MT TECH
MACHINERY SOLUTIONS

SPARE PARTS AND ATTACHMENTS
FOR MULTISPINDLE SCREW MACHINES

WICKMAN
catalog 0318

6-spindle machines:

WICKMAN 5/8"-6

WICKMAN 1"-6

WICKMAN 1.3/4"-6

WICKMAN 1.3/8"-6

WICKMAN 2.1/4"-6

8-spindle machines:

WICKMAN 32/8

WICKMAN 1"-8

WICKMAN 1.3/4"-8
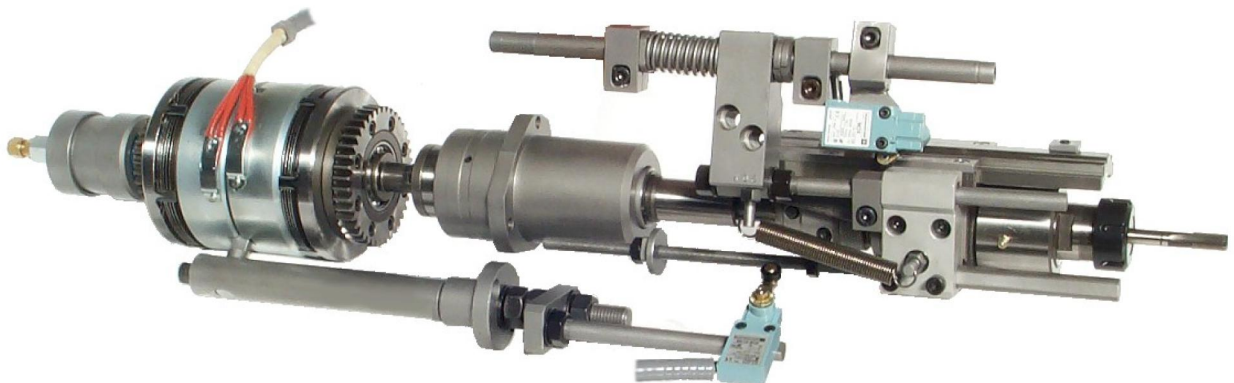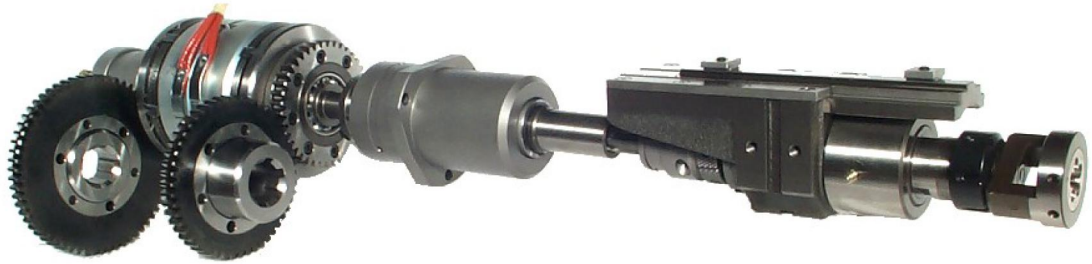
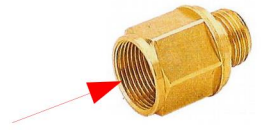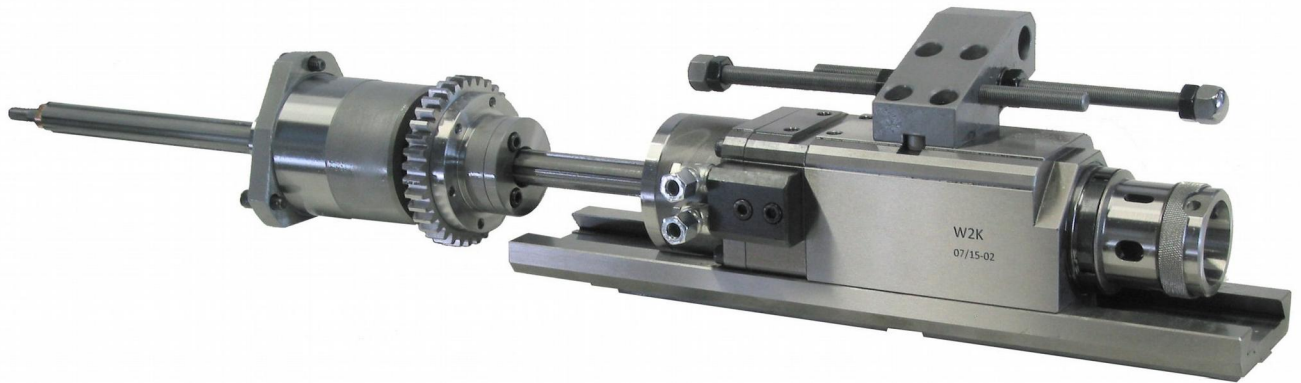## COLLETS AND FEED FINGER

TOGGLES

TOGGLE SLEEVE

CAMS

FULL THREADING ATTACHMENT

HYDRAULIC PICK-UP ATTACHMENT

The pick-up attachment is used on pos.6.

Its spindle rotates at the same speed than the bar, it clamps the part with the collet during the cutting-off.
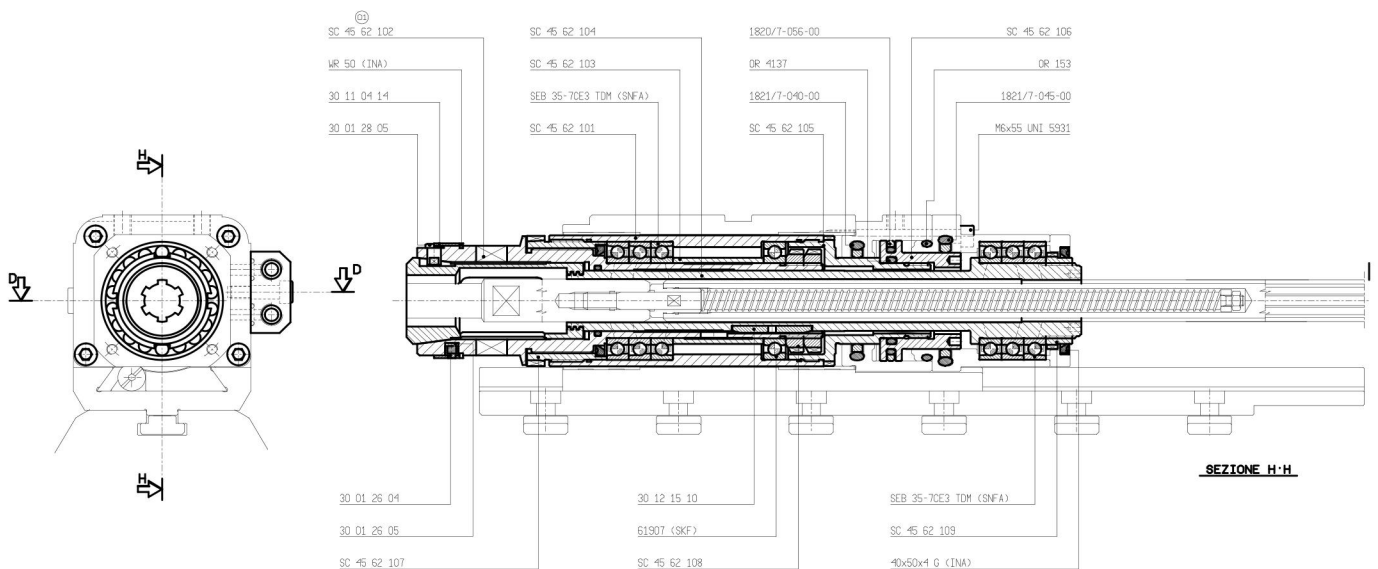
Still with the part in the collet, it goes backward, allowing the positioning of the reprise tool-holder in front.

Going forward against the reprise tool it makes the finishing of the part on the back side.

The last phase is the opening of the collet and the expulsion of the part.

The opening and closing of the collet is fully hydraulic.

We can supply the hydraulic unit in case it is missing in the machine.

SC 45 62 102	SC 45 62 104	1820/7-056-00	SC 45 62 106
WR 50 (INA)	SC 45 62 103	OR 4137	OR 153
30 11 04 14	SEB 35-7CE3 TDM (SNFA)	1821/7-040-00	1821/7-045-00
30 01 28 05	SC 45 62 101	SC 45 62 105	M6x55 UNI 5931

30 01 26 04	30 12 15 10	SEB 35-7CE3 TDM (SNFA)
30 01 26 05	61907 (SKF)	SC 45 62 109
SC 45 62 107	SC 45 62 108	40x50x4 G (INA)

SEZIONE H·H

DIRECT POLYGON-GENERATING AND THREAD-MILLING ATTACHMENT

driven 1:1 ratio gear for thread-milling

gear set for centre shaft

driven 1:2 ratio gear for polygon

cardan spline shaft

tool-head with Wickman original tool-fitting

This attachment can be fitted in any station.
It usually comes with 2 couples of gears, for the 1:1 thread milling and the 1:2 polygon generating.
The 1:2 ratio is used to mill flats on the external diameter of the component.
The cutter rotates at double speed than the bar, samerotating direction,
so the number of milled flats is always twice the number of cutters on the tool.

polygon tool

1 cutter = 2 flats at 180° (key)

2 cutters at 180° = 4 flats at 90° (squares)

3 cutters at 120° = 6 flats at 60° (hexagons).

carbide insert
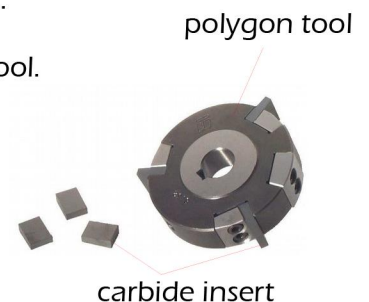
The cutters can have different width and they must be grinded by the user.
The tool fitting can be chosen between original Wickman fitting or 8°32' degree taper (conical)+ key.
By quick replacing the back driven ratio gear you can convert the attachment in thread-milling
Tool rotates at the same speed of the bar, same direction and makes external threads on soft materials,
like brass, but also on hard materials.
We don't supply thread-milling tools but we can suggest where to get them.
This direct version has 2 gears only, and that is good for the finishing of the milled flats.
But the cardan shaft is very close to centre block and so it may be required a smaller drill-holder support.

We also can supply smaller drill-holders in order to make drilling
operations in the same station where you are fitting the attachment.

# POLYGON-GENERATING AND THREAD-MILLING ATTACHMENT
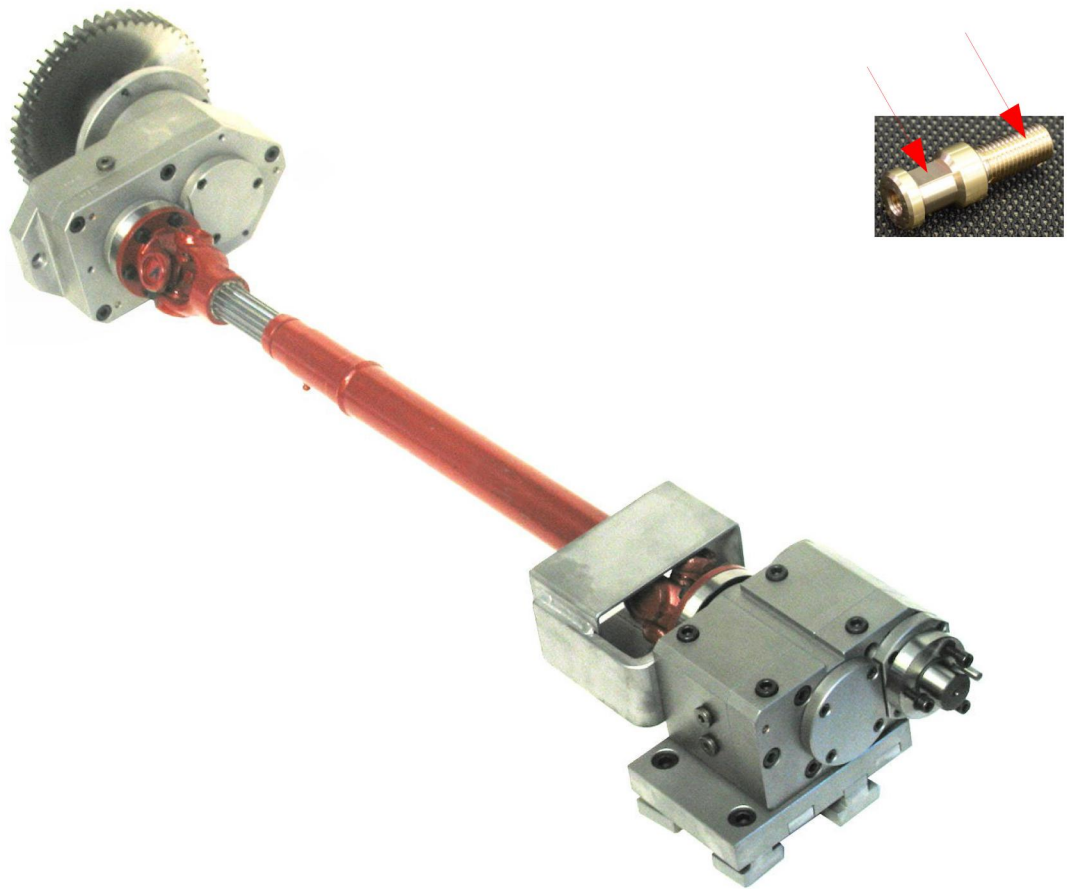
This polygon and thread milling attachment can be fitted in any station.
It has the same features of the attachment in the previous page except for the number of gears.
Here you have 6 gears in total from the centre shaft to the tool.
But the cardan spline shaft is away enough from the centre block to allow the use of standard drill holder brackets.

POLYGON HEAD WITH AXIAL MOVEMENT OF THE TOOL FOR STEEL

pushing bracket
from centre-block

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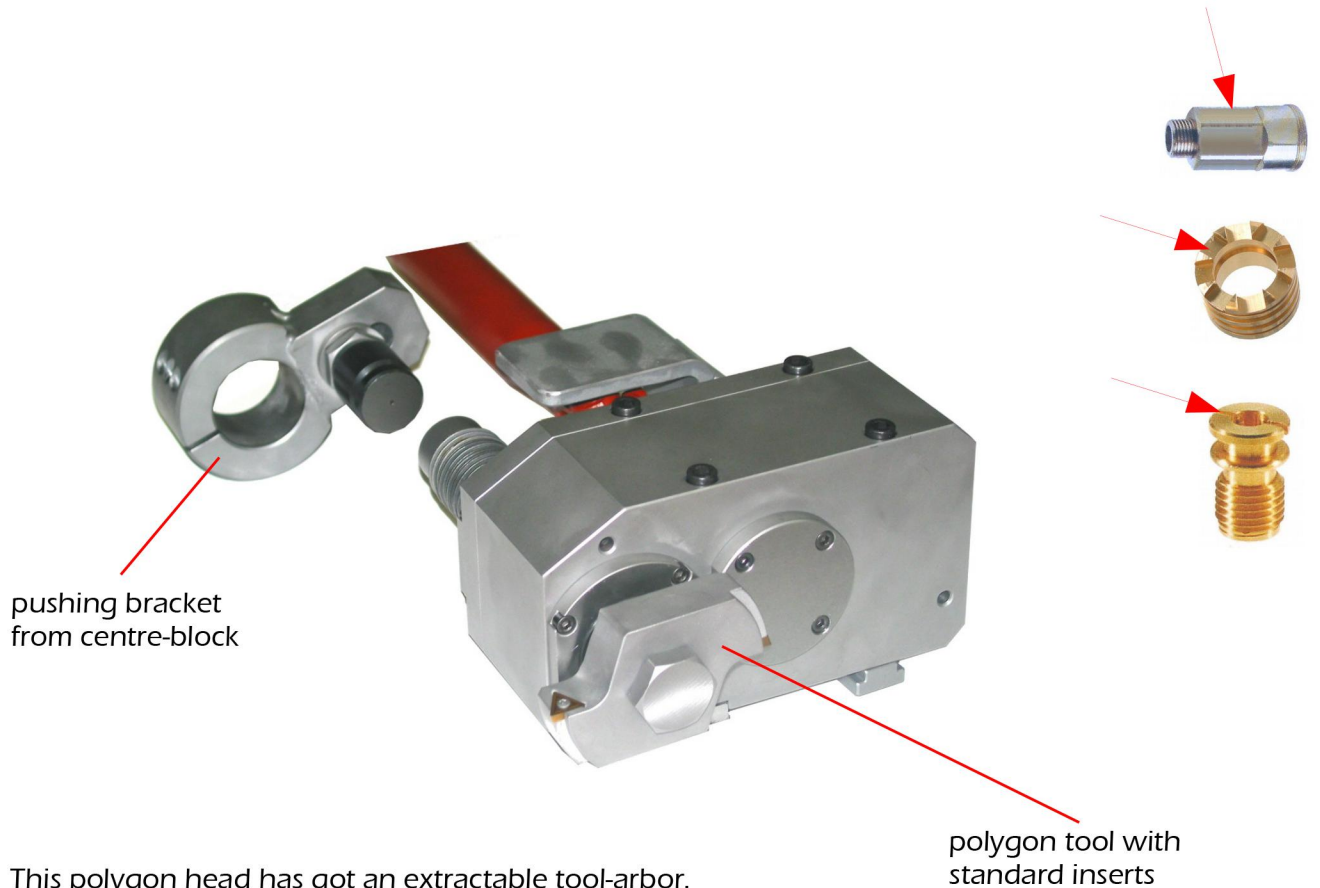
This polygon head has got an extractable tool-arbor.
The tool-arbor back end is outside the head,
so it can be pushed forward by a bracket fixed on the centre block in the same station.
A set of belleville washers will pull the arbor into start position at the end of the cycle.
This kind of attachment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

extractable tool-arbor

belleville washers
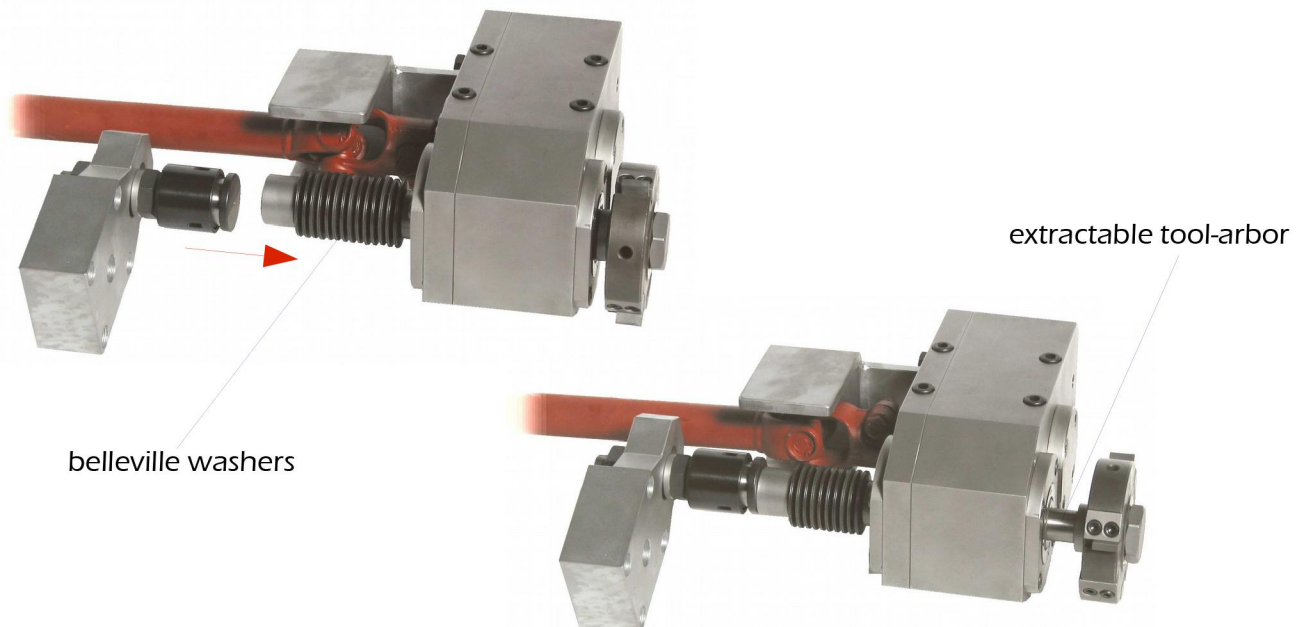
SYNCHRO FRONTAL MILLING ATTACHMENT

TECHNICAL DATAS

- Fitting position   all
- Max speed for the bar   3000rpm
- Max Ø for the milling tool   Ø70mm
- Max Ø for the component   Ø25mm
- Inside rotating ratio speed   0,39 for the steel – 0,61 for the brass
- Adjusteable cross position for the tool

The attachment head rotates at the same speed and the same direction of the bar.

So the milling disk has always the same orientation compared to component.

When the tool touches the component, it can make a slot in centre (for screwdriver) or off-centre, or it can make an external flat.

Using two milling disks it makes two slots or even two external flats (for key).

Also available the attachment version for spindle-stopping machine.

HIGH SPEED DRILLING ATTACHMENT

The High Speed Drilling Attachment rotates in the opposite direction than the bar,

that allows to drill at higher cutting speed.

Different pairs of ratio gears can be supplied to change the cutting speed.

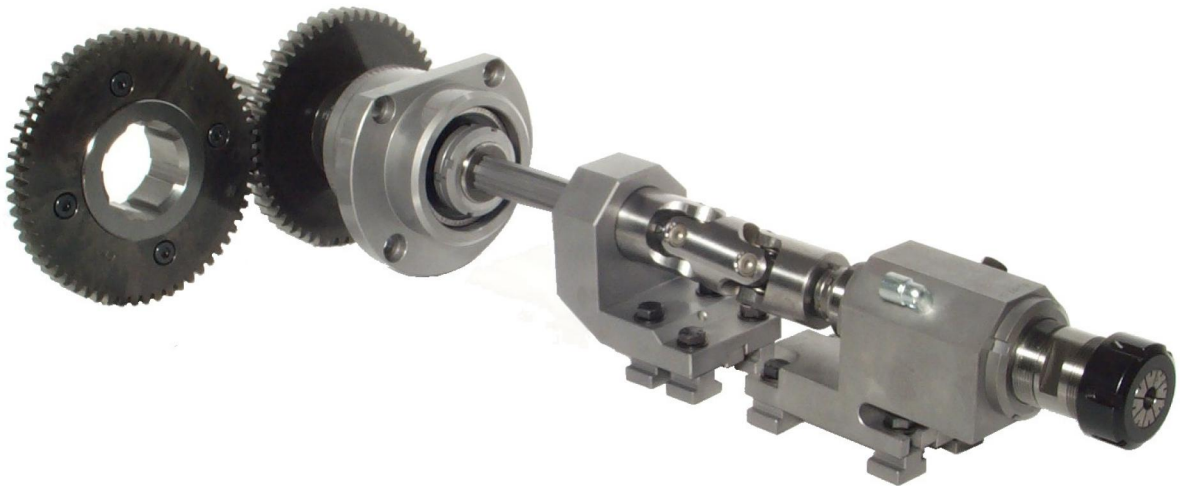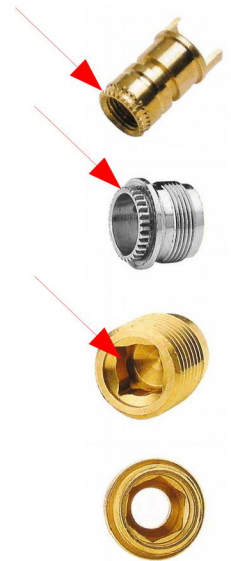The spindle is hold by the standard centre block braket.

The attachment is also available in the coolant through version:

the coolant liquid can be pushed through the drilling tool at high pressure during the drilling operation.

Usually supplied with spindle for ER collets.

It is good to be fit in any position.

BROACHING ATTACHMENT

This attachment is designed to make polygons or geometrical profiles inside or outside the component, provided that they can be reached frontally.
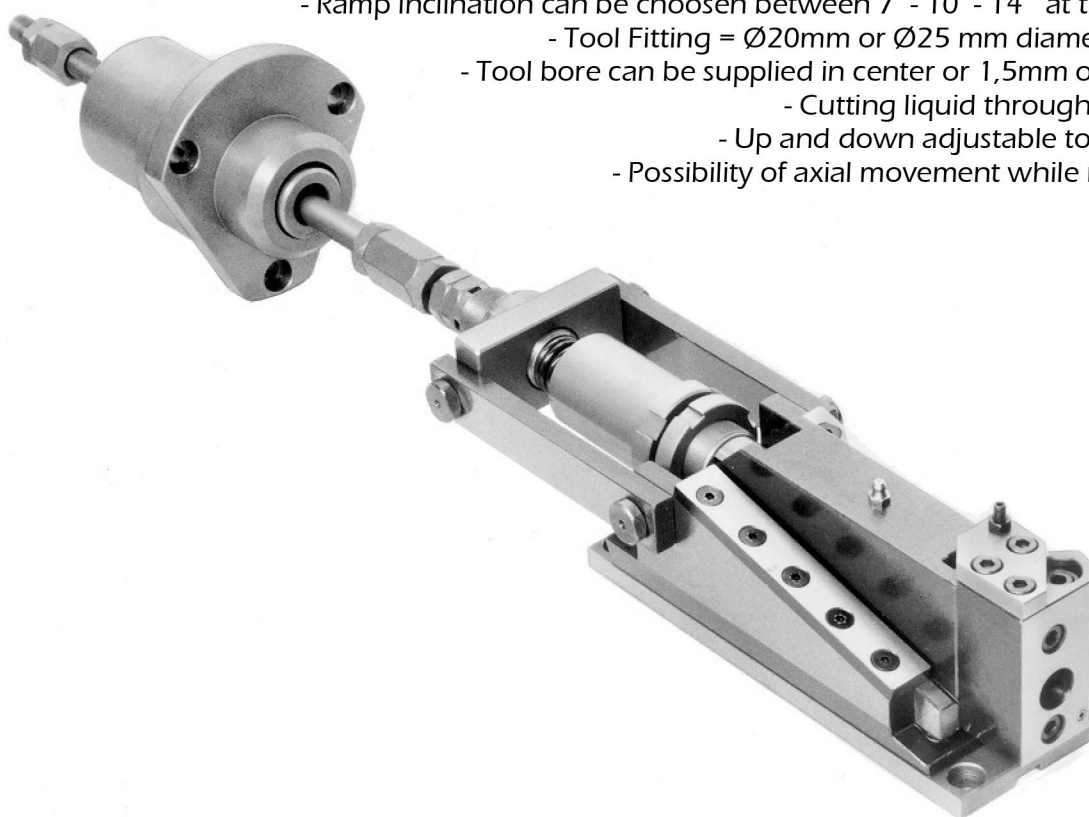
It has to be fitted on the centre block of the machine (or upper indipendent longitudinal slides).

The tool rotates at the same speed than the bar.

The tool spindle axis is slightly inclinated in order to reduce the axial load during the broaching.

The standard tool-spindle uses ER type collets.

RAMP RECESSING ATTACHMENT

TECHNICAL DATA:
- Ramp inclination can be choosen between 7° - 10° - 14° at the order
- Tool Fitting = Ø20mm or Ø25 mm diameter bore
- Tool bore can be supplied in center or 1,5mm off-centre
- Cutting liquid through the tool
- Up and down adjustable toolholder
- Possibility of axial movement while recessing

This attachment is used to make recesses inside the component.
It has to be fixed on the centre block of the machine (frontal station).
After reached the right position inside the component the tool-holder moves upwards, sliding on a inclinated ramp (in case of 14° ramp : 1 mm upwards every 4 mm of axial movement of the centre 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, doing long turning while recessing.
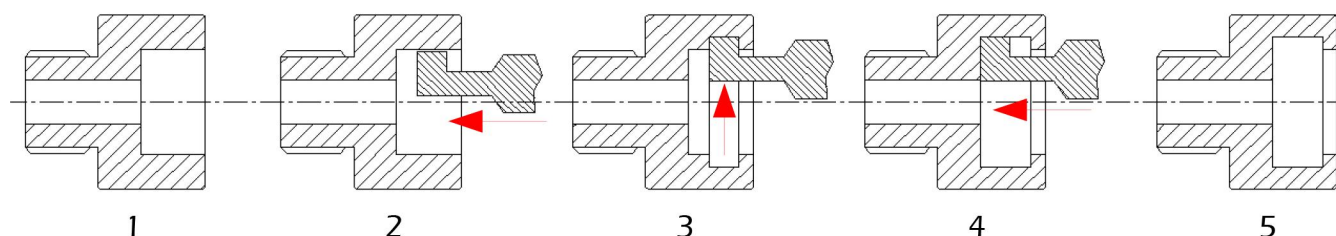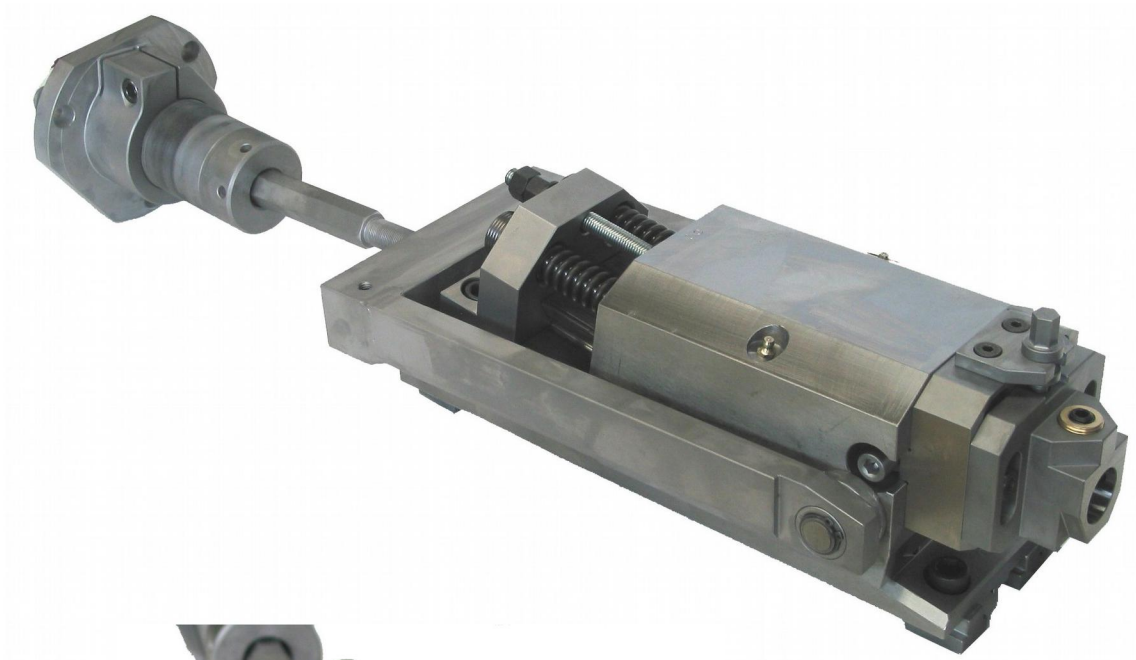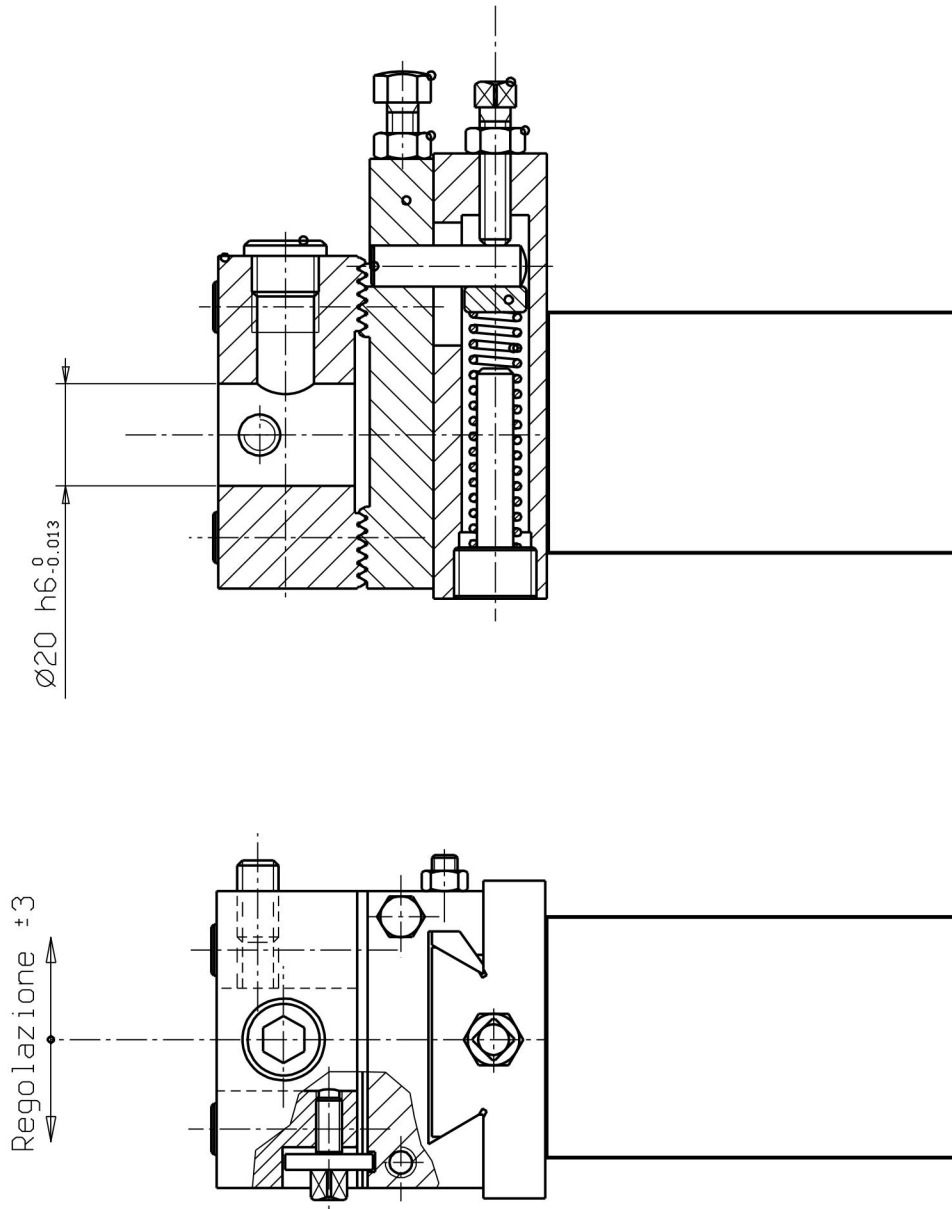
1   2   3   4   5

RAMP RECESSING ATTACHMENT - HEAVY DUTY VERSION

RECESSING HEAD – pushed by cross slide

$\varnothing 20 \ h6_{-0.013}^{0}$

Regolazione ± 3

SYNCHRO FRONTAL MULTI-DRILLING ATTACHMENT
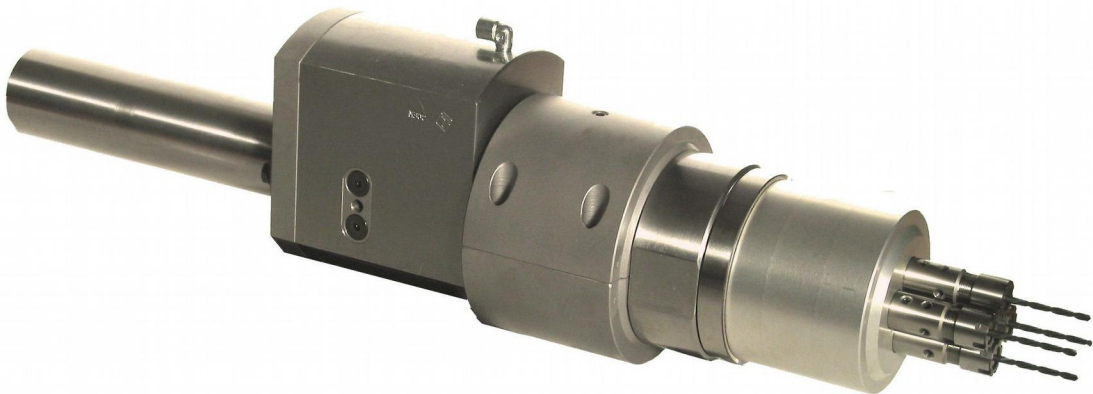
This multi-driller in particular is designed to make 4 drilled holes on a specific interaxis, we can supply it for a special spindle-stopping machine, but also for standard machines.

For standard machines the multi-driller head rotates at the same speed than the bar.

The multi-driller heads are customized for the kind of component you are going to produce.
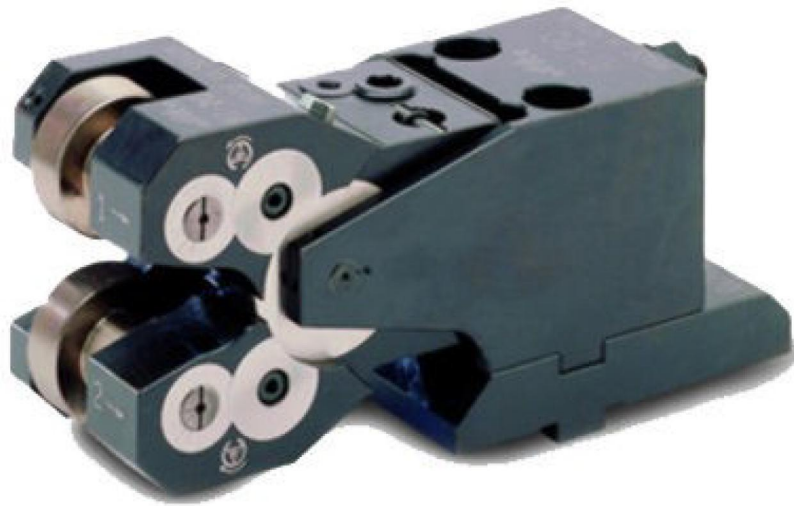
THREAD CHASING ATTACHMENT
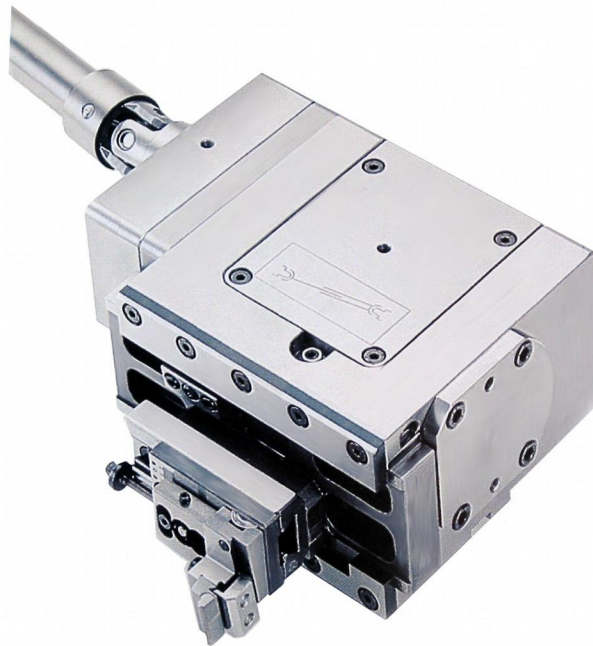
THREAD CHASING ATTACHMENT

Attachment for multispindle automatics with mechanic motion used for threading pieces on diameters which usually can't be reached by a normal die. This attachment is a valid alternative to thread rolling and to milling devices. With suitable variants, internal threads can be obtained in addition to external
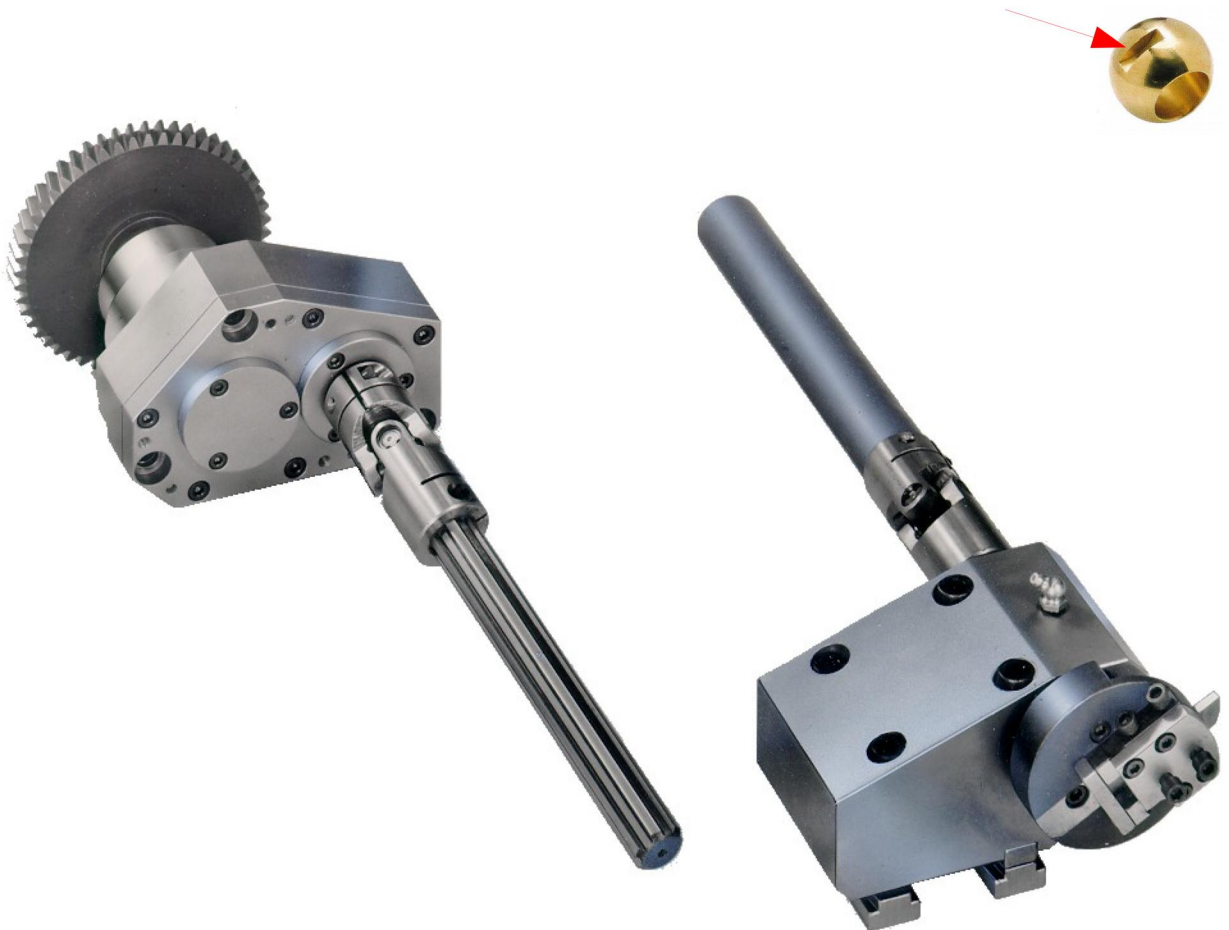
THREAD ROLLING ATTACHMENT for cross slide

We can supply new or good used cross thread-rolling Fette heads,

models are the following T12, T18, T27

We can adapt them to any kind of machine model

RADIAL SLOT CUTTING ATTACHMENT

This attachment is designed to make radial slots on the external of the component.
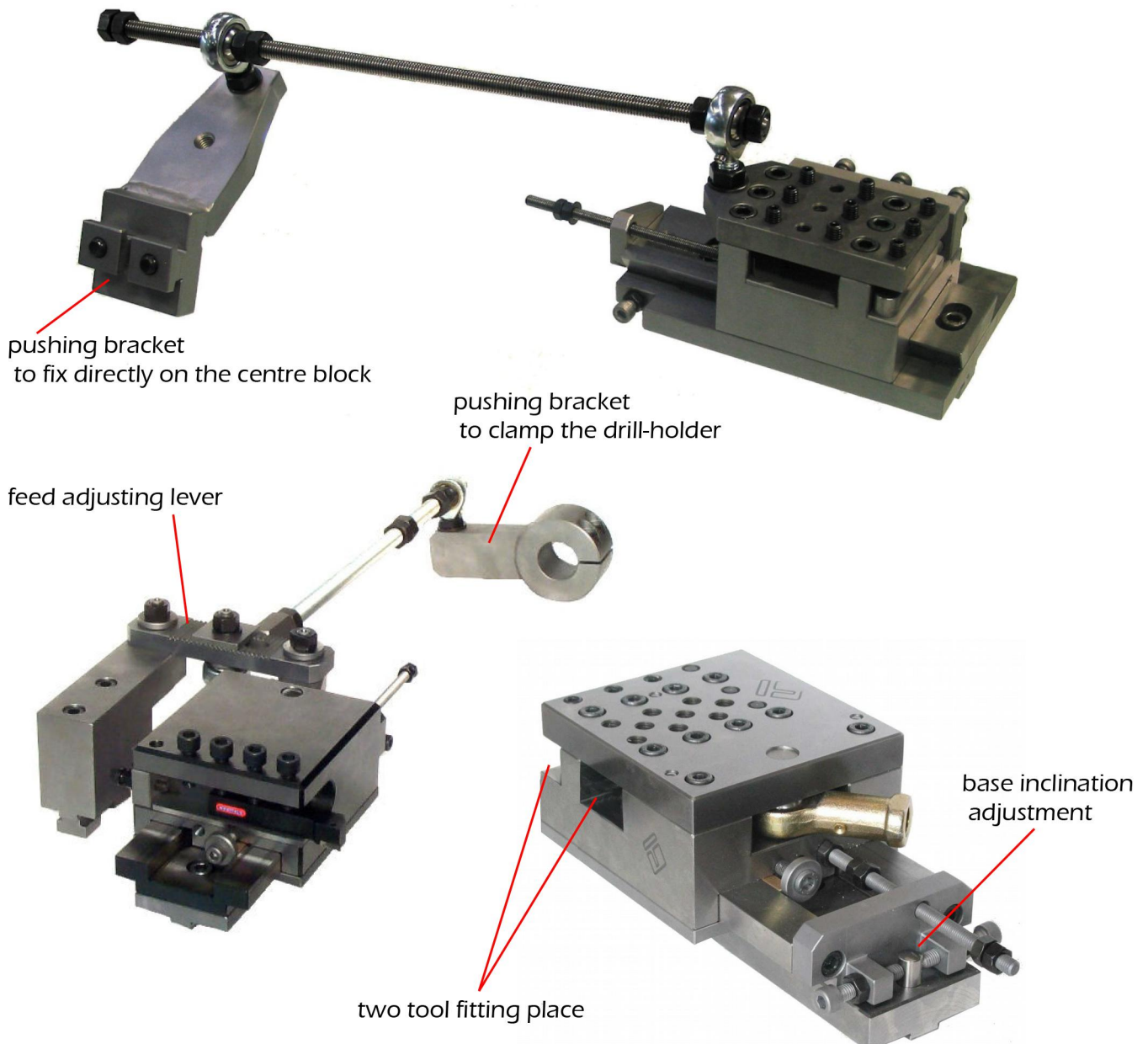
It must be fitted on the cross slide of the machine. The tool rotates at the same speed of the bar but in opposite direction. Each cutter on the tool makes a single slot on the component.

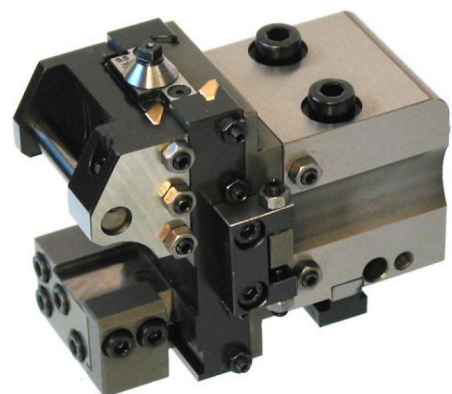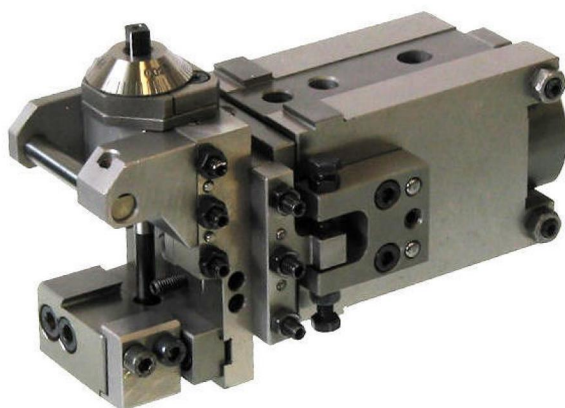The radius of the slot it is not the same than the radius on which rotate the cutter.
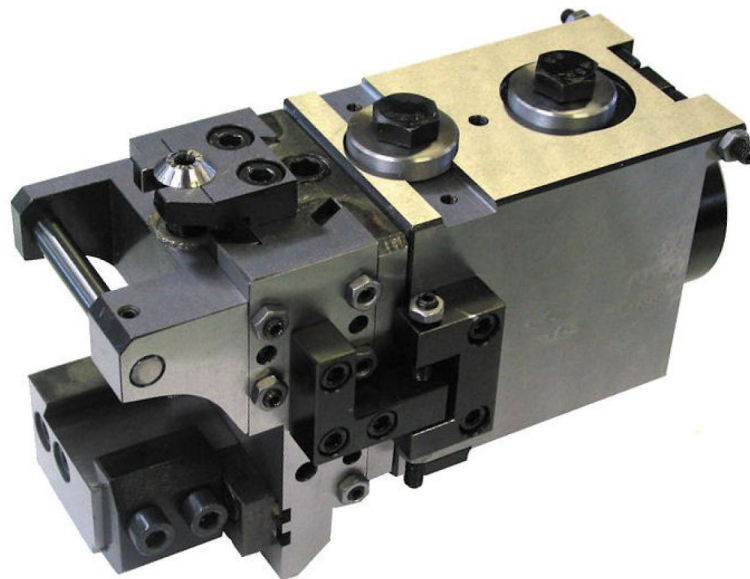
The radius of the slot depends on different geometrical factors and that allows to make even small slots with a bigger tools.

LONGITUDINAL TURNING CHARIOT

The axial chariot can be used on machine cross slides to make long turning operations.
The feed is taken by fitting a pushing bracket on the centre block (same station).
The bracket can be fixed directly on the centre block or it can clamp the drill holder back end.
The inclination of the bottom base is adjustable.
The chariot has the same feed than the centre block
unless you prefer the version with adjustable feed lever.

pushing bracket
 to fix directly on the centre block

pushing bracket
 to clamp the drill-holder

feed adjusting lever

base inclination
adjustment

two tool fitting place

SHAVING TOOL-HOLDER

The shaving tool-holder is used to have very precise diameter.

It can be used on any cross-slides. It must be completed by the customer by a roller on

The top carbide pin and a cutting insert clamped at the bottom.

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.

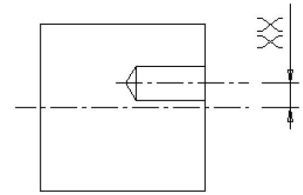We can supply blank disks or engraved disk, following customer's requirements.

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.
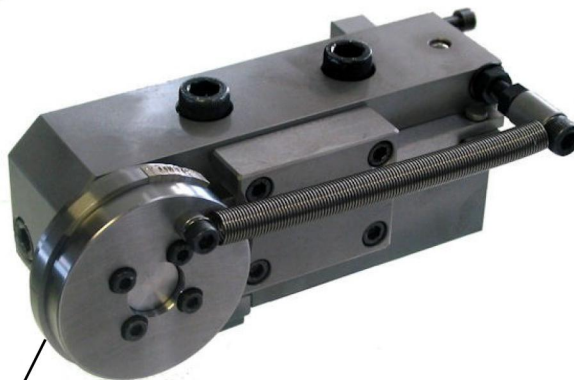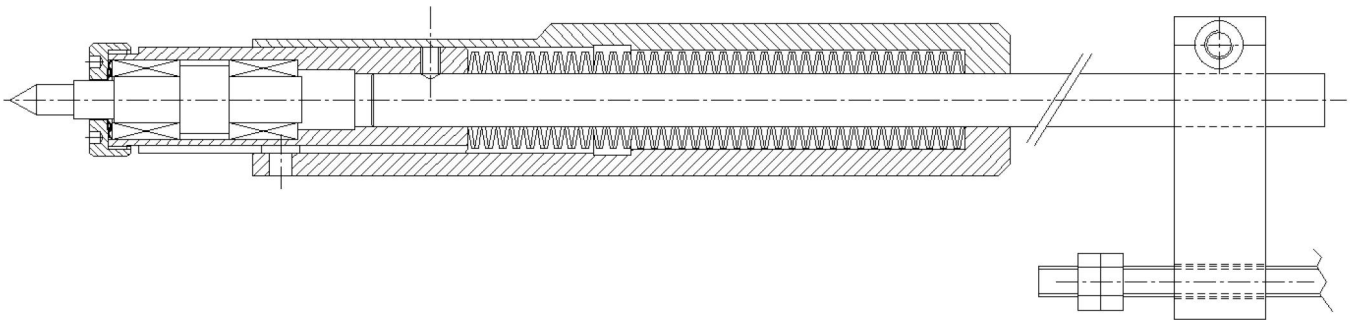
The new roller with interchangeable characters

OFF-CENTRE DRILLING SPINDLE

Thi rotating spindle drills off-centre holes in a very easy way.

The interaxis is customized.

ROTATING LIVE CENTER WITH COMPENSATION

model : CRE

Contropunta standard con cono morse2
standard live center with morse2

model : CE_CM2
corpo elastico non rotante con cono morse2
non rotating body with morse2 and compensation