

TURNING CONCEPTS

Solutions to the Metal Working Industry



Attachments and Spare Parts for
Multi-Spindle Machines

machine

Wickman

for models

5/8" - 6

1" - 6

1 3/4" - 6

1 1/4" - 6

2 5/8" - 6

3 1/4" - 6

catalog

**Wickman Repair Parts Catalog
2018-2019**

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Wickman

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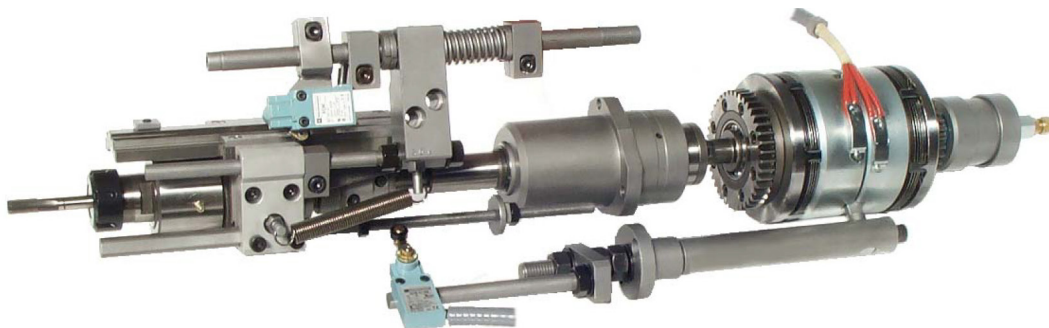
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FULL THREADING ATTACHMENT



- We have always supplied the Wickman threading attachment driven by electromagnetic clutches.
- The self-adjusting electromagnetic clutches have oversized power and they are piloted by our electronic Power Unit.
- The microswitches give the Power Unit the right inputs to drive the attachment properly.
- They can also check any malfunctioning (tap stuck in the component or missed threading operation), and allow the unit to stop the machine.
- The threading spindle is usually supplied for ER type collets, some spindles are now available in coolant and fed version (high pressure fluid inside bored tap).
- All gears and shafts are hardened and grinded.
- The mechanical parts are supplied fitted together as much as possible to make fitting easier.



POLYGON-GENERATING AND THREAD-MILLING ATTACHMENT - STRAIGHT



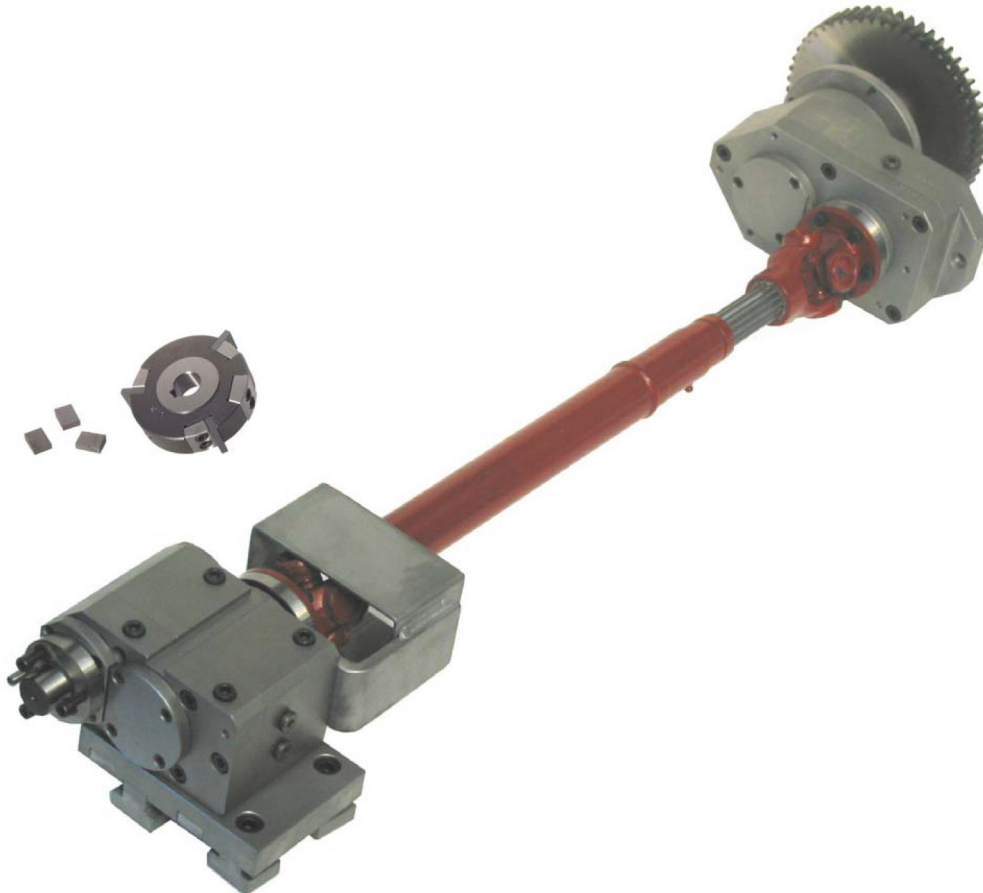
Wickman 1"-6

- The polygon and thread milling attachment can be fitted in any station.
- The attachment is usually supplied with 2 couples of gears, the 1:1 thread milling ratio and the 1:2 polygon generating ratio. All the gears and shafts are hardened and grinded.
- The tool fitting can be choosed between original Wickman fitting or 8 degrees 32' degree conical shaped + key.
- In case of 8 degree 32' fitting we can also supply the cutter tool.

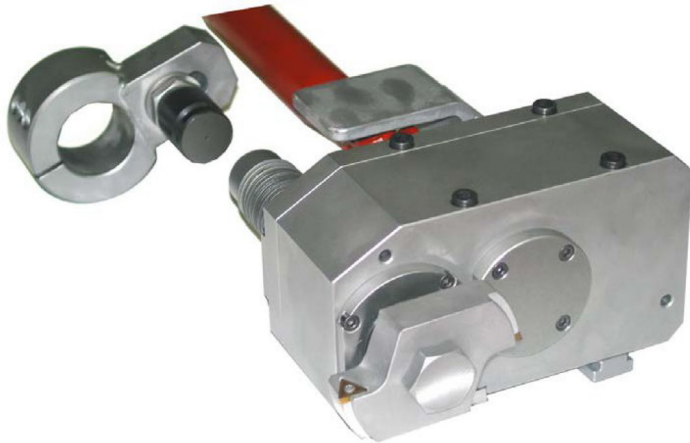


As you can see in the picture, they have the possibility to hold 1 cutter (flats) or 2 cutters at 180 degrees (squares) or 3 cutters at 120 degrees (hexagons). The cutters have different widths and they must be grinded by the user.

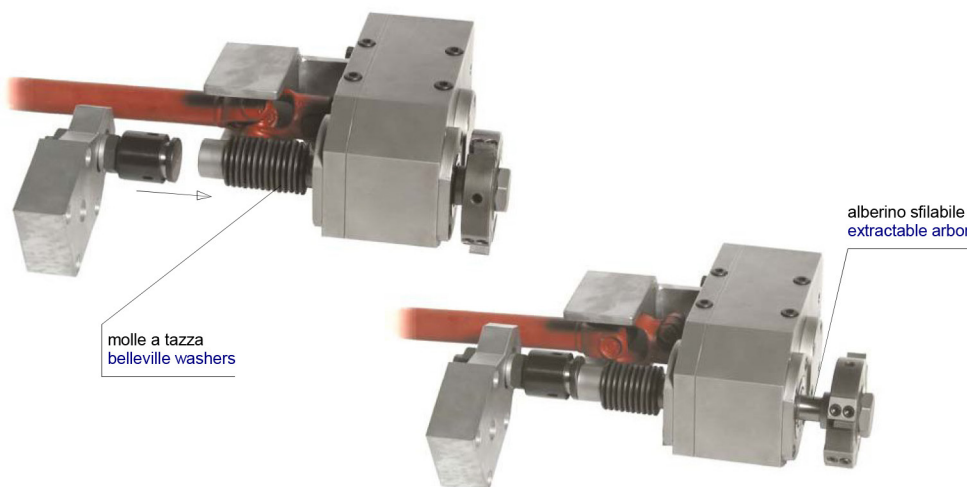
POLYGON-GENERATING AND THREAD-MILLING ATTACHMENT



POLYGON-GENERATING ATTACHMENT WITH LONGITUDINAL MOVEMENT



This attachment has got an extractable tool-arbor in the cross slide head. The tool-arbor back end is outside the head, so it can be pushed forward by a bracket fixed on the centre flock in the same station. A set of belleville washers will pull the arbor into starting position at the end of the cycle. This kind of attachment is very good for long polygon jobs and even better for hard jobs on steel materials. In this case we suggest to use special tools with standard inserts. Please note that using this attachment can avoid buying very expensive compound slides.



HIGH SPEED DRILLING ATTACHMENT

Wickman 1"3/4-6



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.

Wickman 1"-6



BROACHING ATTACHMENT



Wickman 1"3/4-6

- This attachment is designed to create polygons or geometrical profiles inside the component. It has to be fitted on the center block of the machine (longitudinal side).
- The tool rotates at the same speed as the bar.
- The standard tool-spindle uses ER type collets.
- The tool spindle has a slight inclination versus the axis of the component in order to reduce the axial load during the broaching operation.

RAMP RECESSING ATTACHMENT

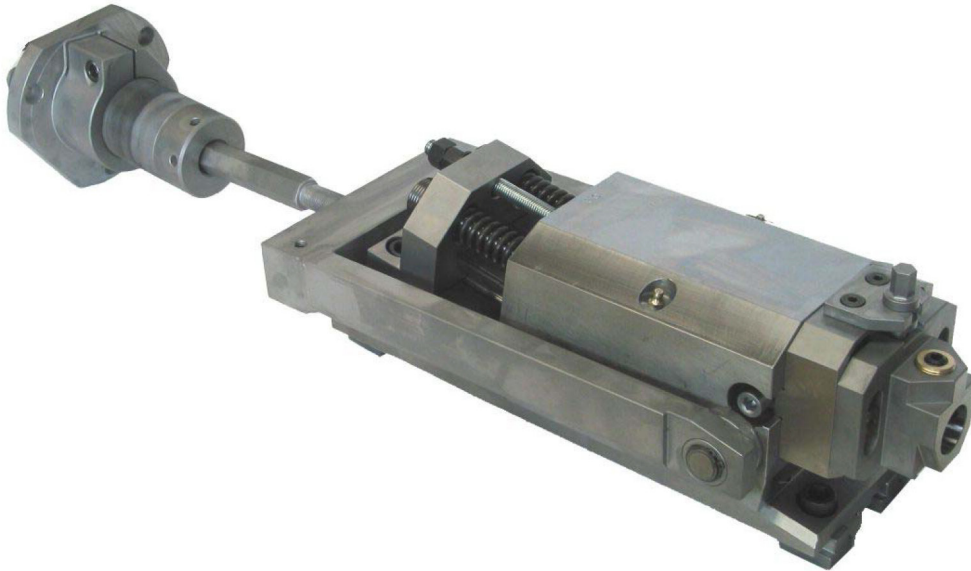
TECHNICAL DATA:

- 14 degree ramp (or other inclinations on demand)
- Tool Fitting = 25 mm diameter bore (eccentric)
- Possibility of lubrication liquid through the tool
- Up and down adjustable tool holder
- Possibility of axial movement while recessing



- The 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.

RAMP RECESSING ATTACHMENT - HEAVY DUTY VERSION

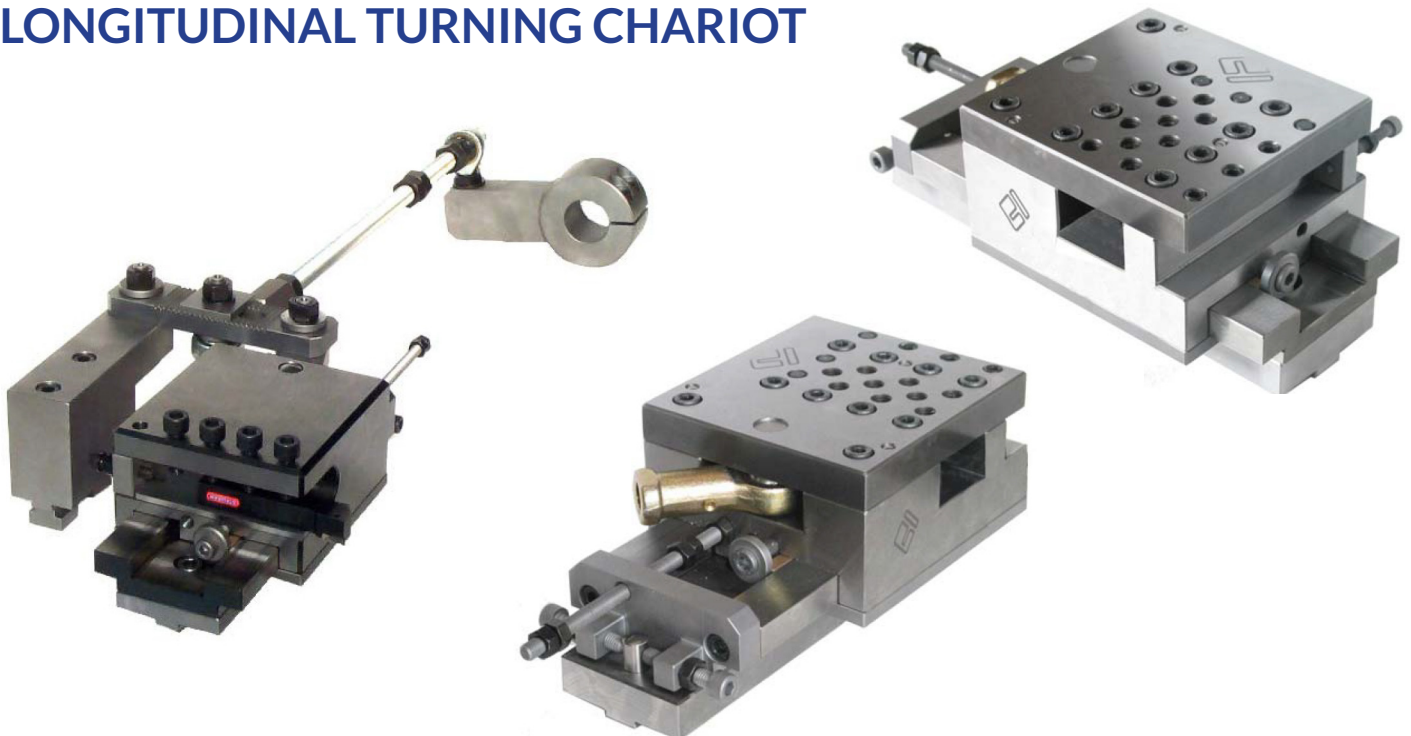


SPHERE CUTTING ATTACHMENT



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

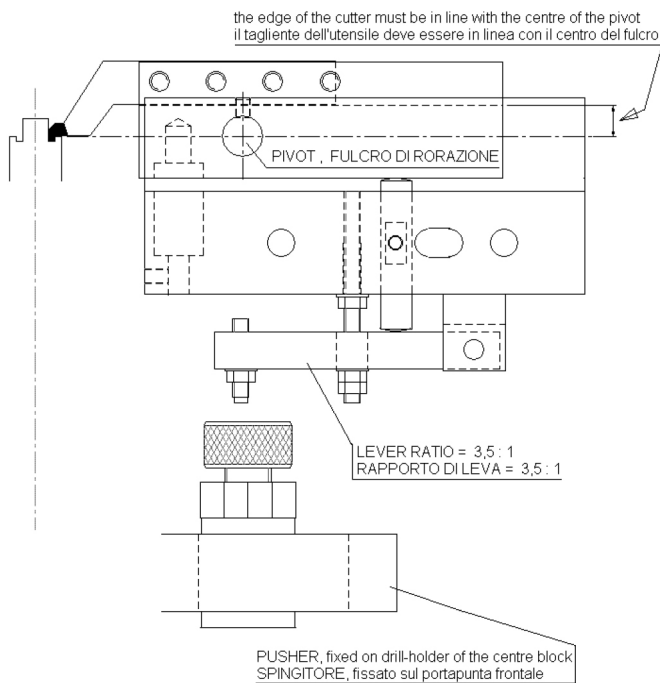


MARKING ATTACHMENT

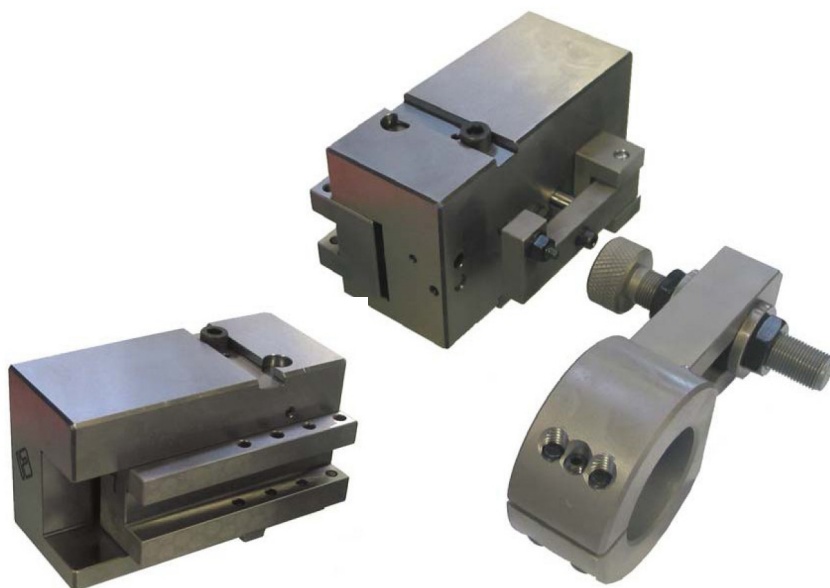
- This attachment is used for marking the components in a very simple and quick way, because it is based on a completely mechanical logic.
- The cross slide, with our attachment on, moves forward till the engraved disk touches the component.
- Because of the friction between them, the disk starts to 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 popper 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.



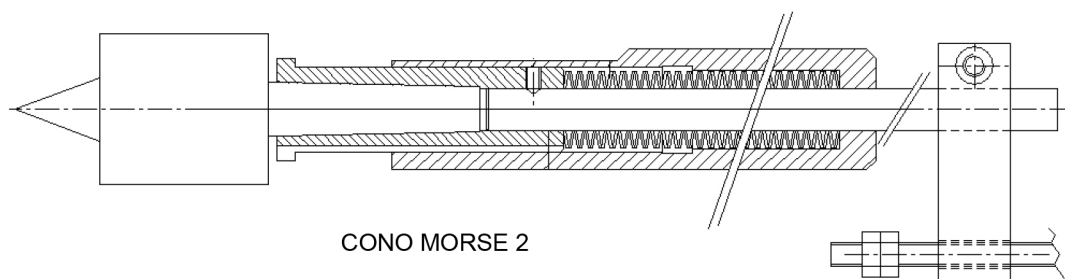
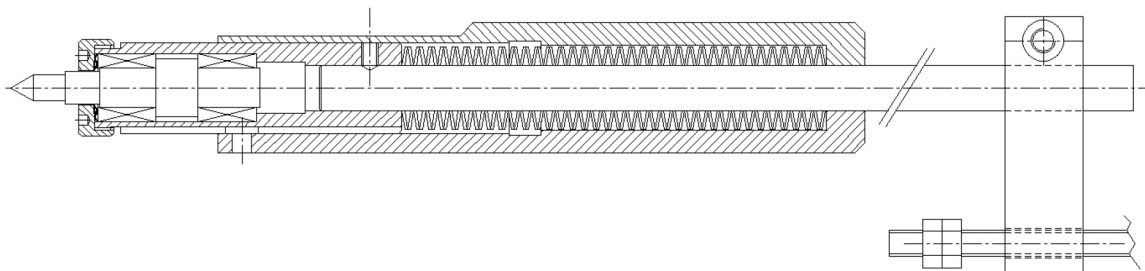
BACK-GROOVING TOOL-HOLDER (ALSO FOR FRONTAL GROOVING)



- 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.



ROTATING LIVE CENTER WITH COMPENSATION



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