Attachments and Spare Parts for Multi-Spindle Automatic Screw Machines

machine
Schutte

for models
SD32 SE16 SF13 AF26
AD40 SE25 SF20 AF32
SD50 SF26 SF26L SF32

catalog #
Schutte
Attachments Catalog
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THREADING ATTACHMENT for

SD32   SE16   SF13   AF26
AD40   SE25   SF20   AF32
SD63   SF26   SF26L  SF32  SF40

We can supply the entire attachment. That means all the sequence of shafts, gears, electromagnetic clutches, bearings and everything else is needed to start the threading operation. All gears and shafts are hardened and grinded as Schutte’s quality needs. The mechanical parts are supplied already fitted together when it is possible.

The electromagnetic clutches are piloted by our Power Unit, that is also able to stop the machine in case of malfunction during the threading operation. Our new concept threading spindles do not require any tap-holder, in fact its frontal part (collet spindle) can slide out the support and follow the tapping operation. That is why we can check the length of the thread directly on the extraction of the collet spindle. SEE NEXT PAGE...
THREADING SPINDLES

This is the adjustable cam that determines the length of the thread.

When the cam touches this side-microswitch, the outway speed for the tap is started.

This back microswitch checks if the collet-spindle is returned to its proper position after the tapping operation.

All necessary lubrication fittings are supplied.

The extension available is much longer than you may ever need.

The collet-spindle slides out very fluently thanks to pin-keys running in 3 grooves at 120 degrees on its stem.

There are 3 different sizes for our threading spindles:

SIZE 1
- with ER25 collet
- Suitable for
  - SE16
  - SF13, SF20, SF26L

SIZE 2
- with ER32 collet
- Suitable for
  - SD32, AD40
  - SE25
  - SF26, SF32, AF26, AF32

SIZE 3
- with Bilz quick-change adapter
- Suitable for
  - SD32, SD40, SD50, SD63
  - SF40, SF42, SF51, SF67

SIZE3 threading spindle

Shock absorber joint

The tool-spindle is designed to receive Bilz quick-change adaptor size 3.
POLYGON AND THREAD MILLING ATTACHMENT for

SD32  SE16  SF13  AF26
AD40  SE25  SF20  AF32
SD50
SD63  SF26L
SF26
SF32
SF40
SF42
SF67

We can also supply cutter tools for polygon generating operations. As you can see in this picture, they have the possibility to hold 1 cutter or 2 cutters at 180° or 3 cutters at 120°. We can supply different sizes of cutters that need to be ground by the customer.
POLYGON ATTACHMENT WITH LONGITUDINAL STROKE

This attachment can make wide polygon-generating operations without being mounted on the optional compound slide of the machine. The tool arbor of the cross slide gear-box is extractable and its back side is outside the gear-box, so it can be pushed forward by a bracket fixed on the tool-spindle in the same station. A set of belleville washers will pull the arbor to its starting position at the end of the cycle.
HIGH SPEED DRILLING ATTACHMENT for

SD32  SE16  SF13  AF26
AD40  SE25  SF20  AF32
SD50  SF26
SD63  SF26L  SF32  SF40  SF42  SF67

The High Speed Drilling Attachment is usually supplied with ER type collets and with different couples of ratio gears. It is now available in the coolant fed version: the coolant liquid can be pushed through the tool at high pressure during the drilling operation.
BROACHING ATTACHMENT

SD32  SE16  SF13  AF26
AD40  SE25  SF20  AF32
SD50  SF26
SD63  SF26L  SF32  SF40  SF42  SF67
RAMP RECESSING ATTACHMENT

SD32  SE16  SF13  AF26
AD40  SE25  SF20  AF32
SD50  SF26
SD63  SF26L
     SF32
     SF40
     SF42
     SF67

TECHNICAL DATA:
- 14° degree ramp
- Tool Fitting = 25 mm diameter bore (eccentric)
- Possibility of lubrication liquid through the tool
- Up and down adjustable toolholder
- Possibility of axial movement while recessing

This attachment is used to create recesses inside the component. It has to be located on the central block of the machine. After reached the right position inside the component the tool-holder moves upwards, sliding on a 14° degree ramp (that means 1 mm upwards every 4 mm of axial movement of the central block).

The length of the recess is usually the same as the length of the cutting tool. However, if you need to create longer recesses, our attachment can also move axially while making the recess.
SLOTTING ATTACHMENT

This attachment is designed to create radial slots on the external surface of the component. The tool rotates at the same speed as the component with opposite direction.

LONGITUDINAL TURNING CHARIOT
BACK SIDE GROOVING ATTACHMENT

It is fixed on cross slide and it makes back or frontal grooving operations. The tool is not included and must be properly profiled by the customer.

The cutter moves on a circle but, because of its distance to the pivot and its small movement inside the part, the result is like it does a straight movement.

The tool-holder is pushed by a bracket fixed on the center block.
MARKING ATTACHMENT

SD32    SE16    SF13    AF26
AD40    SE25    SF20    AF32
SD50    SF26    SF26L
SD63    SF32
        SF40
        SF42
        SF67

- This attachment is used for marking the components in a very simple and quick way, because it is based on a completely mechanical logic.
- The cross slide, with our attachment on, moves forward till the engraved disk touches the component.
- Because of the friction between them, the disk starts to turn and mark the component.
- When the engraving is over, the disk stops in a fixed position to avoid further contact with the component.
- During the return stroke a poper pin fixed on the wall of the machine resets the attachment with the disk able to turn again.
- We can supply blank disks only together with the instructions about how to engrave them.
Maintaining your equipment to its optimum performance is important to your business.

**Turning Concepts** has the knowledge and expertise to help you on your next project. Call one of our experts today and see the difference working with Turning Concepts can make for your business.

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