

Wickman 2¹/₄"-6 spindle bar automatic

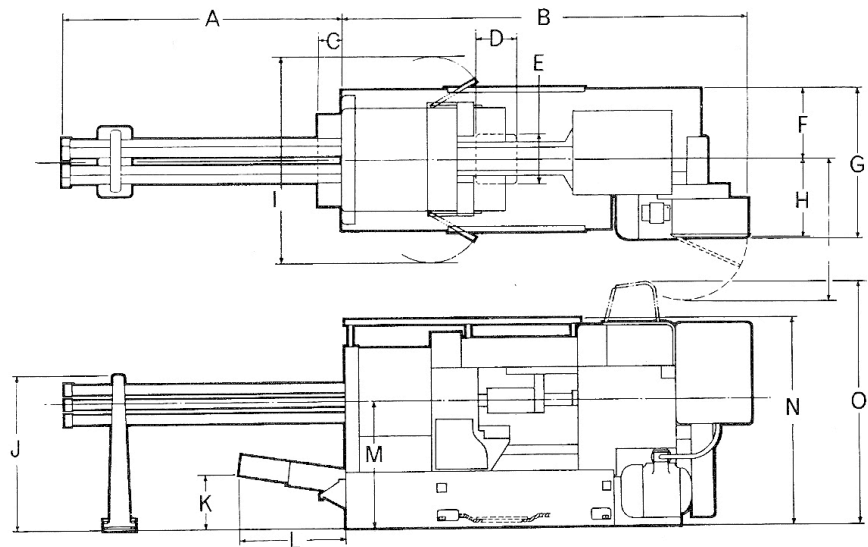


The 2¹/₄"-6 Spindle Automatic has the standard Wickman design features, including the 'no cam change', which secure smooth running at fast production rates, and ensure consistent accuracy of components. The machining slides and centreblock, and setter controls are designed for easy and accurate movement, to ensure that maximum versatility of component machining is obtained with minimum changeover times. The machine's efficient medium and large batch production is 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 ¹ / ₂ " (191mm)
D	1'4" (406mm)
E	6'7.3/8" (2016mm)
F	2'0 ¹ / ₂ " (622mm)
G	4'6.1/8" (1375mm)
H	2'3.5/8" (702mm)
I	6'7 ³ / ₄ " (2026mm)
J	5'8 ¹ / ₂ " (1740mm)
K	1'7" (483mm)
L	4'9" (1448mm)
M	1'10" (559mm)
N	3'11" (1194mm)
O	3'0" (914mm)
P	6'3 ³ / ₄ " (1924mm)



Standard equipment

Four main cross slides
 6th station cut off slide
 Main hexagon block
 Machine mounted control panel with 'Star automatic starter',
 25 HP (18.5 kW) foot mounted motor
 6th station single bar feed with auto stop mechanism,
 Complete coolant system, splash guards 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 longitude
 3rd station forming slide
 3rd and 6th station double bar feeding,
 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	2 ¹ / ₄ " (57)
	Hex. (A/F)	1.95" (49.5mm)
	Square (A/F)	1.59" (40.3 mm)
Bar feed stroke	Standard	1 ¹ / ₂ -10" (12-254 mm)
	Long bar feed	2-16" (50-406 mm)
	Double bar feed	1 ¹ / ₂ -6" (12-153 mm)
	Double long bar feed	2-10" (50-254 mm)
Feed stroke on main tool block		0-5" (0-127 mm)
Feed stroke on independent slides		0-5" (0-127 mm)
Approach stroke on main tool block	Standard	4" (102 mm)
	Special	3 ¹ / ₂ " (90 mm)
Approach stroke on independent slides	Standard	4 ¹ / ₄ " (108 mm)
	Special	3 ³ / ₄ " (95 mm)
Feed stroke on lower cross slides		0-1 ³ / ₈ " (0-35 mm)
Feed stroke on upper cross slides		0-2 ¹ / ₈ " (0-54 mm)
Feed stroke on intermediate cross slides		0-1 3/16"- (0-30 mm)

Motor	Standard	18.5 kW at 1450 rev/min
	Special	30 kW at 1450 rev/min
Spindle speed range	Standard	111-1302 rev/min in 24 steps
	Spindle stopper	111-1302 rev/min in 24 steps
Feed range at max. stroke (/rev)	Standard	0.0048-0.054" (0.12-1.38 mm)
	Spindle stopper	0.0048-0.054" (0.12-1.38 mm)
Idle time	Standard	2.5 secs
	Spindle stopper	2.5 secs
	Long bar feed	4.4 secs
Range of cycle times	Standard	7-602 secs
	Spindle stopper	7-602 secs
Overall dimensions - without stock carriage		58 x 164 ¹ / ₂ "(1473x4178mm)
Overall dimensions - with stock carriage		58 x 262"(1473x6652mm)
Approximate nett weight (including electrics and stock carriage)		22400lb (10150kg)