the shaft has been ground to .248"  $\pm$  .0005". The stud may be secured to a plate with a lock nut on the 8-32 thread, or it may be secured directly into a tapped hole in a plate, housing, or arm.



## 16mm Pad Roller

Part No. AOR2-25

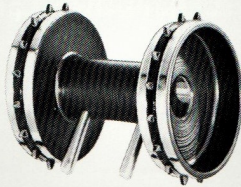
This pad roller is used with any standard LaVeZZi 16mm film sprocket described in this catalog and with most custom manufactured 16mm sprockets to hold the film against the sprocket. It can be used with the LaVeZZi 8mm sprocket 108B012D. It may also be used as an idler or tension roller. It is machined from aluminum, anodized, and fitted with an Oilite bearing. The 2RS25 stud is the ideal mount for this roller, but it may be used on any quality .2500" diameter shaft.



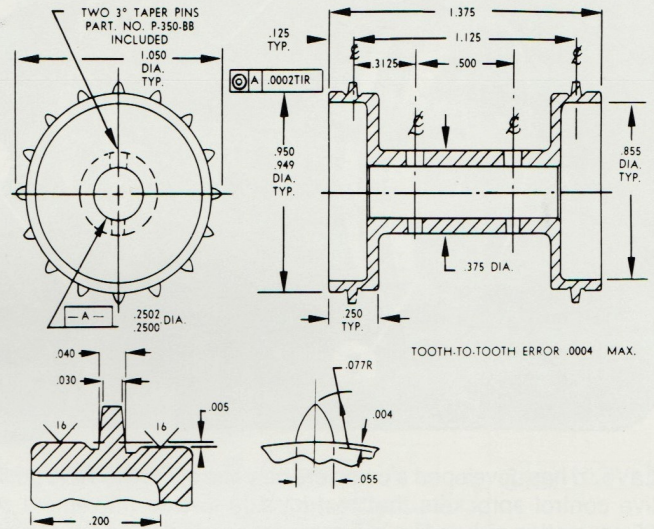


These sprockets are designed for advancing 35mm motion picture film perforated per ANSI PH22.1, PH22.102, or PH22.139 (.1870" pitch). See page 14. They are primarily used for intermittent drive applications in theatrical projection equipment, or in other applications where low inertia is required. These sprockets are manufactured to rigid specifications. Great care is exercised during manufacture to control tooth-to-tooth accuracy, concentricity, squareness and dimensional tolerance.

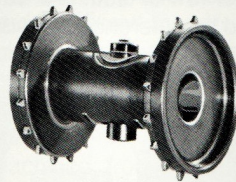
## .1870" Pitch 16 Teeth Part No. 416T25B



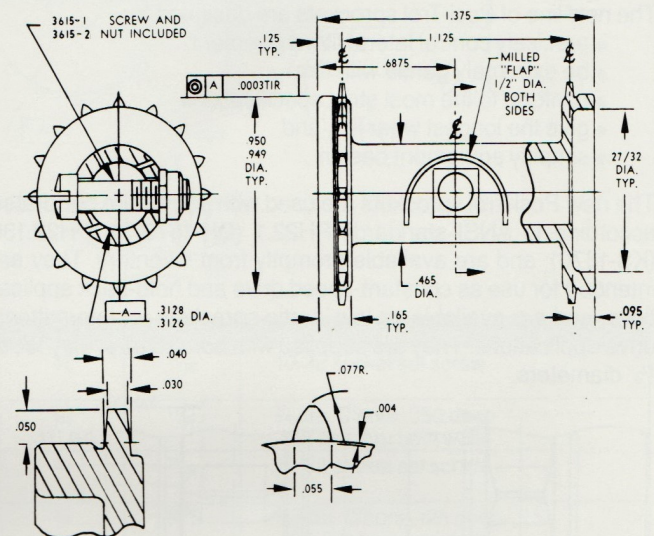
Two taper pins secure this sprocket to any 1/4" diameter shaft. Machined from steel, the 16 teeth and film supporting diameters of this low inertia sprocket are case hardened for long wearability. Two taper pins are included with the sprocket and a taper pin reamer is available to fit the pins to the sprocket and shaft. (Order type "A" helical pin reamer).



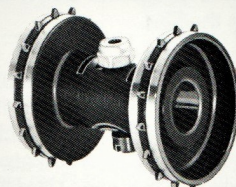
## .1870" Pitch 16 Teeth Part No. 416DG31M



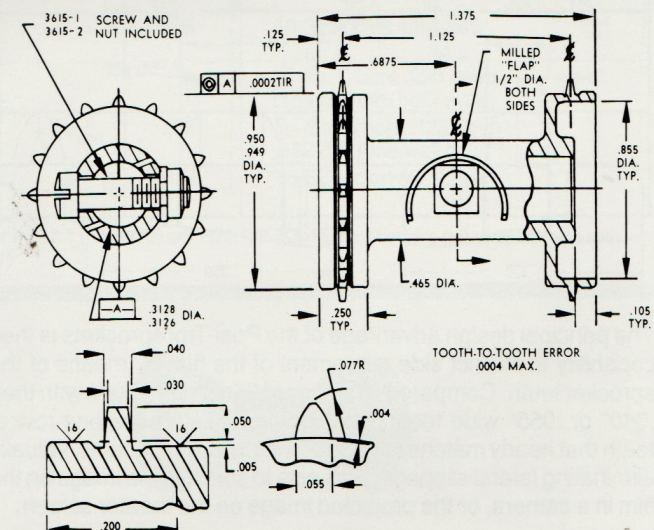
This 16-tooth, low-inertia sprocket is machined from 6061-T6 aluminum for extra light-weight, and finished with a .0015/.0020" thick hard-coat for good wear resistance. The inside film supporting surfaces have been removed to reduce the weight of the sprocket to the lowest practical limit.



## .1870" Pitch 16 Teeth Part No. 416T31B



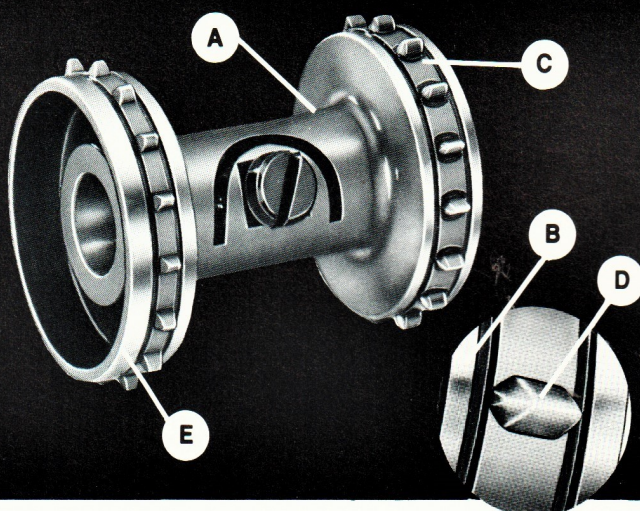
This sprocket, like the other sprockets described on this page, is used in many types of theatre projectors, and in other applications where low inertia is required. Machined from steel, this 16-tooth sprocket has its film supporting diameter and tooth section heat treated for maximum wearability. The sprocket is secured to a .3126/.3124" diameter shaft with a special bolt and nut arrangement that provides a secure fit without distorting the sprocket in any way.





# 35mm

## POSI-TROL™ POSITIVE CONTROL SPROCKETS



**A Available for drive and hold-back constant-speed applications; low-inertia intermittent drives**

**B Fine surface finish minimizes film abrasion and wear**

**C Radi-Blend process smoothes all film-contacting surfaces; extends film life**

**D Tooth radius avoids contact with corners of film perforations; reduces chance of film tears**

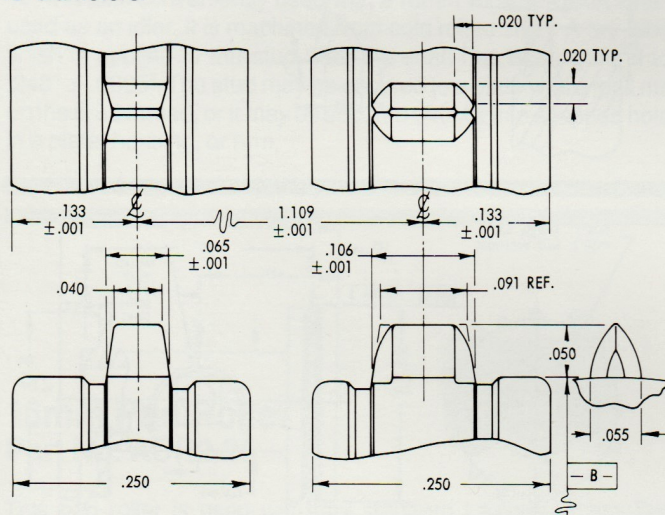
**E Film diameters are concentric to the bore**

LaVezzi has developed a complete new line of POSI-TROL positive control sprockets that restrict side-to-side movement of 35mm motion picture film in a camera or projector, and minimize the chance for film damage.

The new line of Posi-Trol sprockets are designed to:

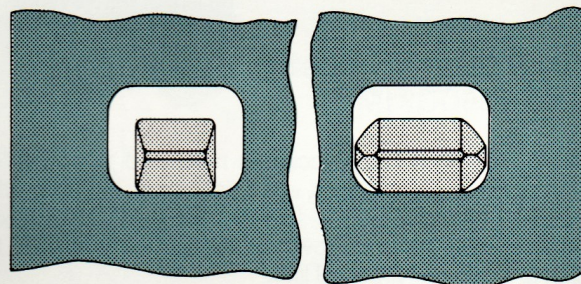
- precisely control lateral film movement
- be extremely gentle with film
- conform to the most strict specifications
- give the longest wear life, and
- simplify equipment design

The new Posi-Trol sprockets are used with 35mm film perforated according to ANSI standards PH22.1 (DH-1870) or PH22.139 (KS-1870), and are available promptly from inventory. They are intended for use as constant-speed drive and hold-back applications, and are available as low inertia sprockets for intermittent-drive applications. They are supplied with bore sizes of  $\frac{5}{16}$ ",  $\frac{3}{8}$ ", or  $\frac{1}{2}$ " diameters.



The principal design advantage of the Posi-Trol sprockets is their capability to restrict side movement of the film by means of the sprocket teeth. Compared to standard 35mm sprockets with their .040" or .055" wide teeth, Posi-Trol sprockets have one row of teeth that nearly matches the .110" wide film perforations, virtually eliminating lateral slippage. This acts to stabilize the image on the film in a camera, or the projected image on the theater screen.

Pictured here is a set of film perforations—one on each side of the 35mm film—with the teeth of the Posi-Trol sprocket shown in the driving position. The four corners of each of the wider teeth are machined to a radius to avoid interference with the fillet radius in the corner of the perforation—the point where film damage usually begins. The second row of teeth has a driving face of .065" and compensates for any variation in the width of the film. The wider row of teeth is always used on the side of the film considered the reference or guided edge.



All features of this line of sprockets have been redesigned to take advantage of the latest manufacturing techniques. Concentricity, tooth alignment, tooth registration, and surface finishes are important considerations in the rigid quality control program. The manufacture of Posi-Trol sprockets includes LaVezzi's exclusive RADI-BLEND™ process which uniformly rounds all edges of the sprocket teeth and other film-contacting surfaces and produces a 16-micro finish or better on every surface that comes in contact with the film.

In conjunction with the engineering design and the Radi-Blend manufacturing process, material selection and heat treatment have been carefully selected for the best surface finish and wear life, and to reduce film abrasion, thereby maintaining the original quality of the film. Posi-Trol sprockets can simplify equipment design by minimizing the dependence on flanges, shoes, rollers and other edge guides that are used to restrict the lateral movement of film.

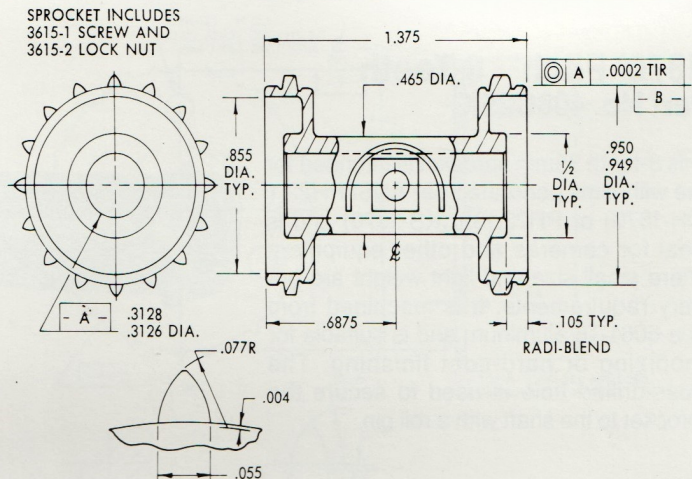
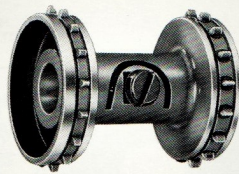
**NOTE:**

Posi-Trol positive control sprockets are to be used with tape or film perforated per PH22.1 (DH-1870) or PH22.139 (KS-1870). They are not suited for use with narrow CinemaScope-type perforations per PH22.102 (CS-1870). (see page 14)



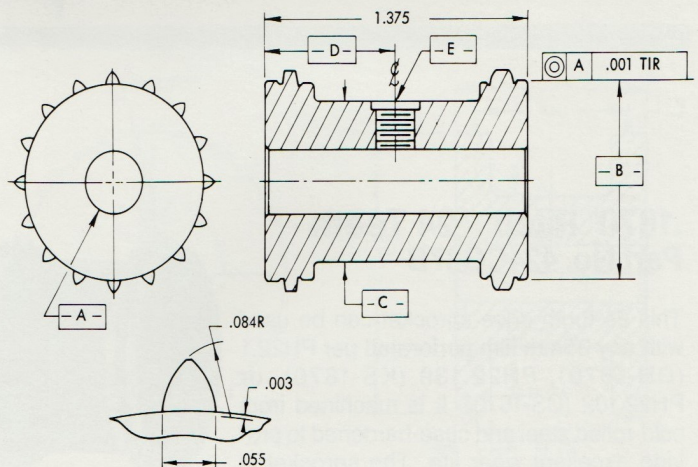
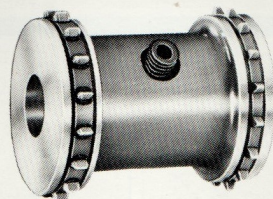
## .1870" Pitch 16-Teeth Part No. L2SP31

One of the most widely used Posi-Trol sprockets, this precisely machined, low-inertia sprocket is designed for rapid intermittent movement applications and in similar situations where the critical control of film or tape is essential to the operation. This sprocket contains all the Posi-Trol features described on the preceding page. It is machined from steel using the exclusive Radi-Blend process, and heat-treated for best wear.



## .1870" Pitch

This group of Posi-Trol positive-control sprockets is intended for use in constant-speed applications, and is offered in drive or holdback sizes. Designed to laterally guide film or tape by means of a row of sprocket teeth, these sprockets minimize side-to-side movement of the media with only limited reliance on flanges, shoes, guides, or other items in contact with the edge of the media. All Posi-Trol sprockets are machined from hardened steel and manufactured with the exclusive Radi-Blend process.

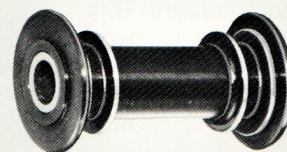


Part No.	Function	Teeth	-A-	-B-	-C-	-D-	-E-
L3SP31	Drive	16	.3130 .3125	.947 .946	3/4	11/16	10-32 socket set screw
L3CP31	Drive	16	.3130 .3125	.947 .946	9/16	11/16	1/4 dia. C'bore .050 deep .154 drill thru both walls
L3RS37	Drive	16	.3755 .3750	.947 .946	3/4	11/16	10-32 socket set screw
L3SS37	Drive	16	.3755 .3750	.947 .946	3/4	.875	5/16 dia. C'bore .125 deep .182 drill (one wall only)
L3XL37	Drive	24	.3755 .3750	1.422 1.420	1.218	11/16	Special combination screw & pin
L4RS31	Holdback	16	.3130 .3125	.940 .939	3/4	11/16	10-32 socket set screw
L4CS31	Holdback	16	.3130 .3125	.940 .939	9/16	11/16	1/4 dia. C'bore .050 deep .154 drill thru both walls
L4SS37	Holdback	16	.3755 .3750	.940 .939	3/4	.750	5/16 dia. C'bore .125 deep .182 drill (one wall only)
L4BS50	Holdback	16	.5005 .5000	.940 .939	7/8	11/16	10-32 socket set screw

**NOTE:** Posi-Trol positive control sprockets are to be used with tape or film perforated per PH22.1 (DH-1870) or PH22.139 (KS-1870). They are not suited for use with narrow CinemaScope-type perforations per PH22.102 (CS-1870). (see page 14)

## POSITIVE CONTROL PAD ROLLER

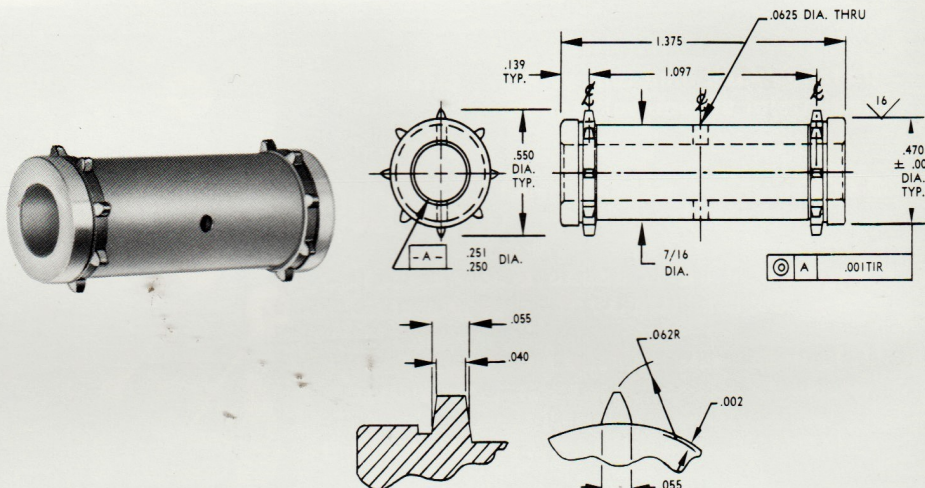
SOR4-22 is a very high precision pad roller that is specifically designed for use in conjunction with the sprockets described above. It provides an extra measure of critical control of film or tape. See page 17 for details.





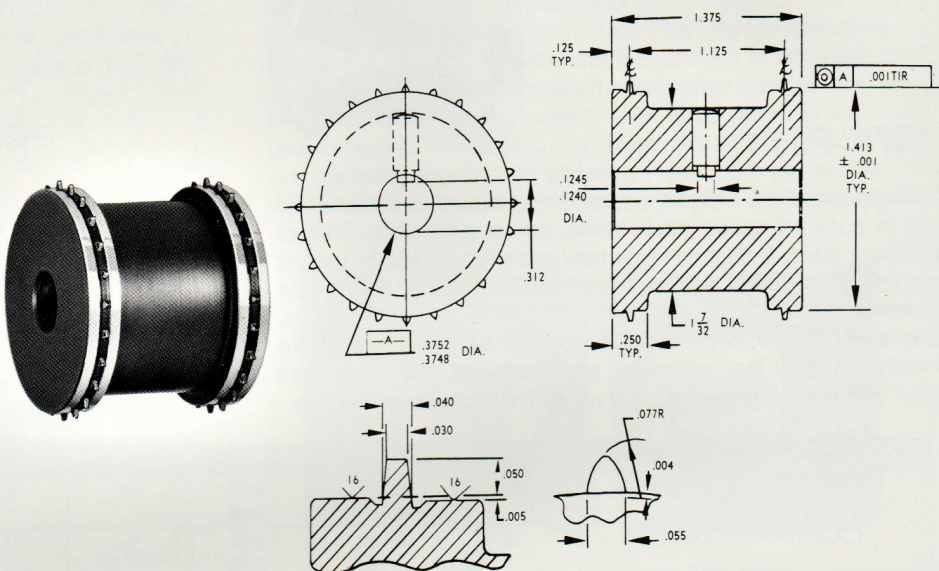
### .1870" Pitch 8 Teeth Part No. 408C25K

This 8-tooth 35mm sprocket is intended for use with films perforated per ANSI PH22.1 (DH-1870) or PH22.139 (KS-1870) and is ideal for cameras and other equipment where small size and light weight are primary requirements. It is machined from type 6061-T6 aluminum and is suitable for anodizing or hard-coat finishing. The cross-drilled hole is used to secure the sprocket to the shaft with a roll pin.



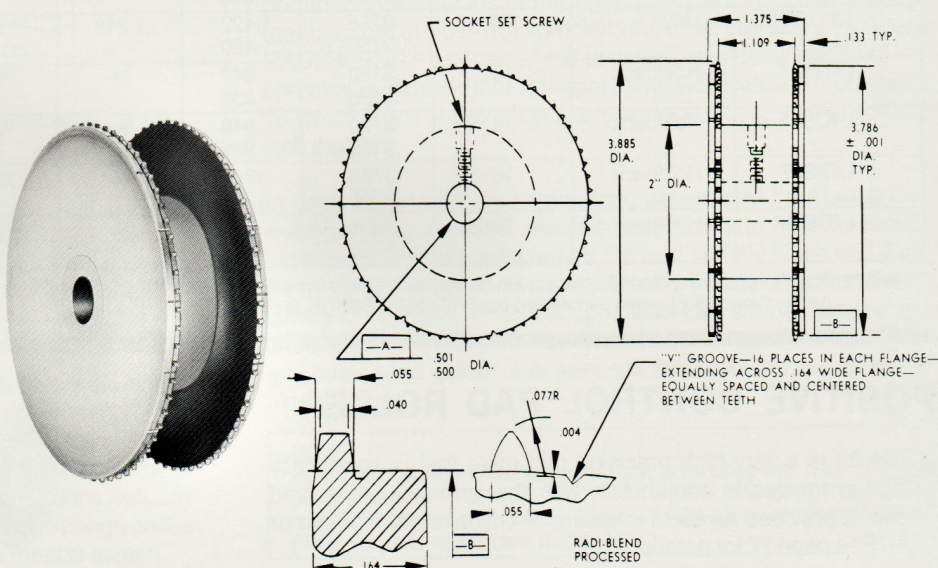
### .1870" Pitch 24 Teeth Part No. 424CG37B

This 24-tooth drive sprocket can be used with any 35mm film perforated per PH22.1 (DH-1870), PH22.139 (KS-1870), or PH22.102 (CS-1870). It is machined from cold-rolled steel and case-hardened to provide excellent wear life. The sprocket is finished with black oxide and the sprocket's film supporting surfaces are ground for good appearance.

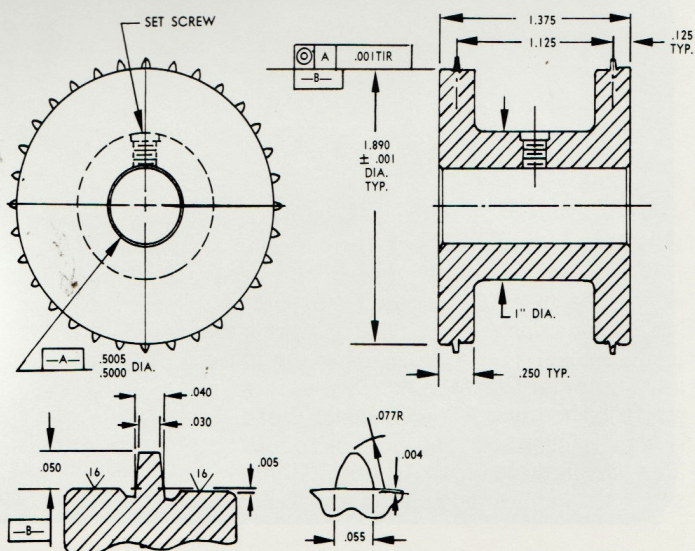
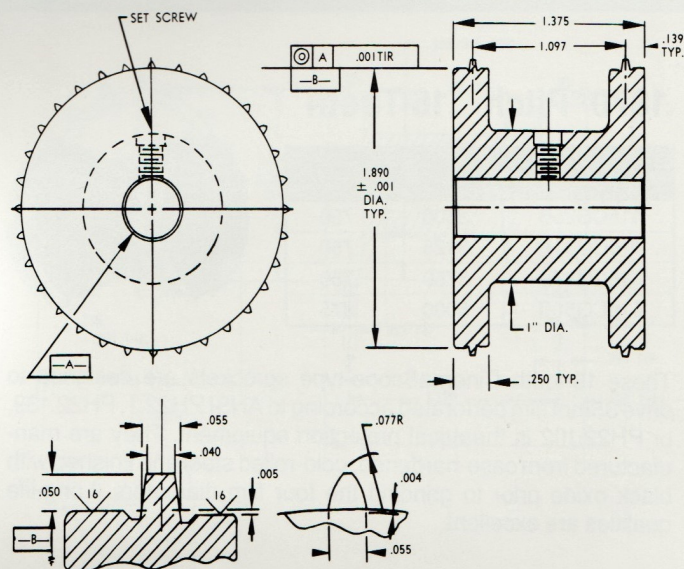
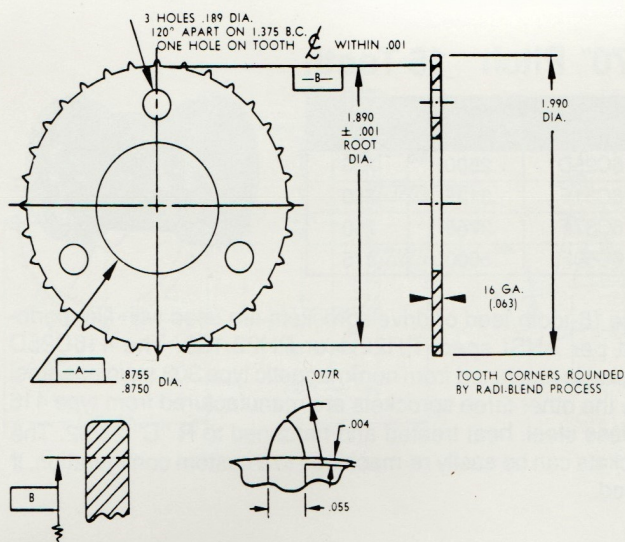


### .1870" Pitch 64 Teeth Part No. 464C50J

With a machined line at each four-tooth interval for a frame marker, this quality 64-tooth sprocket is often used in film measuring equipment or synchronizers. It is machined from type 2024-T4 aluminum and is suitable for an anodized finish. It is equivalent in diameter to a 40-tooth 16mm sprocket, or a 72-tooth Super-8 sprocket.



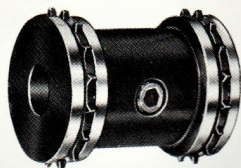




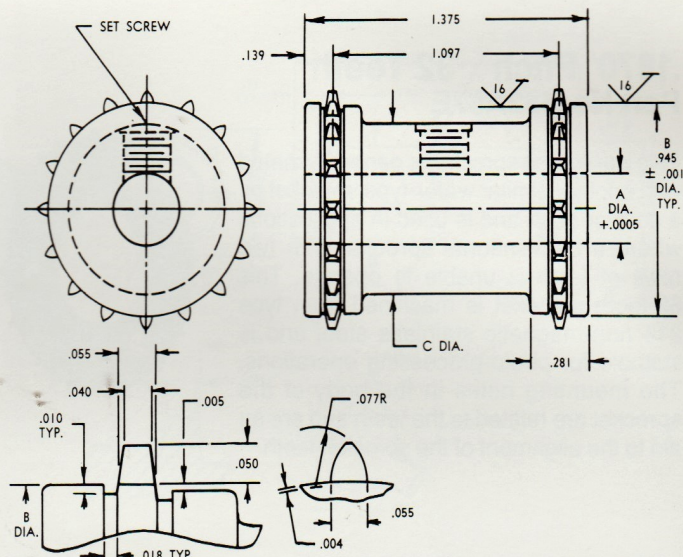


**.1870" Pitch 16 Teeth**

Part No.	'A' In.	'C' In.
416C25D	.2500	.750
416C31F	.3125	.750
416C37F	.3750	.750
416C50F	.5000	.875

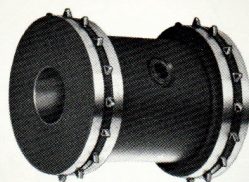


These 16-tooth feed or drive sprockets are used with film perforated per ANSI spec. PH22.1 or PH22.139. The 416C25D sprocket is machined from non-magnetic type 303 stainless steel while the other three sprockets are manufactured from type 416 stainless steel, heat treated and hardened to R "C" 23/32. The sprockets can be easily re-machined to a custom configuration, if needed.

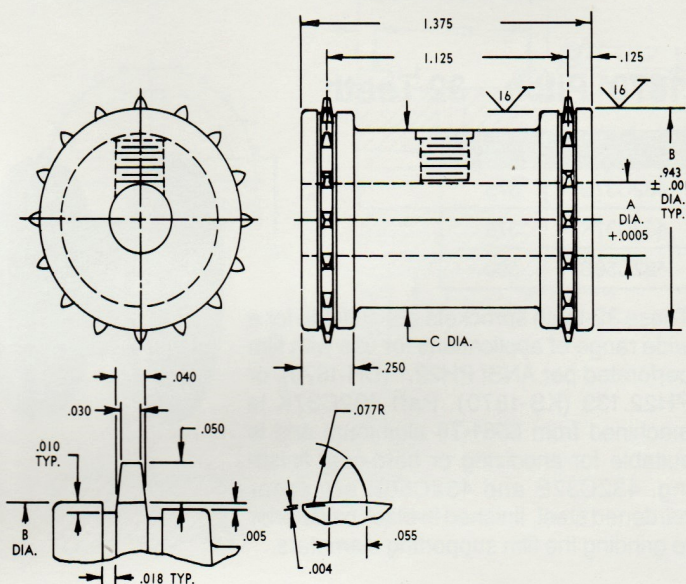


**.1870" Pitch 16 Teeth**

Part No.	"A" In.	"C" In.
416CG25B	.2500	.750
416CG31B	.3125	.750
416CG37B	.3750	.750
416CG50B	.5000	.875



These 16-tooth CinemaScope-type sprockets are designed to drive 35mm film perforated according to ANSI PH22.1, PH22.139, or PH22.102 in theatrical projection equipment. They are manufactured from case-hardened, cold-rolled steel and finished with black oxide prior to grinding the four film diameters. Long-life qualities are excellent.



# 35mm FILM PERFORATION STANDARDS

The American National Standards Institute has published a broad range of standards for film using rectangular perforations.

Most of the standards originated in the motion picture industry and are sponsored by the Society of Motion Picture and Television Engineers. The full description of these standards is available from ANSI or SMPTE. The design engineer is encouraged to review these documents for detailed information prior to the development of the film handling equipment.

Your LaVezzi catalog makes frequent mention of three standards for 35mm film perforations. Briefly, the PH22.1

film has two rows of perforations .110" wide by .073" high and a center to center distance of 1.109". The PH22.139 film is similar except the perforation height is .078". Often referred to as "CinemaScope", film per PH22.102 has smaller perforations that are set closer to the outer edges of the film. The perforations are .078" wide by .073" high and have a center-to-center dimension of 1.127".

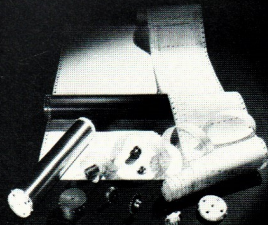
The sprockets described in this catalog which have two rows of teeth on centers of 1.125" may be used with all three film types. Sprockets with center distances of 1.097" or 1.109" are used only with film perforated per PH22.1 or PH22.139.



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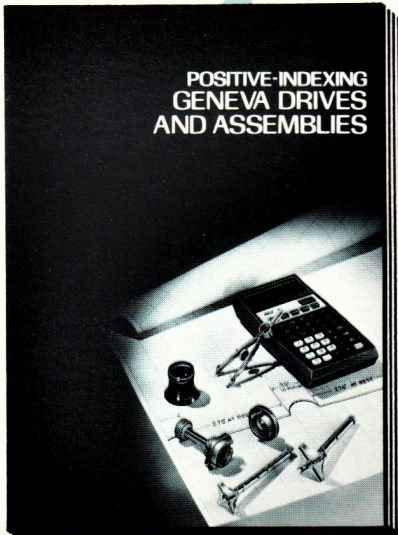
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Effective June 1, 1982

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C12	18	7.50	6.75	6.00	4.50	416C31F	14	29.50	26.55	23.60	17.70
C12-70	19	7.75	7.36	6.98	6.20	416C37F	14	29.50	26.55	23.60	17.70
E73C	18	20.35	18.32	16.28	12.21	416C50F	14	30.50	27.45	24.40	18.30
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S116BO25D	4	23.50	22.33	21.15	18.80	416GL50B	L70-6	32.00	28.80	25.60	19.20
S118A50E	5	8.50	8.08	7.65	6.80	416T25B	9	35.00	31.50	28.00	21.00
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216B31D	6	36.00	34.20	32.40	28.80	716C31K	19	37.50	35.63	33.75	30.00
216B37D	6	35.00	33.25	31.50	28.00	716C37K	19	37.50	35.63	33.75	30.00
216B50D	6	36.00	34.20	32.40	28.80	813C25K	19	40.50	38.48	36.45	32.40
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