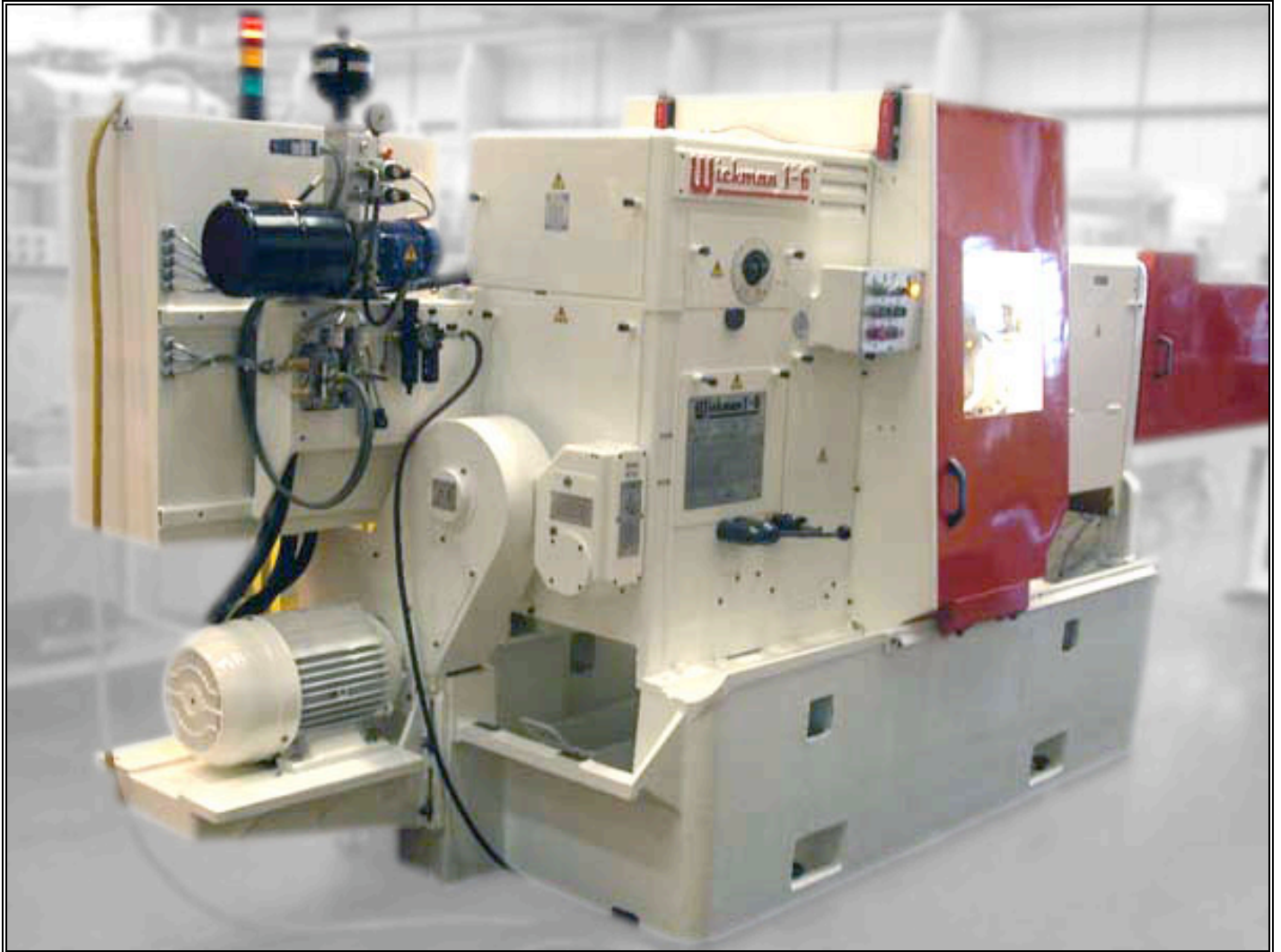


# Wickman 1"-6 spindle bar automatic

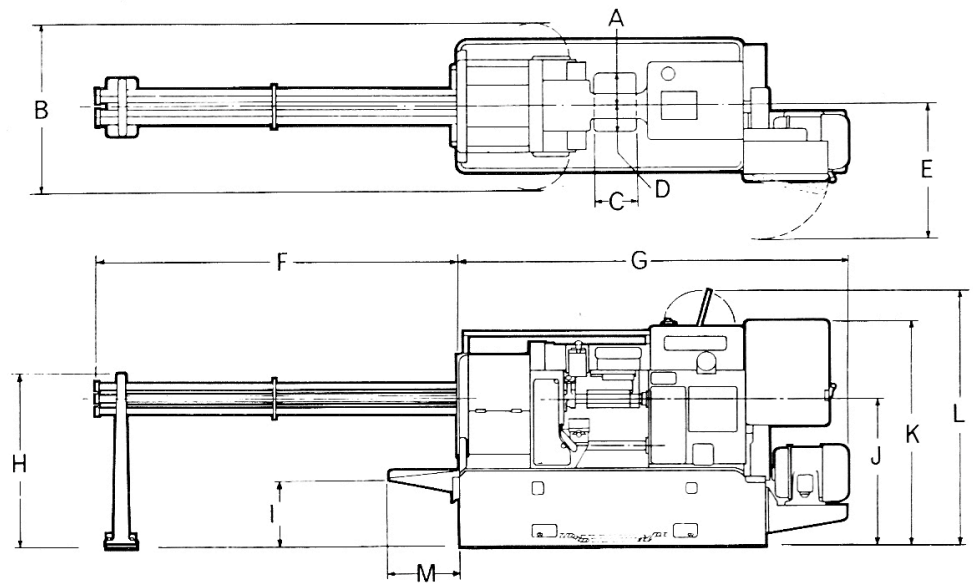


The 1"-6 Spindle Automatic has the standard Wickman design features, including the 'no cam change' which secure smooth running at fast production rates, and ensure consistent accuracy of components. Adjustment to the machining slides and centreblock, and setter controls designed for easy and accurate movement, ensure that maximum versatility of component machining is obtained with minimum changeover times. The machine enables efficient handling of medium and large batch production to be achieved without the necessity of cam manufacture and storage. The versatility of

component production is further enhanced by the availability of the machine in spindle stopping, double and long length feed versions, and the convenient application of a large range of tooling attachments. The operator panel and production progress indication systems, having simplicity of design, promote optimum conditions which encourage fast and accurate production. Optimum performance is also secured by the lubrication, coolant and electrical systems which demand the minimum of necessary routine maintenance.

## Base plan

- A 8"10.3/8" (2702mm)
- B 12'0" (3656mm)
- C 7<sup>1</sup>/<sub>2</sub>" (191mm)
- D 1'4" (406mm)
- E 6'7.3/8" (2016mm)
- F 2'0<sup>1</sup>/<sub>2</sub>" (622mm)
- G 4'6.1/8" (1375mm)
- H 2'3.5/8" (702mm)
- I 6'7<sup>3</sup>/<sub>4</sub>" (2026mm)
- J 5'8<sup>1</sup>/<sub>2</sub>" (1740mm)
- K 1'7" (483mm)
- L 4'9" (1448mm)
- M 1'10" (559mm)
- N 3'11" (1194mm)
- O 3'0" (914mm)
- P 6'3<sup>3</sup>/<sub>4</sub>" (1924mm)



## Standard equipment

Four main cross slides  
 6th station cut off slide  
 Main hexagon block  
 Machine mounted control panel with 'Star Delta' automatic starter.  
 15 HP (11 kW) foot mounted motor  
 6th station single bar feed with auto stop mechanism.  
 Complete coolant system, splash guards and work lighting.  
 Tool kit and setting gauges  
 Lined stock carriage  
 Set of solid collets, feed fingers and steady bushes  
 Sets of standard feed and speed gears

## Optional equipment

4th and 5th station independent long it J  
 3rd station forming slide  
 3rd and 6th station double bar feeding  
 a 3rd Station cut off slide.  
 Spindle stopping arrangement  
 Long bar feed arrangement  
 'Bijur' lubrication.  
 Motorised swarf conveyor'.  
 Comprehensive range of attachments and toolholders (listed on separate sheet in this series).  
 Also special attachments built to customer requirements.

## Specification

Bar capacity	Round	1" (25.4 mm)
	Hex. (A/F)	0.86" (21.8mm)
	Square (A/F)	0.70" (17.7 mm)
Bar feed stroke	Standard	0-5" (0-127 mm)
	Long bar feed	<sup>1</sup> / <sub>2</sub> -8" (12-203 mm)
	Double bar feed	<sup>1</sup> / <sub>2</sub> -5" (12-127 mm)
	Double long bar feed	<sup>1</sup> / <sub>2</sub> -8" (12-203 mm)
Feed stroke on main tool block		0-2 <sup>1</sup> / <sub>2</sub> " (0-63.5 mm)
Feed stroke on independent slides		0-2 <sup>1</sup> / <sub>2</sub> " (0-63.5 mm)
Approach stroke on main tool block	Standard	2 <sup>1</sup> / <sub>2</sub> " (63.5 mm)
	Special	2" (50.8 mm)
Approach stroke on independent slides	Standard	2 <sup>1</sup> / <sub>2</sub> " (63.5 mm)
	Special	2" (50.8 mm)
Feed stroke on lower cross slides		0- <sup>1</sup> / <sub>2</sub> " (0-12.7 mm)
Feed stroke on upper cross slides		0- <sup>1</sup> / <sub>2</sub> " (0-12.7 mm)

Feed stroke on intermediate cross slides		1/32 - 1/2" (0.8-12.7 mm)
Motor		11 kW at 1450 rev/min
	Standard	247-3030 rev/min in 24 steps
Spindle speed range	Spindle stopper	220-2694 rev/min in 24 steps
Feed range at max. stroke (/rev)		
	Standard	0.005-0.056" (0.12-1.34 mm)
	Spindle stopper	0.0056-0.063" (0.13-1.51 mm)
Idle time		
	Standard	1.37 secs
	Spindle stopper	1.37 secs
	Long bar feed	1.92 secs
Range of cycle times		
	Standard	2.4-129 secs
	Spindle stopper	2.4-129 secs
Overall dimensions - without stock carriage		49 <sup>1</sup> / <sub>2</sub> x 123 <sup>3</sup> / <sub>4</sub> "(1257x3143mm)
Overall dimensions - with stock carriage		49 <sup>1</sup> / <sub>2</sub> x 238 "(1257x6047mm)
Approximate nett weight (including electrics and stock carriage)		13890lb (6313kg)