

**GITAL
GILDEMEISTER AS20 GS20 GM20 (AS16)**

Attachments and spare parts

Catalogue issue: [GM20_0118](#)



MAIN SPINDLE COLLETS

48.01.101 (B1103400)

AS16/AS-GS-GM20 standard
Main spindle collet for AS16/AS-GS-GM20
standard machine



48.01.136 (C1103801)

Main spindle collet for AS16/AS-GS-GM20
machine upgraded to Ø25 mm bar



FEED FINGERS

01.31.050 (L1102500)

AS16/AS-GS-GM20 standard
Feed finger for AS16/AS-GS-GM20
standard machine



48.01.308 (L1103050)

Feed finger for AS16/AS-GS-GM20
machine upgraded to Ø25 mm bar



PICK-OFF COLLETS

48.01.104 (C1102600)

Pneumatic pick-off collet



45.68.288 (C0002800)

Hydraulic pick-off collet

COLLET FOR FRONTAL SPINDLE



01.31.003

STANDARD CAMS FOR CROSS SLIDES

POS. 1	POS. 2-3-4-5-6
08.29.105	08.29.101
08.29.106	08.29.102
08.29.107	08.29.103
08.29.111	08.29.104
08.29.117	08.29.118
16.29.301	



STANDARD CAMS FOR AXIAL SLIDES

POS. 1	POS. 2-3-4-5-6
16.29.201	08.29.601
16.29.202	08.29.602
16.29.203	08.29.603
16.29.204	08.29.604
16.29.205	08.29.605
16.29.206	08.29.606
16.29.207	08.29.607

STANDARD CAMS FOR TOOL-SPINDLES

POS. 1	POS. 2-3-4-5-6
16.29.401	08.29.201
16.29.402	08.29.202
16.29.403	08.29.203
16.29.404	08.29.204
16.29.405	08.29.205
16.29.406	16.29.408
16.29.407	

Z1	Z2
19	71
20	70
23	67
26	64
29	61
32	58
41	49



08.10.501

FEED GEARS

Z1	Z2
27	63
29	61
30	60
32	58
38	52
40	50
41	49
42	48
43	47
44	46

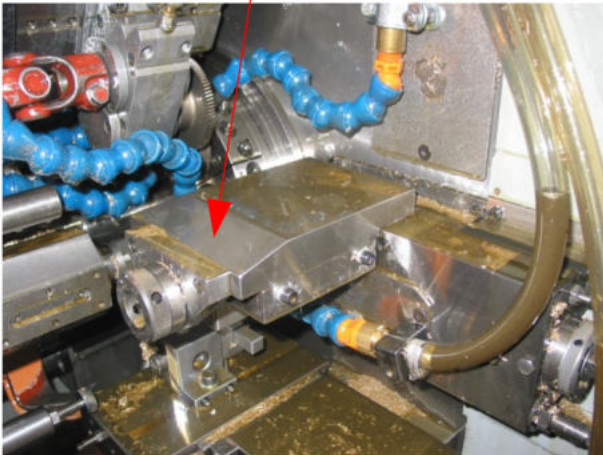
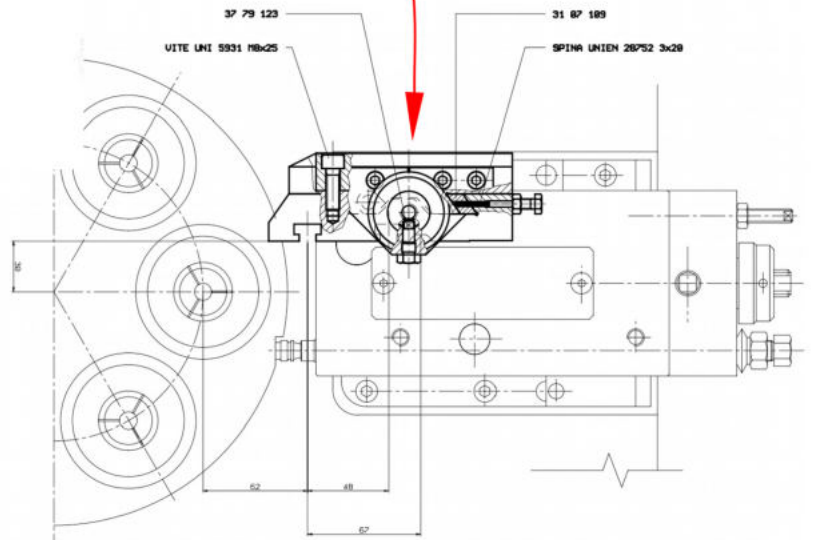
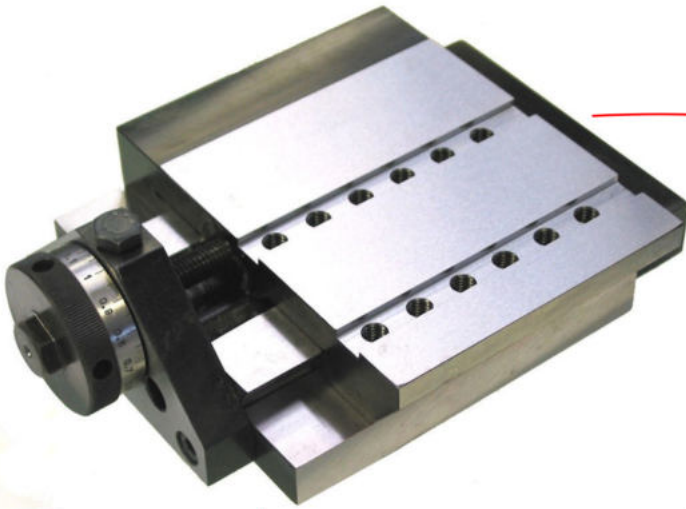


08.10.401

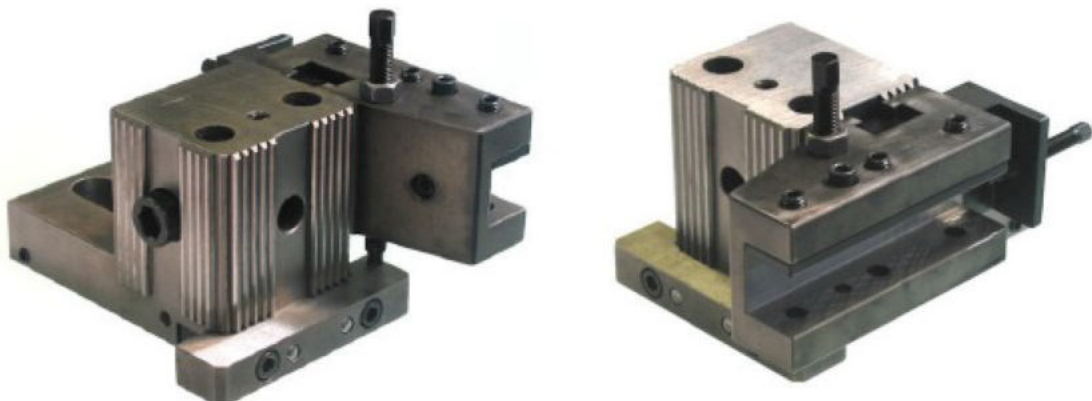
SPEED AND THREAD RATIO GEARS

31.07.007 (SC4552048)

POS.3 SLIDE WITH MICROMETER LONGITUDINAL ADJUSTMENT



STANDARD TOOL-HOLDER FOR CROSS SLIDES



NON-ROTATING FRONTAL SPINDLE

Standard spindle

**We can supply:
SPECIAL NON-ROTATING SPINDLE
with coolant through the drill**

Spindle for ER32 collets

Nut
01.30.001

Collet for frontal spindle
01.31.003

ISO30 taper spindle



ER32 collet



ER25-32-40 collet



We can supply all the models:
- with **notched shank** for AS20 and GS20 machines
- with **smooth shank** for GM20 machine



ISO30-ER20 extended collet-holder

Collet-holder:

ISO30-ER32
ISO30-ER25
ISO30-ER20

**We can supply:
SPECIAL NON-ROTATING SPINDLE
with coolant through the drill**

ROTATING FRONTAL SPINDLE

ISO30 taper spindle

Spindle for ER32 collets

Standard spindle

Collet-holder

ISO30-ER32
ISO30-ER25
ISO30-ER20

ER25-32-40 collet

ISO30-ER20 extended
collet-holder

ER32 collet

Collet for frontal spindle

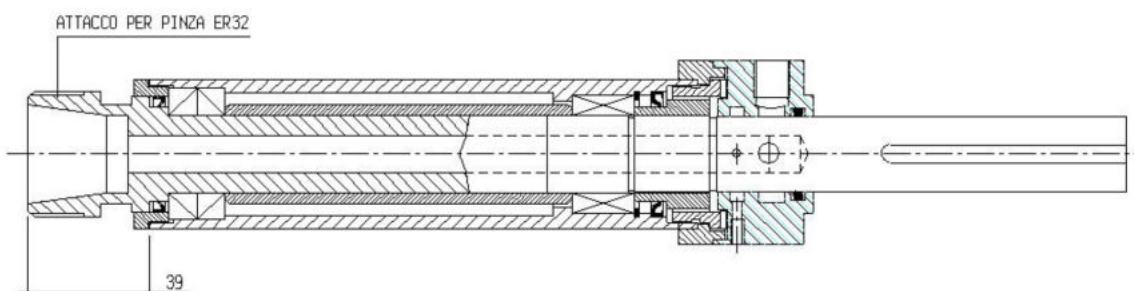
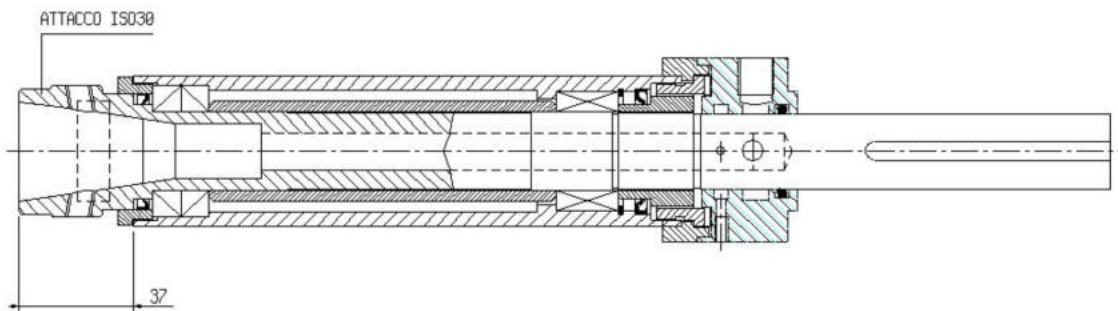
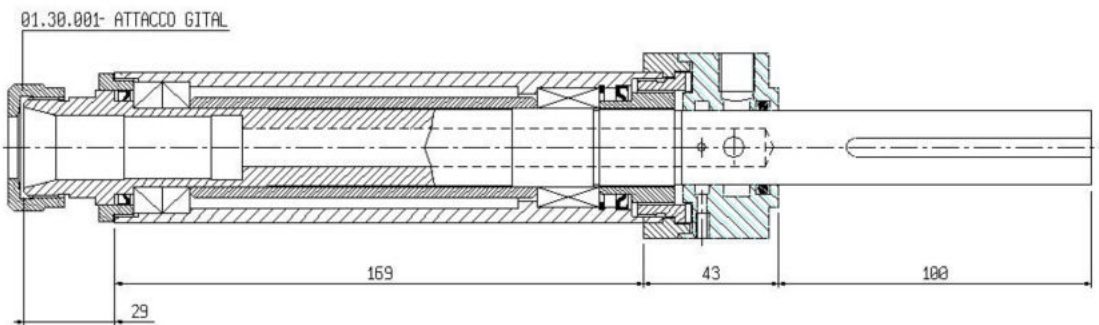
01.31.003

Nut
01.30.001

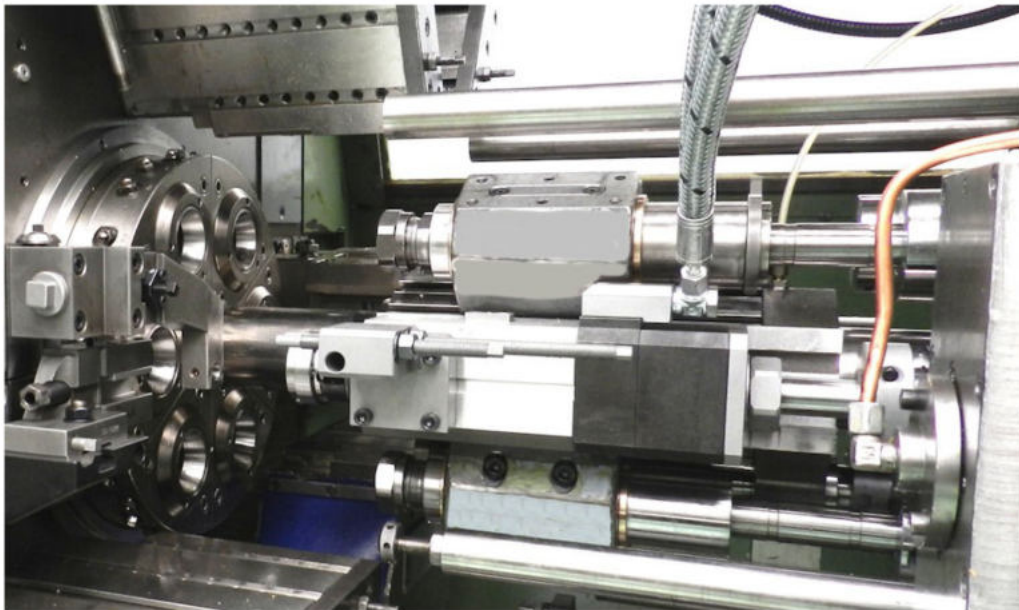
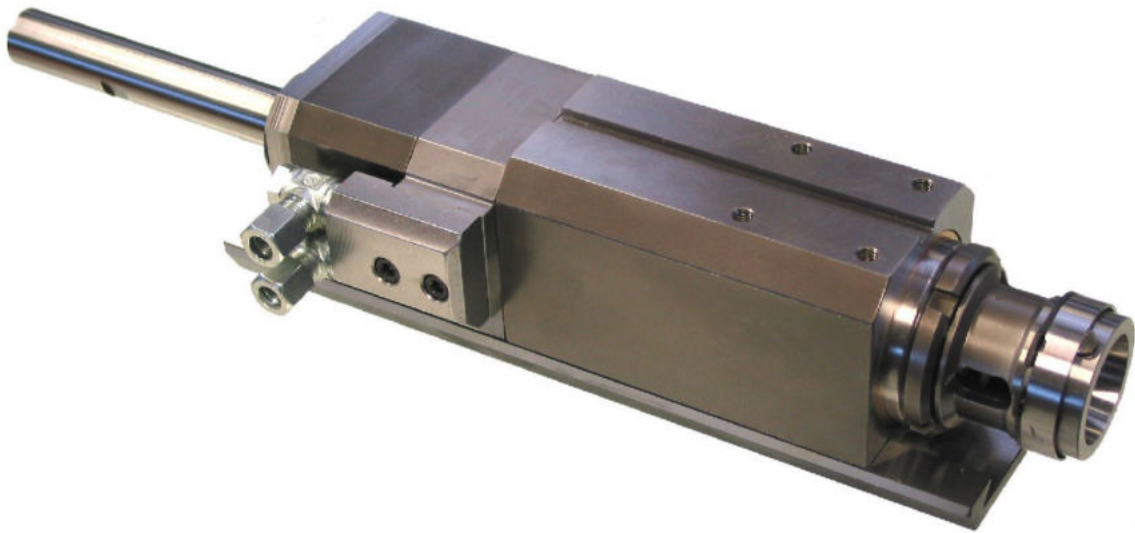
We can supply all the models:
- with **notched shank** for AS20 and GS20 machines
- with **smooth shank** for GM20 machine



ROTATING SPINDLE with high pressure coolant through the drill

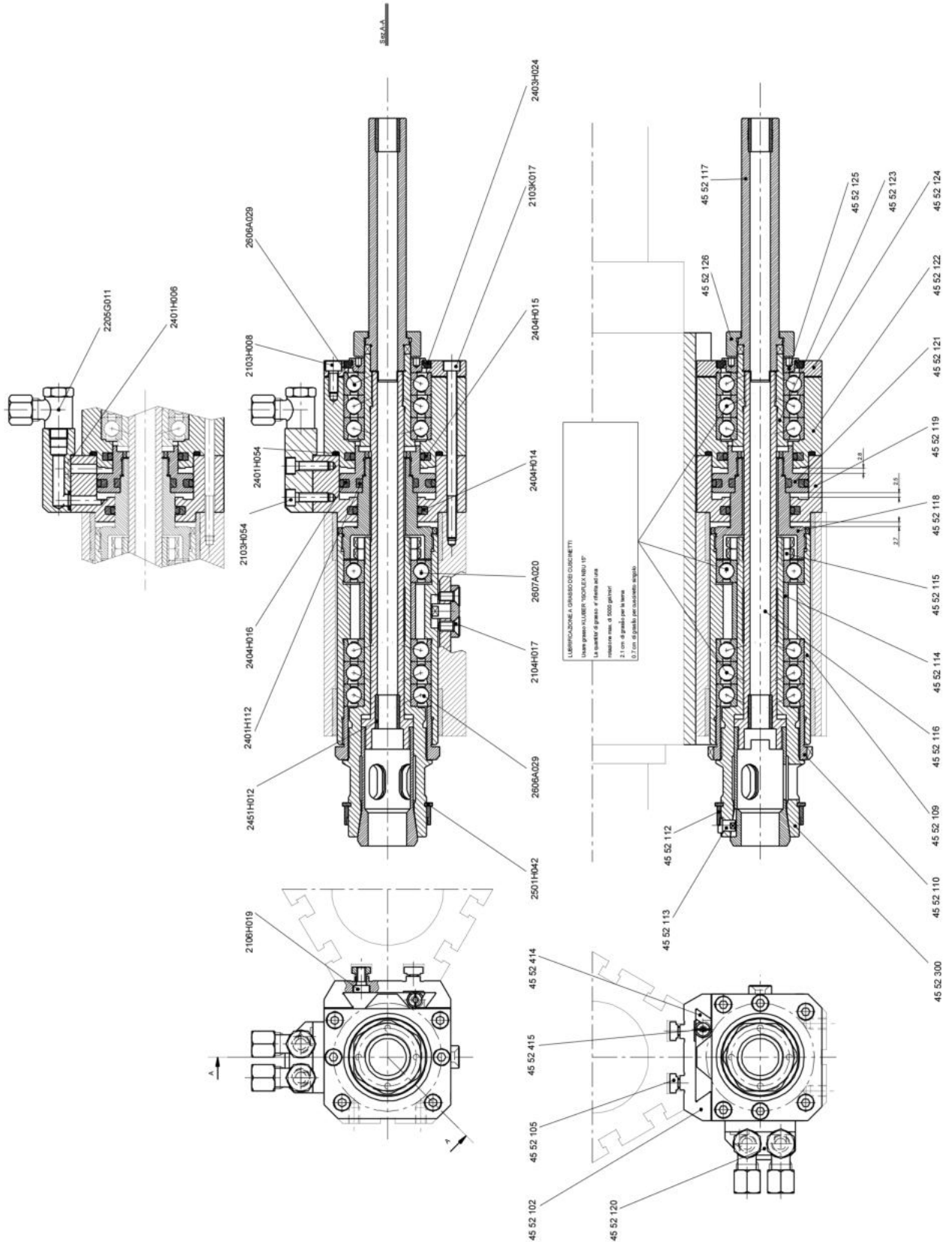


POS.6 AND POS.3 HYDRAULIC PICK-UP ATTACHMENT



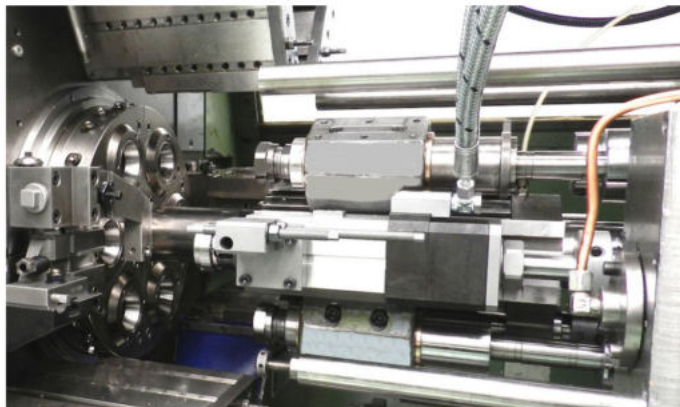
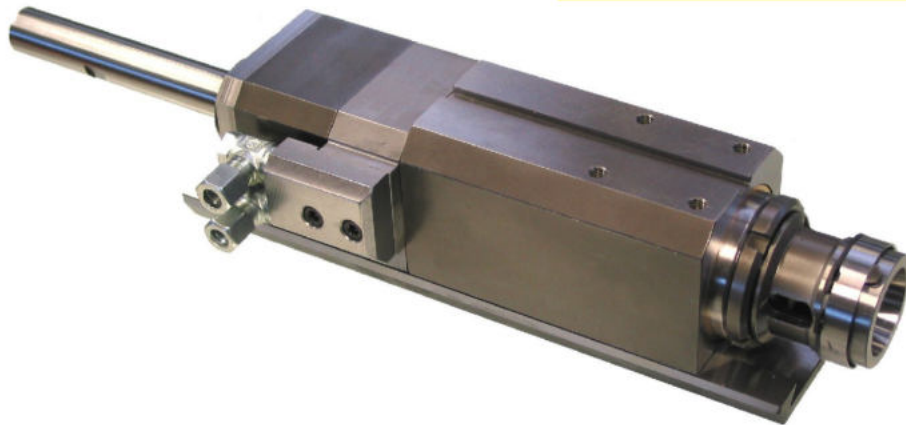
**WE CAN SUPPLY NEW COMPLETE ATTACHMENTS
OR SPARE PARTS FOR YOUR ORIGINAL ATTACHMENTS
OR WE CAN REBUILD YOUR OLD ATTACHMENTS**

HYDRAULIC PICK-UP ATTACHMENT



POS.6 AND POS.3 PNEUMATIC PICK-UP ATTACHMENT

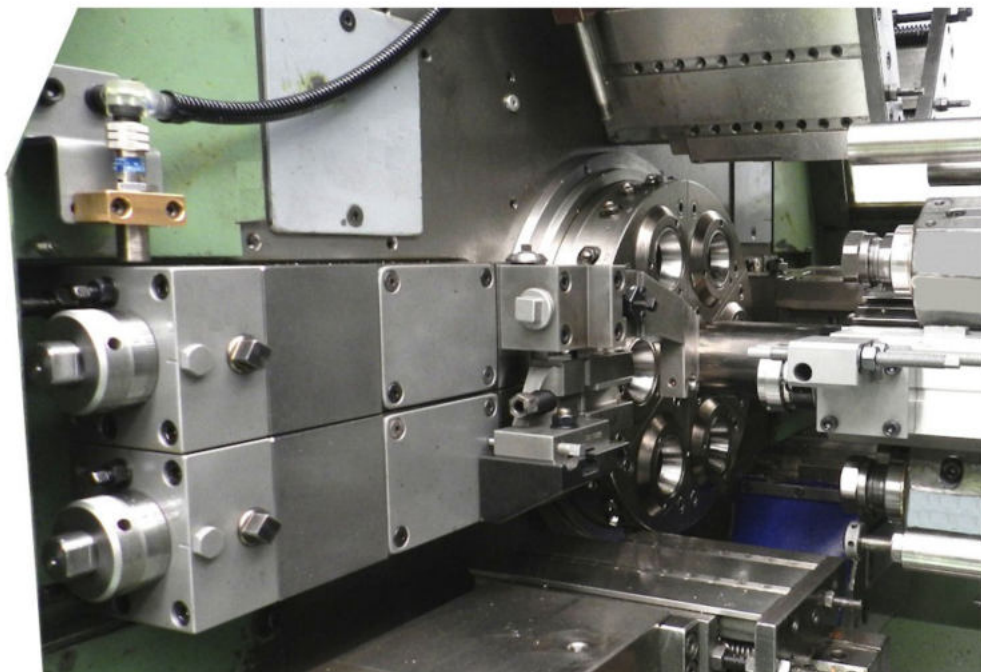
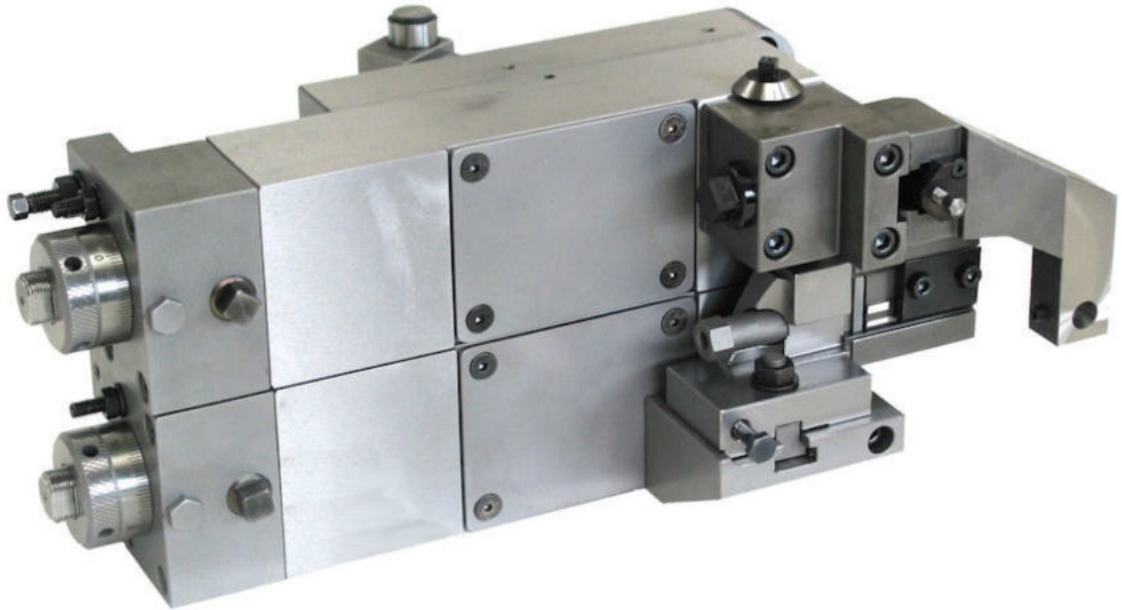
NEW PNEUMATIC



This is a new pick-off spindle with pneumatic collet clamping/unclamping. Compared with Gildemeister old style pneumatic pick-up, it has much more rigidity and strength, thanks to the dove tail base, and it has 1,5 more power in the collet clamping. Compared with the recent Saco hydraulic pick-up, it has the same rigidity and strength with much quicker collet activation, and it does not need any expensive hydraulic unit to run.

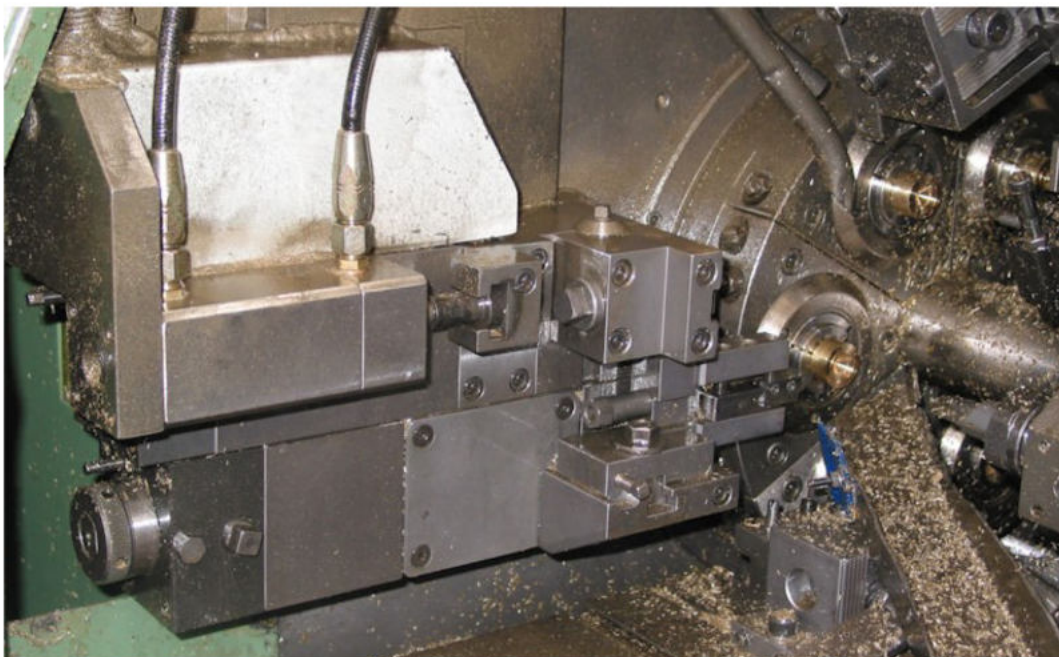
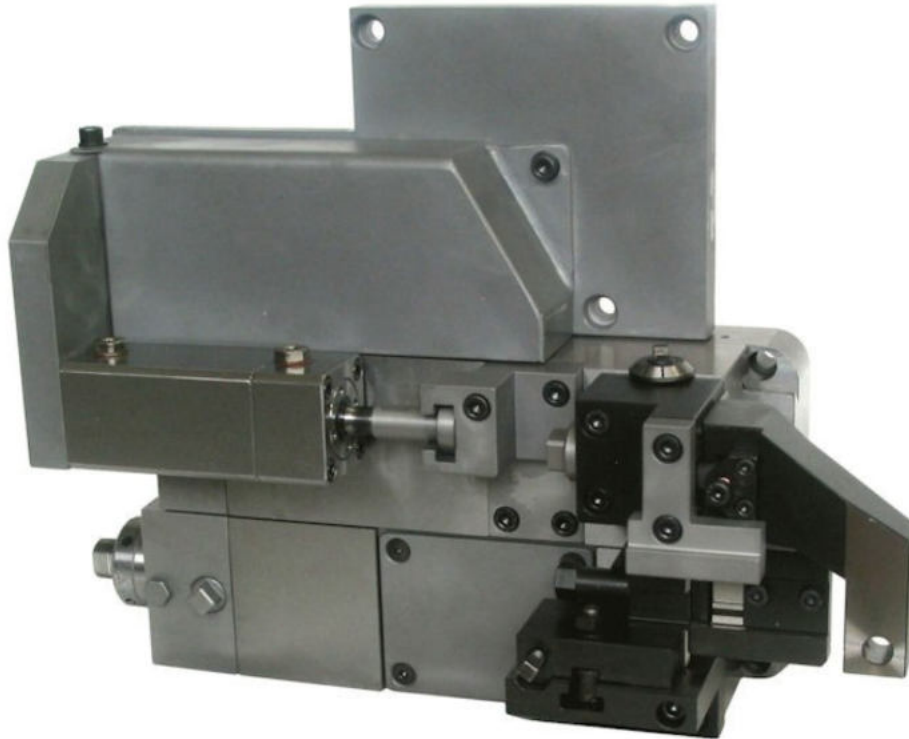


MECHANICAL DOUBLE SLIDE FOR POS.6 AND POS.3



POS.6 AND POS.3 DOUBLE SLIDE :

**MECHANICAL SLIDE FOR CUT-OFF JOB
HYDRAULIC SLIDE FOR BACK-SIDE JOB**



BRAKE FOR PICK-OFF ATTACHMENT POS.6



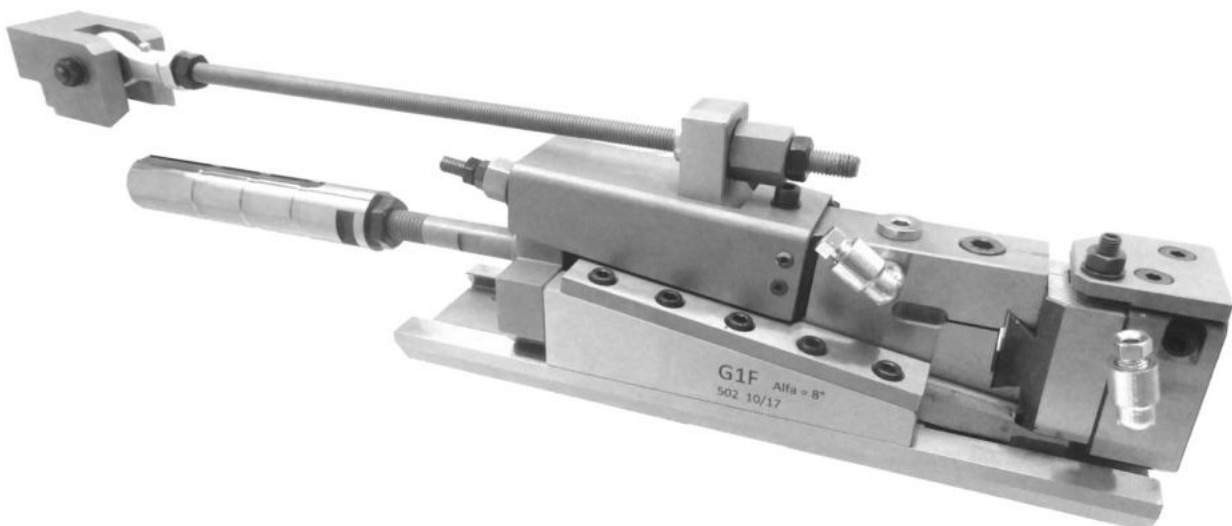
**WE CAN SUPPLY NEW COMPLETE ATTACHMENTS
OR SPARE PARTS FOR YOUR ORIGINAL ATTACHMENTS
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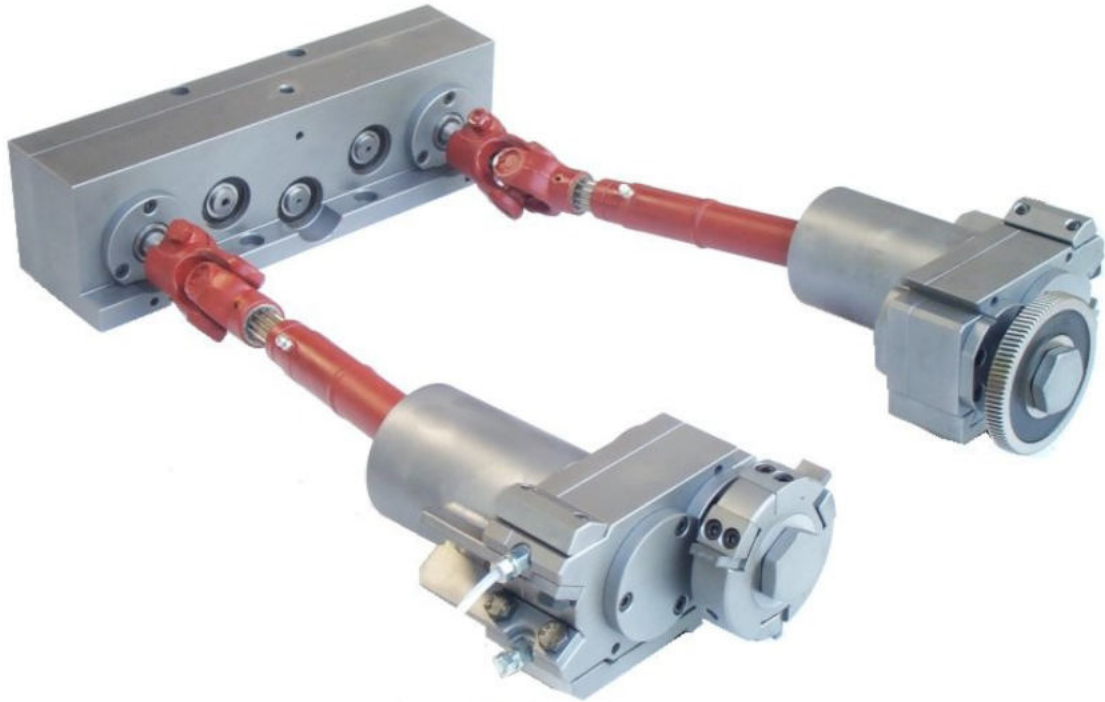
RAMP RECESSING ATTACHMENT

TECHNICAL DATA:

- Ramp inclination is 8° degree
- Tool Fitting = \varnothing 16mm or \varnothing 20 mm diameter bore
- Cutting liquid through the tool
- Up and down adjustable toolholder
- Possibility of axial movement while recessing



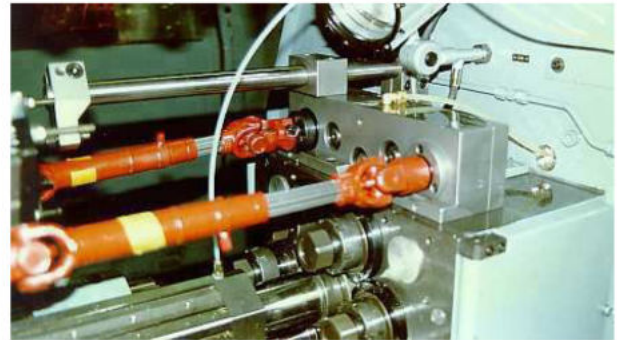
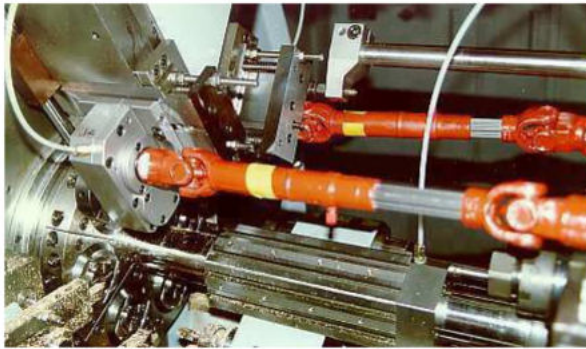
POLYGON GENERATING AND THREAD MILLING ATTACHMENT



The "A" Driving Gear-box must be placed on the tool-spindle casting as you can see in the bottom right picture. The "A" Driving Gear-box is driven by the "G1D/1" gear that is usually already fitted in the casting. The "A" Driving Gear-box has been designed to drive two Tool Gear-boxes at the same time, on the cross slides in 4th and 5th position. Tool Gear-boxes can be fitted in 4th or 5th position as you like. To make flats and polygons you need to order the "C" Tool Gear-box with 1:2 ratio inside. Meanwhile to mill threads you need to order the "B" Tool Gear-box with 1:1 ratio inside. If you need two phased polygon generating operations, you can do that by using our adjustable joint in one of the two outputs in the "A" Gear-box. We also supply "G" Tool-holder for polygon generating operations and hard metal cutters.

OPTIONAL FOR POLYGON GENERATING AND THREAD MILLING ATTACHMENT

SPECIAL PUSHING SYSTEM FOR AXIAL SLIDES POS.4-5

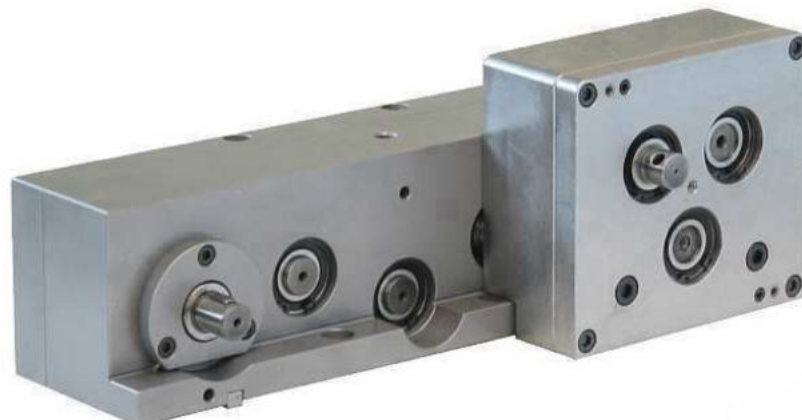


DRIVING GEAR-BOX FOR THREAD-CHASING ATTACHMENT



G1D/6

The gear-box G1D/6 is able to drive Gildemeister Saco-Autor "GR.1" thread chasing attachment. It must be fitted on 2-outputs driving unit of our polygon attachment. It allows you to do polygon operation and thread-chasing operation at the same time in pos.4-5, without taking off our 2-outputs driving unit from the machine

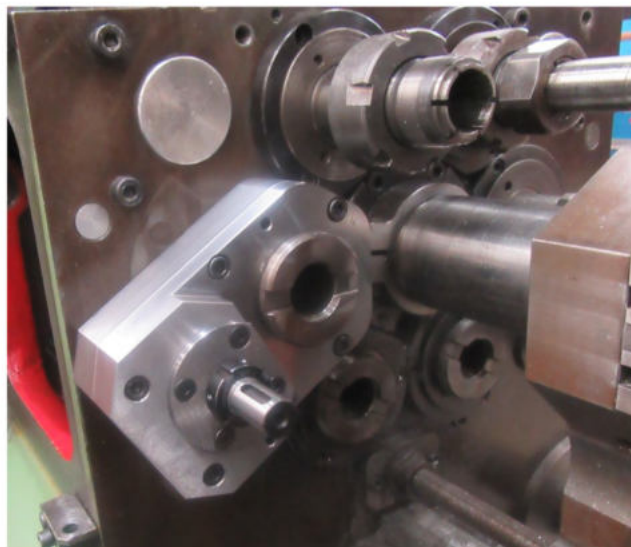


POLYGON AND THREAD-MILLING ATTACHMENT in pos.2

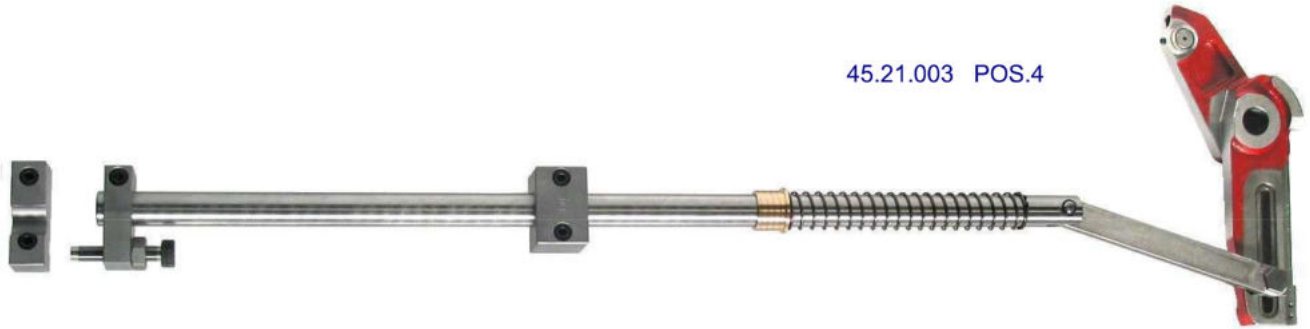


Technical datas:

- the driving gear-box has to be placed on pos.3, instead the tool-head is going on pos.2 cross slide
- it is possible to keep doing frontal drilling operation in pos.3 by using our special tool-spindle
- a pair of elicoidal gears in the driving gear-box allows a low play transmission of the motion
- we can supply tool-head with 1:2 ratio to make polygon-milling or with 1:1 ratio to make thread-milling
- our traditional pos.4-5 tool-heads are good to be used in pos.2 with this kind of driving



45.21.003 POS.4



45.21.004 POS.5



OPTIONAL :

PUSHING SET FOR AXIAL SLIDES

45.21.002 POS.2



45.21.001 POS.1



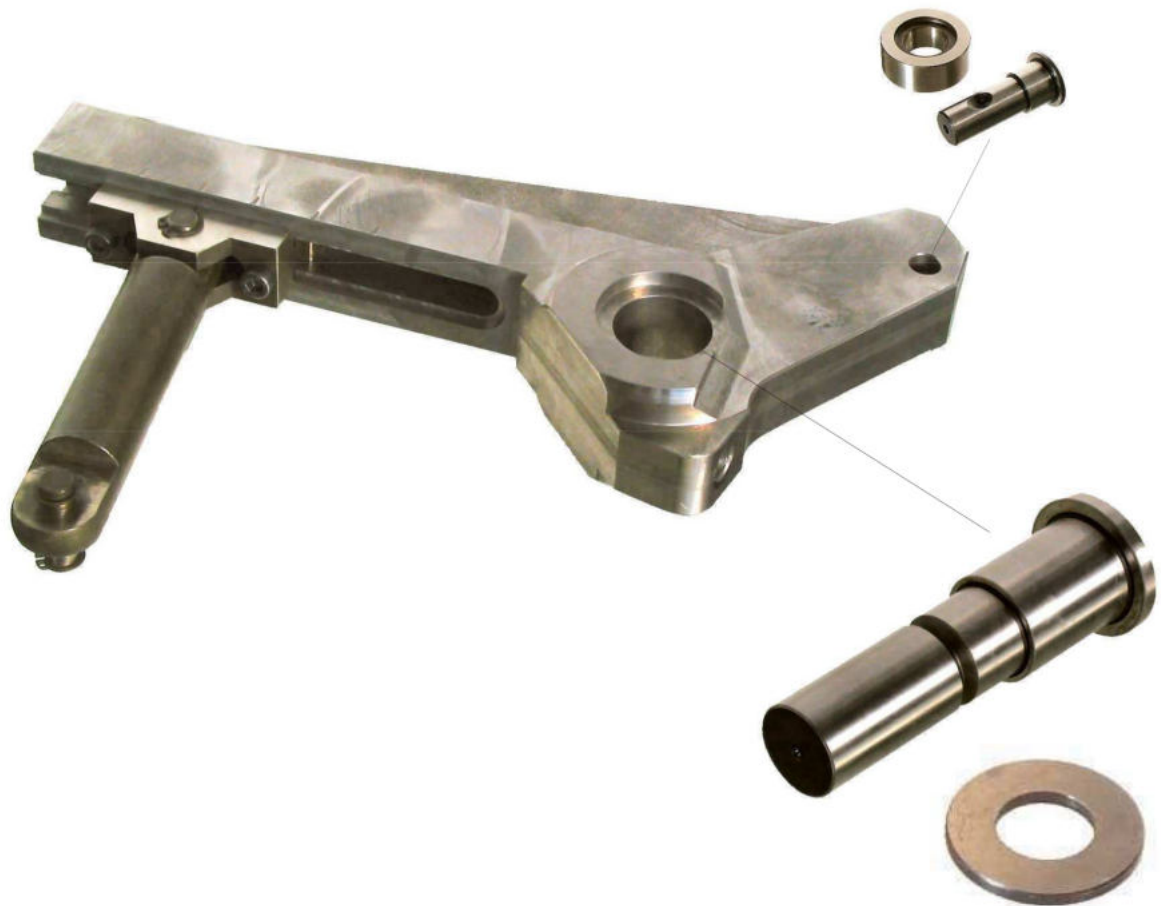
OPTIONAL :

25mm MODIFIED BAR FEEDING



OPTIONAL: 31.27.001

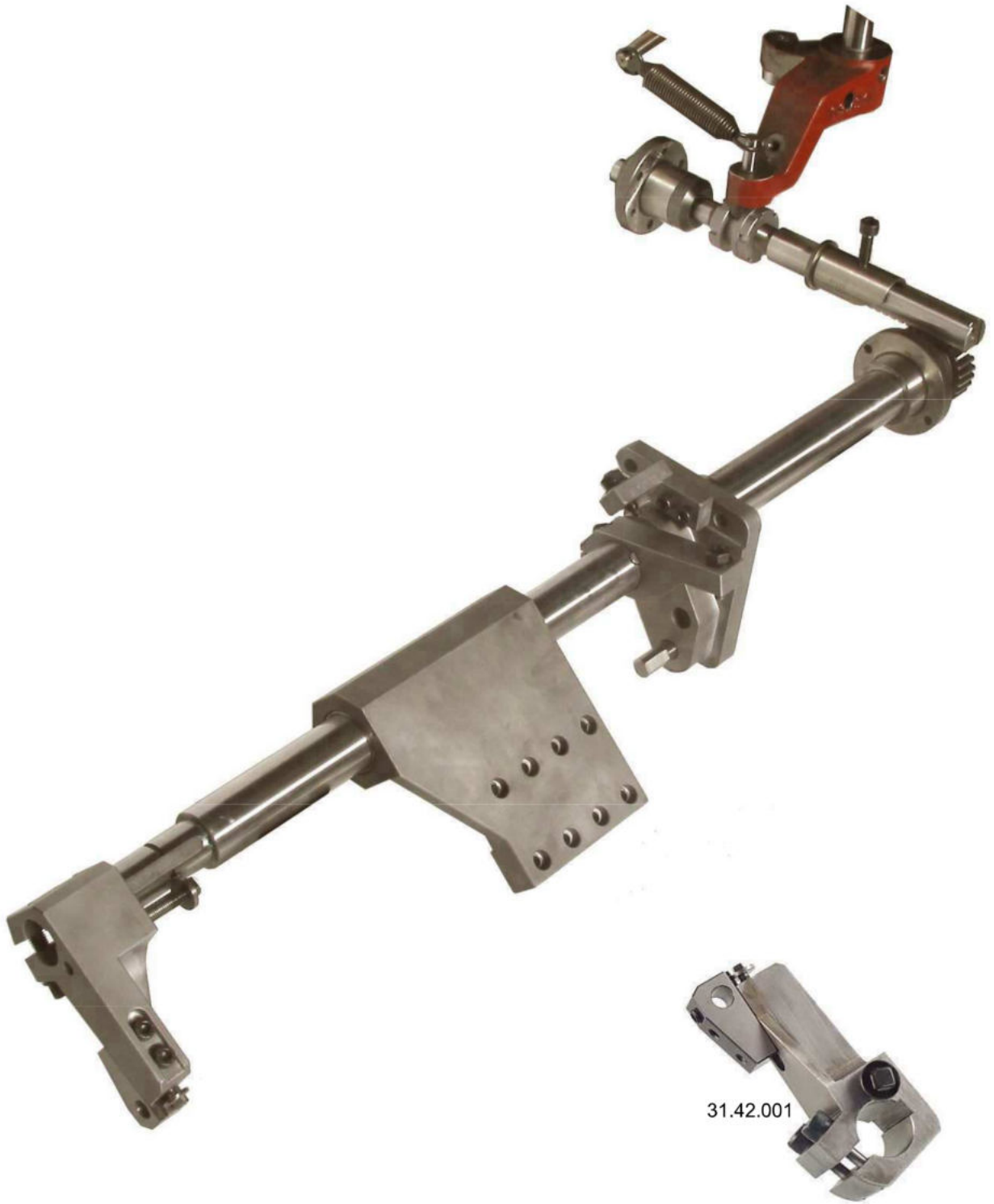
CENTRE BLOCK MOVING SET



PNEUMATIC PICK-OFF SPINDLE



OPTIONAL : 31.42.101



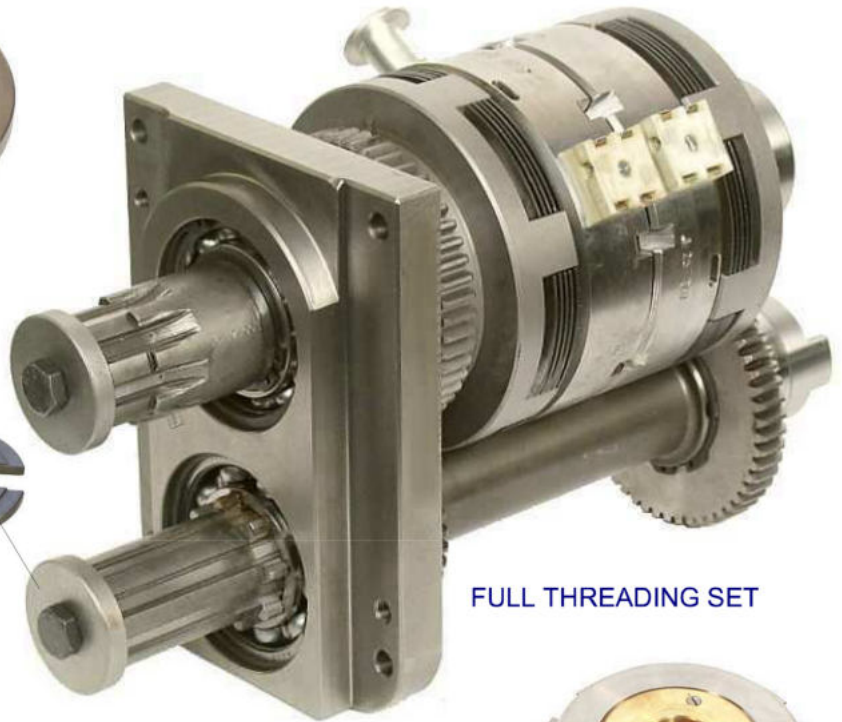
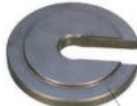
08.10.201



08.10.202



08.10.002



FULL THREADING SET



08.10.203 Ortlinghaus



14.17.201



08.10.020

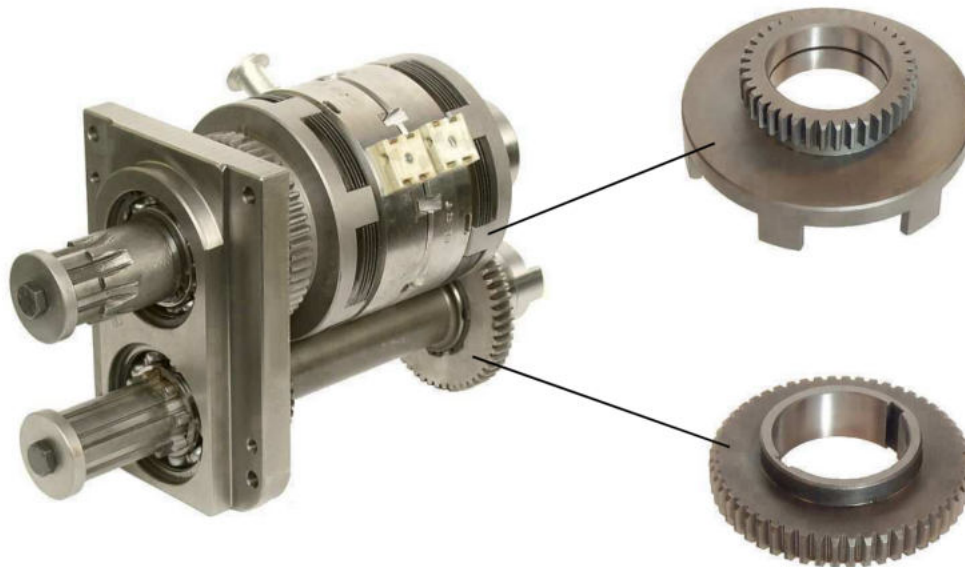


08.10.001



05.13.021





THREADING RATIO MODIFICATION IN THE CLUTCH ASSEMBLY

As you know in Gildemeister 20 machine you have the possibility to change the threading ratios by replacing a single pair of ratio gears (usually called K and L in the machine book).

But, each time you change the ratio gears, you modify the threading in-speed as well as the threading off-speed.

For example: if you want to set a very quick in-speed (ratio -2.41)

to save cycle time by using the gears $k=40$ and $L=50$,

then the off-speed will be very slow (+10.56) without any improvement for the cycle time.

Therefore, above all when the threading is quite a long operation compared

with the part cycle, you haven't got the possibility to optimize the threading speed and so the cycle time.

For that reason we have recently realized a simple modification of the clutch gears that allows fast in-speed and off-speed at the same time.

There could be different possible ratio modifications to suite customer requirements.

For example we can replace the off-speed clutch gears to obtain the following ratios:

In-speed = -2.41 (like the previous example)

Off-speed = +3.15

But we can supply modified gears to get even faster speeds or slower speeds than that.

Together with the modified gears we supply a new ratio table to see

how your machine threading ratios will change by replacing the ratio gears K and L.

Replacing the clutch gears is quite a simple operation and that can be done even just to machine a single components, if it is opportune.

CROSS MARKING ATTACHMENT



This attachment is used to mark the components in a very simple and quick way, it is based on a completely mechanical logic.

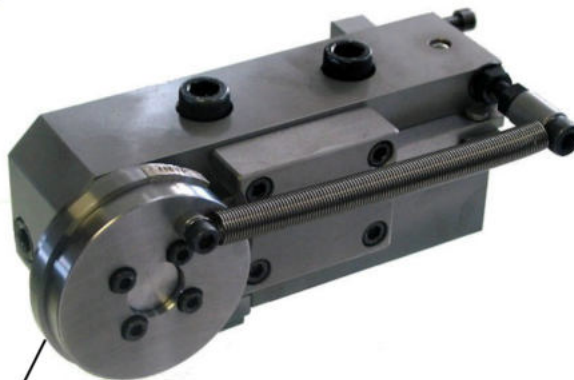
With our attachment on, the cross slide moves forward till the engraved disk hits the component. Because of the friction between them, the disk starts to turn and mark the component. After one rotation engraving is over and a locking pin stops the disk in a special position, where it cannot touch the component again.

When cross slide returns back, a proper pin, fixed on the wall of the machine, unlocks the disk, and the spring takes it to its start position.

We can supply blank disks or engraved disk, following customer's requirements.

The same attachment can be taken apart and re-assembled the other way round in order to fit all station of the machine.

Now it is also possible to fit a disk with interchangeable letters.



The new roller with interchangeable characters





AS16 - AS20 OPTIONAL :

SPECIAL CLAMPING MECHANISM

20096301



20096303



20096305



20096304



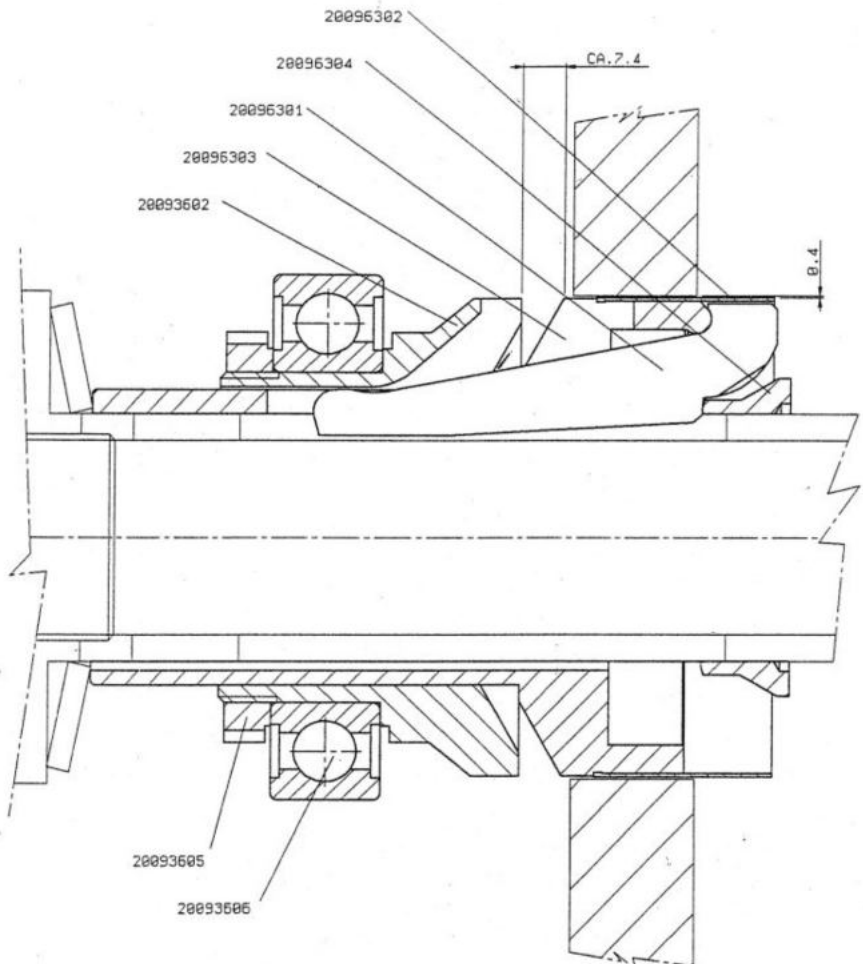
20093605



20093602



20093606
(d = 56 / D = 89 mm)



31.01.106
31.60.202



31.01.108



01.01.405



01.33.553



08.01.351



31.01.110



← 31.01.107 →



01.25.202

05.02.009



05.02.012





15.01.007



01.01.505



14.01.251



01.01.510



14.01.202



08.01.017



08.01.012

15.01.351

15.01.352



15.01.003



02.01.203



02.01.202



08.01.016

08.01.402

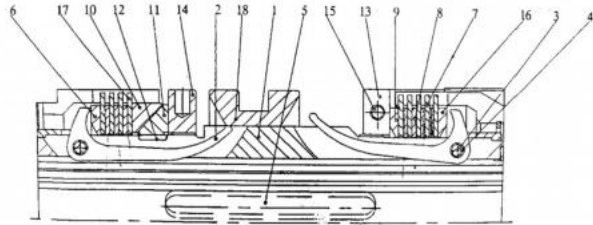


08.01.401

08.01.015

SPINDLE STOPPING MACHINE

0-300-609-31-156-000
double mechanical clutch



0-300-209-15-159-000
double mechanical clutch

08.53.152
longer Feed-Tube for Spindle-stopping machine



08.53.151
longer Collet-Tube for Spindle-stopping machine



15.18.203



15.18.201



15.18.107



08.07.012

08.14.006



15.18.204



15.18.001



15.18.105



15.18.202



15.18.205



15.25.009



15.25.013



31.18.153



31.25.112



15.25.205
15.25.304



15.25.303



15.25.104



31.18.154

TOOL SPINDLES LEVERS

Pos. 1-6
08.07.002 GS20
31.22.112 GM20



15.22.001 GS20
31.22.116 GM20



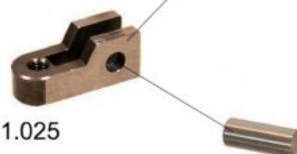
06.07.009



Pos. 2-3
08.07.004 GS20
31.22.113 GM20



01.11.025







08.14.013



08.47.028
(08.47.006)
(08.47.021)



08.58.355

PICK-UP AS16

08.47.027
(08.47.005)
(08.47.020)

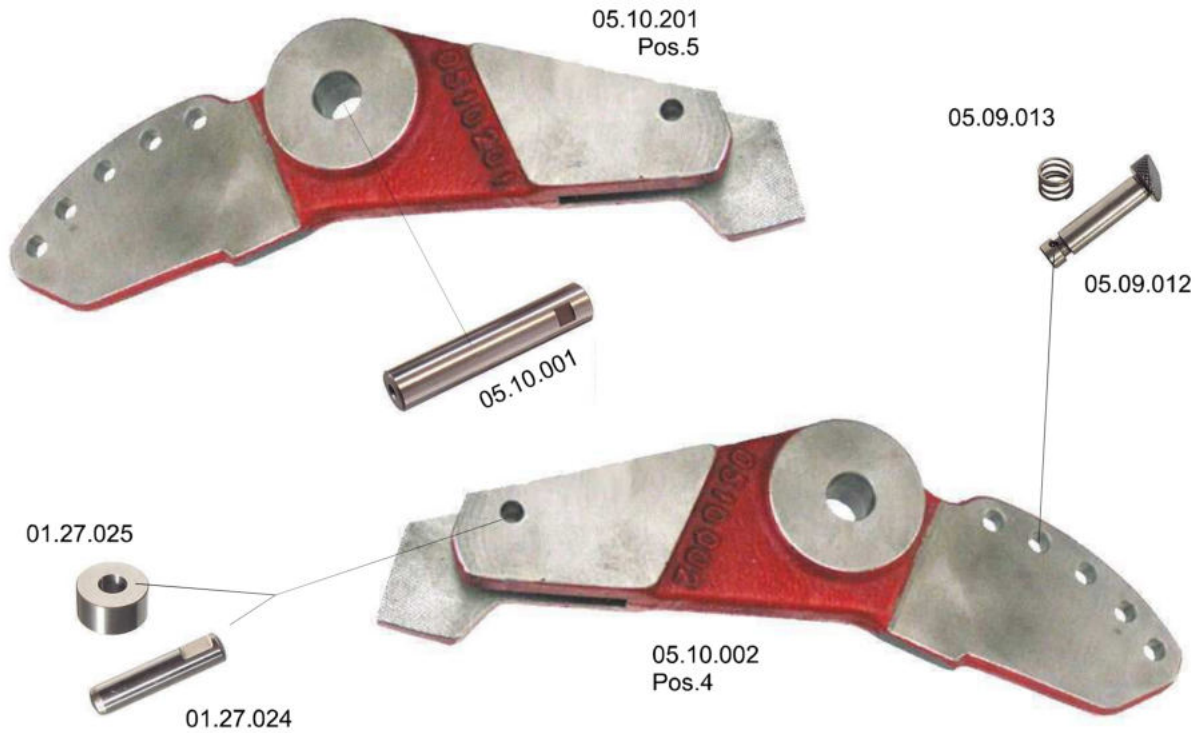




CROSS SLIDES LEVERS

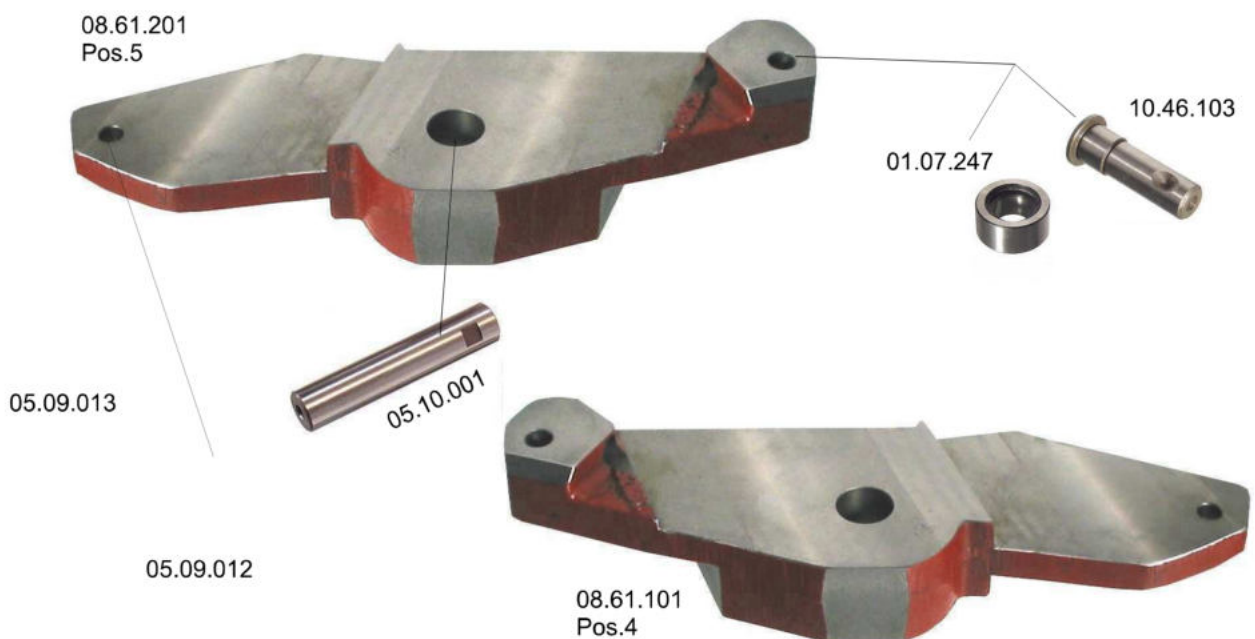


CROSS SLIDES LEVERS



OPTIONAL :

**HEAVY DUTY LEVERS FOR POS.4 AND POS.5 CROSS SLIDES WITH
ROLL-THREADING ATTACHMENTS ON**





15.21.101 AS/GS20
31.21.105 GM20



15.21.201 AS/GS20
31.21.106 GM20



15.22.008



15.22.007



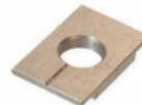
15.22.009



17.01.513



15.21.108



15.21.109



15.21.106



15.21.107



08.40.019



05.25.654



06.07.009



15.21.305



15.22.001

Ø20

15.21.303



15.21.104



31.22.116

Ø24



08.06.308 pos. 1-2



05.09.109 pos. 4-5



15.21.304



14.21.403



01.34.907



15.21.102 pos. 4-5



15.21.105



15.21.301 pos. 1-2



15.21.110



15.21.651
GS20-GM20
pos. 1-2



05.09.451



15.21.111



15.21.652
GS20-GM20
pos. 1-2



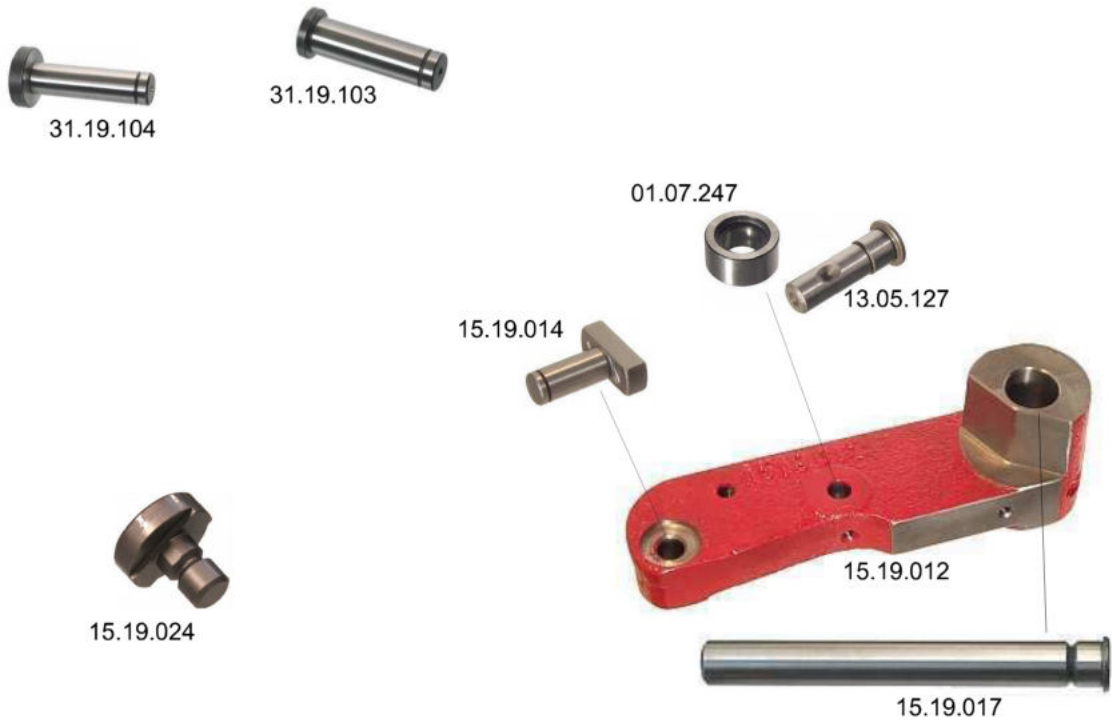
15.21.302
AS16-AS20
pos. 1-2

11.09.207
AS16-AS20
pos. 1-2

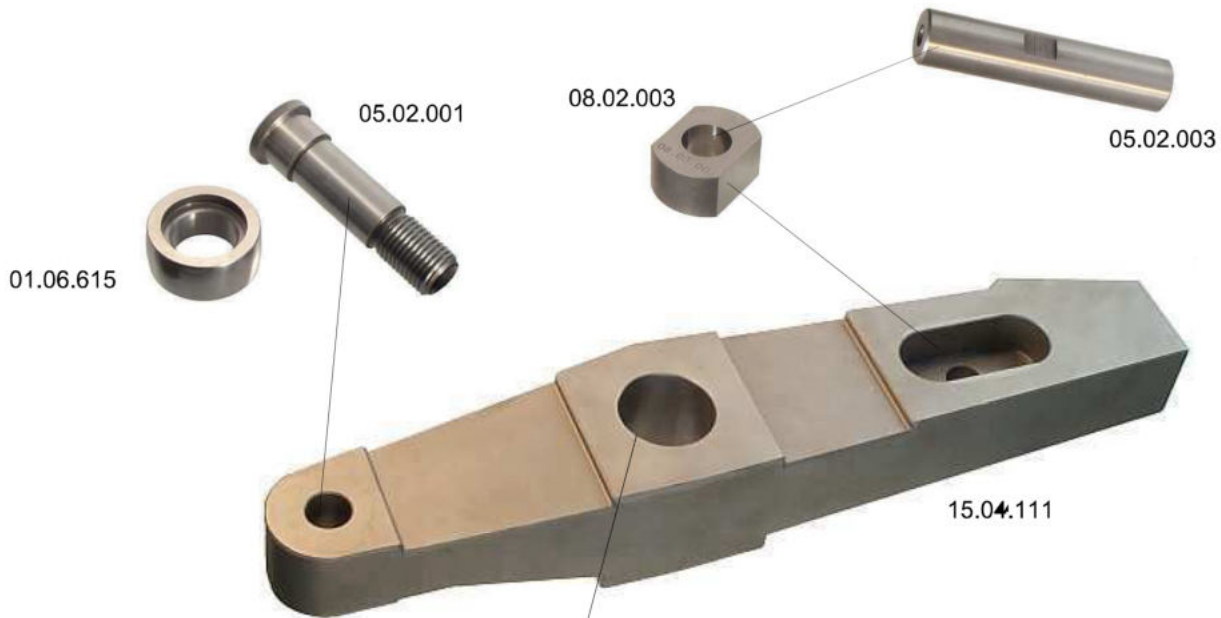
15.21.103
pos. 4-5



11.09.101









01.06.606



01.06.615









VOGEL MFE5



VOGEL 34-34



VOGEL 34-24



OPTOACCOPIATORE
MOF5

