



MULTI-SPINDLE AUTOMATICS

TOOLHOLDERS
CHUCKS
&
COLLETS

FRAME 1,2,3,& 5

5/8" - 6

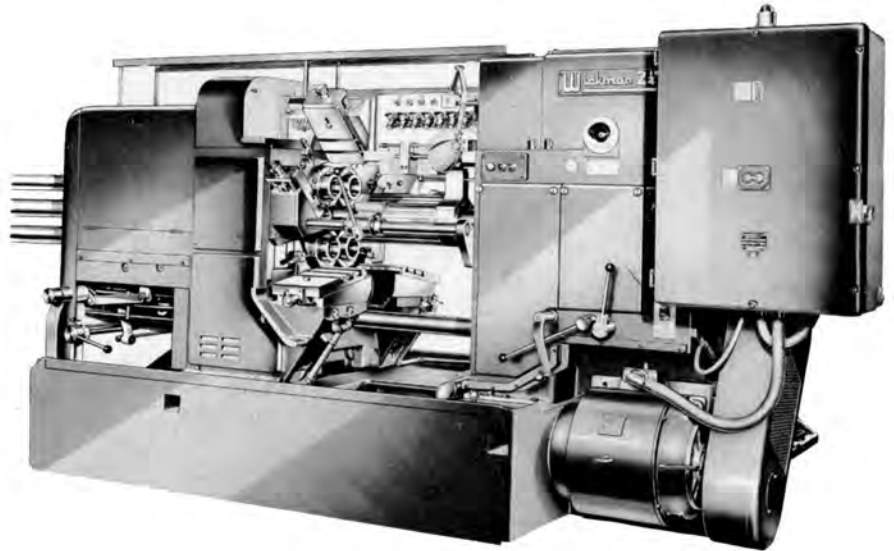
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Range of Bar Automatics

Spindles	Capacity
4	3½"
	*4⅛"
5	1⅜"
	1¾"
	2¼"
	1"
6	1⅜"
	1¾"
	2¼"
	2⅝"
	†3¼"
8	1¾"

*4⅛"—4. Toolholders as used on 3½"—4 machine.

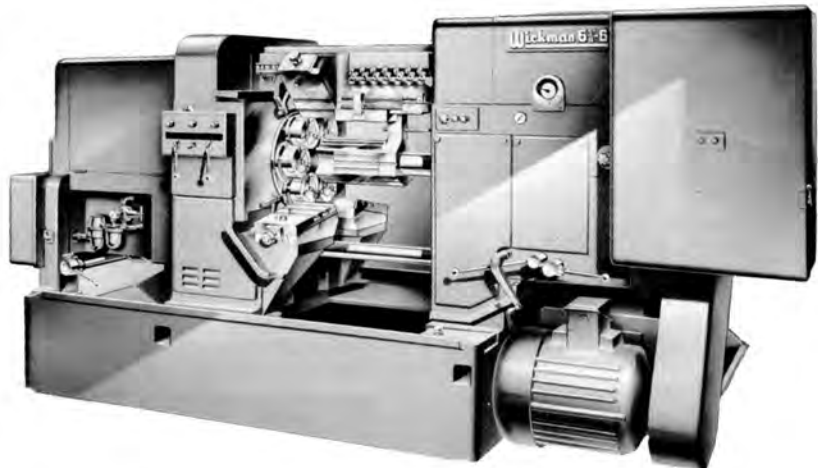
†3¼"—6. Toolholders as used on 2⅝"—6 machine.



2¼"—6 Bar Automatic

Range of Chucking Automatics

Spindles	Capacity
4	9"
5	5"
	6"
6	5⅝"
	6⅝"
	7¼"



6⅝"—6 Chucking Automatic

Interchangeable Toolholders

See chart at end of book for interchangeability of toolholders between all machines in the Wickman range.

THE purpose of this catalogue is to assist users of Wickman Multi-Spindle Automatics to select and correctly order standard toolholders.

Toolholders for the range of Wickman Bar and Chucking Automatics are listed and the interchangeability of toolholders between stations and various machines is defined.

Illustrations, general outline drawings and dimensions are given to enable designers and tooling engineers to apply toolholders and fully exploit the productive capacity of the machines. The illustrations are intended to typify the type of toolholder ; the design varies to suit differing machine sizes.

Special toolholders can also be designed to suit customers' individual requirements.

Collets, feed fingers, chucks, dieheads and yokes are dealt with in Section 3.

See page 6 for ordering instructions.

All 'open' dimensions are given to 0.01 ins. or to 0.5 mm., *i.e.* 1.56 ins. = 39.5 mm. All toleranced dimensions are given to 0.001 ins. or to 0.01 mm., *i.e.* 1.562 ins. = 39.68 mm.

Stations for any particular toolholder are recommended stations only.

The design of Wickman Automatics, Toolholders and Attachments is subject to continuing development and the right must be reserved to incorporate modifications when necessary and without notice.

While every effort has been made to ensure the accuracy of information herein, Wickman Limited does not accept liability for omissions and errors.

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		Boring & Turning (Centre Block)	32.CB	11	
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		With Morse Taper Inserts	27	14	
		Adjustable	30	15	
		Collet		86-89 incl.	
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		Lightweight	51	17	
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STEADYING	Roller Steady	Centre Block Mounted	23,24 & 47	20-23 incl.	
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		Shank	55	25	
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OPERATION	TOOLHOLDER	TYPE OF TOOLHOLDER	TOOLHOLDER No.	PAGE
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Collets, Feed Fingers, etc.	—	89-92 incl.
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Metric and Conversion Tables	—	102 & 103
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TOOLHOLDER ORDERING INSTRUCTIONS

When ordering toolholders state:

TOOLHOLDER NAME & DRAWING NUMBER

MACHINE SERIAL & INSPECTION NUMBERS

MACHINE SIZE & NUMBER OF SPINDLES

STATION on which holder will be used.

NUMERICAL INDEX

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38R	72	55	25	83	31
39	71	56	26	84	80
39L	73	58	47	85	80
		60	8A	88	24
				98	8B



SECTION 1

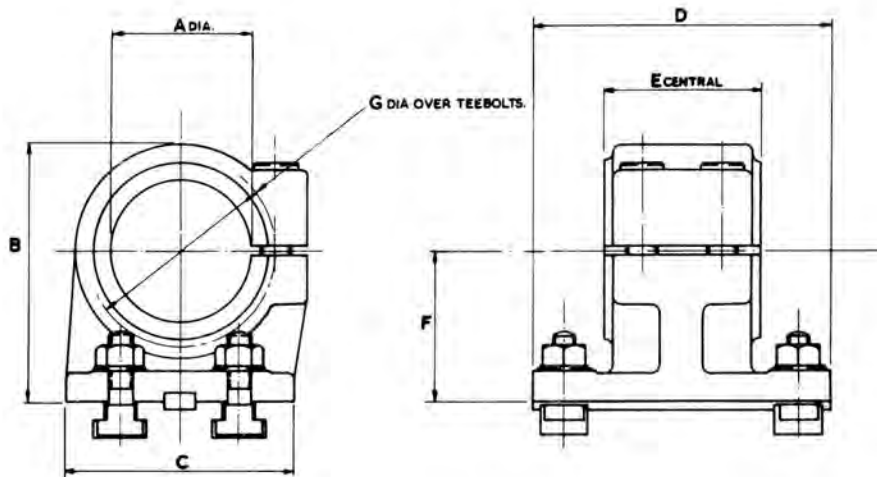
ENDWORKING TOOLHOLDERS

BRACKET TOOLHOLDER



The bracket toolholder bore accommodates shank type tools such as drills, reamers, etc. This holder can also be used for carrying boring bars and other shank type toolholders and steadies.

See pages 8A, 8B, 9, 10 and 11 for other types of bracket toolholder.



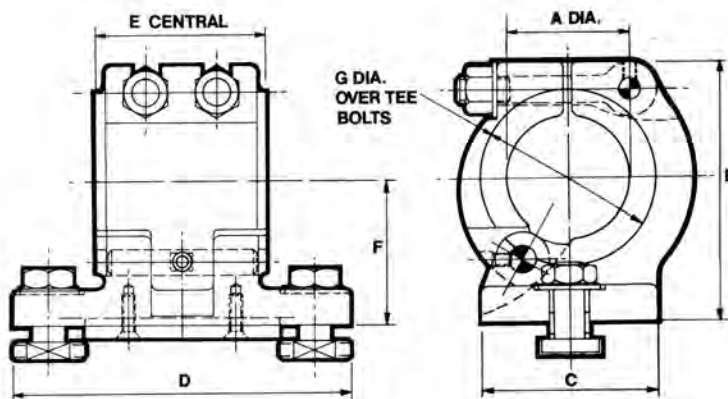
Machine	1 3/8" — 5 Bar 5" — 5 Chucker		1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker		1 3/4" — 8 Bar 2 1/4" — 6 Bar 6 3/8" — 6 Chucker		2 3/8", 3 1/4" — 6 Bar 7 1/2" — 6 Chucker		3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker	
	W5—138—20		W5—134—20		W6—214—20		W6—258—20		W4—350—20	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A dia.	2-000	50-80	2-000	50-80	2-000	50-80	2-500	63-50	3-00	76-20
B	3-62	92-0	3-81	97-0	4-00	101-5	5-00	127-0	5-25	133-0
C	3-25	82-5	3-25	82-5	3-75	95-0	4-12	105-0	5-12	130-0
D	4-25	108-0	4-25	108-0	5-00	127-0	6-00	152-0	6-50	165-0
E	2-25	57-0	2-25	57-0	3-00	76-0	3-50	89-0	3-75	95-0
F	2-12	54-0	2-31	59-0	2-50	63-5	3-00	76-0	3-00	76-0
G	2-75	70-0	2-87	73-0	3-00	76-0	3-62	92-0	3-50	89-0

BRACKET TOOLHOLDER

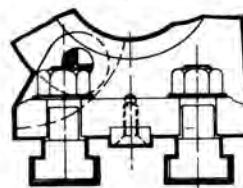
(HINGED TYPE)

The bracket toolholder bore accommodates shank type tools such as drills, reamers, etc. This holder can also be used for carrying boring bars and other shank type toolholders and steadies.

See pages 8, 8B, 9, 10 and 11 for other types of bracket toolholder.



NOTE:-
1/6 MACHINE 1 TEE BOLT.
ALL OTHER MACHINES
2 TEE BOLTS AS SHOWN.



Machine	1''-6 Bar		1 3/8'', 1 3/4''-6 Bar 5 5/8''-6 Chucker 1 3/4'', 2 1/4''-5 Bar 6''-5 Chucker		1 3/4''-8 Bar 2 1/4''-6 Bar 6 5/8''-6 Chucker		2 5/8'', 3 1/4''-6 Bar 7 1/4''-6 Chucker	
	W6-1-60		W6-138-60		W6-214-60		W6-258-60	
Drg. No.	W6-1-60		W6-138-60		W6-214-60		W6-258-60	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.500	63.50
B	3.62	92.0	4.12	105.0	4.31	109.5	5.31	135.0
C	2.50	63.5	3.25	82.5	3.75	95.0	4.12	105.0
D	4.75	120.5	4.25	108.0	5.00	127.0	6.00	152.5
E	2.37	60.5	2.25	57.0	3.00	76.0	3.50	89.0
F	2.000	50.80	2.312	58.74	2.500	63.50	3.000	76.20
G	2.12	54.0	2.87	73.0	3.37	85.5	3.62	92.07

TOOLHOLDER for WICKMAN AUTOMATICS

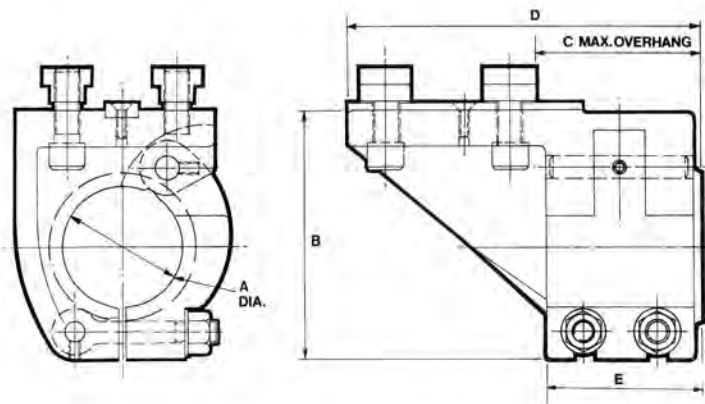
BRACKET TOOLHOLDER

(OVERHANGING HINGED TYPE)



This holder is designed primarily for use on the independent slides, but can also be used on all centre block positions. Accommodates shank type tools and toolholders.

See pages 8, 8A, 9 and 10 for other types of bracket toolholder.



Machine	1 $\frac{3}{8}$ "', 1 $\frac{3}{4}$ "-6 Bar 5 $\frac{5}{8}$ "-6 Chucker 1 $\frac{3}{4}$ "', 2 $\frac{1}{4}$ "-5 Bar 6"-5 Chucker		1 $\frac{3}{4}$ "-8 Bar 2 $\frac{1}{4}$ "-6 Bar 6 $\frac{5}{8}$ "-6 Chucker		2 $\frac{5}{8}$ "', 3 $\frac{1}{4}$ "-6 Bar 7 $\frac{1}{4}$ "-6 Chucker	
Drg. No.	W6-138-98/4		W6-214-98/4		W6-258-98/4	
Station	3 4	1 $\frac{3}{4}$ "-5 Bar 1 $\frac{3}{8}$ "-6 Bar	5 4	1 $\frac{3}{4}$ "-8 Bar 2 $\frac{1}{4}$ "-6 Bar	4	
Drg. No.	W6-138-98/5		W6-214-98/5		W6-258-98/5	
Station	4 5	1 $\frac{3}{4}$ "-5 Bar 1 $\frac{3}{8}$ "-6 Bar	6 5	1 $\frac{3}{4}$ "-8 Bar 2 $\frac{1}{4}$ "-6 Bar	5	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A dia.	2.000	50.80	2.000	50.80	2.500	63.50
B	4.19	106.5	4.37	111.0	5.31	135.0
C	2.82	71.5	2.62	66.5	1.25	31.5
D	6.00	152.5	6.50	165.0	7.37	187.5
E	2.62	66.5	2.62	66.5	3.50	89.0

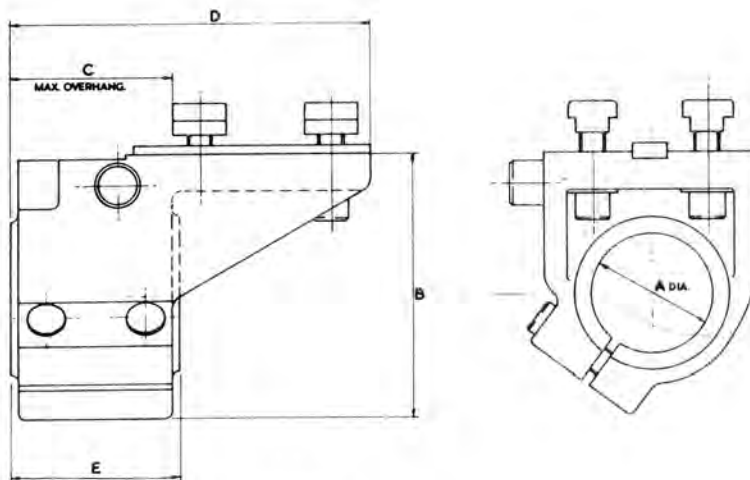
TOOLHOLDER for WICKMAN AUTOMATICS

BRACKET TOOLHOLDER

(OVERHANGING TYPE)

This holder is designed primarily for use on the independent slides, but can also be used on all centre block positions. Accommodates shank type tools and toolholders.

See pages 8, 8A, 8B, 10 and 11 for other types of bracket toolholder.



INDEPENDENT SLIDES

Machine	1" — 6 Bar		1 3/8" — 5 Bar 5" — 5 Chucker		1 3/8", 1 3/4" — 6 Bar 5 5/8" — 6 Chucker		1 3/4" — 8 Bar		2 5/8", 3 1/4" — 6 Bar		3 1/2", 4 1/8" — 4 Bar	
	Hinged Type				1 3/4", 2 1/4" — 5 Bar 6" — 5 Chucker		2 1/4" — 6 Bar 6 5/8" — 6 Chucker		7 1/4" — 6 Chucker		9" — 4 Chucker	
Dr. No.	W6-1-33/4		W5-138-33/3		W5-134-33/3		W6-214-33/4		W6-258-33		W4-350-33/3	
Station	4		3		3 1 3/4" — 5 Bar 4 1 3/8" — 6 Bar	5 1 3/4" — 8 Bar 4 2 1/4" — 6 Bar		4		3		
Dr. No.	W6-1-33/5		W5-138-33/4		W5-134-33/4		W6-214-33/5		W6-258-33		W4-350-33/4	
Station	5		4		4 1 3/4" — 5 Bar 5 1 3/8" — 6 Bar	6 1 3/4" — 8 Bar 4 2 1/4" — 6 Bar		5		4		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.000	50.80	2.500	63.50	3.000	76.20
B	3.62	92.0	4.06	103.0	4.31	109.5	4.50	114.5	5.00	127.0	5.25	133.0
C	2.25	57.0	2.62	66.5	2.62	66.5	2.62	66.5	1.25	31.5	1.25	31.5
D	4.75	120.5	5.87	149.0	5.87	149.0	5.87	149.0	7.37	187.3	8.25	209.5
E	2.37	60.0	2.75	70.0	2.75	70.0	2.75	70.0	3.50	89.0	3.87	98.5

TOOLHOLDER for WICKMAN AUTOMATICS

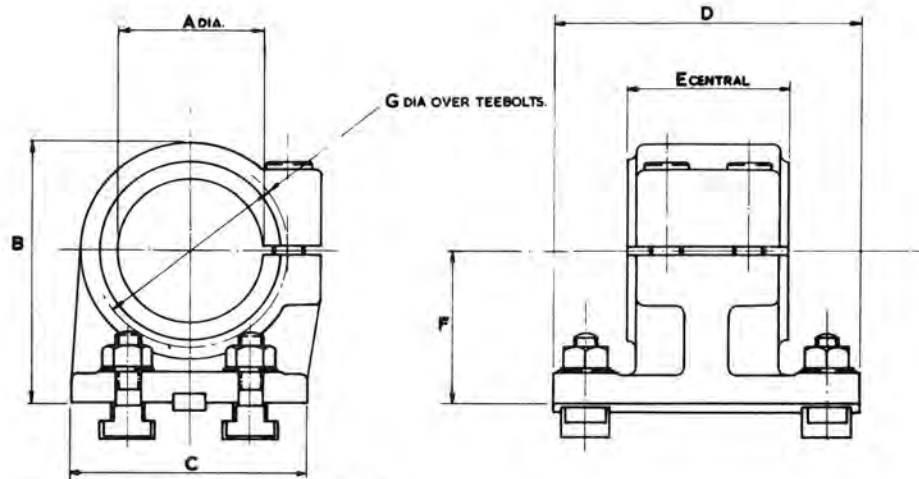
BRACKET TOOLHOLDER

(OVERSIZE TYPE)



Designed to give extra support to shank type tools and toolholders, this holder is used mainly for accommodating shank type roller steadies.

See pages 8, 8A, 8B, 9, and 10 for other types of bracket toolholder.



CENTRE BLOCK AND INDEPENDENT SLIDES
ALL STATIONS

Machine	1 3/8"—5 Bar 5"—5 Chucker		1 3/8", 1 1/2"—6 Bar 5 3/8"—6 Chucker	
	W5—138—46		W5—134—46	
Drg. No.	W5—138—46		W5—134—46	
Dims.	Ins.	mm.	Ins.	mm.
A dia.	2-000	50-80	2-000	50-80
B	3-62	92-0	3-81	97-0
C	3-25	82-5	3-25	82-5
D	5-00	127-0	5-00	127-0
E	3-00	76-0	3-00	76-0
F	2-12	54-0	2-31	58-5
G	2-75	70-0	2-87	73-0

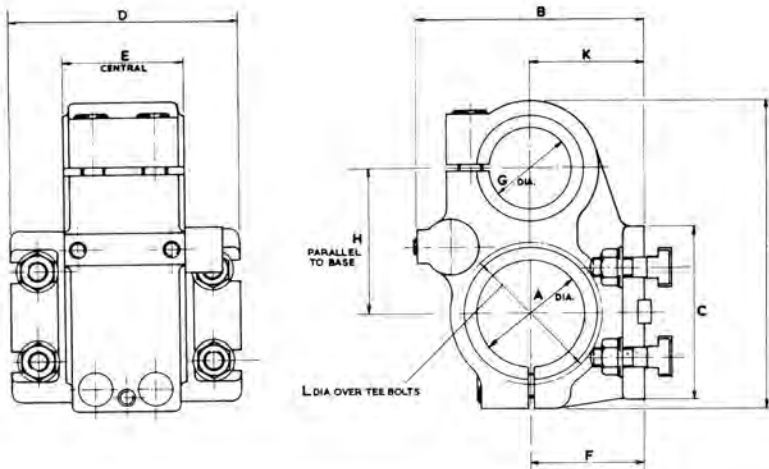
TOOLHOLDER for WICKMAN AUTOMATICS

BORING AND TURNING TOOLHOLDER



Drills, reamers, boring bars and shank type toolholders are accommodated in the main bore of this toolholder. The additional offset bore can be used to accommodate tools for obtaining combined cuts or carrying turning tools on Chucking Automatics.

See pages 8, 8A, 8B, 10 and 11 for other types of bracket toolholder.



Station	Centre Block										Independent Slides			
	5"-5 Chucker		5 $\frac{3}{8}$ "-6 Chucker		6"-5 Chucker		6 $\frac{3}{8}$ "-6 Chucker		7 $\frac{1}{4}$ "-6 Chucker		5 $\frac{3}{8}$ "-6 Chucker		6 $\frac{3}{8}$ "-6 Chucker	
Machine	W5-138-32		W6-138-32.CB		W5-134-32		W6-214-32.CB		W6-258-32		W6-138-32.IS		W6-214-32.IS	
Drg. No.	W5-138-32		W6-138-32.CB		W5-134-32		W6-214-32.CB		W6-258-32		W6-138-32.IS		W6-214-32.IS	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A dia.	2-000	50-80	2-000	50-80	2-000	50-80	2-000	50-80	2-500	63-50	2-000	50-80	2-000	50-80
B	4-25	108-0	5-75	146-0	4-56	116-0	6-87	174-5	6-25	158-0	3-81	97-0	5-37	136-5
C	3-25	82-5	3-25	82-5	3-25	82-5	3-75	95-0	4-00	101-5	3-25	82-5	3-75	95-0
D	4-25	108-0	4-50	114-5	4-25	108-0	5-00	127-0	5-75	146-0	4-50	114-5	5-00	127-0
E	2-25	57-0	2-50	63-5	2-25	57-0	3-00	76-0	3-50	89-0	2-50	63-5	3-00	76-0
F	2-12	54-0	2-31	58-5	2-31	58-5	2-50	63-5	3-00	76-0	2-31	58-5	2-50	63-5
G dia.	1-500	38-10	1-500	38-10	1-500	38-10	1-500	38-10	2-000	50-80	1-500	38-10	1-500	38-10
H	2-75	70-0	3-00	76-00	3-00	76-0	2-21	56-5	2-90	73-5	2-83	72-0	3-26	83-0
J	5-81	147-5	6-00	152-0	6-06	154-0	6-37	162-0	7-75	197-0	5-87	149-0	6-75	171-5
K	2-12	54-0	4-44	112-0	2-31	58-5	5-05	128-0	2-22	56-5	1-31	33-5	3-37	85-5
L	2-75	70-0	2-75	70-0	2-87	73-0	3-00	76-0	3-12	79-5	2-75	70-0	3-00	76-0

DRILL HOLDER

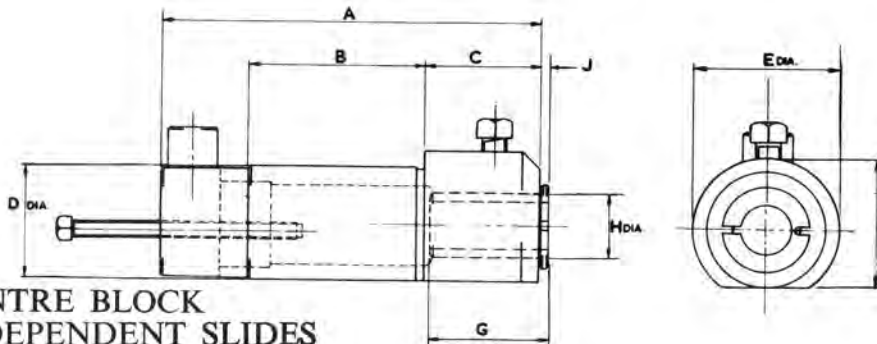
(PARALLEL BORE)



This holder will accommodate drills and straight shank tools either directly or in a bush. Used in conjunction with a bracket toolholder the drill holder carries an adjusting screw for backing up tools against end thrust.

One bush, bored to customer's order or blank, is supplied with each holder.

See pages 14 and 15 for other types of drill holder.



CENTRE BLOCK
AND INDEPENDENT SLIDES
ALL STATIONS

Machine	1" — 6 Bar		1 3/8" — 5 Bar 5" — 5 Chucker		1 3/4" — 8 Bar		2 3/8", 3 1/4" — 6 Bar		3 1/2", 4 1/8" — 4 Bar		
			1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker		2 1/4" — 6 Bar 6 3/8" — 6 Chucker		7 1/4" — 6 Chucker		9" — 4 Chucker		
Drg. No.	W6-1-26		W5-134-26		W6-214-26		W6-258-26		W4-350-26		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	4.87	124.0	6.12	155.5	6.50	165.0	8.44	214.5	7.81	198.0	
B	2.62	66.5	3.00	76.0	3.00	76.0	4.25	108.0	4.25	108.0	
C	1.75	44.5	1.50	38.0	1.50	38.0	3.00	76.0	3.00	76.0	
D dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.500	63.50	3.000	76.20	
E dia.	2.25	57.0	2.44	62.0	2.44	62.0	3.00	76.0	3.00	76.0	
F	2.00	51.0	2.37	60.5	2.37	60.5	3.00	76.0	3.00	76.0	
G	1.87	47.5	2.25	57.0	2.25	57.0	2.56	65.0	2.56	65.0	
H dia.	1.00	25.5	1.37	35.0	1.37	35.0	1.62	41.0	1.62	41.0	
J	0.12	3.0	0.12	3.0	0.12	3.0	0.22	5.5	0.22	5.5	
Bush	Max.	—	—	—	—	—	0.50	12.7*	0.50	12.7*	
Bore	Min.	—	—	—	—	—	0.25	6.5*	0.25	6.5*	
Bush	Max.	0.75	19.0	1.12	28.5	1.12	28.5	1.37	35.0	1.37	35.0
Bore	Min.	0.18	4.5	0.18	4.5	0.18	4.5	0.50	12.7	0.50	12.7
Bush	Bored	S.142A		S.135B		S.135B		DS.131		DS.131	
No.	Blank	S.369A		S.368A		S.368A		DS.523		DS.523	

* A bush for small diameter drills to capacity shown can be supplied on request.
Drg. No.: (bored) DS.130A
(blank) DS.523

DRILL HOLDER

(TAPER DRILLS)

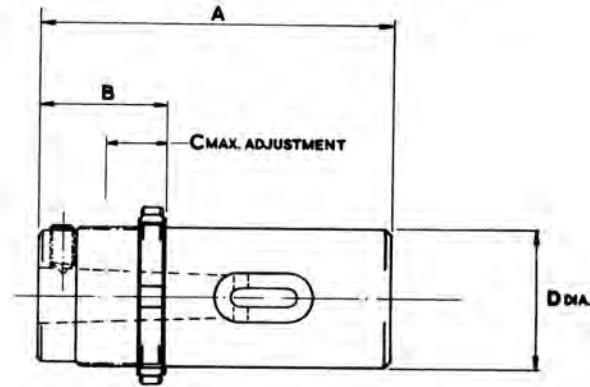
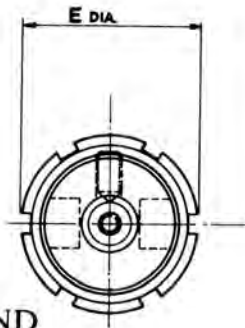


For carrying taper shank drills and cutters, this holder is used mounted in a bracket toolholder. The holder can be supplied with a Morse taper, as listed below.

The locknut, which forms a shoulder, can be adjusted to give a forwards or backwards movement when positioning the holder.

When ordering holders state number of Morse taper required.

See pages 12, and 15 for other types of drill holder.



CENTRE BLOCK AND INDEPENDENT SLIDES

Machine	1" — 6 Bar		1 3/8" — 5 Bar 5" — 5 Chucker		2 3/8", 3 1/4" — 6 Bar 7 1/4" — 6 Chucker		3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker				
			1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker								
			1 3/4", 2 1/4" — 5 Bar 6" — 5 Chucker								
			1 3/4" — 8 Bar								
			2 1/4" — 6 Bar 6 5/8" — 6 Chucker								
Drg. No.	W6—1—27P		W6—138—27		W6—258—27P		W4—350—27				
Dims.	Ins.	mms.	Ins.	mms.	Ins.	mms.	Ins.	mms.			
A	6.00	152.5	6.00	152.5	7.50	190.5	8.00	203.0			
B	3.50	89.0	3.50	89.0	4.00	101.5	4.25	108.0			
C	1.87	47.5	2.50	63.5	2.75	70.0	2.50	63.5			
D dia.	1.750	44.45	2.000	50.80	2.500	63.50	3.000	76.00			
E dia.	2.75	70.0	2.87	73.0	3.50	89.0	4.00	101.5			
Morse Taper Available	1	2	1	2	3	4	1	2	3	4	5

DRILL HOLDER

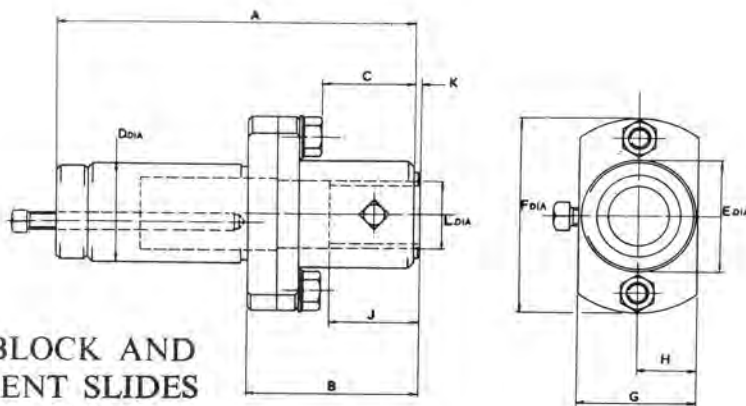
(ADJUSTABLE)



Drills, reamers and other shank type tools can be held either directly or in a bush. Any slight misalignment of the tool can be corrected by adjustment of the front flange of the Toolholder.

One bush, bored to customer's order or blank, is supplied with each holder.

See pages 12, and 14 for other types of drill holder.



CENTRE BLOCK AND INDEPENDENT SLIDES ALL STATIONS

Machine	1" — 6 Bar		1 3/8" — 5 Bar 5" — 5 Chucker		1 3/4" — 8 Bar		2 3/8", 3 1/4" — 6 Bar		3 1/2", 4 1/2" — 4 Bar		
	1" — 6 Bar		1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker		2 1/4" — 6 Bar		7 1/4" — 6 Chucker		9" — 4 Chucker		
Drg. No.	W6—1—30		W5—134—30		W6—214—30		W6—258—30B		W4—350—30		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	6.62	168.5	7.62	193.5	8.12	206.5	8.78	223.0	8.78	223.0	
B	2.56	65.0	3.25	82.5	3.25	82.5	3.40	86.5	3.40	86.5	
C	1.44	36.5	1.75	44.5	1.75	44.5	1.37	35.0	1.37	35.0	
D dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.500	63.50	3.000	76.20	
E dia.	1.75	44.5	2.18	55.5	2.18	55.5	3.00	76.0	3.00	76.0	
F dia.	3.50	89.0	3.94	100.0	3.94	100.0	5.37	136.5	5.37	136.5	
G	1.75	44.5	2.31	58.5	2.31	58.5	2.78	73.0	2.78	73.0	
H	0.87	22.0	1.16	29.5	1.16	29.5	1.28	32.5	1.28	32.5	
J	1.87	47.5	2.25	57.0	2.25	57.0	2.56	65.0	2.56	65.0	
K	0.12	3.0	0.12	3.0	0.12	3.0	0.22	5.5	0.22	5.5	
L dia.	1.000	25.40	1.375	34.93	1.375	34.93	1.625	41.28	1.625	41.28	
Bush	Max.	0.75	19.0	1.12	28.5	1.12	28.5	1.37	35.0	1.37	35.0
Bore	Min.	0.18	4.5	0.18	4.5	0.18	4.5	0.50	12.7	0.50	12.7
Bush	Bored	S.142A		S.135B		S.135B		DS.131		DS.131	
No.	Blank	S.369A		S.368A		S.368A		DS.523		DS.523	

NOTE: For toolholders Nos. W6—258—30B and W4—350—30 a drill bush DS.130A for drills .25"—.50" dia. can be supplied.

REAMER HOLDER

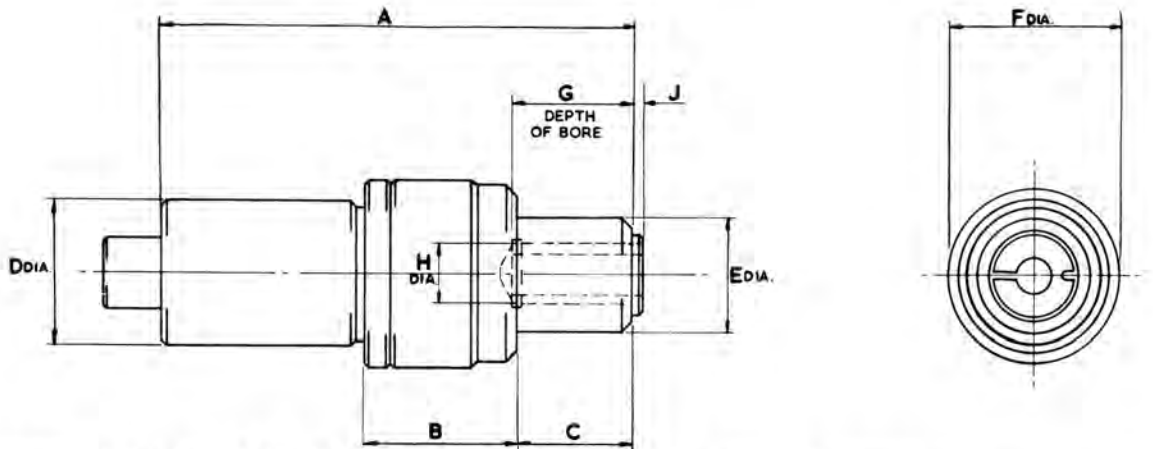
FLOATING TYPE
STANDARD



For use in all end working positions and also with the accelerated reaming attachment. Reamers can be designed to fit directly into the bore of this holder or held in a split bush.

One bush, bored to customer's order or blank, is supplied with each holder.

See page 17 for Lightweight type.



CENTRE BLOCK AND INDEPENDENT SLIDES ALL STATIONS

Machine	1" — 6 Bar		1 1/8" — 5 Bar 5" — 5 Chucker		1 1/2" — 8 Bar		2 5/8", 3 1/4" — 6 Bar 7 1/4" — 6 Chucker		
			1 3/8", 1 1/4" — 6 Bar 5 3/8" — 6 Chucker		2 1/4" — 6 Bar 6 5/8" — 6 Chucker		3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker Plus Bush DS.300A		
	Drg. No.		W5—134—29		W6—214—29		W6—258—29B		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	5.81	147.5	6.81	173.0	6.81	173.0	8.12	206.0	
B	1.87	47.5	2.06	52.5	2.06	52.5	2.62	66.5	
C	1.44	36.5	1.75	44.5	1.75	44.5	1.50	38.1	
D dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.500	63.50	
E dia.	1.37	35.0	1.75	44.5	1.75	44.5	2.00	51.0	
F dia.	2.25	57.0	2.62	66.5	2.62	66.5	3.50	89.0	
G	1.50	38.1	1.94	49.2	1.94	49.2	1.87	47.6	
H dia.	0.750	19.05	1.000	25.40	1.000	25.40	1.000	25.40	
J	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	
Bush Bore	Max.	0.625	12.70	0.75	19.0	0.75	19.0	0.75	19.0
	Min.	0.18	4.5	0.18	4.5	0.18	4.5	0.18	4.5
Bush Bored	S.1145		S.142A		S.142A		S.142A		
Bush Blank	S.1147		S.369A		S.369A		S.369A		

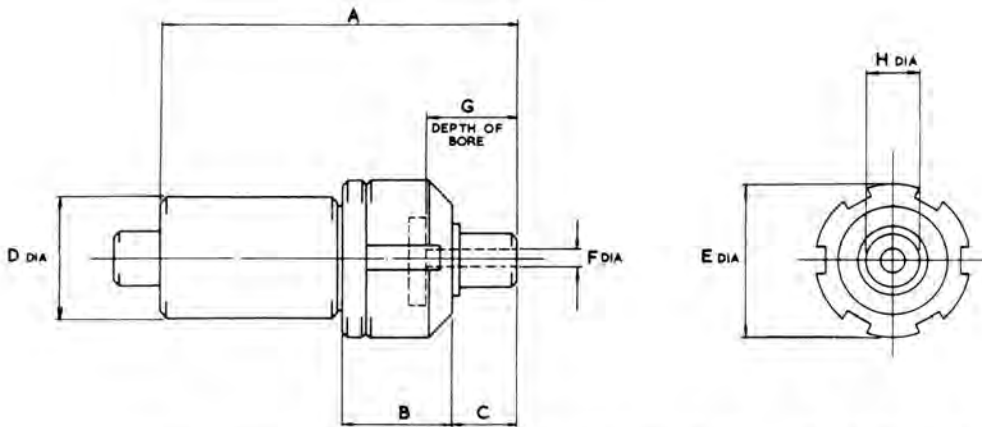
REAMER HOLDER

(FLOATING LIGHTWEIGHT)



Designed for use with small diameter reamers and used where the weight of a large tool would have an adverse effect on the finish of a component. This holder can be used floating, or locked, by adjustment of the threaded collars.

See page 16 for Standard type.



CENTRE BLOCK AND INDEPENDENT SLIDES ALL STATIONS

Machine	1" — 6 Bar		1 3/8" — 5 Bar 5" — 5 Chucker		1 1/4" — 8 Bar	
			1 3/8", 1 1/2" — 6 Bar 5 3/8" — 6 Chucker		2 1/4" — 6 Bar 6 3/8" — 6 Chucker	
Drg. No.	W6-1-51		W5-134-51		W6-214-51	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	5.06	128.5	6.00	152.5	6.00	152.5
B	1.50	38.0	1.50	38.0	1.50	38.0
C	0.94	24.0	0.94	24.0	0.94	24.0
D dia.	1.750	44.45	2.000	50.80	2.000	50.80
E dia.	2.18	55.5	2.18	55.5	2.18	55.5
F dia.	0.312	7.94	0.312	7.94	0.312	7.94
G	1.25	31.5	1.25	31.5	1.25	31.5
H dia.	0.75	19.0	0.75	19.0	0.75	19.0

* Reamer is clamped directly into the toolholder and no bush is supplied.

TAP HOLDER

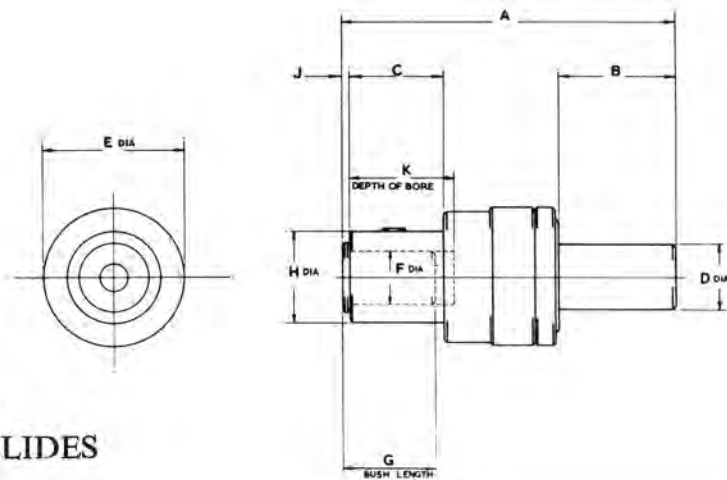
(STANDARD)



Used for adapting and driving taps in conjunction with full screwing attachments. Taps are held in a split bush which can be bored to customer's requirements.

One bush, bored to customer's order or blank, is supplied with each holder.

See page 19 for Lightweight type.



CENTRE BLOCK
AND INDEPENDENT SLIDES
ALL STATIONS

Machine	1 ³ / ₈ "—5 Bar 5"—5 Chucker		1 ¹ / ₂ "—8 Bar		2 ⁵ / ₈ ", 3 ¹ / ₂ "—6 Bar 7 ¹ / ₄ "—6 Chucker		
	1 ³ / ₈ ", 1 ³ / ₄ "—6 Bar 5 ⁵ / ₈ "—6 Chucker		2 ¹ / ₄ "—6 Bar 6 ⁵ / ₈ "—6 Chucker		3 ¹ / ₂ ", 4 ¹ / ₈ "—4 Bar 9"—4 Chucker		
	W5—134—34		W6—214—34		W6—258—34		
Drg. No.	W5—134—34		W6—214—34		W6—258—34		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	6.12	155.5	6.12	155.5	7.75	197.0	
B	2.19	55.5	2.19	55.5	3.38	85.5	
C	1.75	44.5	1.75	44.5	1.87	47.5	
D dia.	1.250	31.75	1.500	38.10	2.125	53.97	
E dia.	2.62	66.5	2.62	66.5	3.50	89.0	
F dia.	1.000	25.40	1.000	25.40	1.000	25.40	
G	1.87	47.5	1.87	47.5	1.87	47.5	
H	1.75	44.5	1.75	44.5	2.00	51.0	
J	0.12	3.0	0.12	3.0	0.12	3.0	
K	1.94	49.0	1.94	49.0	1.87	47.5	
Bush	Max.	0.75	19.0	0.75	19.0	0.75	19.0
Bore	Min.	0.25	6.5	0.25	6.5	0.25	6.5
Bush Bored	S.142A		S.142A		S.142A		
Bush Blank	S.369A		S.369A		S.369A		

TAP HOLDER

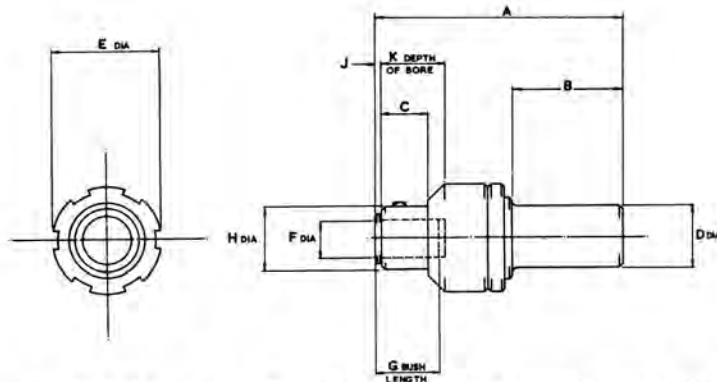
(LIGHTWEIGHT)



Used in conjunction with screwing attachments, this holder can be used floating, or centred and locked in position.

One bush, bored to customer's order or blank, is supplied with each holder.

See page 18 for Standard type.



CENTRE BLOCK AND INDEPENDENT SLIDES ALL STATIONS

Machine	1" — 6 Bar		1 1/8" — 5 Bar* 5" — 5 Chucker		1 1/2" — 8 Bar*	
			1 3/8", 1 3/4" — 6 Bar* 5 3/8" — 6 Chucker		2 1/4" — 6 Bar* 6 3/8" — 6 Chucker	
Drg. No.	W5—78—53		W5—134—53/1		W5—134—53/2	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	5.44	138.1	4.81	122.0	4.81	122.0
B	2.00	50.5	2.25	57.0	2.25	57.0
C	1.50	38.0	0.94	23.5	0.94	23.5
D dia.	1.000	25.40	1.250	31.75	1.500	38.10
E dia.	2.25	57.0	2.18	55.5	2.18	55.5
F dia.	0.750	19.05	0.312	7.94	0.312	7.94
G	1.56	39.5	—	—	—	—
H dia.	1.37	35.0	0.75	19.0	0.75	19.0
J	0.12	3.0	—	—	—	—
K	1.50	38.0	1.25	31.5	1.25	31.5
Bush	Max.	0.50	12.5	—	—	—
	Min.	0.19	4.5	—	—	—
Bush Bored	S.1145		—		—	
Bush Blank	S.1147		—		—	

*On these machines the tap shank fits directly into the holders and no bushes are required.

ROLLER STEADY

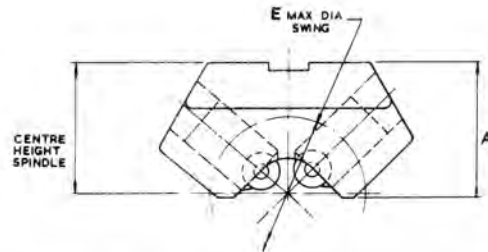
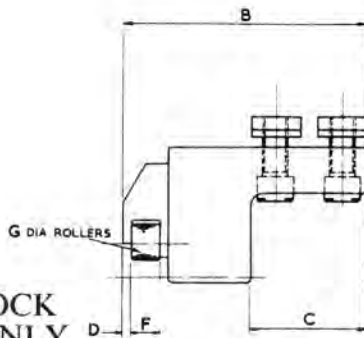
(CENTRE BLOCK MOUNTED)



Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

See pages 22 and 23 for roller steady used in stations 2, 3 and 4.



CENTRE BLOCK
STATION 1 ONLY

Machine	1" — 6 Bar		1 3/8", 1 1/4" — 6 Bar 5 9/8" — 6 Chucker		2 5/8", 3 1/4" — 6 Bar 7 1/4" — 6 Chucker	
	Drg. No. W6-1-23		Drg. No. W6-138-23		Drg. No. W6-258-23	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	2.06	52.5	2.25	57.0	3.44	87.5
B	3.69	93.5	5.37	136.5	5.94	151.0
C	1.75	44.5	2.87	73.0	3.25	82.5
D	0.12	3.0	0.12	3.0	0.25	6.5
E dia.	2.50	63.5	3.25	82.5	2.50	63.5
Large Roller Assembly Details and Capacities (Standard)						
F	0.4375	11.11	0.4375	11.11	0.5977	15.08
G dia.	0.56	14.5	0.87	22.0	1.37	35.0
Capacity	Max.	1.00	25.5	1.50	38.0	54.0
	Min.	0.25	6.5	0.37	9.5	19.0
Roller Assy. Drg. No.	D.43169 2 off		DS.923 2 off		DS.1276 2 off	
Small Roller Assembly Details and Capacities (Optional Extra)						
F	0.3125	7.94	0.4375	11.11	—	—
G dia.	0.44	11.0	0.62	16.0	—	—
Capacity	Max.	0.25	6.5	0.37	9.5	—
	Min.	0.19	5.0	0.25	6.5	—
Roller Assy. Drg. No.	DS.731 2 off		DS.924 2 off		—	

ROLLER STEADY

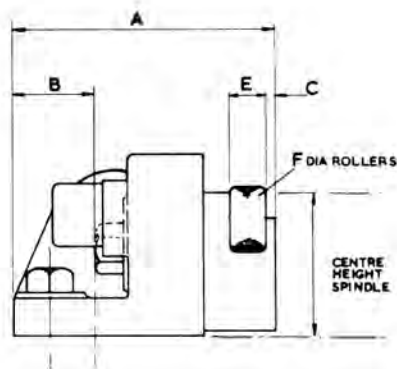
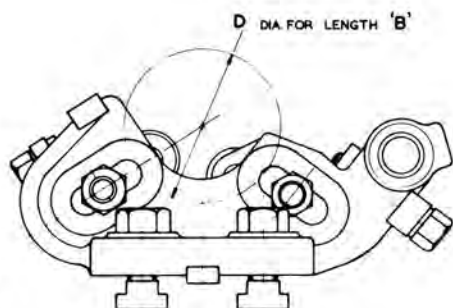
(CENTRE BLOCK MOUNTED)



The roller steady, clamped on the centre block, supports the work while forming, cross drilling or other operations are carried out from the cross slide position.

Large roller assemblies are fitted as standard; small roller assemblies are available as an optional extra.

See pages 22 and 23 for roller steady used in stations 2, 3 and 4.



CENTRE BLOCK
STATION 1 ONLY

Machine	1 $\frac{3}{8}$ "—5 Bar 5"—5 Chucker		1 $\frac{3}{4}$ ", 2 $\frac{1}{4}$ "—5 Bar 6"—5 Chucker		2 $\frac{1}{2}$ "—6 Bar 6 $\frac{5}{8}$ "—6 Chucker		
Drg. No.	W5—138—23		W5—134—23		W6—214—23		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	3.62	92.0	3.75	95.0	4.00	101.5	
B	1.12	28.5	1.00	25.5	—	—	
C	0.12	3.0	0.12	3.0	0.12	3.0	
D dia.	2.37	60.5	2.62	66.5	—	—	
Large Roller Assembly Details and Capacities (Standard)							
E F dia.	0.500 0.87	12.70 22.0	0.500 1.00	12.70 25.5	0.500 1.00	12.70 25.5	
Capacity	Max.	1.37	35.0	1.75	44.5	2.00	50.5
	Min.	0.69	17.5	0.75	19.0	0.75	19.0
Roller Assy. Drg. No.	DS.1277 DS.1279		DS.1274 DS.1275		DS.1274 DS.1275		
Small Roller Assembly Details and Capacities (Optional Extra)							
E F dia.	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	
Capacity	Max.	0.69	17.5	0.75	19.0	0.75	19.0
	Min.	0.28	7.0	0.31	8.0	0.31	8.0
Roller Assy. Drg. No.	DS.1288 DS.1289		DS.1286 DS.1287		DS.1286 DS.1287		

ROLLER STEADY

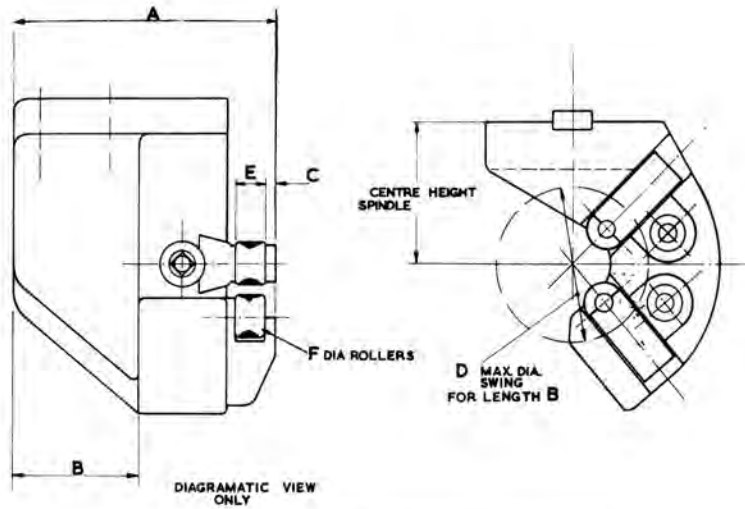
(CENTRE BLOCK MOUNTED)



Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

See pages 20 and 21 for steady used in station 1.



CENTRE BLOCK STATIONS 2 AND 3 ONLY

Machine	1" — 6 Bar		1 3/8", 1 1/2" — 6 Bar 5 3/8" — 6 Chucker		2 5/8", 3 1/2" — 6 Bar 7 1/4" — 6 Chucker	
Drg. No.	W6—1—24		W6—138—24		W6—258—24	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	3.69	93.5	5.25	133.5	5.94	151.0
B	1.75	44.5	2.75	70.0	3.25	82.5
C	0.12	3.0	0.12	3.0	0.12	3.0
D dia.	2.37	60.5	3.00	76.0	3.00	76.0
Large Roller Assembly Details and Capacities (Standard)						
E	0.437	11.11	0.437	11.11	0.594	15.08
F dia.	0.56	14.5	0.87	22.0	1.37	35.0
Capacity	Max.	1.00	25.5	1.50	38.0	54.0
	Min.	0.25	6.5	0.37	9.5	19.0
Roller Assy. Drg. No.	D.43169 2 off		DS.923 2 off		DS.1276 2 off	
Small Roller Assembly Details and Capacities (Optional Extra)						
E	0.312	7.94	0.437	11.11	—	—
F dia.	0.44	11.0	0.62	16.0	—	—
Capacity	Max.	0.25	6.5	0.37	9.5	—
	Min.	0.19	5.0	0.25	6.5	—
Roller Assy. Drg. No.	DS.731 2 off		DS.924 2 off		—	

ROLLER STEADY

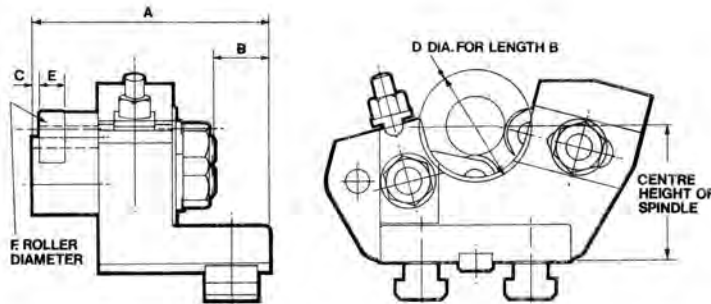
(CENTRE BLOCK MOUNTED)



Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

See pages 20 and 21 for steady used in station 1.



Machine		1''-6 Bar		1 ³ / ₈ '', 1 ³ / ₄ ''-6 Bar 5 ⁵ / ₈ ''-6 Chucker		2 ¹ / ₄ ''-6 Bar 6 ⁵ / ₈ ''-6 Chucker	
Drg. No.	Posn.	W6-1-47/4 W6-1-47/5		W6-138-47		4 W6-214-47/4 5 W6-214-47/5	
Dims.		Ins.	mm.	Ins.	mm.	Ins.	mm.
A		3.68	93.5	4.00	102.0	4.25	108.0
B		1.75	44.5	1.00	25.5	1.25	32.0
C		.12	3.0	.12	3.0	0.12	3.0
D dia.		2.25	57.0	3.37	85.5	3.50	89.0
Large Roller Assembly Details and Capacities (Standard)							
E		.437	11.11	.437	11.11	0.5	12.5
F dia.		.56	14.5	.87	22.2	1.00	25.4
Capacity	Max.	1.00	25.5	1.62	41.5	2.12	54.0
	Min.	.25	6.5	.62	15.5	0.5	12.5
Roller Assy. Drg. No.		D.43169		D.S.1692 D.S.1700		4 DS1813 & 1814 5 DS1829 & 1830	
Small Roller Assembly Details and Capacities (Optional Extra)							
E		.312	7.94	.437	11.11		
F dia.		.43	11.0	.62	16.0		
Capacity	Max.	.25	6.5	.62	16.0		
	Min.	.19	5.0	.25	6.5		
Roller Assy. Drg. No.		D.S.731		D.S.1691 D.S.1701			

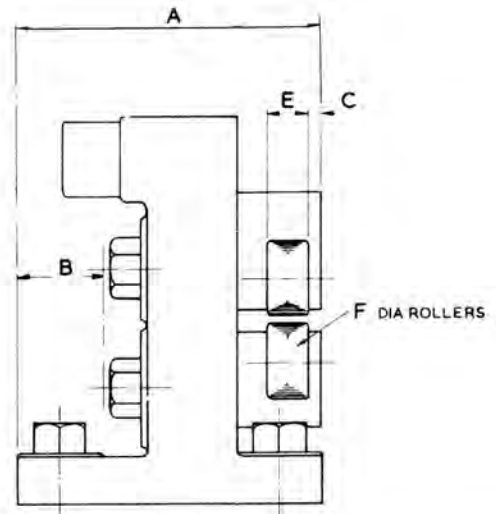
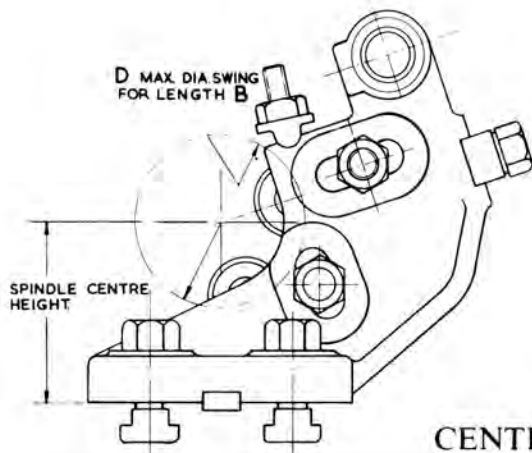
ROLLER STEADY

(CENTRE BLOCK MOUNTED)

The roller steady, clamped on the centre block, supports the work while forming, cross drilling or other operations are carried out from the cross slide position.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

See pages 20 and 21 for steady used in station 1.



CENTRE BLOCK

Machine	1½"–5 Bar 5"–5 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		1½"–8 Bar		2½"–6 Bar 6½"–6 Chucker		
Drg. No.	W5-138-24		W5-134-24		W8-134-24/2		W6-214-24		
Stations	2, 3 & 4		2, 3 & 4		2		2 & 3		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	3.62	92.0	3.75	98.5	5.25	133.5	3.87	98.5	
B	1.06	27.0	1.06	27.0	2.25	57.0	1.00	25.5	
C	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	
D dia.	2.25	57.0	2.63	66.5	3.00	76.0	3.00	76.0	
Large Roller Assembly Details and Capacities (Standard)									
E F dia.	0.500 0.87	12.70 22.0	0.500 1.00	12.70 25.5	0.500 1.00	12.70 25.5	0.500 1.00	12.70 25.5	
Capacity	Max.	1.37	35.0	1.75	44.5	1.75	44.5	2.00	51.0
	Min.	0.69	17.5	0.75	19.0	0.75	19.0	0.75	19.0
Roller Assy. Drg. No.	DS.1256 DS.1257		DS.1260 DS.1261		DS.1260 DS.1261		DS.1260 DS.1261		
Small Roller Assembly Details and Capacities (Optional Extra)									
E F dia.	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	
Capacity	Max.	0.69	17.5	0.75	19.0	0.75	19.0	0.75	19.0
	Min.	0.28	7.0	0.31	8.0	0.31	8.0	0.31	8.0
Roller Assy. Drg. No.	DS.1267 DS.1268		DS.1271 DS.1272		DS.1271 DS.1272		DS.1271 DS.1272		

ROLLER STEADY

(THREE ROLLS)

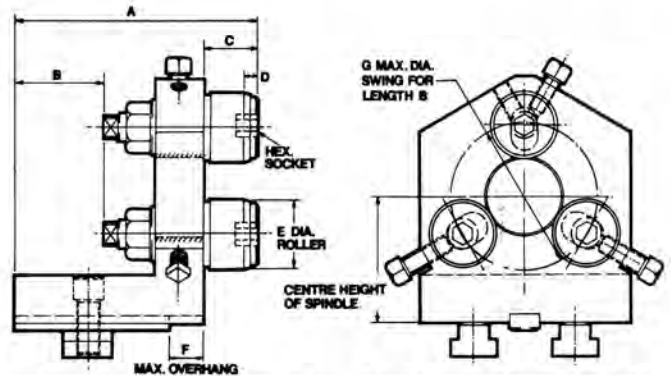


Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming cross drilling, etc.

Large roller assemblies are fitted as standard; small roller assemblies are available as an optional extra.

Capacity of Roller Assembly designated by toolholder No.

CENTRE BLOCK AND
INDEPENDENT SLIDES
ALL STATIONS



MACHINE		CAPACITY	A	B	C	D	E	F	G	roller assy.	base assy.no								
MACHINE		1''-6 Spindle Bar																	
W6-1-88/1	Max.	0.50	12.5	3.87	98.5	1.50	38.0	0.87	22.0	0.25	6.5	0.75	19.0	0.50	12.5	2.19	55.5	DS1804	CS844
	Min.	0.19	5.0																
W6-1-88/2	Max.	0.78	20.0	3.87	98.5	1.50	38.0	0.87	22.0	0.25	6.5	0.75	19.0	0.50	12.5	2.19	55.5	DS1804	CS866
	Min.	0.47	12.0																
W6-1-88/3	Max.	1.00	25.5	3.87	98.5	1.50	38.0	0.87	22.0	0.25	6.5	0.75	19.0	0.50	12.5	2.19	55.5	DS1804	CS867
	Min.	0.69	17.5																
MACHINE		1 3/8'' - 1 1/4''-6 SP. Bar			1 1/4'' - 2 1/4''-5 SP. Bar			5 1/2''-6 Chucker			6''-5 Chucker								
W6-138-88/1	Max.	0.50	12.5	4.37	111.0	2.00	51.0	0.87	22.0	0.25	6.5	0.75	19.0	0.62	16.0	2.75	70.0	DS1804	CS841
	Min.	0.19	5.0																
W6-138-88/2	Max.	0.78	20.0	4.37	111.0	2.00	51.0	0.87	22.0	0.25	6.5	0.75	19.0	0.62	16.0	2.75	70.0	DS1804	CS869
	Min.	0.47	12.0																
W6-138-88/3	Max.	1.00	25.5	4.37	111.0	2.00	51.0	0.87	22.0	0.25	6.5	0.75	19.0	0.62	16.0	2.75	70.0	DS1804	CS870
	Min.	0.75	19.0																
W6-138-88/4	Max.	1.50	38.0	4.50	114.0	1.56	39.5	1.00	25.5	0.25	6.5	1.25	32.0	0.62	16.0	2.75	70.0	DS1808	CS871
	Min.	1.00	25.5																
MACHINE		2 1/4''-6 SP. Bar						6 1/2''-6 SP. Bar											
W6-214-88/1	Max.	0.78	20.0	4.75	120.5	2.37	60.5	0.87	22.0	0.25	6.5	0.75	19.0	1.13	28.5	2.87	73.0	DS1804	CS851
	Min.	0.47	12.0																
W6-214-88/2	Max.	1.06	26.0	4.75	120.5	2.37	60.5	0.87	22.0	0.25	6.5	0.75	19.0	1.13	28.5	2.87	73.0	DS1804	CS876
	Min.	0.75	19.0																
W6-214-88/3	Max.	1.56	39.5	4.87	124.0	2.00	51.0	1.00	25.5	0.25	6.5	1.25	32.0	1.13	28.5	2.87	73.0	DS1808	CS877
	Min.	1.00	25.5																
W6-214-88/4	Max.	2.00	51.0	4.87	124.0	2.00	51.0	1.00	25.5	0.25	6.5	1.25	32.0	1.13	28.5	2.87	73.0	DS1808	CS878
	Min.	1.44	36.5																

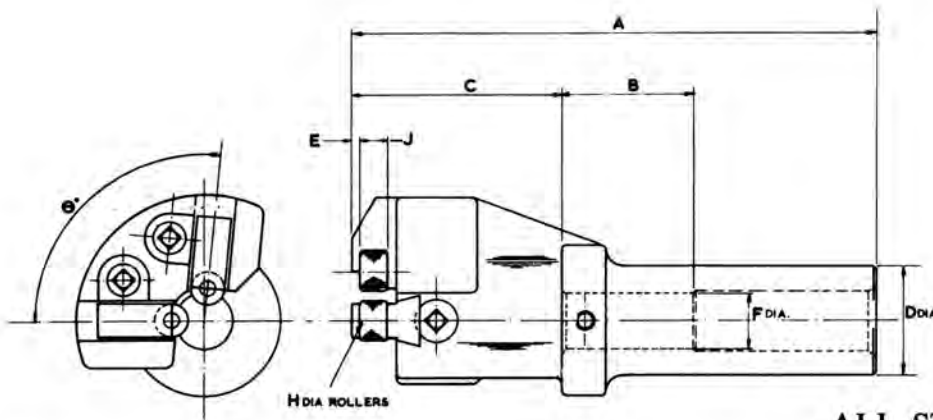
ROLLER STEADY

(SHANK TYPE)



Mounted in a bracket toolholder, the roller steady is used for steadying work when forming, skiving, and long turning on weak or overhanging parts.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.



ALL STATIONS

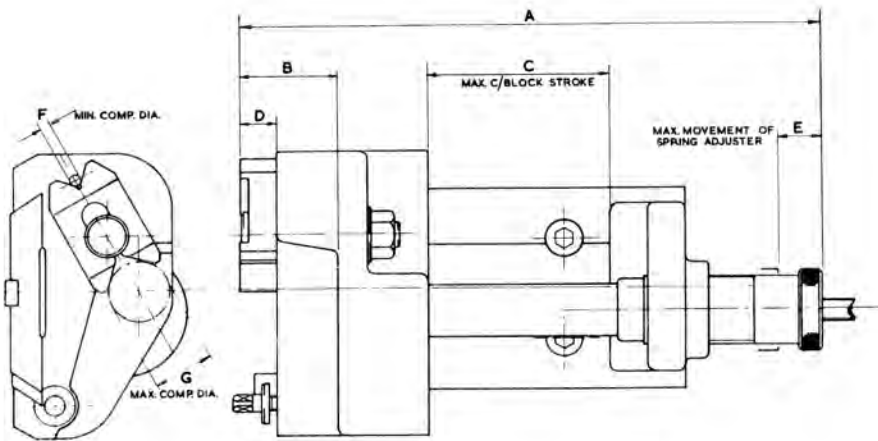
Machine	1"–6 Bar		1½"–5 Bar 5"–5 Chucker		2½"–6 Bar 6½"–6 Chucker		2½", 3½"–6 Bar 7½"–6 Chucker		
	1"–6 Bar		1½"–5 Bar 5"–5 Chucker		2½"–6 Bar 6½"–6 Chucker		2½", 3½"–6 Bar 7½"–6 Chucker		
Drg. No.	W6–1–55		W5–134–55		W6–214–55		W6–258–55		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	8-12	206-0	7-62	193-5	9-25	235-0	9-44	239-5	
B	2-00	50-5	1-25	31-5	2-25	57-0	3-50	89-0	
C	3-25	82-5	2-37	60-5	3-75	95-0	3-44	87-5	
D dia.	1-750	44-45	2-000	50-80	2-000	50-80	2-500	63-50	
E	0-12	3-0	0-12	3-0	0-12	3-0	0-28	7-0	
F dia.	0-875	22-23	1-000	25-40	1-000	25-40	1-500	38-10	
Large Roller Assembly Details and Capacities (Standard)									
H dia.	0-56	14-5	0-56	14-5	0-75	19-0	1-37	35-0	
J	0-437	11-11	0-500	12-70	0-500	12-70	0-594	15-08	
Capacity	Max.	1-00	25-5	0-75	19-0	1-50	38-0	1-75	44-5
	Min.	0-25	6-5	0-18	5-0	0-87	22-0	0-75	19-0
Roller Assy. Drg. No.	D.43169 2 off		DS.1298 2 off		DS.1296 2 off		DS.1255 2 off		
Small Roller Assembly Details and Capacities (Optional Extra)									
H dia.	0-44	11-0	—	—	0-56	14-5	—	—	
J	0-312	7-94	—	—	0-500	12-70	—	—	
Capacity	Max.	0-25	6-5	—	—	0-87	22-0	—	—
	Min.	0-19	5-0	—	—	0-25	6-5	—	—
Roller Assy. Drg. No.	DS.731 2 off		—		DS.1297 2 off		—		

VEE STEADY

(ARRESTED TYPE)



Used for steadying work when all slides have a working feed stroke and a steady is required to remain in a set position. Spring pressure maintains the steady position on vee-ways, while the base returns at the end of each feed stroke. A reversible steady block is supplied to accommodate large or small diameter bar.



CENTRE BLOCK ALL STATIONS

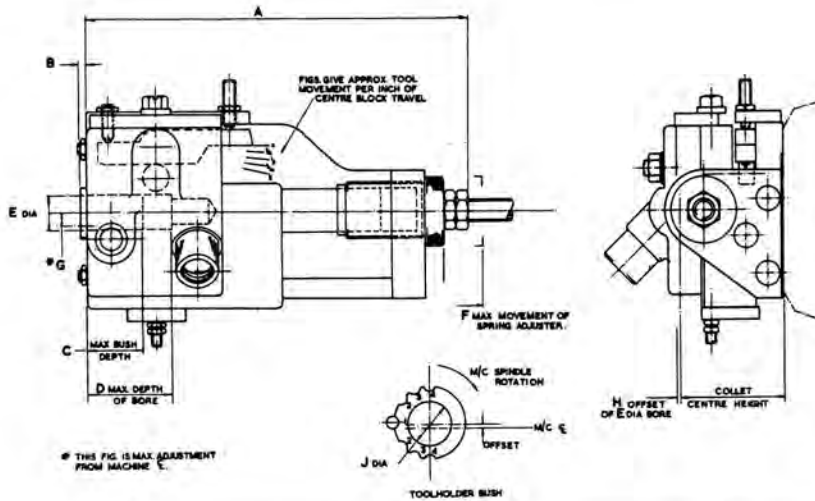
Machine	1" — 6 Bar		1 $\frac{3}{8}$ " — 5 Bar 5" — 5 Chucker		1 $\frac{1}{4}$ ", 2 $\frac{1}{4}$ " — 5 Bar 6" — 5 Chucker	
	Ins.	mm.	Ins.	mm.	Ins.	mm.
Drg. No.	W6—1—56		W5—138—56		W5—134—56	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	8.00	203.0	10.00	254.0	10.00	254.0
B	1.25	31.5	1.62	41.5	1.62	41.5
C	2.12	54.0	3.00	76.0	3.00	76.0
D	0.50	12.5	0.62	16.0	0.62	16.0
E	0.62	16.0	—	—	—	—
F dia.	0.19	5.0	0.19	5.0	0.19	5.0
G dia.	0.75	19.0	1.00	25.5	1.00	25.5

RECESSING SLIDE

(CAM OPERATED)

The recessing slide is operated by a built-in cam arrangement and is self-contained. Recessing cutters are accommodated either directly or in an eccentric bush. Positioning of the bush reduces tool offset in $\frac{1}{32}$ " steps.

See pages 28, 29 and 30 for other types of recessing slide.



Machine	1 $\frac{3}{8}$ "—5 Bar	1 $\frac{3}{8}$ ", 2 $\frac{1}{2}$ "—5 Bar 6"—5 Chucker	1 $\frac{3}{4}$ "—8 Bar
	5"—5 Chucker	1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "—6 Bar* 5 $\frac{5}{8}$ "—6 Chucker*	
Dr. No.	W5—138—28	W5—134—28	W8—134—28
Dims.	Ins.		mm.
A	7.87		200.0
B	0.09		2.5
C	1.62		41.5
D	1.75		44.5
E dia.	0.687		17.46
F	0.62		16.0
G	0.37		9.5
H	0.06		1.5
J	0.500		12.70
Data on Bush Offset and Tool Movement, etc.			
Bush Position	Offset		
1	0.016	0.4	
2	0.03	0.8	
3	0.05	1.2	
4	0.06	1.5	
Without Bush	0.06	1.5	
Max. Tool Movement	0.25	6.5	
Tool Movement/In. C.B. Travel	Variable (0—25")—(0—6.5 mm.)		
Bush Dr. No.	S.771		

* When W5—134—28 is fitted to 1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "—6 Bar and 5 $\frac{5}{8}$ "—6 Chucker Machines, Bung B.8346 has to be fitted to attachment face of main drive housing to operate stop rods.

*Now superseded by W6.214.28/10 & W6.214.28/18.

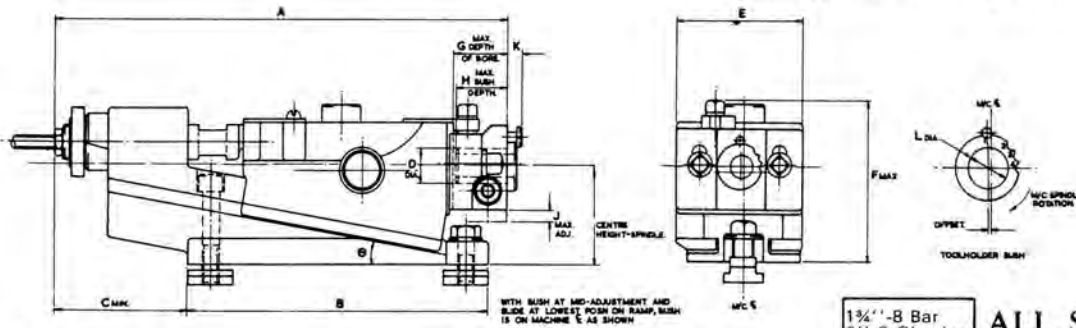
RECESSING SLIDE

(RAMP TYPE)



This holder is used for making recess cuts, boring or facing the base of an internal bore. On commencement of the feed stroke the upper section, carrying the tool, is arrested in the recessing position. The ramp, lower section, continues forward raising the upper section and tool for the recessing cut.

The 10° angle ramp is standard. The 18° angle ramp is an alternative available for the 2¼"-6, 2½", 3¼"-6, and 3½" 4⅛"-4 bar machines and equivalent chuckers, and is used for increased recess cuts, also for obtaining a required depth of recess with a short centre block stroke. See pages 27, 29 and 30 for other types of recessing slide.



1¼"-8 Bar
6"-8 Chucker

ALL STATIONS

0°	Machine	1"-6 Bar		1½", 1¾"-6 Bar 5⅛"-6 Chucker		1½", 1¾"-6 Bar 5⅛"-6 Chucker		2¼"-6 Bar 6⅛"-6 Chucker		2½", 3¼"-6 Bar 7½"-6 Chucker		3½", 4⅛"-4 Bar 9"-4 Chucker			
10° 18°	Dr. No.	W6-1-28		W6-138-28*		W6-138-28N		W6-2-28/10*		W6-214-28/10 W6-214-28/18		W6-258-28/10 W6-258-28/18		W4-350-28/10 W4-350-28/18	
	Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
10° 18°	A	10-00	254-0	11-12	282-5	16-25	413-0	11-94	303-0	16-75	425-0	16-25	413-0	16-50	419-0
10° 18°	B	6-69	170-0	9-62	244-5	9-62	244-5	10-62	270-0	10-62	270-0	14-25	362-0	14-25	362-0
Both 10° & 18°	C D dia. E	2-87 0-750 3-00	73-0 19-05 76-0	1-06 1-000 3-25	27-0 .25-40 82-5	5-75 1-000 3-25	146-0 25-40 82-5	1-06 1-000 3-62	27-0 25-40 92-0	5-75 1-000 3-62	146-0 25-40 92-0	— 1-000 5-69	25-40 144-5	— 1-000 5-69	25-40 144-5
10° 18°	F	3-75	95-0	4-50	114-5	4-50	114-5	4-75	120-5	4-75	120-5	5-50	139-5	5-50	139-5
Both 10° & 18°	G H	1-18 1-12	30-0 28-5	1-37 1-31	35-0 33-5	1-37 1-31	35-0 33-5	1-37 1-31	35-0 33-5	1-37 1-31	35-0 33-5	2-37 —	60-5	2-37 —	60-5
10° 18°	J	0-25	6-5	0-12	3-0	0-12	3-0	0-12	3-0	0-12	3-0	0-12	3-0	0-12	3-0
Both 10° & 18°	K L dia.	0-28 0-500	7-0 12-70	0-31 0-625	8-0 15-87	0-31 0-625	8-0 15-87	0-31 0-750	8-0 15-87	0-31 0-750	8-0 15-87	—	—	—	—

DATA ON BUSH OFFSET AND TOOL MOVEMENT, ETC.

Bush Position		Offset													
1		0-016	0-4	0-05	1-2	0-05	1-2	0-05	1-2	0-05	1-2	—	—	—	—
2		0-03	0-8	0-06	1-5	0-06	1-5	0-06	1-5	0-06	1-5	—	—	—	—
3		0-05	1-2	0-08	2-0	0-08	2-0	0-08	2-0	0-08	2-0	—	—	—	—
4		0-06	1-5	0-09	2-3	0-09	2-3	0-09	2-3	0-09	2-3	—	—	—	—
Without Bush		0-06	1-5	0-09	2-3	0-09	2-3	0-09	2-3	0-09	2-3	0-13	3-3	0-13	3-3
10° 18°	Tool Movement/in. of C.B. Travel	0-176	4-47	0-176	4-47	0-176	4-47	0-176	4-47	0-176	4-47	0-176	4-47	0-176	4-47
										0-325	8-25	0-325	8-25	0-325	8-25
10° 18°	Max. Tool Movement	0-20	5-0	0-26	6-6	0-26	6-6	0-29	7-4	0-29	7-4	0-40	10-0	0-40	10-0
										0-52	13-2	0-62	15-8	0-62	15-8
Bush Drawing No.		DS.676		DS.983		DS.983		DS.893		DS.893		—		—	

28 * As stocks of W6-138-28 and W6-2-28/10 become exhausted they will be replaced by W6-138-28N and W6-214-28/10 respectively.

TOOLHOLDER for WICKMAN AUTOMATICS

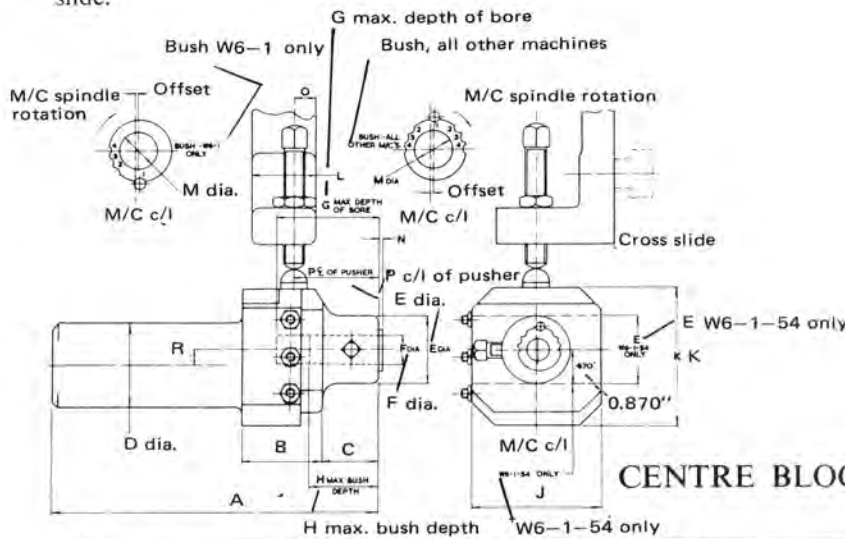
RECESSING SLIDE

(SHANK TYPE)

CROSS SLIDE OPERATED

Mounted in a bracket toolholder and operated from a pusher bracket on an adjoining cross slide, this toolholder is used for recessing, boring or facing the base of an internal bore. Cutters can be accommodated directly or with an eccentric bush which reduces tool offset in $\frac{1}{64}$ " steps.

See pages 27, 28 and 30 for other types of recessing slide.



CENTRE BLOCK AND INDEPENDENT SLIDES ALL STATIONS

Machine	1" - 6 Bar		1 1/4" - 5 Bar 5" - 5 Chucker		2 1/4" - 6 Bar 6 1/2" - 6 Chucker		2 3/4", 3 1/4" - 6 Bar 7 1/4" - 6 Chucker	
	1 3/4", 1 1/2" - 6 Bar 5 1/4" - 6 Chucker		1 3/4", 2 1/4" - 5 Bar 6" - 5 Chucker				3 1/4", 4 1/4" - 4 Bar Plus Bush DS 300A	
Drg. No.	W6-1-54N		W5-134-54N		W6-214-54N		W6-258-54N	
Dims	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	7.12	181.0	9.06	230.0	9.06	230.0	9.62	244.5
B	1.81	46.0	1.87	47.5	1.87	47.5	2.62	66.5
C	0.81	20.5	1.31	33.5	1.31	33.5	1.50	38.0
D dia.	1.750	44-45	2.000	50-80	2.000	50-80	2.500	63.50
E	1.44	36.5	1.62	41.5	1.62	41.5	2.62	66.5
F dia.	0.750	19.05	0.687	17.46	0.687	17.46	1.375	34.92
G	1.75	45.5	2.31	58.5	2.31	58.5	2.00	51.0
H	1.12	28.5	1.62	41.5	1.62	41.5	1.56	40.0
J	3.00	76.0	3.00	76.0	3.00	76.0	4.75	120.5
K	3.25	82.5	3.25	82.5	3.25	82.5	4.00	101.5
L	0.87	22.0	1.50	38.0	1.25	31.5	3.00	76.0
M dia.	0.500	12.70	0.500	12.70	0.500	12.70	—*	—*
N	0.19	5.0	0.09	2.5	0.09	2.5	0.19	5.0
O	0.44	11.0	0.50	12.5	0.62	16.0	2.00	51.0
P	1.37	35.0	2.00	51.0	2.00	51.0	2.62	68.5
R	0.16	4.0	0.37	9.5	0.37	9.5	on E	—
Bush Position	Offset							
1	0.016	0.4	0.016	0.4	0.016	0.4	0.16	0.4
2	0.03	0.8	0.03	0.8	0.03	0.8	0.05	1.2
3	0.05	1.2	0.05	1.2	0.05	1.2	0.08	2.0
4	0.06	1.5	0.06	1.5	0.06	1.5	0.11	2.8
Without Bush	0.06	1.5	0.06	1.5	0.06	1.5	0.11	2.8
Max. Tool Movement	0.37	9.5	0.37	9.5	0.37	9.5	0.75	19.0
Bush No.	DS.676		S.771		S.771		DS.520B	

* This dia. to be called for on layout. Max. dia. 0.87 in (22.0 mm.)

RECESSING SLIDE

(BRACKET TYPE)

This type of recessing slide is mounted on the independent slides and pushed from the cross slides. The 2 $\frac{3}{8}$ "-6 and 2 $\frac{1}{4}$ "-6 machines have an eccentric bush for tool mounting and offset. On the 1 $\frac{3}{8}$ "-6 machine the tool is mounted in a simple block holder.

See pages 27, 28 and 29 for other types of recessing slide.



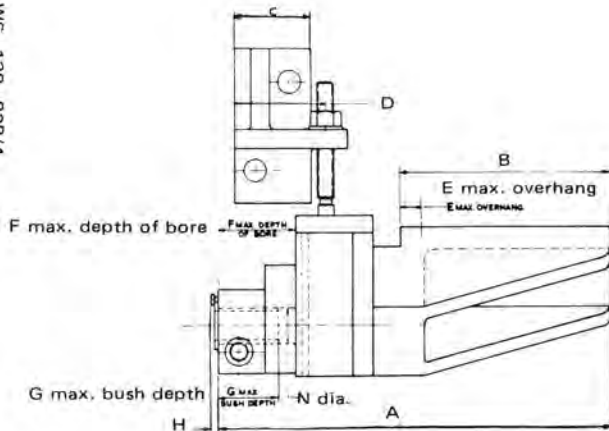
Note: On W6-138-82P/4

W6-138-82P/5

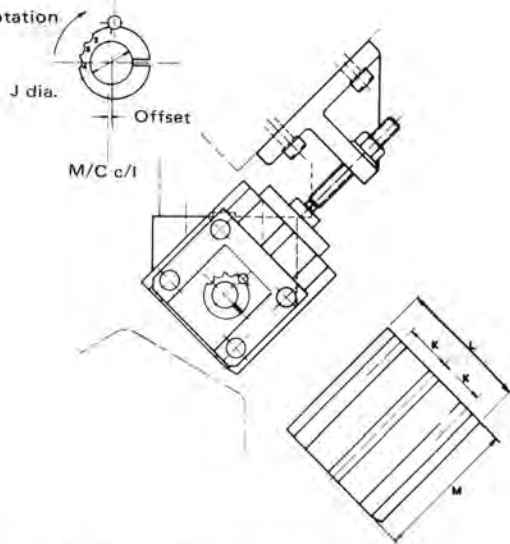
On W6-258-82N/4

W6-258-82N/5

there is one central tee slot only, & no eccentric bush is fitted. nose piece is integral with sliding portion.



M/C spindle rotation



Machine	1 $\frac{1}{2}$ ", 2 $\frac{1}{2}$ "-5 Bar 6"-5 Chucker	1 $\frac{1}{2}$ ", 1 $\frac{1}{2}$ "-6 Bar 5 $\frac{1}{2}$ "-6 Chucker	2 $\frac{1}{2}$ "-6 Bar 6 $\frac{1}{2}$ "-6 Chucker		2 $\frac{1}{2}$ ", 3 $\frac{1}{2}$ "-6 Bar 7 $\frac{1}{2}$ "-6 Chucker		3 $\frac{1}{2}$ ", 4 $\frac{1}{2}$ "-4 Bar 9"-4 Chucker	
	Dr. No.	Dr. No.	Dr. No.		Dr. No.		Dr. No.	
Station	3	4	4		4		3	
Dr. No.	W6-138-82 P/5		W6-214-82 N/5		W6-258-82 N/5			
Station	4	5	5		5			
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	9.87	251.0	13.25	336.5	13.56	344.5	14.62	371.5
B	5.00	127.0	7.00	178.0	7.50	190.5	7.62	193.5
C	2.00	51.0	2.30	58.4	2.00	51.0	2.12	54.0
D	3.81	97.0	3.00	76.0	3.62	92.0	3.62	92.0
E	0.50	12.5	0.75	19.0	0.62	16.0	1.12	28.5
F	1.50	38.0	2.37	60.5	1.87	47.5	2.37	60.5
G	—	—	2.25	57.0	1.75	44.5	2.25	57.0
H	—	—	0.37	9.5	0.25	6.5	0.37	9.5
J	—	—	0.87	22.0	0.87	22.0	0.87	22.0
K	—	—	1.37	35.0	—	—	1.37	35.0
L	4.25	108.0	4.25	108.0	—	—	4.50	114.5
M	4.75	120.5	4.62	117.5	—	—	5.12	130.0
N	1.000	25.40	1.187	30.15	1.375	34.92	1.187	30.15

BUSH DATA AND TOOL MOVEMENT

Bush Posn.	OFF SET							
			D.57890		DS.520B		D.57890	
1	—	—	0.05	1.20	0.11	2.5	0.05	1.2
2	—	—	0.06	1.5	0.08	2.0	0.06	1.5
3	—	—	0.08	2.0	0.05	1.2	0.08	2.0
4	—	—	0.09	2.3	0.016	0.4	0.09	2.3
Without Bush	0.06	1.5	0.09	2.3	0.11	2.5	0.09	2.3
Max. Tool Travel	0.87	22.0	1.00	25.5	0.75	19.0	0.75	19.0
Bush No.	—		D.57890		DS.520B		D.57890	

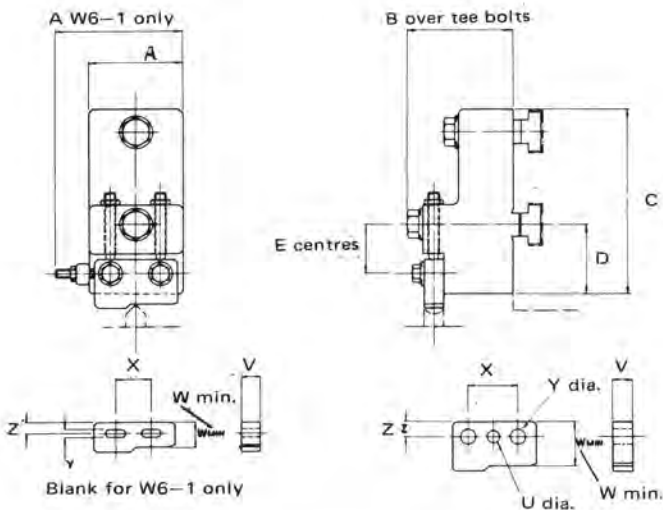
TOOLHOLDER for WICKMAN AUTOMATICS

FORMER BLOCK ASSEMBLY

(FOR USE WITH SHANK TYPE RECESSING SLIDE)



The Former Block can be designed as a master to guide the recessing tool to give a required form.



CROSS SLIDES

Machine	1" — 6 Bar		1 1/8", 1 3/8" — 6 Bar 5 3/8" — 6 Chucker		1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker		1 3/8", 1 3/4" — 6 Bar 5 3/8" — 6 Chucker		2 1/4" — 6 Bar 6 5/8" — 6 Chucker	
	1" — 6 Bar		1 1/8", 1 3/8" — 5 Bar 6" — 5 Chucker		1 3/8", 1 3/4" — 5 Bar 6" — 5 Chucker		1 3/8", 1 3/4" — 5 Bar 6" — 5 Chucker		6 5/8" — 6 Chucker	
Dr. No.	W6-1-83N		W6-138-83N/4*		W6-138-83N/5*		W5-134-83N†		W6-214-83N	
Station	6-Sp.		All		4		5		All	
	5 Sp.		All		3		4		All	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
	A	3.75±	95.0	2.75	70.0	2.75	70.0	3.00	76.0	3.00
B	2.69	68.5	2.44	62.0	2.44	62.0	3.00	76.0	3.37	85.5
C	4.00	101.5	3.75	95.0	3.75	95.0	5.00	127.0	6.00	152.5
D	1.06	27.0	0.50	13.0	0.50	13.0	1.75	44.5	2.25	57.0
E	0.78	20.0	0.94	24.0	0.94	24.0	1.25	31.5	1.62	41.0
Former Block Blank Details										
U	—	—	0.3750	9.53	0.3750	9.53	0.437	11.112	0.4375	11.11
V	0.50	13.0	0.50	13.0	0.50	13.0	0.62	16.0	0.62	16.0
W	0.75	19.0	0.69	17.5	0.69	17.5	1.12	28.5	1.37	35.0
X	1.25	31.5	1.75	44.5	1.75	44.5	1.75	44.5	1.62	41.0
Y	0.28	7.0	0.34	8.5	0.34	8.5	0.44	11.0	0.50	13.0
Z	0.31	13.0	0.31	8.0	0.31	8.0	0.50	13.0	0.50	13.0

* Used with W6-138-82N only.

† Used with W5-134-54N only.

‡ This dimension includes side setting screw.

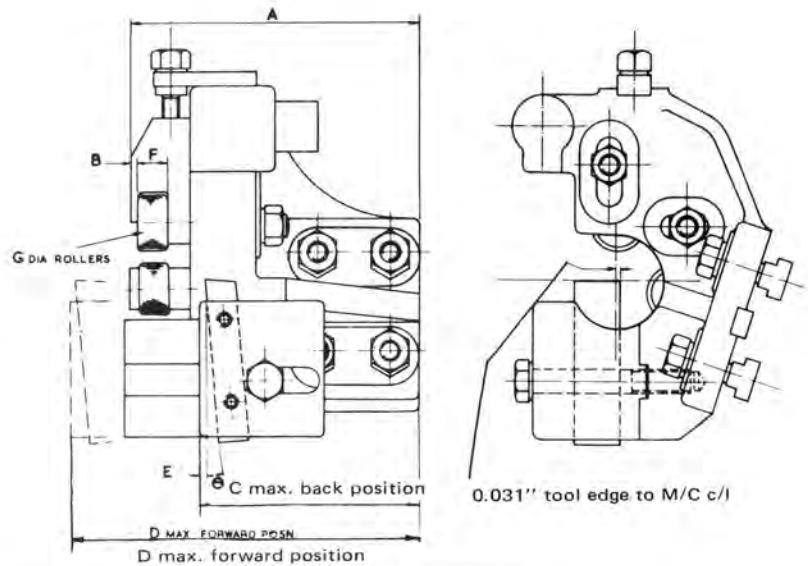
TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER ENDING BOX

(CENTRE BLOCK MOUNTED)



Roller support is given, by the toolholder, while facing to length, chamfering, pointing and similar operations are carried out on shafts and spindles. The design of the ending box and the support given to the bar allow forming operations to be carried out from the adjoining cross slide positions.



CENTRE BLOCK ONLY

Machine	1 1/4" - 5 Bar 5" - 5 Chucker		1 1/2", 2 1/4" - 5 Bar 6" - 5 Chucker		1 1/2" - 8 Bar		
Drg. No.	W5-138-31		W5-134-31		W8-134-31		
Station	2, 3 & 4		2, 3 & 4		5 & 6		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	4.75	120.5	5.00	127.0	5.25	133.5	
B	0.12	3.0	0.12	3.0	0.12	3.0	
C	3.56	90.5	3.81	97.0	4.06	103.0	
D	5.25	133.5	5.65	143.5	5.34	135.5	
E	0.12	3.0	0.19	5.0	0.19	5.0	
θ°	5°		5°		5°		
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)							
F G dia.	0.500 0.87	12.70 22.0	0.500 1.00	12.70 25.5	0.500 1.00	12.70 25.5	
Capacity	Max.	1.37	35.0	1.75	44.5	44.5	
	Min.	0.69	17.5	0.75	19.0	19.0	
Roller Assy. Drg. No.	DS.1256 DS.1257		DS.1260 DS.1261		DS.1260 DS.1261		
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)							
F G dia.	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	0.500 0.56	12.70 14.5	
Capacity	Max.	0.69	17.5	0.75	19.0	19.0	
	Min.	0.28	7.0	0.37	9.5	9.5	
Roller Assy. Drg. No.	DS.1267 DS.1268		DS.1271 DS.1272		DS.1271 DS.1273		
Tool Size	Ins.	.500 x .75 x 2.75		.562 x .75 x 2.75		.562 x .75 x 2.75	
	mm.	12.70 x 19.0 x 70.0		14.29 x 19.0 x 70.0		14.29 x 19.0 x 70.0	

TOOLHOLDER for WICKMAN AUTOMATICS

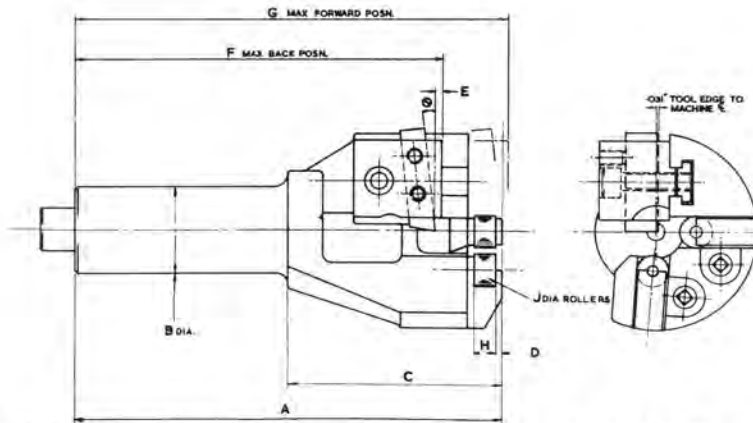
ROLLER ENDING BOX

(SHANK TYPE)



Roller support is given to the bar during ending operations. This holder is used mounted in a bracket toolholder.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.



CENTRE BLOCK AND INDEPENDENT SLIDES

Machine	1"–6 Bar		1"–5 Bar 5"–5 Chucker		1½", 2¼"–5 Bar 6"–5 Chucker		1½", 1½"–6 Bar 5½"–6 Chucker		2½"–6 Bar 6½"–6 Chucker		2½", 3½"–6 Bar 7¼"–6 Chucker	
	W6–1–68		W5–138–68		W5–134–68*		W6–138–68		W6–214–68		W6–258–68	
Station	3, 4 & 5		3 & 4		4 & 5		2, 3, 4 & 5		2, 3, 4 & 5		3, 4 & 5	
Dirns.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	8.44	214.5	10.62	254.0	10.37	263.5	9.62	244.5	9.62	244.5	9.94	252.5
B dia.	1.750	44.45	2.000	50.80	2.000	50.80	2.000	50.80	2.000	50.80	2.500	63.50
C	4.25	108.0	5.75	146.0	6.12	155.5	5.12	130.0	5.12	130.0	5.44	138.0
D	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	0.28	7.0
E	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	0.19	5.0
F	7.25	184.0	8.75	222.0	9.19	233.5	7.75	197.0	7.75	197.0	8.75	222.0
G	8.37	212.7	10.62	270.0	10.50	266.5	9.75	247.5	9.75	247.5	9.50	241.5
(j)	6"		7"		7"		6"		6"		6"	
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)												
H J dia.	0.437 0.56	11.11 14.5	0.500 0.87	12.70 22.0	0.500 1.00	12.70 25.5	0.437 0.87	11.11 22.0	0.500 1.00	12.70 25.5	0.593 1.37	15.08 35.0
Capacity	Max	1.00 25.5	1.37 35.0	1.75 44.5	1.50 38.0	2.00 † 50.5 †	1.75 44.5	0.75 19.0	0.75 19.0	1.75 44.5	0.75 19.0	1.75 44.5
	Min	0.25 6.50	0.50 13.0	0.44 11.0	0.37 9.5	0.75 19.0	0.25 6.50	0.31 8.00	0.31 8.00	0.75 19.0	0.25 6.50	0.25 6.50
Roller Assy. Drg. No.	D.43169 2 off		DS.1258 DS.1259		DS.1306 DS.1307		DS.923 DS.997		DS.1253 DS.1254		DS.1255 2 off	
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)												
H J dia.	0.312 0.44	7.93 11.00	0.500 0.56	12.70 14.50	—	—	0.437 0.62	11.11 16.00	0.500 0.56	12.70 14.50	—	—
Capacity	Max	0.25 6.50	0.62 16.00	—	—	—	0.50 12.50	0.75 19.00	0.75 19.00	—	—	—
	Min	0.19 5.00	0.28 7.00	—	—	—	0.25 6.50	0.31 8.00	0.31 8.00	—	—	—
Roller Assy. Drg. No.	DS.731 2 off		DS.1269 DS.1270		—		DS.924 DS.996		DS.1265 DS.1266		—	
Tool Size	Ins.	0.500 x 0.62 x 2.00	0.500 x 0.75 x 2.62	0.562 x 0.81 x 3.00	0.625 x 0.87 x 2.50	0.625 x 0.87 x 2.50	0.625 x 0.87 x 2.50	1.000 x 1.000 x 3.0	0.625 x 0.87 x 2.50	0.625 x 0.87 x 2.50	1.000 x 1.000 x 3.0	1.000 x 1.000 x 3.0
	mm.	12.70 x 16.0 x 50.8	12.70 x 19.0 x 66.5	14.29 x 20.5 x 76.0	15.87 x 22.0 x 63.5	15.87 x 22.0 x 63.5	15.87 x 22.0 x 63.5	15.87 x 22.0 x 63.5	25.4 x 25.5 x 76.0	15.87 x 22.0 x 63.5	25.4 x 25.5 x 76.0	25.4 x 25.5 x 76.0

* As stocks of these toolholders become exhausted, they will be replaced by W6–138–68.

† Roller Capacity only. Max. ending capacity 1.62" (41.5 mm.)

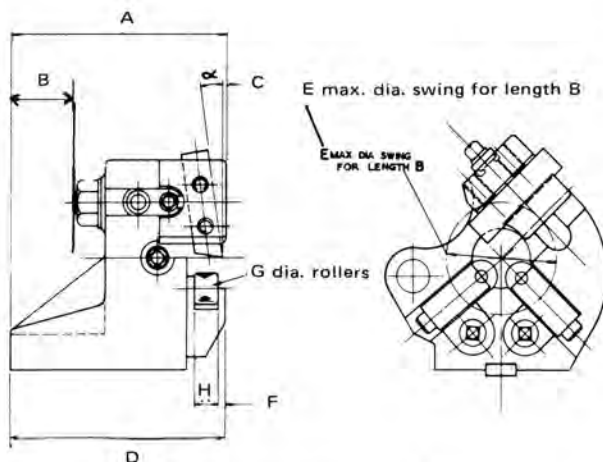
ROLLER TURNER (CENTRE BLOCK MOUNTED)



Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position.

When turning shaft type components the use of advanced rollers is recommended.

The Wimet series ATT tools have been specially developed for this application, and are available for the 1"-6 bar and 1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "-6 bar machines only.



CENTRE BLOCK

Machine	1"-6 Bar		1 $\frac{1}{8}$ ", 1 $\frac{1}{2}$ "-6 Bar 5 $\frac{1}{8}$ "-6 Chucker		2 $\frac{1}{4}$ ", 3 $\frac{1}{2}$ "-6 Bar 7 $\frac{1}{2}$ "-6 Chucker	
Drg. No.	W6-1-21		W6-138-21		W6-258-21	
Station	1 only		1 only		1 only	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	3.90	99.0	5.25	133.5	7.31	186.0
B	1.25	32.0	2.37	60.0	2.00	51.00
C	0.06	1.5	0.12	3.0	0.06	1.5
D	3.87	98.5	5.25	133.5	7.44	189.0
E dia.	1.12	28.5	2.62	66.5	3.00	76.0
F	0.12	3.0	0.12	3.0	0.28	7.0
α	8		5		5	
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)						
G dia.	0.56	14.0	0.87	22.0	1.37	35.0
H	0.437	11.11	0.437	11.11	0.594	15.08
Capacity	Max.	1.00	1.50	38.0	2.12	54.0
	Min.	0.25	6.5	0.37	9.5	0.75
Roller Assy. Drg. No.	D.43169 2 off		D5.923 2 off		D5.1276 2 off	
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)						
G dia.	0.43	11.0	0.62	15.5	—	—
H	0.312	7.94	0.437	11.11	—	—
Capacity	Max.	0.25	6.5	0.37	9.5	—
	Min.	0.19	5.0	0.25	6.5	—
Roller Assy. Drg. No.	D5.731 2 off		D5.924 2 off		—	
Tool	Ins.	0.500 x 0.50 x 1.94		0.562 x 0.562 x 3.0		1.00 x 0.750 x 2.75
Size	mm.	12.70 x 12.5 x 49.0		14.28 x 14.28 x 76.0		25.5 x 19.05 x 70.0
Tool Nos.						
H.S.S.	WSP.436/2		WSP.436/3		WSP.436/5	
Wimet	ATC.5		ATC.8		ATC.10	

TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER TURNER

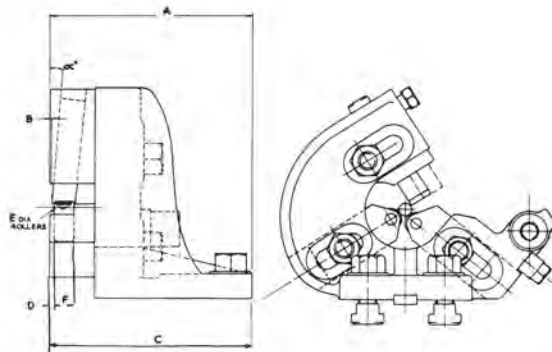
(CENTRE BLOCK MOUNTED)

Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

When turning shaft type components the use of advanced type rollers is recommended.

The Wimet series ATT tools have been specially developed for this application.



CENTRE BLOCK

Machine	1½"–5 Bar 5"–5 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		1½"–8 Bar		2½"–6 Bar 6½"–6 Chucker	
Dr. No.	W5-138-21		W5-134-21		W8-134-21		W6-214-21	
Station	1 only		1 only		1 only		1 only	
Dim's.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	4.78	121.5	5.00	127.0	5.25	133.5	5.25	133.5
B	0.09	2.5	0.09	2.5	0.06	1.5	0.09	2.5
C	4.75	120.5	5.00	127.0	5.25	133.5	5.25	133.5
D	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0
α	5"		5"		5"		5"	
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)								
E dia.	0.87	22.0	1.00	25.5	1.00	25.5	1.00	25.5
F	0.500	12.70	0.500	12.70	0.500	12.70	0.500	12.70
Capacity	Max.	1.37	35.0	1.75	44.5	1.75	44.5	2.00
	Min.	0.69	17.5	0.75	19.0	0.75	19.0	0.75
Roller Assy. Dr. No.	DS.1277 DS.1279		DS.1274 DS.1275		DS.1284 DS.1275		DS.1274 DS.1275	
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)								
E dia.	0.56	14.0	0.56	14.0	0.56	14.0	0.56	14.0
F	0.500	12.70	0.500	12.70	0.500	12.70	0.500	12.70
Capacity	Max.	0.69	17.5	0.75	19.0	0.75	19.0	0.75
	Min.	0.28	7.0	0.31	8.0	0.37	9.5	0.31
Roller Assy. Dr. No.	DS.1288 DS.1289		DS.1286 DS.1287		DS.1286 DS.1287		DS.1286 DS.1287	
Tool Size	Ins.	0.500 x 0.500 x 2.75	0.562 x 0.562 x 3.0		0.562 x 0.562 x 3.0		0.562 x 0.562 x 3.0	
	mm.	12.70 x 12.70 x 70.0	14.29 x 14.29 x 76.0		14.29 x 14.29 x 76.0		14.29 x 14.29 x 76.0	
TOOL Nos.								
H.S.S.	WSP.436/1		WSP.436/3		WSP.436/3		WSP.436/3	
Wimet	ATC.7		ATC.8		ATC.8		ATC.8	



TOOLHOLDER for WICKMAN AUTOMATICS

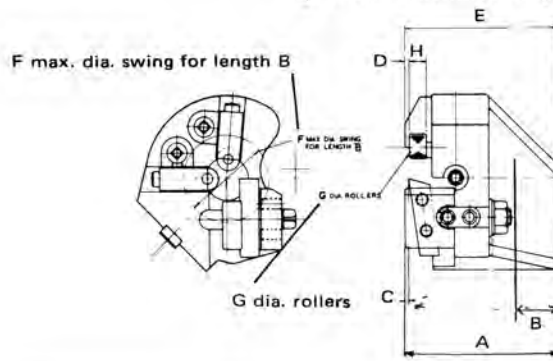
ROLLER TURNER
(CENTRE BLOCK MOUNTED)

Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position.

Large roller assemblies are fitted as standard ; small roller assemblies are available as an optional extra.

When turning shaft type components the use of advanced type rollers is recommended. The Wimet series ATT tools have been specially developed for this application.

These tools are available for 1"-6 bar and 1 3/8", 1 3/4"-6 bar machines only.



CENTRE BLOCK

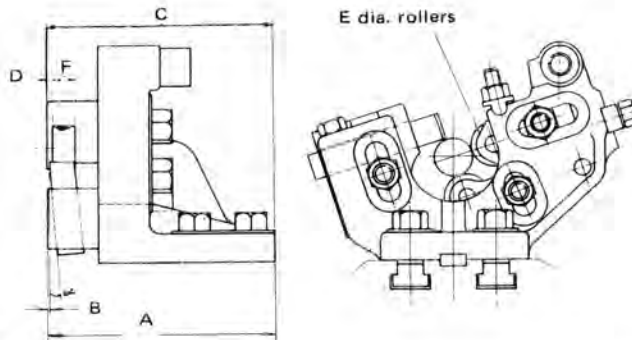
Machine	1"-6 Bar		1 1/4", 1 1/2"-6 Bar 5 1/4"-6 Chucker		2 1/4", 3 1/2"-6 Bar 7 1/2"-6 Chucker		
Drg. No.	W6-1-22		W6-13B-22		W6-25B-22		
Station	2 & 3		2 & 3		2 & 3		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	3.84	97.5	5.50	139.5	7.31	185.5	
B	1.25	32.0	2.37	60.0	2.00	51.0	
C	0.06	1.5	0.06	1.5	0.06	1.5	
D	0.12	3.0	0.12	3.0	0.28	7.0	
E	3.87	98.5	2.62	66.5	3.00	76.0	
F dia.	1.12	28.5	2.75	70.0	3.25	82.5	
α	B		5		5		
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)							
G dia.	0.56	14.0	0.87	22.0	1.37	35.0	
H	0.437	11.11	0.437	11.11	0.593	15.08	
Turning Capacity	Max.	1.00	25.5	1.50	38.0	2.12	54.0
	Min.	0.25	6.5	0.37	9.5	0.75	19.0
Roller Assy. Drg. No.	D.43169 2 off		DS.923 2 off		DS.1276 2 off		
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)							
G dia.	0.43	11.0	0.62	15.5	—	—	
H	0.312	7.94	0.437	11.11	—	—	
Turning Capacity	Max.	0.25	6.5	0.37	9.5	—	
	Min.	0.19	5.0	0.25	6.5	—	
Roller Assy. Drg. No.	DS.731 2 off		DS.924 2 off		—		
Tool Size	Ins.	0.500 x 0.50 x 1.94		0.562 x 0.562 x 3.0		0.750 x 1.00 x 2.75	
	mm.	12.70 x 12.5 x 49.0		14.28 x 14.28 x 76.0		19.05 x 25.5 x 70.0	
TOOL Nos.							
H.S.S.	WSP.436/2		WSP.436/3		WSP.436/5		
Wimet	ATC.5		ATC.8		ATC.10		

TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER TURNER (CENTRE BLOCK MOUNTED)

Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position.

When turning shaft type components the use of advanced type rollers is recommended. The Wimet series ATT tools have been specially developed for this application.



CENTRE BLOCK

Machine	1½"–5 Bar 5"–5 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		1½"–8 Bar	1½"–8 Bar	1½"–8 Bar		2½"–6 Bar 6½"–6 Chucker		
Drg. No.	W5–138–22		W5–134–22		W8–134–22/2*	W8–134–22/5*	W8–134–22/3*		W6–214–22		
Station	2 3 & 4		2, 3 & 4		2	5	3		2 & 3		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	4.78	121.5	5.00	127.0	5.25	133.5	5.00	127.0	5.25	133.5	
B	0.06	1.5	0.06	1.5	0.06	1.5	0.06	1.5	0.06	1.5	
C	4.75	120.5	5.00	127.0	5.25	133.5	5.00	127.0	5.25	133.5	
D	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	0.12	3.0	
α	5°		5°		5	5	5		5		
LARGE ROLLER ASSEMBLY DETAILS AND CAPACITIES (STANDARD)											
E dia. F	0.87 0.500	22.0 12.70	1.00 0.500	25.5 12.70	1.00 0.500	25.5 12.70	1.00 0.500	25.5 12.70	1.00 0.500	25.5 12.70	
Turning Capacity	Max. Min.	1.37 0.69	35.0 17.5	1.75 0.75	44.5 19.0	1.75 0.75	44.5 19.0	1.75 0.75	44.5 19.0	2.00 0.75	50.5 19.0
Roller Assy. Drg. No.	DS.1256 DS.1257		DS.1260 DS.1261		DS.1260 DS.1261		DS.1275 DS.1285		DS.1260 DS.1261		DS.1260 DS.1261
SMALL ROLLER ASSEMBLY DETAILS AND CAPACITIES (OPTIONAL EXTRA)											
E dia. F	0.56 0.500	14.0 12.70	0.56 0.500	14.0 12.70	0.56 0.500	14.0 12.70	0.56 0.500	14.0 12.70	0.56 0.500	14.0 12.70	
Turning Capacity	Max. Min.	0.69 0.28	17.5 7.0	0.75 0.31	19.0 8.0	0.75 0.31	19.0 8.0	0.75 0.31	19.0 8.0	0.75 0.31	19.0 8.0
Roller Assy. Drg. No.	DS.1267 DS.1268		DS.1271 DS.1272		DS.1271 DS.1272		DS.1294 DS.1295		DS.1271 DS.1272		DS.1271 DS.1272
Tool Size	Ins. mm.	0.500 x 0.500 x 2.75 12.70 x 12.70 x 70.0		0.562 x 0.562 x 3.00 14.29 x 14.29 x 76.0		0.562 x 0.562 x 3.00 14.29 x 14.29 x 76.0		0.562 x 0.562 x 3.00 14.29 x 14.29 x 76.0		0.562 x 0.562 x 3.00 14.29 x 14.29 x 76.0	
TOOL Nos.											
H.S.S.	WSP.436/1		WSP.436/3		WSP.436/3		WSP.436/3		WSP.436/3		WSP.436/3
Wimet	ATC.7		ATC.B		ATC.8		ATC.B		ATC.8		ATC.8

* These toolholders cannot be used in conjunction in successive stations.

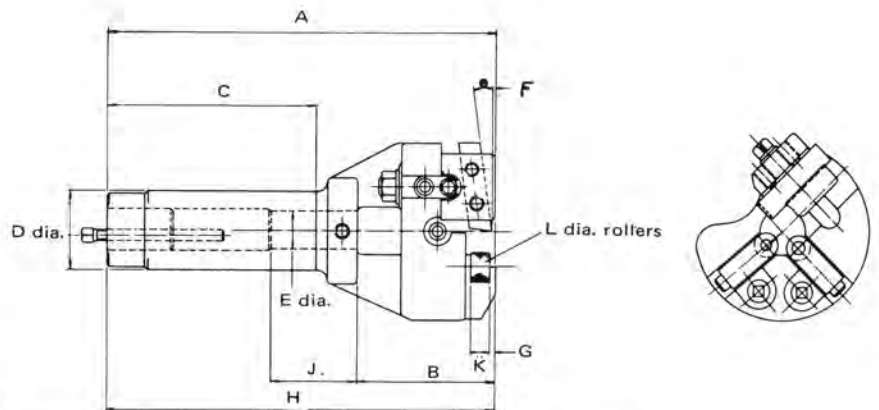
ROLLER TURNER (SHANK TYPE)



This roller turner carries one tool and gives roller support to the work. The turner is usually mounted in a bracket toolholder.

When turning shaft type components the use of advanced rollers is recommended.

The Wimet series ATT tools have been specially developed for this application, and are available for the 1"-6 bar and 1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "-6 bar machines only.



CENTRE BLOCK AND INDEPENDENT SLIDES

Machine	1"-6 Bar		1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "-6 Bar 5 $\frac{1}{8}$ "-6 Chucker		2 $\frac{1}{2}$ ", 3 $\frac{1}{2}$ "-6 Bar 7 $\frac{1}{2}$ "-6 Chucker		3 $\frac{1}{2}$ ", 4 $\frac{1}{2}$ "-4 Bar 9"-4 Chucker		
Drg. No.	W6-4-45		W6-138-45		W6-258-45		W6-258-45 Plus Bush DS.300A		
Station	4 & 5		4 & 5		4 & 5		3 & 4		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	8.97	228.0	9.75	247.5	9.16	233.0	9.16	233.0	
B	3.12	79.5	4.25	108.0	1.75	44.5	1.75	44.5	
C	3.94	100.0	4.37	110.0	3.50	89.0	3.50	89.0	
D dia.	1.750	44.45	2.000	50.80	2.500	63.50	2.500	63.50	
E dia.	0.875	22.22	1.000	25.40	1.812	46.04	1.812	46.04	
F	0.09	2.5	0.12	3.0	0.09	2.5	0.09	2.5	
G	0.12	3.0	0.12	3.0	0.28	7.0	0.28	7.0	
H	8.94	227.0	9.75	247.5	9.31	236.5	9.31	236.5	
J	2.00	51.0	1.56	39.5	3.00	76.0	3.00	76.0	
(I)	8		5		5		5		
K L dia.	0.437 0.56	11.11 14.0	0.437 0.87	11.11 22.0	0.594 1.37	15.08 35.0	0.594 1.37	15.08 35.0	
Turning Capacity	Max. Min.	1.00 0.25	25.5 6.5	1.50 0.37	38.0 9.5	1.75 0.75	44.5 19.0	1.75 0.75	44.5 19.0
Roller Assy. Drg. No.	D.43169 2 off		DS.923 DS.997		DS.1255 2 off		DS.1255 2 off		
K L dia.	0.312 0.44	7.94 11.0	0.437 0.62	11.11 15.5	—	—	—	—	
Turning Capacity	Max. Min.	0.25 0.19	6.5 5.0	0.50 0.25	13.0 6.50	—	—	—	
Roller Assy. Drg. No.	DS.731 2 off		DS.924 DS.996		—		—		
Tool Size	Ins. mm.	0.50 x 0.500 x 1.94 12.5 x 12.70 x 49.0	0.56 x 0.562 x 3.0 14.5 x 14.28 x 76.0	0.75 x 0.625 x 2.75 19.0 x 15.87 x 70.0	0.75 x 0.625 x 2.75 19.0 x 15.87 x 70.0	—	—	—	
Tool No.	H.S.S. Wimet	WSP.436/2 ATC.5	WSP.436/3 ATC.8	WSP.436/4 ATC.9	WSP.436/4 ATC.9	—	—	—	

LARGE ROLLER
ASSEMBLY DETAILS
AND CAPACITIES
(STANDARD)

SMALL ROLLER
ASSEMBLY DETAILS
AND CAPACITIES
(OPTIONAL EXTRA)

TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER TURNER (SHANK TYPE)

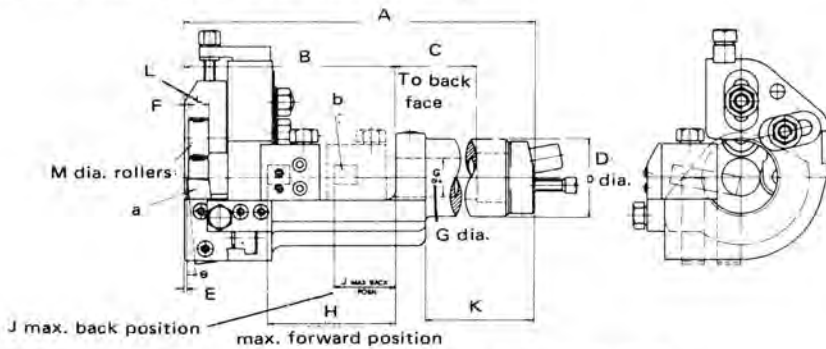
The Roller Turner for the 5 Spindle machines is fitted with two tools. Roller support for the work is given opposite the main tool and a vee steady support can be supplied, to special order, to give support to the work opposite the rear radial tool. The rear tool is used mainly as an ending tool or for taking small reducing cuts.

The roller turner used on the 2½"–6 Automatics has no rear auxiliary tool.

When turning shaft type components the use of advanced type rollers is recommended.

The Wimet series ATT tools have been specially developed for this application.

These tools can be used in the front box only.



CENTRE BLOCK AND INDEPENDENT SLIDES

Machine	1½"–5 Bar 5"–5 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		2½"–6 Bar 6½"–6 Chucker	
	W5-138-45*		W5-134-45*		W6-214-45	
Station	2, 3 & 4		2, 3 & 4		2, 3, 4 & 5	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.
	A	10.62	270.0	11.00	279.5	10.5
B	5.00	127.0	6.00	152.5	3.87	98.5
C	2.87	73.0	2.87	73.0	4.62	117.5
D dia.	2.000	50.80	2.000	50.80	2.000	50.80
E	0.06	1.5	0.06	1.5	0.09	2.5
F	0.12	3.0	0.12	3.0	0.12	3.0
G dia.	1.000	25.40	1.000	25.40	1.000	25.40
H	3.50	90.0	3.75	95.0	—	—
J	1.50	38.0	1.31	33.5	—	—
K	4.25	108.0	4.87	124.0	5.56	141.5
Ø	5		5		6	

* A vee steady for Rear tool "B" can be supplied as an optional extra as follows:

W5-138-45 Vee Steady S.971
W5-134-45 Vee Steady S.970

Machine	1½"–5 Bar 5"–5 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		2½"–6 Bar 6½"–6 Chucker			
	W5-138-45*		W5-134-45*		W6-214-45			
Station	2, 3 & 4		2, 3 & 4		2, 3, 4 & 5			
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.		
	Large Roller Assembly Details and Capacities (Standard)							
Turning	L		0.500	12.70	0.500	12.70	0.500	12.70
	M dia.		0.87	22.0	1.00	25.5	1.00	25.5
Capacity	Max.		1.31	33.5	1.69	43.0	1.94	49.0
	Min.		0.50	12.5	0.56	14.5	0.75	19.0
Roller Assy. Drg. No.	DS.1280 DS.1281		DS.1282 DS.1283		DS.1253 DS.1254			
Small Roller Assembly Details and Capacities (Optional Extra)								
Turning	L		0.500	12.70	0.500	12.70	0.500	12.70
	M dia.		0.56	14.5	0.56	14.5	0.56	14.5
Capacity	Max.		0.50	12.5	0.75	19.0	0.75	19.0
	Min.		0.19	5.0	0.28	7.0	0.31	8.0
Roller Assy. Drg. No.	DS.1290 DS.1291		DS.1292 DS.1293		DS.1265 DS.1266			
TOOL DETAILS—FRONT TOOL "A"								
Tool Size	Ins.	0.50 x 0.500 x 2.75		0.56 x 0.5625 x 3.00		0.56 x 0.5625 x 3.00		
	mm.	12.5 x 12.70 x 70.0		14.5 x 14.29 x 76.0		14.5 x 14.29 x 76.0		
Tool No.	H.S.S.	WSP.436/1		WSP.436/3		WSP.436/3		
	Wimet	ATC.7		ATC.8		ATC.8		
TOOL DETAILS—REAR TOOL "B"								
Tool Size	Ins.	0.50 x 0.500 x 1.75		0.50 x 0.562 x 1.75		—		
	mm.	12.5 x 12.70 x 44.5		12.5 x 14.29 x 44.5		—		

KNEE TURNER

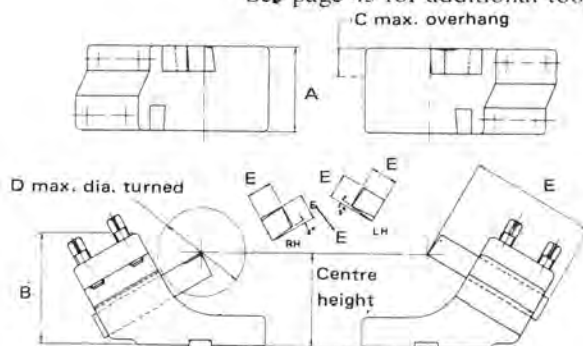


Turning, chamfering and trepanning operations are carried out with this holder. With exception of the 3½", 4½"-4 and 2¼"-5 bar machines, toolholders are reversible to assist tool layout and clearance.

The knee turner is used mainly for rough turning or facing on short work and removing metal and scale before forming cuts. Right- and left-hand turners are available to suit the position of the knee turner on the centre block.

Additional tools are available for this holder. These tools are manufactured with different approach angles and are available in high speed steel or Wimet carbide. When ordering Wimet tools state grade required.

See page 45 for additional tools.



CENTRE BLOCK ALL STATIONS

Machine	1"-6 Bar		1½"-5 Bar 5"-5 Chucker		1¾"-6 Bar 5½"-6 Chucker		1¾"-6 Bar 5½"-6 Chucker		1½"-5 Bar 6"-5 Chucker		2¼"-5 Bar 6"-5 Chucker		
	W6-1-25		W5-138-25		W6-138-25		W6-134-25		W5-134-25		W5-214-25		
Dr. No.													
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
	A	2.12	54.0	1.81	46.0	2.12	54.0	2.12	54.0	2.12	54.0	2.12	54.0
	B	2.62	66.5	2.50	63.5	2.87	73.0	2.75	70.0	2.75	70.0	2.25	57.0
	C	0.19	5.0	0.50	12.5	0.62	16.0	0.62	16.0	0.62	16.0	0.62	16.0
D dia.	0.87	22.0	1.37	35.0	1.37	35.0	2.12	54.0	1.75	44.5	2.25	57.0	
E. Tool Dims.	Ins.	0.50 x 0.50 x 2.00		0.50 x 0.50 x 2.75		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00	
	mm.	12.5 x 12.5 x 50.5		12.5 x 12.5 x 70.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0	
Tool No. 'Wimet'	RH	AK 0		AK 2		AK 4		AK 4		AK 4		AK 4	
	LH	AK 1		AK 3		AK 5		AK 5		AK 5		—	
Tool No. H.S.S.	RH	WSP.425/1		WSP.425/3		WSP.425/5		WSP.425/5		WSP.425/5		WSP.425/5	
	LH	WSP.425/2		WSP.425/4		WSP.425/6		WSP.425/6		WSP.425/6		—	

Machine	1¼"-8 Bar		2¼"-6 Bar 6½"-6 Chucker		2½"-6 Bar 7½"-6 Chucker		3¼"-6 Bar 7½"-6 Chucker		3½"-4 Bar 9"-4 Chucker		4¼"-4 Bar 9"-4 Chucker		
	W8-134-25		W6-214-25		W6-258-25		W6-314-25		W4-350-25		W4-418-25		
Dr. No.													
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
	A	2.12	54.0	2.50	63.5	3.00	76.0	3.00	76.0	3.25	82.5	3.25	82.5
	B	3.00	76.0	2.87	73.0	3.00	76.0	2.75	70.0	3.12	80.0	3.00	76.0
	C	0.62	16.0	—	—	—	—	—	—	—	—	—	—
D dia.	1.62	41.5	2.00	50.5	2.50	63.5	3.00	76.0	2.87	73.0	3.50	90.0	
E. Tool Dims.	Ins.	0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00		0.75 x 0.75 x 3.50		0.75 x 0.75 x 3.50	
	mm.	16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0		19.0 x 19.0 x 89.0		19.0 x 19.0 x 89.0	
Tool No. 'Wimet'	RH	AK 4		AK 4		AK 4		AK 4		—		—	
	LH	AK 5		AK 5		AK 5		AK 5		AK 7		AK 7	
Tool No. H.S.S.	RH	WSP.425/5		WSP.425/5		WSP.425/5		WSP.425/5		—		—	
	LH	WSP.425/6		WSP.425/6		WSP.425/6		WSP.425/6		WSP.425/7		WSP.425/7	

KNEE TURNER

(WIDE TYPE)

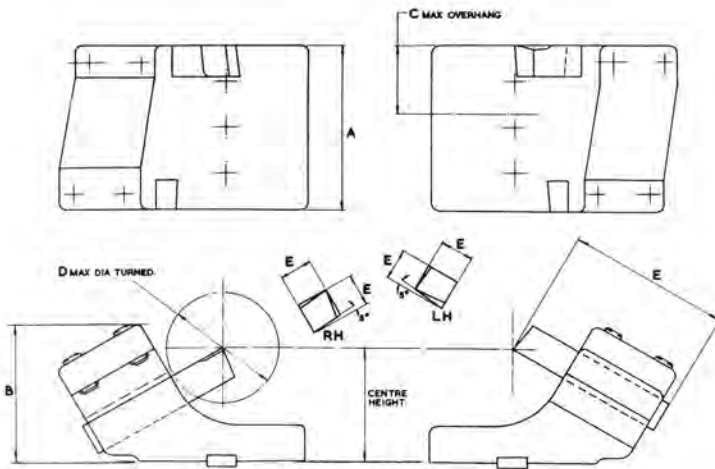


Turning, chamfering and trepanning operations are carried out with this holder. These holders are reversible to assist tool layout and clearances.

The wide type knee turner is designed so that it can overhang the front of the centre-block to enable cuts to be taken close to the collet nose.

Additional tools are available for this holder. These tools have differing approach angles and are manufactured in H.S.S. or Wimet carbide. When ordering Wimet tools state grade required.

See page 45 for additional tools.



CENTRE BLOCK ALL STATIONS

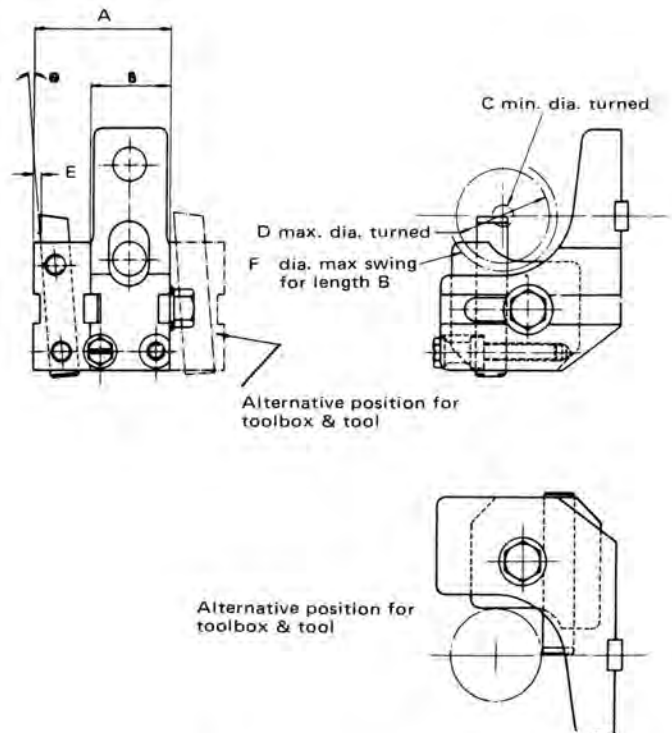
Machine		1" — 6 Bar		1 3/8", 1 3/4" 6 Bar 5/8" — 6 Chucker		2 1/4" 6 Bar 6/8" — 6 Chucker	
Drg. No.		W6—1—80		W6—138—80		W6—214—80	
Dims.		Ins.	mm.	Ins.	mm.	Ins.	mm.
A		3.75	95.0	3.75	95.0	4.00	101.5
B		2.62	66.5	2.87	73.0	3.00	76.0
C		1.37	35.0	1.44	36.5	1.37	35.0
D dia.		1.00	25.5	1.50	38.0	2.00	51.0
E Tool Dims.	Ins.	0.50 x 0.50 x 2.00		0.62 x 0.62 x 3.00		0.62 x 0.62 x 3.00	
	mm.	12.5 x 12.5 x 51.0		16.0 x 16.0 x 76.0		16.0 x 16.0 x 76.0	
Tool No. Wimet	RH	AK 0		AK 4		AK 4	
	LH	AK 1		AK 5		AK 5	
Tool No. H.S.S.	RH	WSP.425/1		WSP.425/5		WSP.425/5	
	LH	WSP.425/2		WSP.425/6		WSP.425/6	



KNEE TURNER

(TANGENTIAL)

Using tangential tools this holder can be used to perform a variety of turning operations such as chamfering, etc.



ALL STATIONS (See below)*

Machine	1"–6 Bar		1½"–5 Bar 5"–5 Chucker		1½", 1½"–6 Bar 5½"–6 Chucker		1½", 2½"–5 Bar 6"–5 Chucker		2½"–6 Bar 6½"–6 Chucker		2½"–6 Bar 7½"–6 Chucker		3½"–6 Bar		
	W6–1–50		W5–138–50		W6–138–50		W5–134–50		W6–214–50		W6–258–50*		W6–325–50*		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	2.87	73.0	2.37	60.5	2.62	66.5	2.59	66.0	3.16	80.0	4.25	108.0	4.25	108.0	
B	1.56	39.5	1.50	38.0	1.50	38.0	1.50	38.0	1.87	47.5	2.75	70.0	2.75	70.0	
C dia.	To Centre	—	To Centre	—	To Centre	—	To Centre	—	To Centre	—	0.50	12.5	1.25	31.5	
D dia.	1.00	25.5	1.37	35.0	1.50	38.0	1.75	44.5	2.00	50.5	2.62	66.5	3.25	82.5	
E	0.19	5.0	0.09	2.5	0.12	3.0	0.12	3.0	0.19	5.0	0.06	1.5	0.06	1.5	
F dia.	1.25	31.5	1.94	49.0	1.94	49.0	2.69	68.5	2.31	58.5	2.62	66.5	3.25	82.5	
θ	8°		5°		5°		5°		5°		8°		8°		
Tool Size	Ins.	0.50x0.500x2.25		0.50x0.500x2.75		0.56x0.562x3.00		0.56x0.562x3.00		0.75x0.625x2.75		0.75x0.625x3.25		0.75x0.625x3.25	
	mm.	12.5x12.70x57.0		12.5x12.70x70.0		14.5x14.28x76.0		14.5x14.28x76.0		19.0x15.88x70.0		19.0x15.88x82.5		19.0x15.88x82.5	
Tool No.	H.S.S.	WSP.436/6		WSP.436/1		WSP.436/3		WSP.436/3		WSP.436/4		WSP.436/7		WSP.436/7	
	Wimet	ATC.6		ATC.7		ATC.8		ATC.8		ATC.9		—		—	

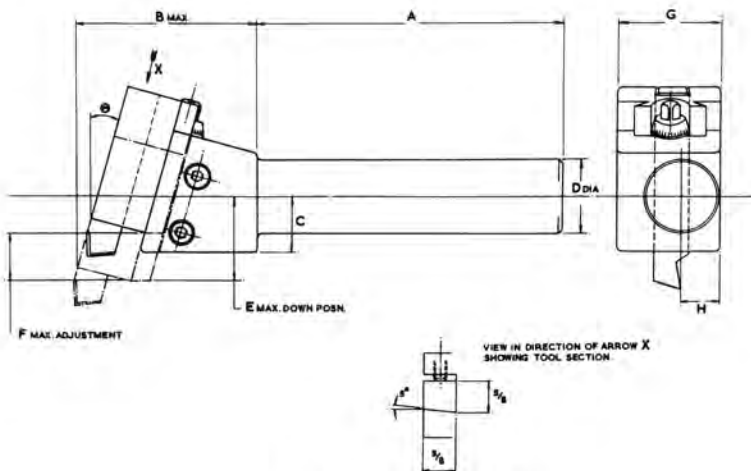
* These toolholders are used in stations 2, 3, 4, 5 and station 1 if the cross slide is clear.

TOOLHOLDER for WICKMAN AUTOMATICS

KNEE TURNER

(MICROMETER ADJUSTMENT)

The shank type knee turner is mounted in a bracket toolholder and used only on Chucking Automatics. Diameters from a maximum of 3½" to a minimum of 2" can be turned.



ALL STATIONS

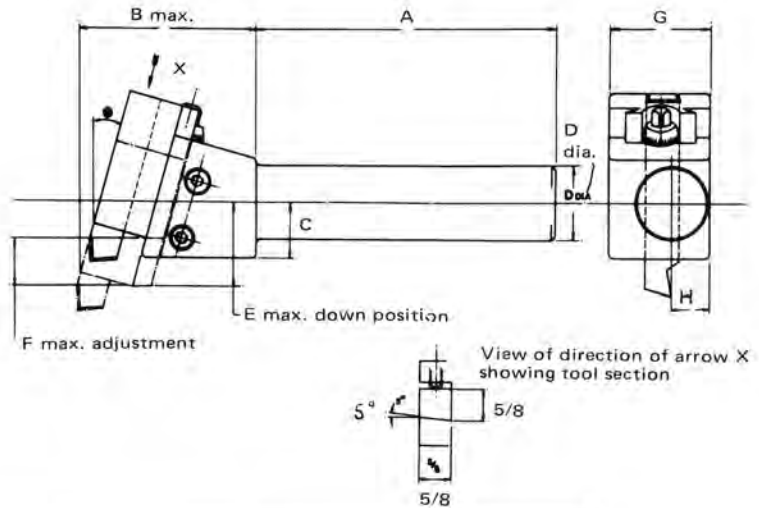
Machine	5" —5 Chucker 5½" —6 Chucker 6" —5 Chucker 6½" —6 Chucker	7¼" —6 Chucker
Drawing No.	W5-134-64	W5-134-64 Plus Bush D.49998
Dims.	Ins.	mm.
A	6.00	152.5
B	3.37	85.5
C	1.12	28.5
D dia.	1.500	38.10
E	1.62	41.5
F	0.75	19.0
G	2.00	50.5
H	0.75	19.0
θ	15°	
AVAILABLE TOOLS		
Approach Angle	H.S.S.	Wimet
15°	WSP.427/1	AK 22
30°	WSP.427/8	AK 24
45°	WSP.428/1	AK 26

KNEE TURNER

(MICROMETER ADJUSTMENT)



Mounted in a bracket holder the shank type knee turner is used on Chucking Automatics only. Diameters turned are from a maximum of 5" on the 6"-5 Chucker, 4½" on the 5½"-6 Chucker and 4" on the 5"-5 Chucker down to a minimum of 3½" on all three machines.



ALL STATIONS

Machine	5" —5 Chucker 5½" —6 Chucker 6" —5 Chucker 6½" —6 Chucker	7¼" —6 Chucker
Drawing No.	W5-134-65	W5-134-65 Plus Bush D.49998
Dims.	Ins.	mm.
A	6.00	152.5
B	3.25	82.5
C	0.75	19.0
D dia.	1.500	38.10
E	0.81	20.5
F	0.75	19.0
G	2.00	50.5
H	0.75	19.0
θ	15°	
AVAILABLE TOOLS		
Approach Angle	H.S.S.	Wimet
15°	WSP.427/1	AK 22
30°	WSP.427/8	AK 24
45°	WSP.428/1	AK 26

ADDITIONAL TOOLS FOR NO. 25 AND 80 KNEETURNER

The tools listed below are for use in knee-turners, described on pages 40 & 41.



Machine	Hand	Tool Nos.—H.S.S.			Tool Nos.—Wimet		
		Approach Angle			Approach Angle		
		15°	30°	45°	15	30	45
1" — 6 Bar	RH	WSP.427/3	WSP.427/10	WSP.428/3	AK 10	AK 12	AK 14
	LH	WSP.429/3	WSP.429/9	WSP.430/3	AK 11	AK 13	AK 15
1 1/8" — 5 Bar 5" — 5 Chucker	RH	WSP.427/2	WSP.427/9	WSP.428/2	AK 16	AK 18	AK 20
	LH	WSP.429/2	WSP.429/8	WSP.430/2	AK 17	AK 19	AK 21
1 1/8", 1 1/2" — 6 Bar 5 1/2" — 6 Chucker	RH	WSP.427/1	WSP.427/8	WSP.428/1	AK 22	AK 24	AK 26
1 1/4", 2 1/4" — 5 Bar 6" — 5 Chucker							
1 1/4" — 8 Bar	LH	WSP.429/1	WSP.429/7	WSP.430/1	AK 23	AK 25	AK 27
2 1/4" — 6 Bar 6 1/2" — 6 Chucker							
2 1/4", 3 1/4" — 6 Bar 7 1/4" — 6 Chucker	RH	—	—	—	—	—	—
3 1/2", 4 1/2" — 4 Bar 9" — 4 Chucker	LH	WSP.429/4	WSP.429/10	WSP.430/4	AK 29	AK 31	AK 33

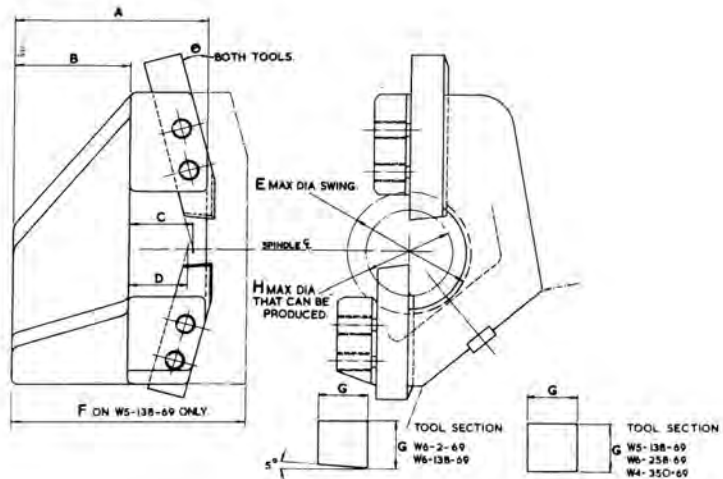
BALANCED TURNER

(CENTRE BLOCK MOUNTED)



Mounted on the centre block, and accommodating two opposed turning tools, the balanced turner is used for heavy turning operations.

High speed steel or Wimet carbide tools are available for this holder, with differing approach angles. When ordering Wimet tools state grade required.



CENTRE BLOCK

Machine	1½" — 5 Bar		1½", 1½" — 6 Bar 1½", 2¼" — 5 Bar		2¼" — 6 Bar		2½", 3½" — 6 Bar		3½", 4½" — 4 Bar		3½", 4½" — 4 Bar	
	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
Dr. No.	W5-138-69		W6-138-69		W6-214-69		W6-258-69		W4-350-69/1		W4-350-69/2	
Station	1 & 2 *		1 & 2 *		1 & 2 *		1 & 2 *		1 *		2 *	
Dim.												
A	3.12	79.5	3.94	100.0	4.25	103.0	5.50	139.5	7.50	190.5	7.50	190.5
B	1.50	38.0	2.37	60.5	3.12	79.5	3.62	92.0	4.37	111.0	4.37	111.0
C	1.44	36.5	1.29	32.5	0.87	22.0	1.69	43.0	2.81	71.5	2.68	68.5
D	1.37	35.0	1.19	30.0	0.78	20.0	1.60	40.5	2.69	68.0	2.59	66.0
E	2.00	51.0	2.31	58.5	2.07	73.0	3.00	76.0	3.50	89.0	3.50	89.0
F	4.19	105.3	—	—	—	—	—	—	—	—	—	—
G	0.50	12.5	0.75	19.0	0.62	16.0	0.62	16.0	1.00	25.5	1.00	25.5
H	1.25	31.0	1.62	41.5	1.87	47.5	1.75	44.5	1.87	47.5	1.50	38.0
(l)	15°		15°		15°		15°		15°		15°	
Tool Dr. No.	DS.627		See Table Below		See Table Below		S.1139		DS.1278		DS.1278	

* Care should be taken to ensure that these toolholders clear toolholders used on adjacent cross slides.

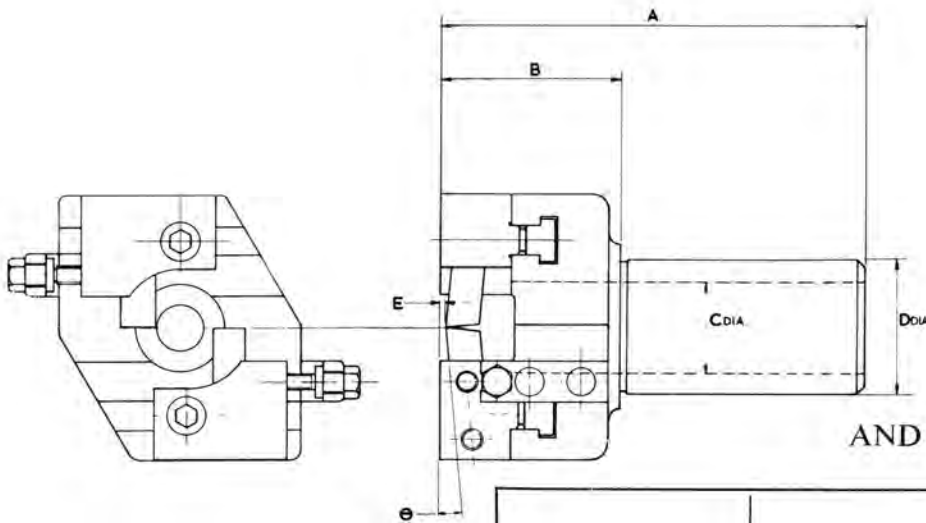
Machine	Hand	Tool No. H.S.S.			Tool No. Wimet		
		Approach Angle			Approach Angle		
		15°	30°	45°	15°	30°	45°
1½", 1½" — 6 Bar	RH	WSP.427/4	WSP.427/11	WSP.428/4	AK.28	AK.30	AK.32
1½", 2¼" — 5 Bar	LH	WSP.429/4	WSP.429/10	WSP.430/4	AK.29	AK.31	AK.33
2¼" — 6 Bar	RH	WSP.427/1	WSP.427/8	WSP.428/1	AK.22	AK.24	AK.26
	LH	WSP.429/1	WSP.429/7	WSP.430/1	AK.23	AK.25	AK.27

TOOLHOLDER for WICKMAN AUTOMATICS

BALANCED TURNER

(SHANK TYPE)

Mounted in a bracket toolholder, the shank type balanced turner accommodates two opposed tangential turning tools.



CENTRE BLOCK
AND INDEPENDENT SLIDES
ALL STATIONS

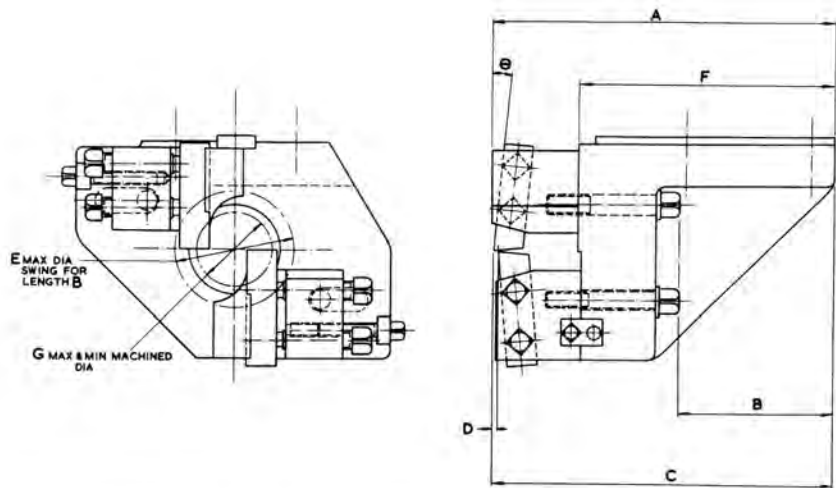
Machine		1"–6 Bar		1 $\frac{3}{8}$ "–5 Bar 5"–5 Chucker 1 $\frac{3}{8}$ " $\frac{3}{4}$ "–6 Bar 5 $\frac{8}{16}$ "–6 Chucker 1 $\frac{3}{4}$ " $\frac{1}{2}$ "–5 Bar 6"–5 Chucker	
		W6–1–58		W5–134–58	
Drg. No.		W6–1–58		W5–134–58	
Dims.		Ins.	mm.	Ins.	mm.
A		6.65	169.0	6.31	160.0
B		2.65	67.5	2.69	68.5
C dia.		0.81	20.5	1.37	35.0
D dia.		1.750	44.45	2.000	50.80
E		0.06	1.5	0.09	2.5
0		8°		5°	
Turning Capacity	Max.	0.75	19.0	1.31	33.5
	Min.	0.25	6.5	0.69	17.5
Tool Size	Ins.	0.50 x 0.500 x 1.94		0.50 x 0.500 x 2.75	
	mm.	12.5 x 12.70 x 49.0		12.5 x 12.70 x 70.0	
Tool Drg. No.	H.S.S.	436/2		436/1	
	Wimet	ATC.5		ATC.7	

BALANCED TURNER

(TANGENTIAL)



Mounted on the centre block and accommodating two opposed tangential turning tools. The balanced turner is used for heavy turning operations, see pages 46 and 47 for other types of balanced turner.



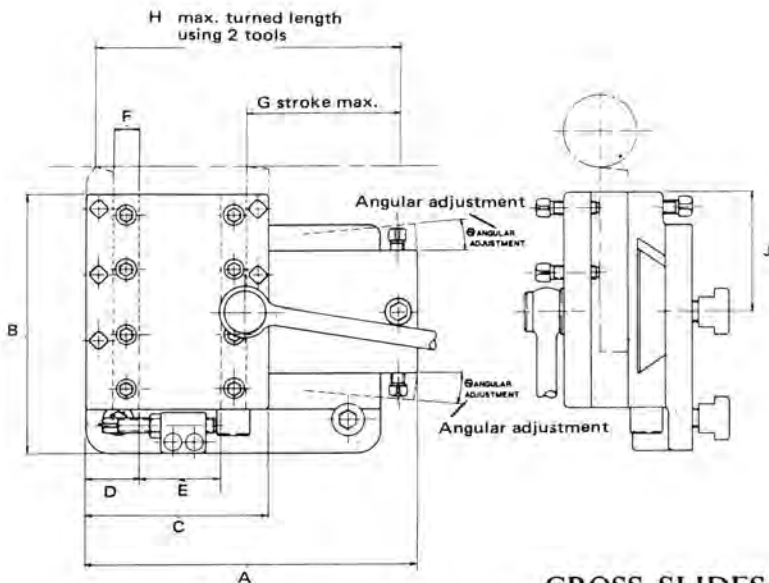
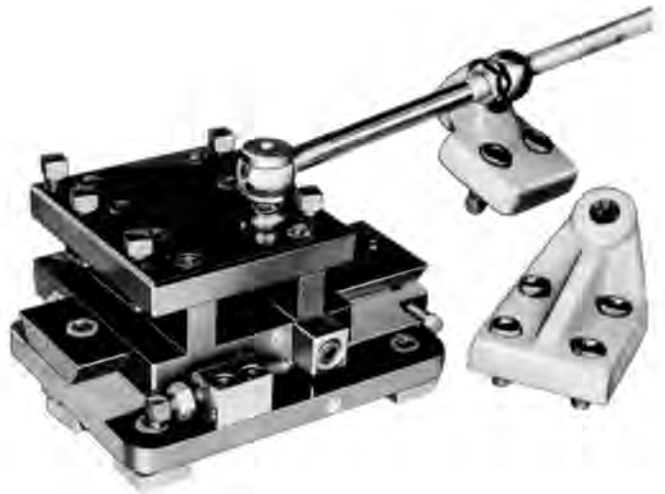
Machine	1 $\frac{3}{8}$ "—5 Bar*		2 $\frac{1}{4}$ "—6 Bar		2 $\frac{5}{8}$ ", 3 $\frac{1}{4}$ "—6 Bar		
	1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "—6 Bar		W6—214—81N		W6—258—81N		
Drg. No.	W6—138—81N		W6—214—81N		W6—258—81N		
Station	1, 2 & 3		1, 2 & 3		1, 2 & 3		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	4.75	120.5	5.12	130.0	7.56	192.0	
B	1.25	31.5	1.50	38.0	3.62	92.0	
C	4.52	115.0	5.00	127.0	7.50	190.0	
D	0.03	0.8	0.03	0.8	0.06	1.5	
E dia.	2.37	60.0	2.87	73.0	3.50	89.0	
F	3.12	79.5	3.50	89.0	5.62	143.0	
G dia.	Max.	1.50	38.0	2.00	51.0	2.12	54.0
	Min.	0.44	11.0	0.62	16.0	0.75	19.0
θ	5°		5°		5°		
Tool Size	Ins.	0.56 x 0.562 x 3.0		0.75 x 0.625 x 2.75		1.00 x 0.750 x 2.75	
	mm.	14.5 x 14.5 x 76.0		19.0 x 15.87 x 70.0		25.5 x 19.05 x 70.0	
Tool Drg. No.	H.S.S.	WSP.436/3		WSP.436/4		WSP.436/5	
	Wimet	ATC.8		ATC.9		ATC.10	

TOOLHOLDER for WICKMAN AUTOMATICS

LONG TURNING SLIDE

This toolholder can be used for operations such as shaft turning, light turning behind a shoulder and taper turning up to a 10° included angle. Mounted on the cross slide, this toolholder can be operated by a pusher rod from either the centre block or independent slide.

See page 51 for additional tools.



CROSS SLIDES

Machine	1" — 6 Bar		1½" — 5 Bar 5" — 5 Chucker		1½", 2½" — 6 Bar 5½" — 6 Chucker		1½", 2½" — 5 Bar 6" — 5 Chucker		2½" — 6 Bar 6½" — 6 Chucker		2½", 3½" — 6 Bar 7½" — 6 Chucker		3½", 4½" — 4 Bar 9" — 4 Chucker	
	W6-1-66		W5-13B-66		W6-13B-66		W5-134-66		W6-214-66		W6-258-65		W6-258-66	
Dr. No.	W6-1-66		W5-13B-66		W6-13B-66		W5-134-66		W6-214-66		W6-258-65		W6-258-66	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	6.81	173.0	6.94	176.0	7.87	210.0	7.62	193.5	8.87	225.5	9.25	235.0	9.25	235.0
B	5.44	138.0	5.19	132.0	6.12	155.5	6.00	152.5	7.75	197.0	6.50	165.0	6.50	165.0
C	3.50	89.0	3.81	97.0	4.87	124.0	4.19	106.5	4.50	114.5	5.87	149.0	5.87	149.0
D	1.00	25.5	1.12	28.5	1.87	47.5	1.12	28.5	1.37	35.0	2.75	70.0	2.75	70.0
E	2.00	51.0	1.56	39.5	2.37	60.5	1.81	46.0	2.50	63.5	1.75	44.5	1.75	44.5
F	0.50	12.5	0.50	12.5	0.62	16.0	0.62	16.0	0.75	19.0	0.62	16.0	0.62	16.0
G	2.50	63.5	3.12	79.5	3.00	76.0	3.50	89.0	3.25	82.5	3.50	89.0	3.50	89.0
H	5.00	127.0	6.25	159.0	6.00	152.0	7.00	178.0	6.50	165.0	7.00	178.0	7.00	178.0
J	2.56	65.0	2.25	57.0	2.75	70.0	2.75	70.0	3.87	98.5	3.00	76.0	3.00	76.0
θ	5°		5°		5°		5°		5°		5°		5°	

PUSHER BLOCK DETAILS														
	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.
Centre Block	1	CS.559	1	CS.633	1	BS.633	1	S.1078A	1	CS.562	1	B.9801	1	B.9800
	4	CS.560			4	BS.634			4	CS.563				
Ind. Slides	4	CS.561	3	CS.634	4	CS.647	3	S.1079	4	CS.616	4	C.16715	3	C.16091
Tool	Ins.	0.50 x 0.50 x 3.50	0.62 x 0.62 x 4.50	0.62 x 0.62 x 5.0	0.62 x 0.62 x 4.50	0.62 x 0.62 x 4.50	0.62 x 0.62 x 4.50	0.75 x 1.00 x 5.00	0.75 x 1.00 x 5.00					
Size	mm.	12.5 x 12.5 x 89.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 127.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 114.0	19.0 x 25.5 x 127.0	19.0 x 25.5 x 127.0					

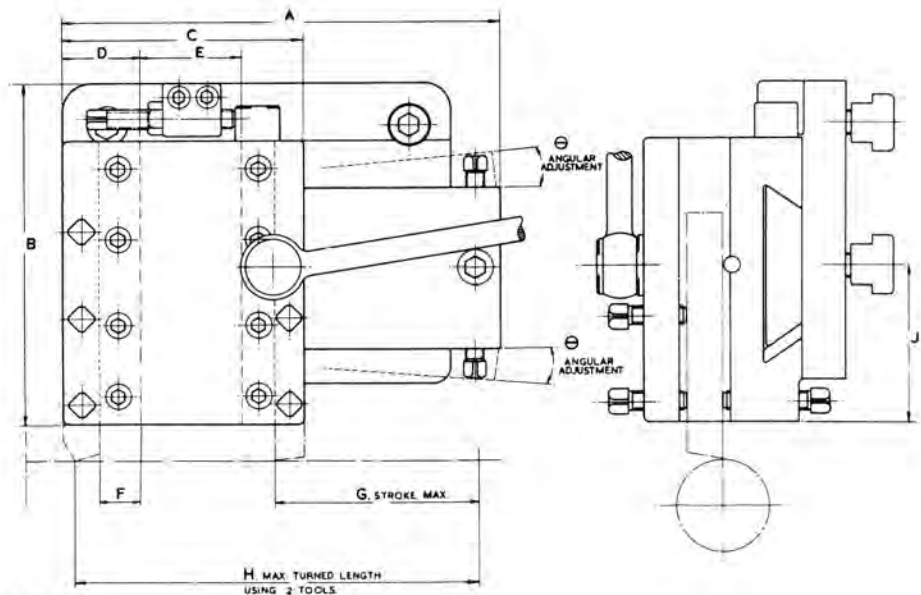
NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4-9-85 will be required.

LONG TURNING SLIDE



This toolholder can be used for operations such as shaft turning, light turning behind a shoulder and taper turning up to a 10° included angle. Mounted on the cross slides, operation of this slide is by pusher rod from the centre block or independent slides.

See page 51 for additional tools.



CROSS SLIDES

Machine	1"—6 Bar		1½"—5 Bar 5"—5 Chuck		1½", 1½"—6 Bar 5½"—6 Chuck		1½", 2½"—5 Bar 6"—5 Chuck		2½"—6 Bar 6½"—6 Chuck		2½", 3½"—6 Bar 7½"—6 Chuck		3½", 4½"—4 Bar 9"—4 Chuck		
	Drg. No.		W6—1—67		W5—138—67		W6—138—67		W5—134—67		W6—214—67		W6—258—67		W6—258—67
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A	6.81	173.0	6.94	176.0	7.87	210.0	7.62	193.5	8.87	225.5	9.25	235.0	9.25	235.0	
B	5.50	139.5	5.19	132.0	5.94	151.0	6.00	152.5	7.75	197.0	7.50	190.5	7.50	190.5	
C	3.50	89.0	3.81	97.0	4.87	124.0	4.19	106.5	4.50	114.5	5.87	149.0	5.87	149.0	
D	1.00	25.5	1.12	28.5	1.87	47.5	1.25	31.5	1.37	35.0	2.75	70.0	2.75	70.0	
E	2.00	51.0	1.56	39.5	2.37	60.5	1.81	46.0	2.50	63.5	1.75	44.5	1.75	44.5	
F	0.50	12.5	0.50	12.5	0.62	16.0	0.62	16.0	0.75	19.0	0.62	16.0	0.62	16.0	
G	2.50	63.5	3.12	79.5	3.00	76.0	3.50	89.0	3.25	82.5	3.50	89.0	3.50	89.0	
H	5.00	127.0	6.25	159.0	6.00	152.0	7.00	178.0	6.50	165.0	7.00	178.0	7.00	178.0	
J	2.62	66.5	2.25	57.0	2.56	65.0	2.75	70.0	3.87	98.5	3.25	82.5	3.25	82.5	
I)	5		5		5		5		5		5		5		
PUSHER BLOCK DETAILS															
	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.	Station	No.	
Centre Block	2	CS.559	2	S.1057	2	CS.633	2	S.1083	2	BS.565	2	BS.590	2	BS.592	
	5	CS.560			5	CS.634			5	BS.564	5	BS.666			
Ind. Slides	5	CS.561	4	S.1040	5	CS.647	4	S.1084	5	CS.617	5	CS.609			
Tool	Ins.	0.50 x 0.50 x 3.50	0.62 x 0.62 x 4.50	0.62 x 0.62 x 5.0	0.62 x 0.62 x 4.50	0.62 x 0.62 x 4.50	0.62 x 0.62 x 4.50	0.62 x 0.62 x 4.50	0.75 x 1.00 x 5.00	0.75 x 1.00 x 5.00					
Size	mm.	12.5 x 12.5 x 89.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 127.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 114.0	16.0 x 16.0 x 114.0	19.0 x 25.5 x 127.0	19.0 x 25.5 x 127.0					

* If long turning is required in 3rd station on all six spindle machines a special cross slide operating mechanism must be fitted and is available on request.
NOTE: When this holder is used on 9" 4-Chucker, Riser Plate W4—9—85 will be required.

TURNING TOOLS for WICKMAN AUTOMATICS

TURNING TOOLS

The tools listed below are for use in the Long Turning Slides described on pages 49 and 50

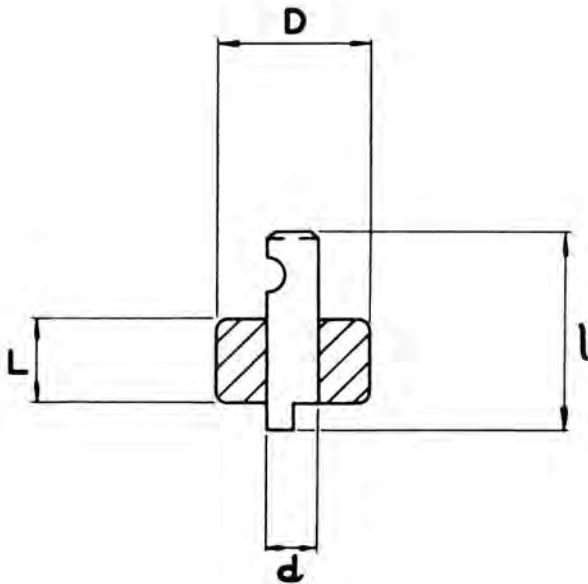
For normal operation of the holders right-hand tools (as illustrated) are used. The left-hand tools listed are used in special applications of the holder.



LONG TURNING SLIDES

Machine	Tool Size	Tool No.	Primary Rake
1" — 6 Bar	Ins. 0.50 x 0.50 x 4.00	H.S.S. Blanks WSP.410/080832	To suit
	mm. 12.5 x 12.5 x 101.5	RH Wimet 102 LH Wimet 103	3° or 8°
1 3/8" — 5 Bar 5" — 5 Chucker	Ins. 0.62 x 0.62 x 5.00	H.S.S. Blanks WSP.410/101040	To suit
1 3/8", 1 1/4" — 6 Bar 5 5/8" — 6 Chucker			
1 3/4", 2 1/4" — 5 Bar 6" — 5 Chucker	mm. 16.0 x 16.0 x 127.0	RH Wimet 106 LH Wimet 107	3° or 8°
1 3/4" — 8 Bar			
2 1/4" — 6 Bar 6 5/8" — 6 Chucker	Ins. 1.00 x 0.75 x 5.5	H.S.S. Blanks WSP.410/161240	To suit
2 5/8" — 6 Bar 7 1/4" — 6 Chucker			
3 1/2" — 4 Bar 9" — 4 Chucker	mm. 25.5 x 19.0 x 140.0	RH Wimet 114 LH Wimet 115	3° or 8°

'WIMET' CARBIDE ROLLERS AND PINS FOR 5-SPINDLE ROLLER BOX TOOLHOLDERS

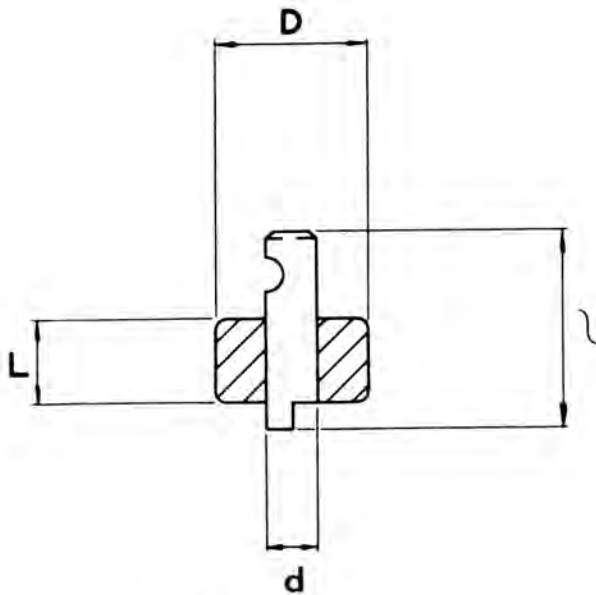


STANDARD ROLLER

Wimet carbide rollers and pins can be used in all Wickman roller turners and roller steadies, when high surface speeds make the use of standard steel rollers and pins unsuitable. The 'Wimet' rollers and pins are completely interchangeable with the equivalent steel rollers and pins.

Machine	Used with Holder No.	Rollers								Pins					
		No. Off	Drg. No.	D dia.		L		d dia.		No. Off	Drg. No.	d dia.			
				Ins.	mm.	Ins.	mm.	Ins.	mm.			Ins.	mm.		
5/8", 1 1/2" — 5 Bar 5" — 5 Chucker	21	2	MSR1L	0.87	22.0	0.500	12.70	0.375	9.52	2	MSP1L	1.09	27.5	0.375	9.52
	23	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	2	MSP1S	1.09	27.5	0.250	6.35
	22	2	MSR1L	0.87	22.0	0.500	12.70	0.375	9.52	1	MSP1L	1.09	27.5	0.375	9.52
	24									1	MSP2L	0.97	24.5		
	31	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP1S	1.09	27.5	0.250	6.35
	45	2	MSR1L	0.87	22.0	0.500	12.70	0.375	9.52	1	MSP1L	1.09	27.5	0.375	9.52
	68									1	MSP3L	0.97	24.5		
	68	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP1S	1.09	27.5	0.250	6.35
68	1									MSP2S	0.97	24.5			
1 1/2", 2 1/2" — 5 Bar 6" — 5 Chucker	21	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	2	MSP4L	1.22	31.0	0.375	9.52
	23	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	2	MSP3S	1.22	31.0	0.250	6.35
	22	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	1	MSP4L	1.22	31.0	0.375	9.52
	24									1	MSP5L	1.09	27.5		
	31	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP3S	1.22	31.0	0.250	6.35
	45	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	1	MSP4L	1.22	31.0	0.375	9.52
	45									1	MSP6L	1.09	27.5		
	45	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP3S	1.22	31.0	0.250	6.35
	45									1	MSP4S	1.09	27.5		
	68	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	1	MSP4L	1.22	31.0	0.375	9.52
68	1									MSP7L	1.09	27.5			
5/8", 1 1/2", 1 3/4", 2 1/4" — 5 Bar	55	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	2	MSP1S	1.09	27.5	0.250	6.35

'WIMET' CARBIDE ROLLERS AND PINS FOR 6-SPINDLE ROLLER BOX TOOLHOLDERS



STANDARD ROLLER

Wimet carbide rollers and pins can be used in all Wickman roller turners and roller steadies, when high surface speeds make the use of standard steel rollers and pins unsuitable. The 'Wimet' rollers and pins are completely interchangeable with the equivalent steel rollers and pins.

* Note:

On 1 1/8" and 1 3/4" Six Bar and 5 3/8" Six Chucking Machines, Holders No's. 45 and 68 cannot be fitted with "large" rollers and pins.

When fitting "small" rollers and pins, use rollers and pins as follows: Rollers MSR2S, 2 off; Pins MSP5S, 1 off, MSP4S, 1off.

Machine	Used with Holder No.	Roller								PIN					
		No. Off	Drg. No.	D dia.		L		d dia.		No. Off	Drg. No.	L		d dia.	
				Ins.	mm.	Ins.	mm.	Ins.	mm.			Ins.	mm.		
1" — 6 Bar	21, 22, 23, 24	2	MSR6L	0.56	14.5	0.437	11.11	0.250	6.35	2	MSP13L	0.94	24.0	0.250	6.35
	45, 55, 68	2	MSR3S	0.44	11.0	0.312	7.94	0.187	4.76	2	MSP7S	0.94	24.0	0.187	4.76
1 1/4", 1 1/2" — 6 Bar 5 3/8" — 6 Chucker	21, 22, 23, 24	2	MSR3L	0.87	22.0	0.437	11.11	0.375	9.52	2	MSP8L	1.44	36.5	0.375	9.52
	31, 45, 68	2	MSR2S	0.62	16.0	0.437	11.11	0.250	6.35	2	MSP5S	1.44	36.5	0.250	6.35
2 1/4" — 6 Bar 6 1/8" — 6 Chucker	55	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	2	MSP1S	1.09	27.5	0.250	6.35
	21	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	2	MSP4L	1.22	31.0	0.375	9.52
	23	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	2	MSP3S	1.22	31.0	0.250	6.35
	22	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	1	MSP4L	1.22	31.0	0.375	9.52
										1	MSP5L	1.09	27.5	0.375	9.52
	24	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP3S	1.22	31.0	0.250	6.35
										1	MSP4S	1.09	27.5	0.250	6.35
	45	2	MSR2L	1.00	25.5	0.500	12.70	0.375	9.52	1	MSP4L	1.22	31.0	0.375	9.52
										1	MSP9L	1.09	27.5	0.375	9.52
	68	2	MSR1S	0.56	14.5	0.500	12.70	0.250	6.35	1	MSP3S	1.22	31.0	0.250	6.35
									1	MSP4S	1.09	27.5	0.250	6.35	
2 1/2", 3" — 6 Bar 7 1/2" — 6 Chucker 3 1/2", 4" — 4 Bar 9" — 4 Chucker	21, 22, 23, 24, 45, 55, 68	2	MSR5L	1.37	35.0	0.562	14.29	0.562	14.29	2	MSP10L	1.72	43.5	0.562	14.29
										1	MSP11L	1.44	36.5	0.562	14.29
	77	2	MSR5L	1.37	35.0	0.562	14.29	0.562	14.29	1	MSP12L	1.31	33.5	0.562	14.29
										1	MSP12L	1.31	33.5	0.562	14.29

When ordering advanced rollers for above holders, prefix standard number with letter 'A', e.g. to order advanced rollers to suit small roller assembly on 1" 6-Sp. No. 21 Roller Box, quote A MSR3S — 2 off. Roller and pins in the MS series are made in two sizes and carry suffixes 'L' (large) and 'S' (small) where applicable. Other sizes can be supplied to order.

TOOLHOLDER ORDERING INSTRUCTIONS

When ordering toolholders state:—

TOOLHOLDER NAME & DRAWING NUMBER

MACHINE SERIAL & INSPECTION NUMBERS

MACHINE SIZE & NUMBER OF SPINDLES

STATION on which holder will be used.



SECTION 2

CROSS SLIDE TOOLHOLDERS

CIRCULAR FORM TOOLHOLDER

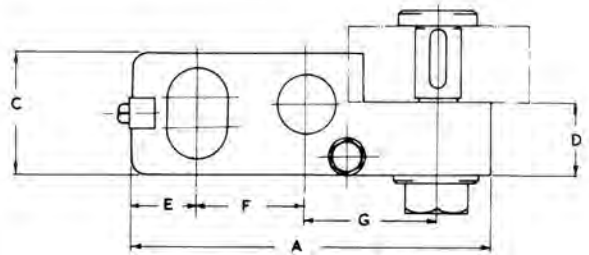
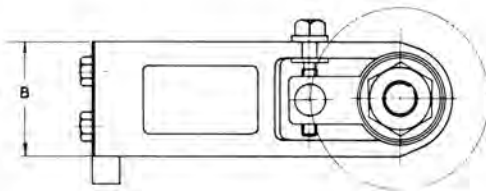


The holder is designed with adjustment for setting the tool on centre and also a secondary adjustment for obtaining maximum tool life. Complete interchangeability of the holder between all cross slides positions is achieved by provision of differing bases.

When ordering holder state width of form tool to enable correct clamping bolt to be supplied.

See pages 59 and 60 for details of interchangeable bases.

See page 61 for tool and clamping bolt details.



ALL STATIONS CROSS SLIDES

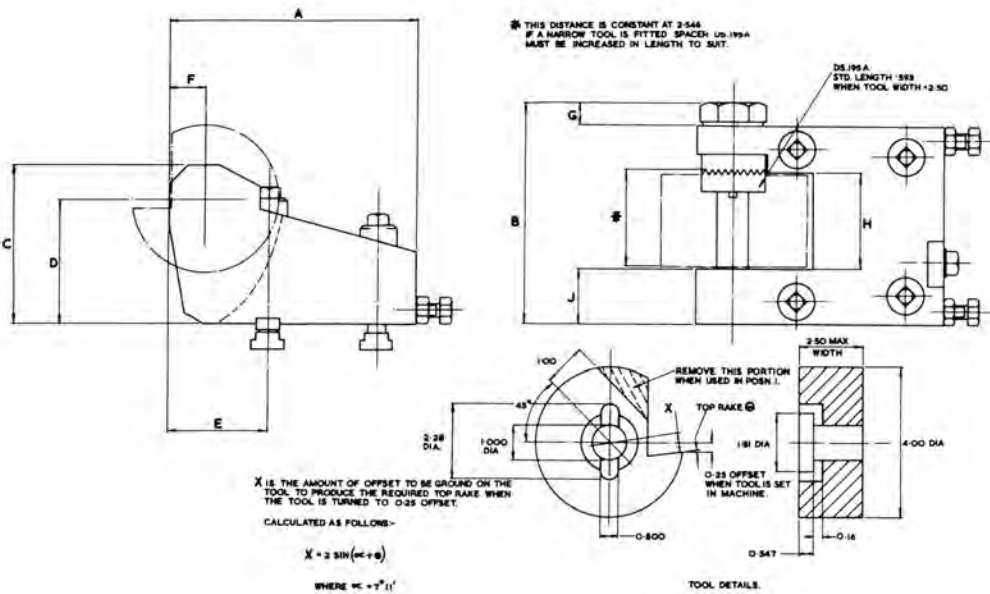
Machine	1" — 6 Bar		1 $\frac{3}{8}$ " — 5 Bar 5" — 5 Chucker		1 $\frac{3}{8}$ ", 2 $\frac{1}{2}$ " — 5 Bar 6" — 5 Chucker 1 $\frac{3}{8}$ ", 1 $\frac{1}{2}$ " — 6 Bar 5 $\frac{3}{8}$ " — 6 Chucker		2 $\frac{1}{2}$ " — 6 Bar 6 $\frac{5}{8}$ " — 6 Chucker 1 $\frac{3}{4}$ " — 8 Bar	
	Drg. No. W6—1—35		W5—138—35		W5—134—35		W6—214—35	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	5.50	139.5	6.00	152.5	6.75	171.5	7.78	172.0
B	1.87	47.5	1.87	47.5	2.25	57.0	2.25	57.0
C	2.12	54.0	2.00	51.0	2.25	57.0	2.37	60.5
D	1.25	32.0	1.19	30.0	1.37	35.0	1.50	38.0
E	1.12	28.5	1.12	28.5	1.12	28.5	1.25	32.0
F	2.25	57.0	1.81	46.0	2.25	57.0	3.00	76.0
G	1.50	38.1	2.19	55.5	2.37	60.5	2.75	70.0

CIRCULAR FORM TOOLHOLDER

(BLOCK TYPE)



This holder is the block type and mounted directly on the cross slide. Adjustment is provided for setting the tool on centre and a secondary adjustment enables maximum tool life to be obtained.



Machine	2 5/8", 3 1/4" — 6 Bar 7 1/4" — 6 Chucker	3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker
Station	1 & 4	1 & 3
Dr. No.	W6-258-36	
Dims.	Ins.	mm.
A	6-81	173-0
B	6-06	154-0
C	4-37	111-0
D	3-37	85-5
E	2-75	70-0
F	1-00	25-5
G	0-69	17-5
H	2-59	66-0
J	1-47	37-5

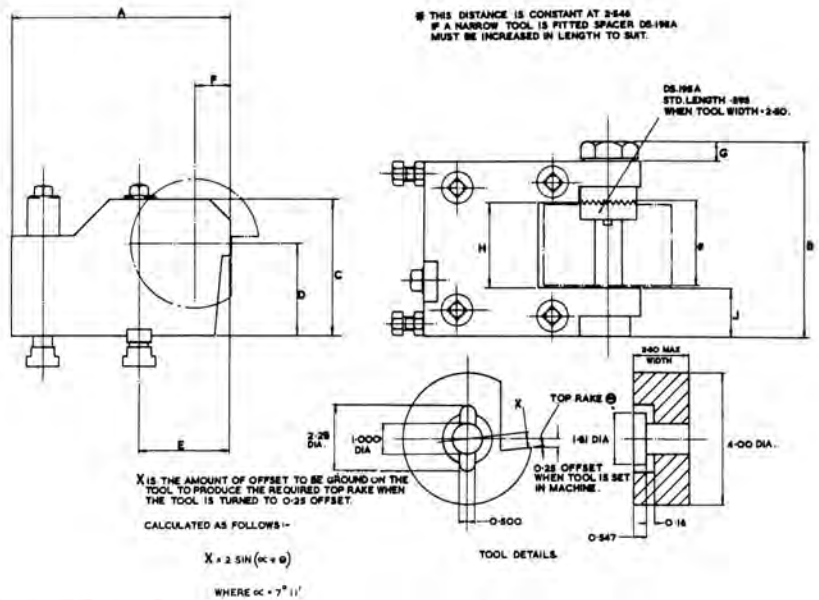
NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate, W4-9-85 will be required. 57

CIRCULAR FORM TOOLHOLDER



Designed for direct mounting on the cross slide, this is a block type holder. Adjustment is provided for setting the tool on centre and a secondary adjustment enables maximum tool life to be obtained.

See page 57 for holder used in other stations. When ordering new form tools the length of DS.195A required must be given if it is longer than standard.

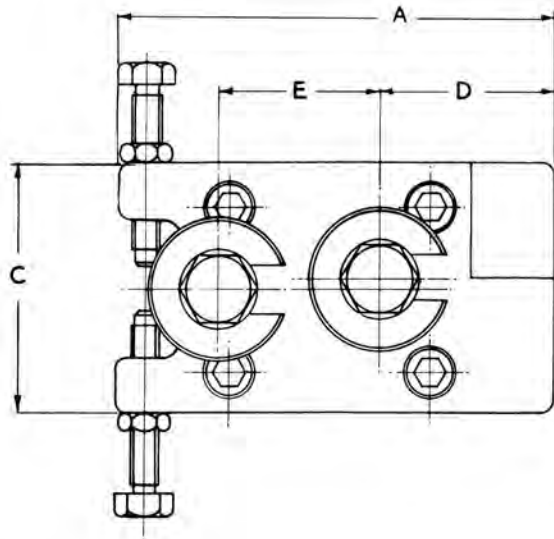
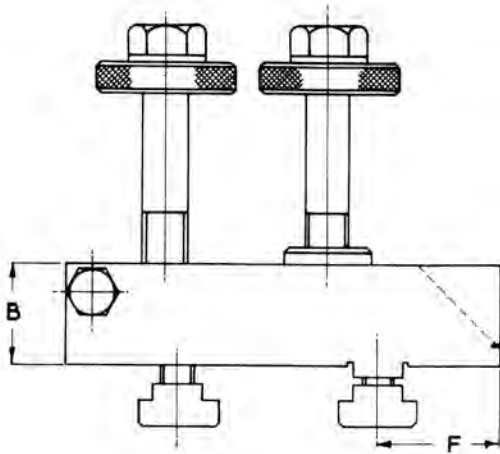


Machine	2 5/8", 3 1/4"—6 Bar 7 1/4"—6 Chucker	3 1/2", 4 1/8"—4 Bar 9"—4 Chucker
Station	2 & 5	2
Drg. No.	W6—258—37	
Dims.	Ins.	mm.
A	6.81	173.0
B	6.06	154.0
C	4.25	108.0
D	2.87	73.0
E	2.75	70.0
F	1.00	25.5
G	0.69	17.5
H	2.59	66.0
J	1.47	37.5

58 NOTE: When this holder is used on 9" 4-Chucker, Riser Plate W4—9—85 will be required.

CIRCULAR FORM TOOLHOLDER BASE

The bases are designed for use with the circular form toolholders listed on page 56. The toolholder is quickly released from the base by removal of two slip washers.



CROSS SLIDES

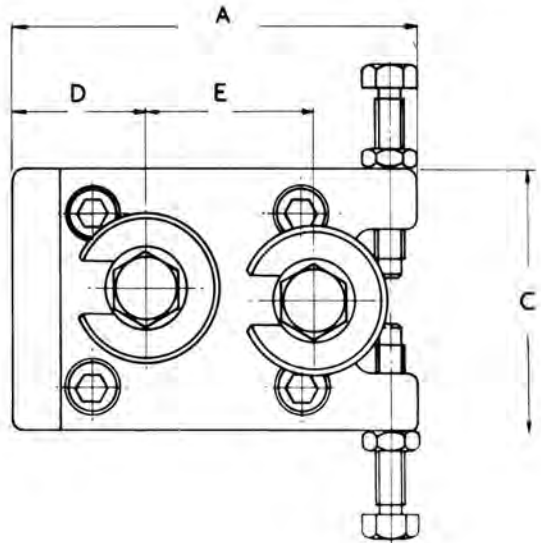
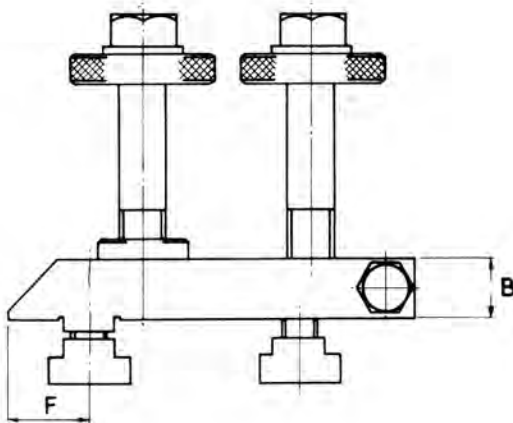
Machine	1" — 6 Bar		1½" — 5 Bar 5" — 5 Chucker		1½", 1½" — 6 Bar 5½" — 6 Chucker		1½", 2¼" — 5 Bar 6" — 5 Chucker		1½" — 3 Bar		2¼" — 6 Bar 6½" — 6 Chucker	
	Station		Station		Station		Station		Station		Station	
Drg. No.	W6—1—36		W5—138—36		W5—134—36		W5—134—36		W6—214—36		W6—214—36	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	4.56	116.0	4.87	124.0	5.75	146.0	5.75	146.0	6.75	171.5	6.75	171.5
B	1.31	33.5	1.12	28.5	1.25	31.5	1.25	31.5	1.62	41.5	1.62	41.5
C	3.75	95.0	2.75	70.0	2.94	74.5	2.94	74.5	4.50	114.5	4.50	114.5
D	1.06	27.0	1.94	49.0	2.19	55.5	2.19	55.5	2.37	60.5	2.37	60.5
E	2.25	57.0	1.81	46.0	2.25	57.0	2.25	57.0	3.00	76.0	3.00	76.0
F	1.06	27.0	1.37	35.0	1.75	44.5	1.75	44.5	2.37	60.5	2.37	60.5

CIRCULAR FORM TOOLHOLDER BASE



The bases are designed for use with the circular form toolholders listed on page 56. The toolholder is quickly released from the base by removal of two slip washers.

See page 60 for base used in other stations.



CROSS SLIDES

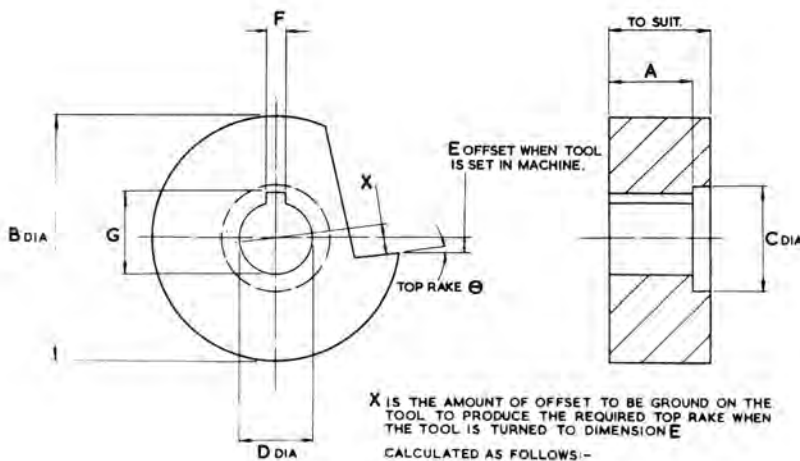
Machine	1" — 6 Bar		1 1/2" — 5 Bar 5" — 5 Chucker		1 3/4", 1 1/2" — 6 Bar 5 1/2" — 6 Chucker		1 1/2", 2 1/4" — 5 Bar 6" — 5 Chucker		1 1/2" — 8 Bar 6 1/2" — 6 Chucker	
	Station		2 & 4		2, 3 & 5		2 & 4		2, 3 & 5	
Drg. No.	W6-1-37		W5-138-37		W5-134-37		W5-134-37		W6-214-37	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	4.56	116.0	4.37	111.0	5.12	130.0	6.75	171.5		
B	0.81	20.5	0.62	15.5	0.75	19.0	1.12	28.5		
C	3.75	95.0	2.75	70.0	2.94	74.5	4.50	114.5		
D	1.06	27.0	1.44	36.5	1.56	39.5	2.37	60.5		
E	2.25	57.0	1.01	46.0	2.25	57.0	3.00	76.0		
F	1.06	27.0	0.87	22.0	1.12	28.5	2.37	60.5		

CIRCULAR FORM TOOLS



Circular form tools for use in the holders detailed on pages 56, 57 and 58 can be supplied to customers requirements.

Alternative clamping bolts to suit two sizes of form tools are available as listed in table below.



X IS THE AMOUNT OF OFFSET TO BE GRIND ON THE TOOL TO PRODUCE THE REQUIRED TOP RAKE WHEN THE TOOL IS TURNED TO DIMENSION E
CALCULATED AS FOLLOWS:-

$$X = \frac{B}{2} \sin(\alpha + \theta)$$

$$\text{WHERE } \alpha = \sin^{-1} \frac{2E}{B}$$

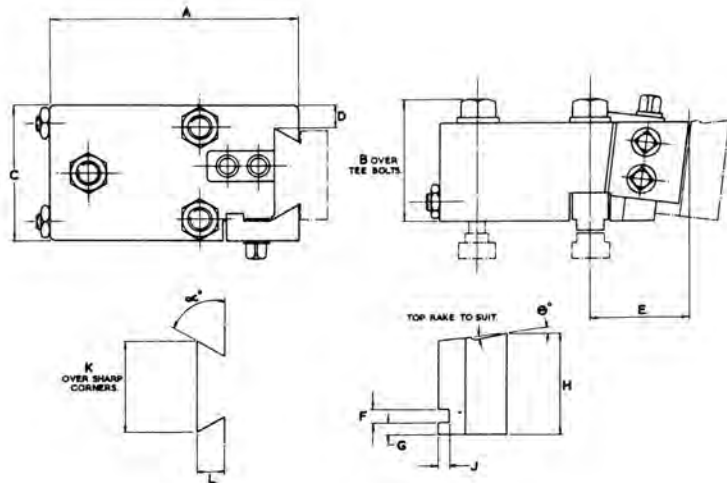
Machine	1" — 6 Bar		1 1/8" — 5 Bar 5" — 5 Chucker		1 3/8", 1 1/4" — 6 Bar 5 3/8" — 6 Chucker		1 1/2" — 8 Bar	
	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	0.75	19.0	0.75	19.0	1.00	25.5	1.00	25.5
B dia.	1.25	31.5	1.25	31.5	1.50	38.0	1.50	38.0
C dia.	3.00	76.0	3.00	76.0	3.25	82.5	3.50	89.0
D dia.	1.06	27.0	1.37	35.0	1.44	36.5	1.44	36.5
E	0.625	15.87	0.750	19.05	0.875	22.22	0.875	22.22
F	0.25	6.5	0.25	6.5	0.25	6.5	0.25	6.5
G	0.187	4.76	0.250	6.35	0.250	6.35	0.250	6.35
	0.708	18.0	0.86	22.0	0.98	25.0	0.98	25.0
CLAMPING BOLT								
	A Dim.	Drg. No.	A Dim.	Drg. No.	A Dim.	Drg. No.	A Dim.	Drg. No.
	0.75	DS.640/1	0.75	S.605A/2	1.00	S.149A/2	1.00	DS.757/1
	1.25	DS.640/2	1.25	S.605A/1	1.50	S.149A/1	1.50	DS.757/2

DOVETAIL FORM TOOLHOLDER

(WIDE TYPE)



The holders, which accommodate prismatic form tools, are used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.



CROSS SLIDES

Machine	1"—6 Bar		1 $\frac{3}{8}$ "—5 Bar 5"—5 Chucker		1 $\frac{3}{4}$ ", 2 $\frac{1}{4}$ "—5 Bar 6"—5 Chucker		1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ "—6 Bar 5 $\frac{3}{8}$ "—6 Chucker		1 $\frac{3}{4}$ ", 2 $\frac{1}{4}$ "—5 Bar 6"—5 Chucker	
	Station		Station		Station		Station		Station	
Drg. No.	W6—1—40		W5—138—40		W5—134—40*		W6—138—40		W6—138—40	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	5-00	127-0	5-25	133-5	6-75	171-5	6-31	160-5	6-31	160-5
B	2-50	63-5	3-62	92-0	3-75	95-5	2-12	54-0	2-12	54-0
C	2-75	70-0	3-12	79-5	3-12	79-5	3-12	79-5	3-12	79-5
D	0-50	12-5	0-67	17-0	0-67	17-0	0-67	17-0	0-67	17-0
E	2-00	51-0	2-25	57-0	3-38	85-5	2-94	74-5	2-94	74-5
F	0-250	6-35	†		†		0-250	6-35	0-250	6-35
G	0-252	6-40	†		†		0-252	6-40	0-252	6-40
H	0-56	14-5	†		†		0-25	6-5	0-25	6-5
J	2-06	52-5	2-12	54-0	2-12	54-0	2-06	52-5	2-06	52-5
K	0-22	5-5	†		†		0-25	6-5	0-25	6-5
L	1-845	46-86	1-845	46-86	1-845	46-86	1-845	46-86	1-845	46-86
	0-53	13-5	0-50	12-5	0-50	12-5	0-53	13-5	0-53	13-5
θ	6°		6°		6°		6°		6°	
α	60°		60°		60°		60°		60°	

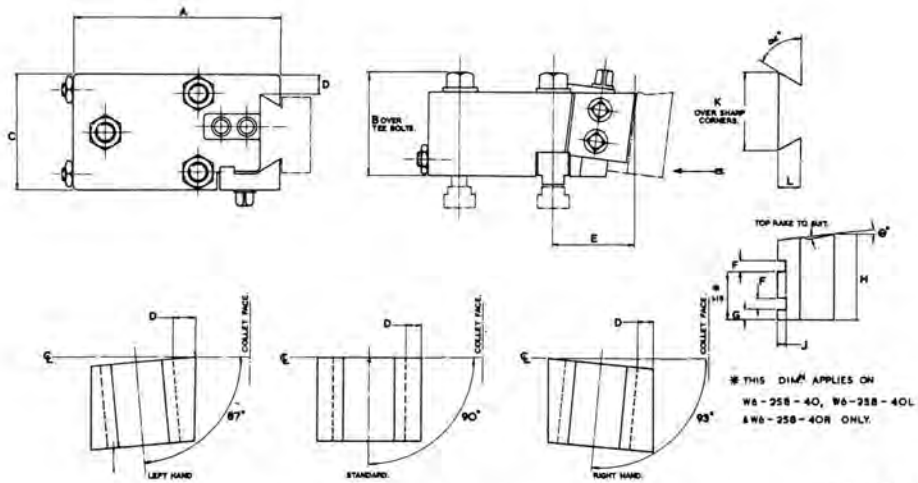
* As existing stocks of this toolholder become exhausted it will be replaced by W6—138—40.
 † On these holders a hole $\frac{3}{8}$ " BSF \times $1\frac{1}{8}$ " long is machined in the body of the tool to provide a means of adjustment.

DOVETAIL FORM TOOLHOLDER

(PLAIN AND ANGLED WIDE TYPE)



This toolholder accommodates prismatic form tools. The tool slot is pitched as shown to give tool clearance when facing in front or behind a shoulder. An adjustment is provided for setting tool height.



VIEW IN DIRECTION OF ARROW, SHOWING ANGULAR POSITION OF DOVETAIL.

CROSS SLIDES

Machine	1 3/4" — 8 Bar	2 1/4" — 6 Bar 6 3/8" — 6 Chucker	2 5/8", 3 1/2" — 6 Bar 7 1/4" — 6 Chucker	3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker
Station	1 & 5	1 & 4	1 & 4	1 & 3
Drg. No. Plain	W6-214-40		W6-258-40	
Drg. No. Left Hand	W6-214-40L		W6-258-40L	
Drg. No. Right Hand	W6-214-40R		W6-258-40R	
Dims.	Ins.	mm.	Ins.	mm.
A	7-37	187-3	8-37	212-7
B	3-00	76-0	4-12	105-0
C	3-50	89-0	3-50	89-0
D	0-81	20-5	0-81	20-5
E	3-00	76-0	2-75	70-0
F	0-250	6-35	0-250	6-35
	0-252	6-40	0-251	6-37
G	0-50	12-5	0-37	9-5
H	2-50	63-5	3-37	85-7
J	0-25	6-5	0-31	8-0
K	1-845	46-86	1-897	48-18
L	0-53	13-5	0-53	13-5
α	60°		60°	
∅	6°		6°	

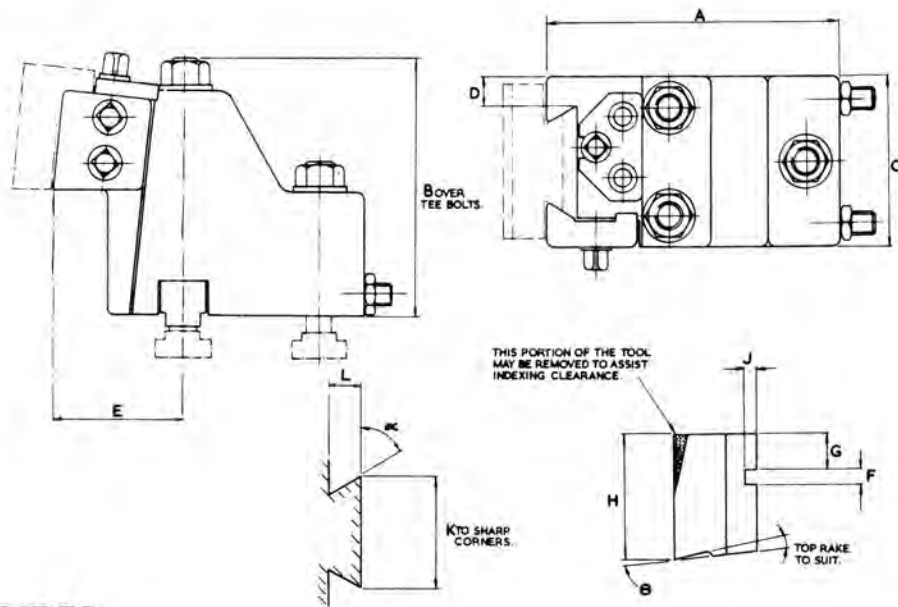
NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4-9-84 will be required.



DOVETAIL FORM TOOLHOLDER

(WIDE TYPE)

The holders, which accommodate prismatic form tools, are used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.



CROSS SLIDES

Machine	1"—6 Bar		1 $\frac{3}{8}$ "—5 Bar 5"—5 Chucker		1 $\frac{1}{4}$ ", 2 $\frac{1}{4}$ "—5 Bar 6"—5 Chucker		1 $\frac{3}{8}$ ", 1 $\frac{1}{2}$ "—6 Bar 5 $\frac{3}{8}$ "—6 Chucker		1 $\frac{1}{4}$ ", 2 $\frac{1}{4}$ "—5 Bar 6"—5 Chucker	
Station	2, 3 & 5		2 & 4		2 & 4		2, 3 & 5		2 & 4	
Drg. No.	W6—1—41		W5—138—41		W5—134—41*		W6—138—41			
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	5.19	131.5	5.25	133.5	6.44	163.5	6.31	160.5		
B	4.12	105.0	6.00	152.5	6.38	162.0	4.37	111.0		
C	2.75	70.0	3.12	79.5	3.12	79.5	3.12	79.5		
D	0.50	12.5	0.67	17.0	0.67	17.0	0.67	17.0		
E	2.19	55.5	2.12	54.0	3.06	78.0	2.94	74.5		
F	0.250	6.35	†		†		0.250	6.35		
G	0.252	6.40	†		†		0.252	6.40		
	0.56	14.5	†		†		0.25	6.5		
H	2.06	52.5	2.62	66.5	2.87	73.0	2.06	52.5		
J	0.21	5.5	†		†		0.25	6.5		
K	1.845	46.86	1.845	46.86	1.845	46.86	1.845	46.86		
L	0.53	13.5	0.50	12.5	0.53	13.5	0.53	13.5		
α	60°		60°		60°		60°			
(i)	6°		6°		6°		6°			

† On these holders a hole $\frac{3}{8}$ " BSF x $1\frac{7}{8}$ " long is machined in the body of the tool to provide a means of adjustment.

64 * As existing stocks of this toolholder become exhausted it will be replaced by W6—138—41.

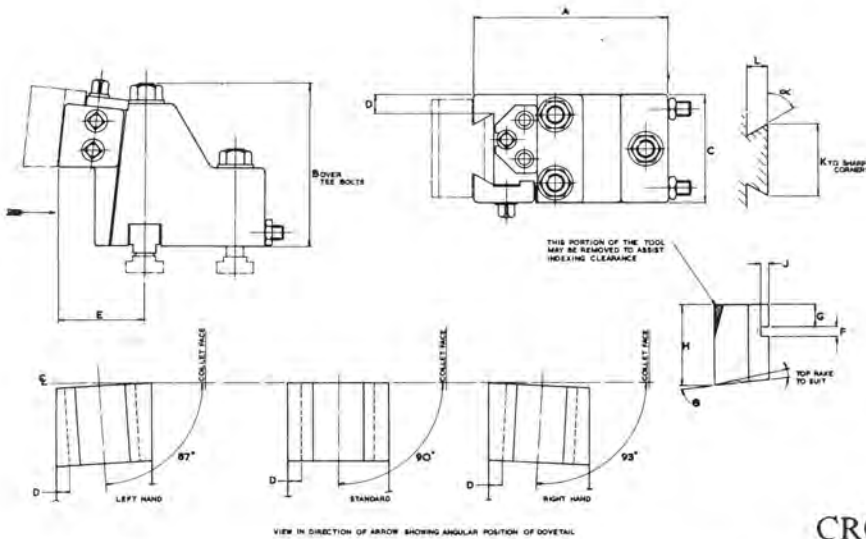
TOOLHOLDER for WICKMAN AUTOMATICS

DOVETAIL FORM TOOLHOLDER

(PLAIN AND ANGLED TYPE)



This toolholder accommodates prismatic form tools. The tool slot is pitched as shown to give tool clearance when facing in front or behind a shoulder. An adjustment is provided for setting tool height.



CROSS SLIDES

Machine	1 3/4" — 8 Bar	2 1/4" — 6 Bar 6 5/8" — 6 Chucker	2 5/8", 3 1/4" — 6 Bar 7 1/2" — 6 Chucker	3 1/2", 4 1/8" — 4 Bar 9" — 4 Chucker
Station	2 & 6	2, 3 & 5	2, 3 & 5	2
Drg. No. Plain	W6—214—41		W6—258—41	
Drg. No. Left Hand	W6—214—41L		W6—258—41L	
Drg. No. Right Hand	W6—214—41R		W6—258—41R	
Dims.	Ins.	mm.	Ins.	mm.
A	7-37	187.5	8-37	212.5
B	5-00	127.0	6-25	159.0
C	3-50	89.0	3-50	89.0
D Plain	0-81	20.5	0-81	20.5
D Left Hand	0-81	20.5	0-94	23.5
D Right Hand	0-81	20.5	0-69	17.5
E	3-00	76.0	2-75	70.0
F	0-250	6-35	0-250	6-35
	0-252	6-40	0-251	6-37
G	0-50	12.5	0-37	9.5
H	2-50	63.5	2-56	65.0
J	0-25	6.5	0-31	8.0
K	1-845	46-86	1-897	48-18
L	0-53	13.5	0-53	13.5
α	60°		60°	
β	6°		6°	

NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

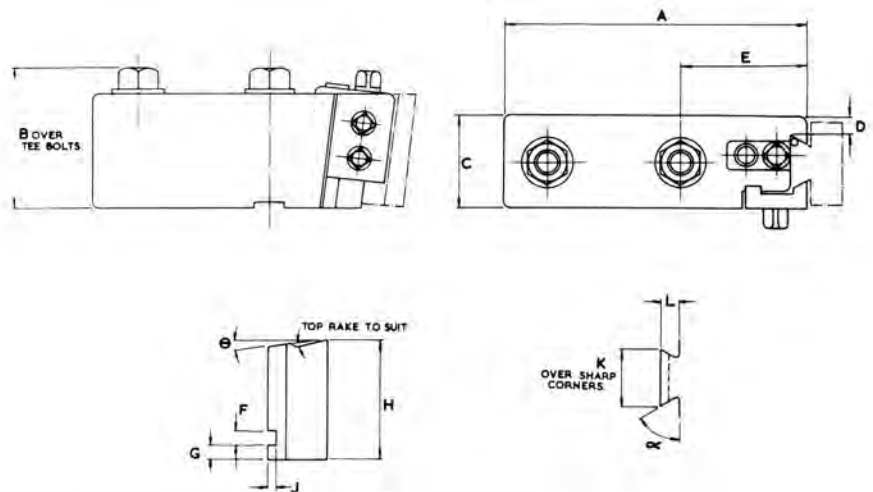
DOVETAIL FORM TOOLHOLDER

(NARROW TYPE)



The holders, which accommodate prismatic form tools, are used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.

The narrow-type holder is especially useful when forming cuts are required close to the spindle.



CROSS SLIDES

Machine	1"—6 Bar		1 $\frac{3}{4}$ "—8 Bar	2 $\frac{1}{2}$ "—6 Bar 6 $\frac{5}{8}$ "—6 Chucker
Station	1 & 4		1 & 5	1 & 4
Drg. No.	W6—1—74		W6—214—74	
Dims.	Ins.	mm.	Ins.	mm.
A	5.12	130.0	7.37	187.5
B	2.50	63.5	3.00	76.0
C	1.62	41.5	1.75	44.5
D	0.33	8.5	0.33	8.5
E	2.12	54.0	3.12	79.5
F	0.250	6.35	0.250	6.35
	0.252	6.40	0.252	6.40
G	0.56	14.5	0.50	12.5
H	2.06	52.5	2.50	63.5
J	0.16	4.0	0.16	4.0
K	0.951	24.15	0.951	24.15
L	0.31	8.0	0.31	8.0
(1)	6°		6°	
(2)	60°		60°	

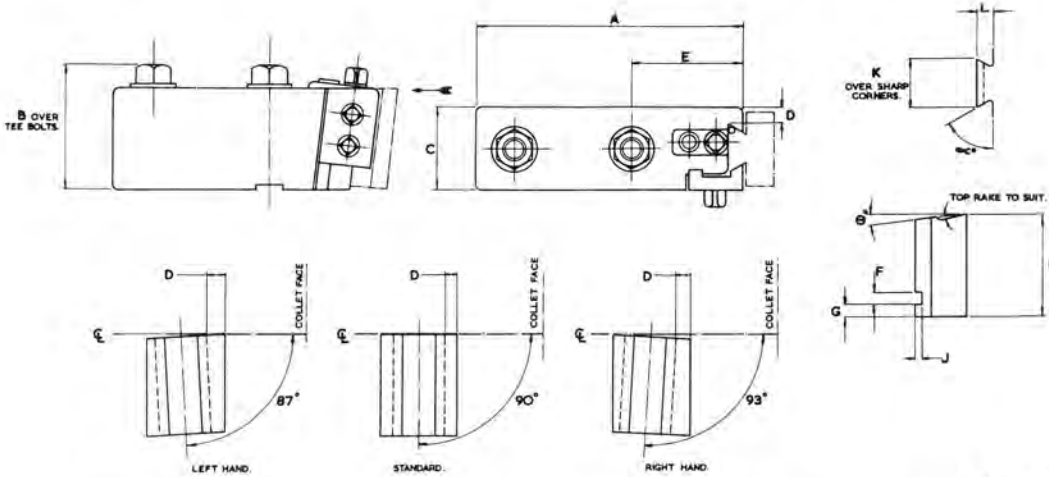
TOOLHOLDER for WICKMAN AUTOMATICS

DOVETAIL FORM TOOLHOLDER

(PLAIN AND ANGLED NARROW
TYPE)



This toolholder accommodates prismatic form tools. The tool slot is pitched as shown to give tool clearance when facing before or behind a shoulder. Adjustment is provided for setting tool height.



VIEW IN DIRECTION OF ARROW SHOWING ANGULAR POSITION OF DOVETAIL.

CROSS SLIDES

Machine	1 3/8", 1 3/4"—6 Bar 5/8"—6 Chucker		1 3/4", 2 1/4"—5 Bar 6"—5 Chucker		2 3/4", 3 1/4"—6 Bar 7 1/4"—6 Chucker		3 1/2", 4 1/8"—4 Bar 9"—4 Chucker	
	1 & 4		1 & 3		1 & 4		1 & 3	
Drg. No. Plain	W6—138—74				W6—258—74N			
Drg. No. Left Hand	W6—138—74N/L				W6—258—74N/L			
Drg. No. Right Hand	W6—138—74N/R				W6—258—74N/R			
Dims.	Ins.	mm.		Ins.	mm.			
A	6.19	157.0		7.50	190.5			
B	2.12	54.0		3.25	82.5			
C	1.94	49.0		2.75	70.0			
D Plain	0.31	8.0		0.56	14.5			
D Left Hand	0.34	8.5		0.67	17.0			
D Right Hand	0.40	10.0		0.45	11.5			
E	2.94	74.5		2.87	73.0			
F	0.250	6.35		0.250	6.35			
	0.252	6.40		0.252	6.40			
G	0.25	6.5		0.37	9.5			
H	2.00	51.0		2.50	63.5			
J	0.22	5.5		0.22	5.5			
K	0.951	24.15		1.433	36.40			
L	0.31	8.0		0.37	9.5			
()	6°				6°			
α	60°				60°			

NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

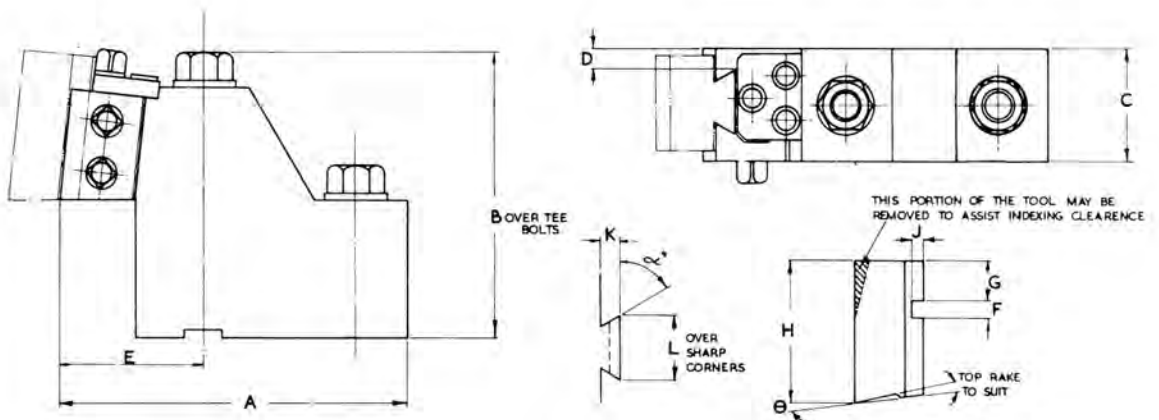
DOVETAIL FORM TOOLHOLDER

(NARROW TYPE)



The holders, which accommodate prismatic form tools, are used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.

The narrow-type holder is especially useful when forming cuts are required close to the spindle.



CROSS SLIDES

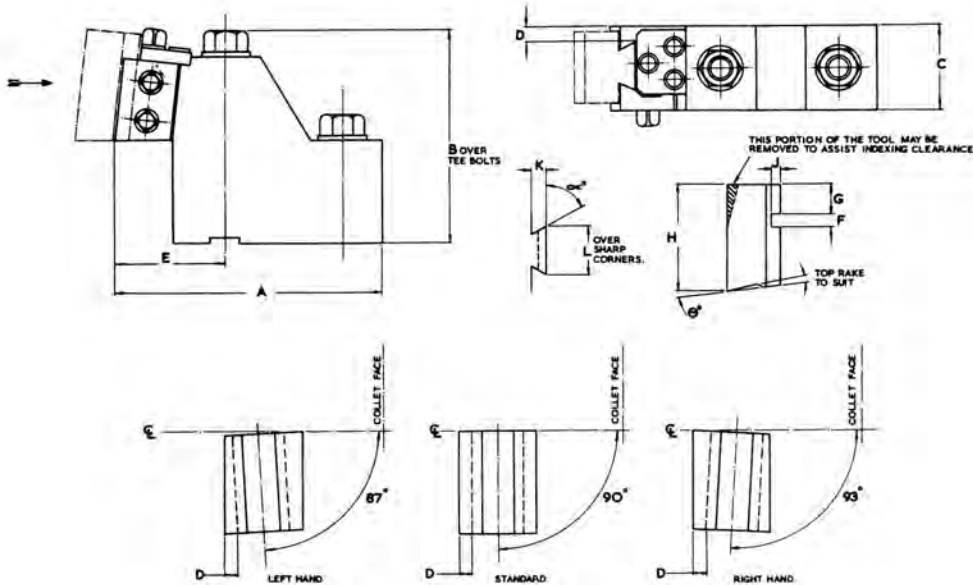
Machine	1" — 6 Bar		1 3/4" — 8 Bar	2 1/4" — 6 Bar 6 5/8" — 6 Chucker
	2, 3 & 5		2 & 6	2, 3 & 5
Drg. No.	W6-1-75		W6-214-75	
Dims.	Ins.	mm.	Ins.	mm.
A	5-12	130-0	7-37	187-5
B	4-12	105-0	5-12	130-0
C	1-62	41-5	1-75	44-5
D	0-33	8-5	0-33	8-5
E	2-12	54-0	3-12	79-5
F	0-250	6-35	0-250	6-35
	0-252	6-40	0-252	6-40
G	0-56	14-5	0-50	12-5
H	2-06	52-5	2-50	63-5
J	0-16	4-0	0-16	4-0
K	0-31	8-0	0-31	8-0
L	0-951	24-15	0-951	24-15
0	6°		6°	
α	60°		60°	

TOOLHOLDER for WICKMAN AUTOMATICS

DOVETAIL FORM TOOLHOLDER

(PLAIN AND ANGLED NARROW
TYPE)

This toolholder accommodates prismatic form tools. The tool slot is pitched as shown to give tool clearance in front or behind a shoulder. Adjustment is provided for setting tool height.



VIEW IN DIRECTION OF ARROW SHOWING ANGULAR POSITION OF DOVETAIL.

CROSS SLIDES

Machine	1 1/2", 1 3/4"—6 Bar 5 3/8"—6 Chucker		1 3/4", 2 1/4"—5 Bar 6"—5 Chucker		2 1/8", 3 1/2"—6 Bar 7 1/2"—6 Chucker		3 1/2", 4 1/2"—4 Bar 9"—4 Chucker		2 1/4", 3 1/2"—6 Bar 7 1/2"—6 Chucker		3 1/2", 4 1/2"—4 Bar 9"—4 Chucker		
	Stations		2, 3 & 5		2 & 4		2, 3 & 5		2		2, 3 & 5		2
Drg. No. Plain	W6—138—75				W6—258—75N				W6—258—75*				
Drg. No. Left Hand	W6—138—75NL				W6—258—75NL				W6—258—75L*				
Drg. No. Right Hand	W6—138—75NR				W6—258—75NR				W6—258—75R*				
Dims.	Ins.		mm.		Ins.		mm.		Ins.		mm.		
A	6.44		163.5		7.05		179.0		7.05		179.0		
B	4.37		112.5		5.37		136.5		5.37		136.5		
C	1.94		49.0		2.75		70.0		2.75		70.0		
D Plain	0.31		8.0		0.69		17.5		0.69		17.5		
D Left Hand	0.42		10.5		0.69		17.5		0.69		17.5		
D Right Hand	0.31		8.0		0.69		17.5		0.69		17.5		
E	2.94		74.5		3.05		77.5		3.05		77.5		
F	0.250		6.35		0.250		6.35		0.125		3.170		
G	0.252		6.40		0.252		6.40		0.130		3.30		
H	0.25		6.5		0.37		9.5		0.37		9.5		
J	2.06		52.5		2.50		63.5		2.50		63.5		
K	0.22		5.5		0.22		5.5		0.16		4.0		
L	0.31		8.0		0.37		9.5		0.37		9.5		
	0.951		24.15		1.433		36.40		1.433		36.40		
θ	6°				6°				6°				
α	60°				60°				60°				

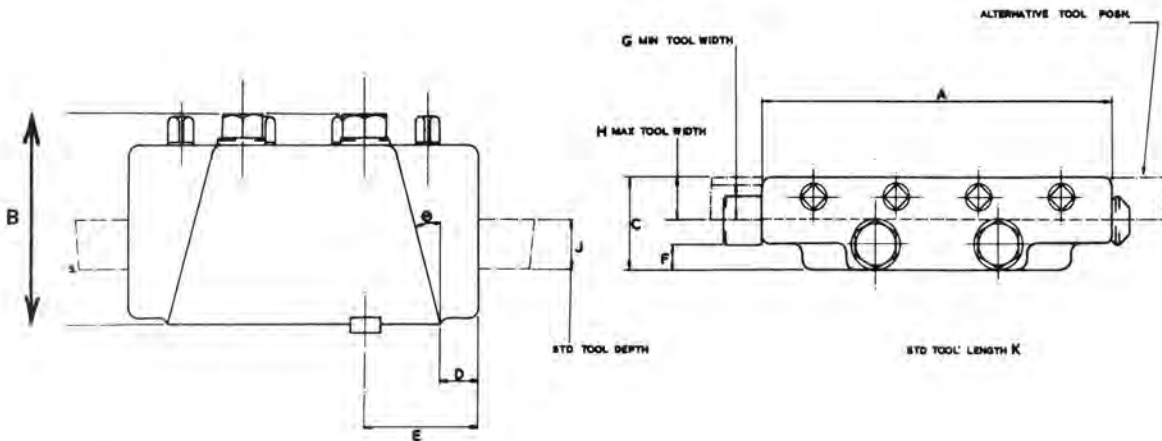
* As existing stocks of this toolholder become exhausted it will be replaced by W6—258—75N, 75NL and 75NR.
NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

FLAT FORM TOOLHOLDER (REVERSIBLE)



Accommodating flat form tools these holders are reversible for right- or left-hand use. Ample adjustment is provided for bringing the tool on centre and a back up screw is incorporated to absorb end thrust.

See page 81 for additional tools.



CROSS SLIDES

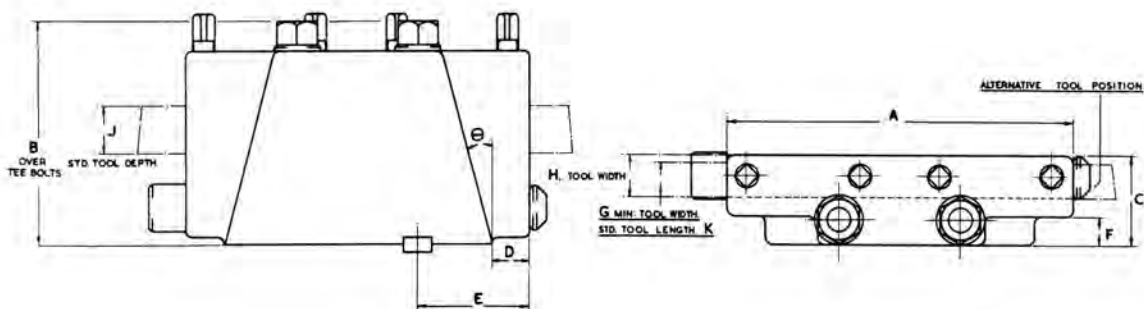
Machine	1" - 6 Bar		4 1/2" - 5 Bar 5" - 5 Chucker		1 1/2", 1 3/4" - 6 Bar 5 1/2" - 6 Chucker 1 3/4", 2 1/4" - 5 Bar 6" - 5 Chucker				2 1/2" - 6 Bar 6 1/2" - 6 Chucker 1 1/2" - 8 Bar					
	W6-1-38*		W6-1-38N		W5-138-38		W5-134-38*		W5-134-38N		W6-2-38*		W6-214-38N	
Drg. No.														
Station	1 & 4		1 & 4		1 & 3		1 & 3		1 & 3		1 & 4		1 & 4	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
	A	6.25	159.0	6.25	159.0	6.37	162.0	8.12	206.0	7.75	197.5	9.00	228.5	9.00
B	3.37	85.5	3.56	90.5	3.69	93.5	3.87	98.5	4.00	101.5	4.50	114.0	4.62	117.5
C	1.62	41.5	1.62	41.5	1.62	41.5	2.00	51.0	2.06	52.5	2.12	54.0	2.25	57.0
D	1.12	28.5	1.12	28.5	0.69	17.5	1.06	27.0	1.75	44.5	1.87	47.5	1.94	49.0
E	2.00	51.0	2.00	51.0	2.06	52.5	2.81	71.5	2.62	66.5	3.50	89.0	3.50	89.0
F	0.50	12.5	0.50	12.5	0.47	12.0	0.50	12.5	0.53	13.5	0.50	12.5	0.50	12.5
G	0.50	12.5	0.50	12.5	0.50	12.5	0.75	19.0	0.75	19.0	0.75	19.0	0.75	19.0
H	0.87	22.0	0.87	22.0	0.87	22.0	1.12	28.5	1.12	28.5	1.25	32.0	1.25	32.0
J	0.75	19.0	0.75	19.0	0.87	22.0	0.87	22.0	1.00	25.5	0.87	22.0	1.00	25.5
K	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0
(J)	0"		0"		15"		15"		0"		0"		0"	

70 * As stocks of these toolholders become exhausted they will be replaced by corresponding 'N' type toolholders, i.e. W6-1-38 by W6-1-38N.

FLAT FORM TOOLHOLDER (REVERSIBLE)

Accommodating flat form tools these holders are reversible for right- or left-hand use. Ample adjustment is provided for bringing the tool on centre and a back up screw is incorporated to absorb end thrust.

See page 81 for further tool details.



CROSS SLIDES

Machine	1" — 6 Bar				1 1/2" — 5 Bar 5" — 5 Chucker		1 1/2", 1 3/4" — 6 Bar 5 1/2" — 6 Chucker 1 1/2", 2 1/4" — 5 Bar 6" — 5 Chucker				2 1/4" — 6 Bar 6 1/2" — 6 Chucker 1 1/2" — 8 Bar			
	W6-1-39*		W6-1-39N		W5-138-39		W5-134-39*		W5-134-39N		W6-2-39*		W6-214-39N	
Drg. No.	W6-1-39*		W6-1-39N		W5-138-39		W5-134-39*		W5-134-39N		W6-2-39*		W6-214-39N	
Station	2, 3 & 5		2, 3 & 5		2 & 4		2, 3, 5		1 1/2" — 6 Bar 2, 3, 5		1 3/4" — 6 Bar 2, 3, 5		2 1/4" — 6 Bar 2, 3, 5	
	2 & 4		1 1/2" — 5 Bar 2 & 4		1 3/4" — 5 Bar 2 & 4		1 1/2" — 8 Bar 2 & 6		1 3/4" — 8 Bar 2 & 6		1 1/2" — 8 Bar 2 & 6		1 3/4" — 8 Bar 2 & 6	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	6.25	159.0	6.25	159.0	6.37	162.0	7.50	190.5	7.50	190.5	8.75	222.0	8.75	222.0
B	4.25	108.0	4.12	105.0	4.25	108.0	4.37	111.0	4.44	112.5	4.87	124.0	5.12	130.0
C	1.62	41.5	1.62	41.5	1.62	41.5	2.00	51.0	2.00	51.0	2.12	54.0	2.25	57.0
D	1.12	28.5	1.12	28.5	0.69	17.5	0.75	19.0	1.75	44.5	1.75	44.5	1.81	46.0
E	2.00	51.0	2.00	51.0	2.06	52.5	2.50	63.5	2.50	63.5	3.37	85.5	3.37	85.5
F	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5
G	0.50	12.5	0.50	12.5	0.50	12.5	0.75	19.0	0.75	19.0	0.75	19.0	0.75	19.0
H	0.87	22.0	0.87	22.0	0.87	22.0	1.12	28.5	1.12	28.5	1.25	32.0	1.25	32.0
J	0.75	19.0	0.75	19.0	0.87	22.0	0.87	22.0	1.00	25.5	0.87	22.0	1.00	25.5
K	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0
(i)	0°		0°		15°		15°		0°		0°		0°	

* As stocks of these toolholders become exhausted they will be replaced by corresponding 'N' type toolholders, i.e. W6-1-39 by W6-1-39N.

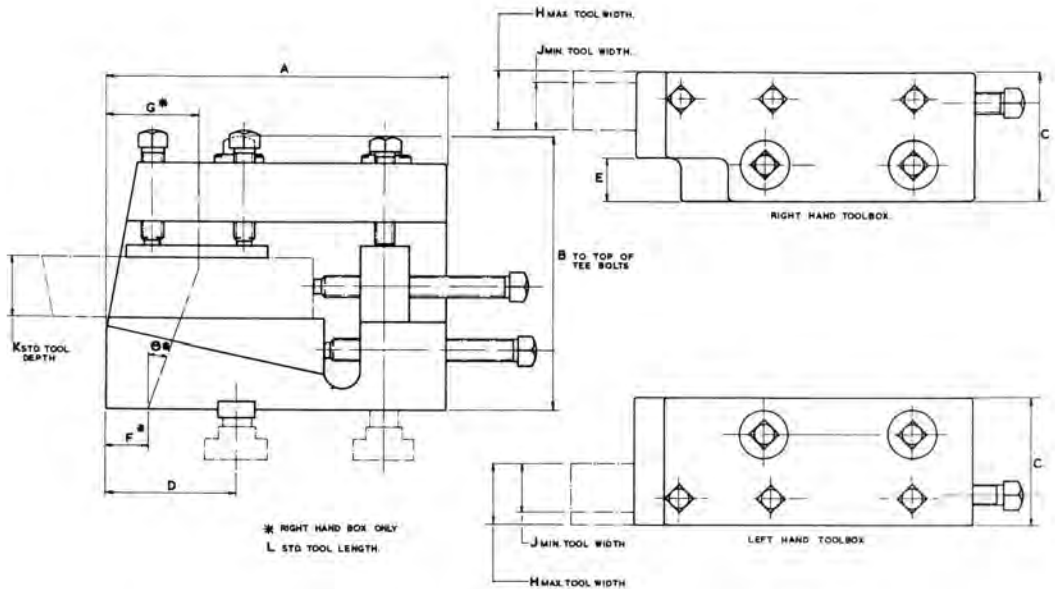


FLAT FORM TOOLHOLDERS

(RIGHT HAND AND LEFT HAND)

Accommodating flat form tools, holders can be supplied for left- or right-hand use. Adjustment is provided for bringing the tool on centre and a back up screw is incorporated to absorb end thrust. When ordering state whether a right- or left-hand holder is required.

See page 81 for additional tools.



CROSS SLIDES

Machine	2 $\frac{5}{8}$ " 3 $\frac{1}{4}$ "—6 Bar 7 $\frac{1}{4}$ "—6 Chucker	3 $\frac{1}{2}$ " 4 $\frac{1}{8}$ "—4 Bar 9"—4 Chucker	2 $\frac{5}{8}$ " 3 $\frac{1}{4}$ "—6 Bar 7 $\frac{1}{4}$ "—6 Chucker	3 $\frac{1}{2}$ " 4 $\frac{1}{8}$ "—4 Bar 9"—4 Chucker
Station	1 & 4	1 & 3	1 & 4	1 & 3
Drg. No.	R.H.	W6—258—38R*	W6—258—38NR	
	L.H.	W6—258—38L*	W6—258—38NL	
Dims.	Ins.	mm.	Ins.	mm.
A	6.94	176.0	6.87	174.5
B	5.62	142.5	5.87	149.0
C	2.62	66.5	2.50	63.5
D	2.62	66.5	2.62	66.5
E	0.87	22.0	0.75	19.0
F	0.87	22.0	0.87	22.0
G	1.87	47.5	1.87	47.5
H	1.50	38.0	1.50	38.0
J	0.87	22.0	0.87	22.0
K	1.25	31.5	1.25	31.5
L	5.50	139.5	5.50	139.5
()	20°		20°	

* As stocks of these toolholders become exhausted they will be replaced by W6—258—38NR and NL.
NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

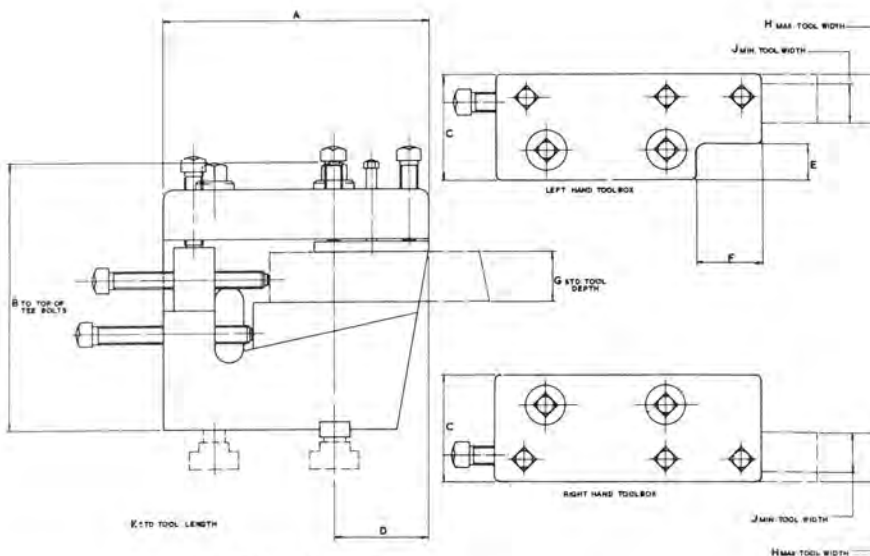
FLAT FORM TOOLHOLDERS

(RIGHT HAND AND LEFT HAND)



Accommodating flat form tools, holders can be supplied for left- or right-hand use. Adjustment is provided for bringing the tool on centre and a back up screw is incorporated to absorb end thrust. When ordering state whether a right- or left-hand holder is required.

See page 81 for additional tools.



CROSS SLIDES

Machine	2 $\frac{5}{8}$ " 3 $\frac{1}{2}$ "—6 Bar 7 $\frac{1}{4}$ "—6 Chucker	3 $\frac{1}{2}$ " 4 $\frac{1}{8}$ "—4 Bar 9"—4 Chucker	2 $\frac{3}{8}$ " 3 $\frac{1}{4}$ "—6 Bar 7 $\frac{1}{4}$ "—6 Chucker	3 $\frac{1}{2}$ " 4 $\frac{1}{8}$ "—4 Bar 9"—4 Chucker
Station	2, 3 & 5		2 & 4	
Drg. No.	R.H.	W6—258—39R*		W6—258—39NR
	L.H.	W6—258—39L*		W6—258—39NL
Dims.	Ins.	mm.	Ins.	mm.
A	6-62	168-0	6-62	168-0
B	6-62	168-0	6-37	162-0
C	2-62	66-5	2-50	63-5
D	2-37	60-5	2-37	60-5
E	0-77	22-0	0-75	19-0
F	1-62	41-5	1-62	41-5
G	1-25	31-5	1-25	31-5
H	1-50	38-0	1-50	38-0
J	0-87	22-0	0-87	22-0
K	5-50	139-5	5-50	139-5

NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

* As stocks of these toolholders become exhausted they will be replaced by W6—258—39 NR and NL.

FLAT FORM TOOLHOLDER

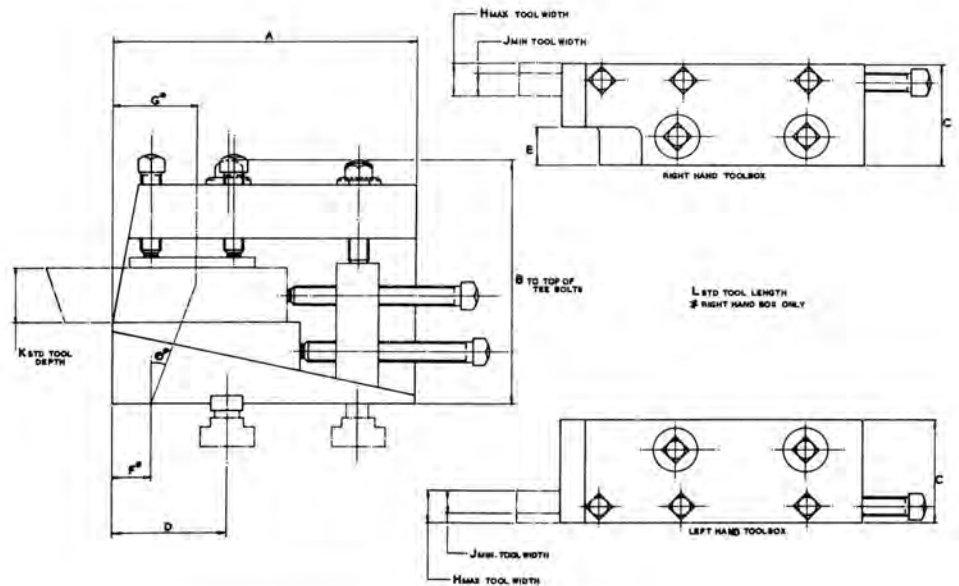
(NARROW RIGHT HAND AND
LEFT HAND)



Using flat form tools, holders can be supplied for left- or right-hand use. Adjustment is provided for bringing the tool on centre and a back up screw is incorporated to absorb end thrust.

When ordering state whether right- or left-hand holder is required.

See page 81 for additional tools.



CROSS SLIDES

Machine	2 5/8", 3 1/4"—6 Bar 7 1/4"—6 Chucker	3 1/2", 4 1/8"—4 Bar 9"—4 Chucker
Station	1 & 4	1 & 3
Drg. No.	R.H.	W6—258—70R
	L.H.	W6—258—70L
Dims.	Ins.	mm.
A	6.94	176.0
B	5.75	146.0
C	2.37	60.5
D	2.62	66.5
E	0.87	22.0
F	0.87	22.0
G	1.87	47.5
H	1.00	25.5
J	0.62	16.0
K	1.25	31.5
0	20°	

74 NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

FLAT FORM TOOLHOLDER

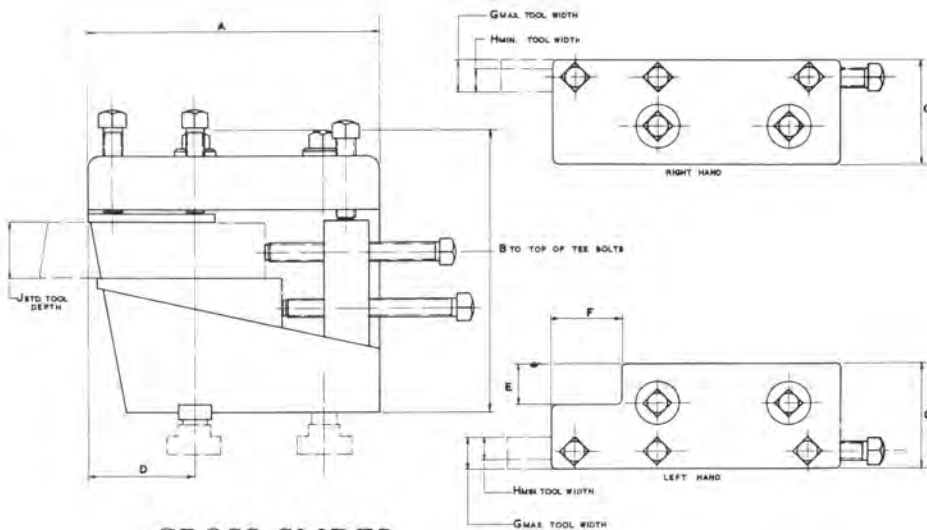
(NARROW RIGHT HAND AND
LEFT HAND)



Using flat form tools, holders can be supplied for left- or right-hand use. Adjustment is provided for bringing the tool on centre and back up screw is incorporated to absorb end thrust.

When ordering state whether a left- or right-hand holder is required.

See page 81 for additional tools.



CROSS SLIDES

Machine		2 ⁵ / ₈ " , 3 ¹ / ₄ "—6 Bar 7 ¹ / ₄ "—6 Chucker	3 ¹ / ₂ " , 4 ¹ / ₈ "—4 Bar 9"—4 Chucker
Station		2, 3 & 5	2
Drg. No.	R.H.	W6—258—71R	
	L.H.	W6—258—71L	
Dims.		Ins.	mm.
A		6.69	170.0
B		6.62	168.0
C		2.37	60.5
D		2.37	60.5
E		0.87	22.0
F		1.62	41.5
G		1.00	25.5
H		0.62	16.0

NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

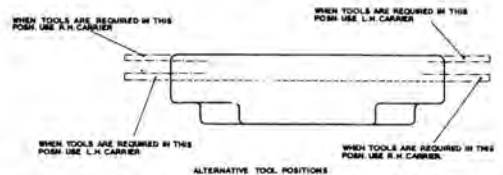
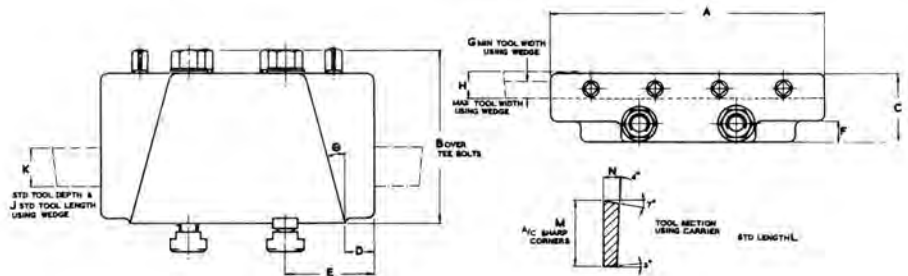
BLADE TOOLHOLDER

(REVERSIBLE)



These toolholders accommodating blade type tools are reversible for right- or left-hand use. Adjustment is provided for setting the tool on centre and a back screw absorbs end thrust. Blade tools are ground with clearance on both sides for the full length and require end grinding only.

When Wimet parting tools AP1 and AP2 for the 1"-6 bar machine and tools AP3 and AP4 for the 1 3/8"-5, 1 3/8"-6, 1 3/4"-5 and 2 1/4"-6 bar machines are used the appropriate wedge for the machine will be required.



CROSS SLIDES

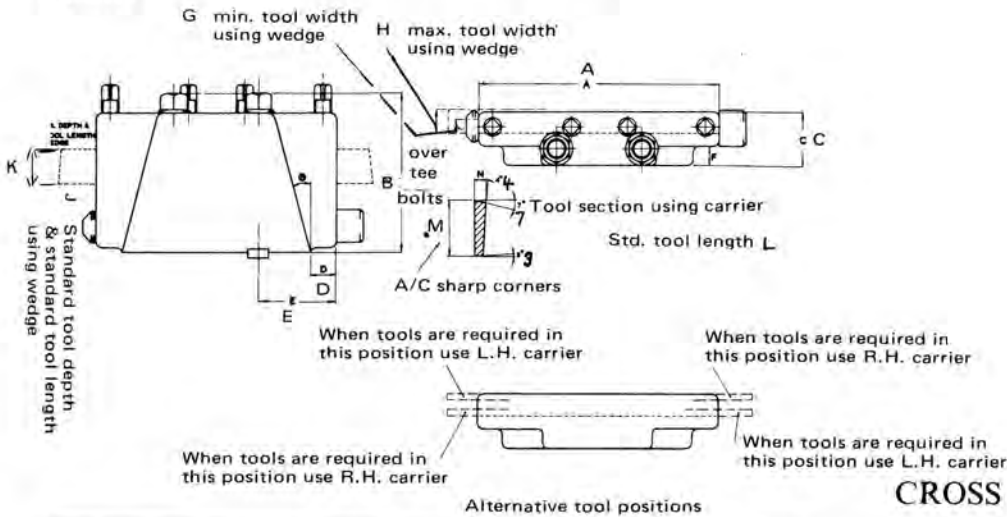
Machine	1"-6 Bar		1 3/8"-5 Bar 5"-5 Chucker		1 3/8", 1 3/4"-6 Bar 5 3/8"-6 Chucker		1 3/8", 2 1/4"-5 Bar 6"-5 Chucker		1 1/2"-8 Bar		2 1/4"-6 Bar 6 1/2"-6 Chucker	
Station	1 & 4		1 & 3		1 & 4		1 & 3		1 & 5		1 & 4	
Drg. No.	W6-1-48		W5-138-48		W5-134-48		W5-134-48		W6-214-48		W6-214-48	
Dims.	Ins.		mm.		Ins.		mm.		Ins.		mm.	
A	6.25	159.0	6.37	162.0	8.12	206.0	8.12	206.0	8.25	209.5	209.5	209.5
B	3.37	85.5	4.25	108.0	4.50	114.5	4.50	114.5	4.50	114.5	114.5	114.5
C	1.44	36.5	1.62	41.5	2.00	51.0	2.00	51.0	2.00	51.0	51.0	51.0
D	1.12	28.5	0.69	17.5	1.06	27.0	1.06	27.0	1.37	35.0	35.0	35.0
E	2.00	51.0	2.06	52.5	2.81	71.5	2.81	71.5	3.25	82.5	82.5	82.5
F	0.56	14.5	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5	12.5	12.5
(θ)	0°		15°		15°		15°		0°		0°	
FLAT TOOL AND WEDGE DETAILS												
G	0.37	9.5	0.37	9.5	0.50	12.5	0.50	12.5	0.50	12.5	12.5	12.5
H	0.62	16.0	0.62	16.0	0.75	19.0	0.75	19.0	0.75	19.0	19.0	19.0
J	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	127.0	127.0
K	0.75	19.0	0.87	22.0	0.87	22.0	0.87	22.0	0.87	22.0	22.0	22.0
Wedge No.	DS.938		D.45934		D.45783		D.45783		D.45783		D.45783	
BLADE TOOLS AND CARRIER DETAILS												
Carrier R.H.	CS.541		S.770		S.475		S.475		S.475		S.475	
Carrier L.H.	CS.539		S.860		S.861		S.861		S.861		S.861	
L	5.00	127.0	4.50	114.5	4.50	114.5	4.50	114.5	4.50	114.5	114.5	114.5
M	0.750	19.05	0.900	22.86	0.900	22.86	0.900	22.86	0.900	22.86	22.86	22.86
N Inches	0.12	0.19	0.25	0.12*	0.19*	0.25*	0.25*	0.25*	0.31*	0.31*	0.27*	0.27*
N mm.	3.0	5.0	6.5	3.0	5.0	6.5	6.5	6.5	8.0	8.0	9.5	9.5
Drg. No.	WSP.423/14	WSP.423/15	WSP.423/16	WSP.423/19	WSP.423/21	WSP.423/23	WSP.423/23	WSP.423/23	WSP.423/25	WSP.423/25	WSP.423/27	WSP.423/27

* Tools are common to the 1 3/8"-5, 1 3/8"-6, 1 3/4"-5, 1 3/4"-8 and 2 1/4"-6 Bar Machines and equivalent Chuckers.

BLADE TOOLHOLDER (REVERSIBLE)

These toolholders accommodating blade type tools are reversible for right- or left-hand use. Adjustment is provided for setting the tool on centre and a back screw absorbs end thrust. Blade tools are ground with clearance on both sides for the full length and require end grinding only.

When Wimet parting tools AP1 and AP2 for the 1"-6 bar machine and tools AP3 and AP4 for the 1 1/8"-5, 1 3/8"-6, 1 3/4"-5 and 2 1/4"-6 bar machines are used the appropriate wedge for the machine will be required.



CROSS SLIDES

Machine	1"-6 Bar		1 1/2"-5 Bar 5"-5 Chucker		1 1/2", 1 3/4"-6 Bar 5 1/2"-6 Chucker		1 1/2", 2 1/4"-5 Bar 6"-5 Chucker		1 1/2"-8 Bar 6 1/2"-6 Chucker	
	2, 3 & 5		2 & 4		2, 3 & 5		2 & 4		2 & 6	
Station	2, 3 & 5		2 & 4		2, 3 & 5		2 & 4		2 & 6	
Dr. No.	W6-1-49		W5-138-49		W5-134-49				W6-214-49	
Dims.	Ins.		mm.		Ins.		mm.		Ins.	
	mm.		Ins.		mm.		Ins.		mm.	
A	6.25	159.0	6.37	162.0	8.00	203.0	8.25	209.5	8.25	209.5
B	4.12	105.0	4.25	108.0	4.75	120.5	5.25	133.5	5.25	133.5
C	1.44	36.5	1.37	35.0	1.62	41.5	1.75	44.5	1.75	44.5
D	1.12	28.5	0.69	17.5	1.00	25.5	1.37	35.0	1.37	35.0
E	2.00	51.0	2.06	52.5	2.75	70.0	3.25	82.5	3.25	82.5
F	0.56	14.5	0.50	12.5	0.50	12.5	0.50	12.5	0.50	12.5
θ	0°		15°		15°		15°		0°	
FLAT TOOL AND WEDGE DETAILS										
G	0.37	9.5	0.37	9.5	0.50	12.5	0.50	12.5	0.50	12.5
H	0.62	16.0	0.62	16.0	0.75	19.0	0.75	19.0	0.75	19.0
J	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0	5.00	127.0
K	0.75	19.0	0.87	22.0	0.87	22.0	0.87	22.0	0.87	22.0
Wedge No.	DS.938		D.45934		D.45783				D.45783	
BLADE TOOL AND CARRIER DETAILS										
Carrier L.H.	CS.545		S.859		S.857		S.857		S.857	
Carrier R.H.	CS.546		S.764		S.858		S.858		S.858	
L	5.00	127.0	4.50	114.5	4.50	114.5	4.50	114.5	4.50	114.5
M	0.750	19.05	0.900	22.86	0.900	22.86	0.900	22.86	0.900	22.86
N Inches	0.12	0.19	0.25	0.12*	0.19*	0.25*	0.31*	0.37*	0.31*	0.37*
N mm.	3.0	5.0	6.5	3.0	5.0	6.5	8.0	9.5	8.0	9.5
Dr. No.	WSP.423/14	WSP.423/15	WSP.423/16	WSP.423/19	WSP.423/21	WSP.423/23	WSP.423/25	WSP.423/27	WSP.423/25	WSP.423/27

* Tools are common to the 1 1/4"-5, 1 1/8"-6, 1 1/2"-5, 1 1/2"-8 and 2 1/4"-6 Bar Machines and equivalent Chuckers.

TOOLHOLDER for WICKMAN AUTOMATICS

BLADE TOOLHOLDER

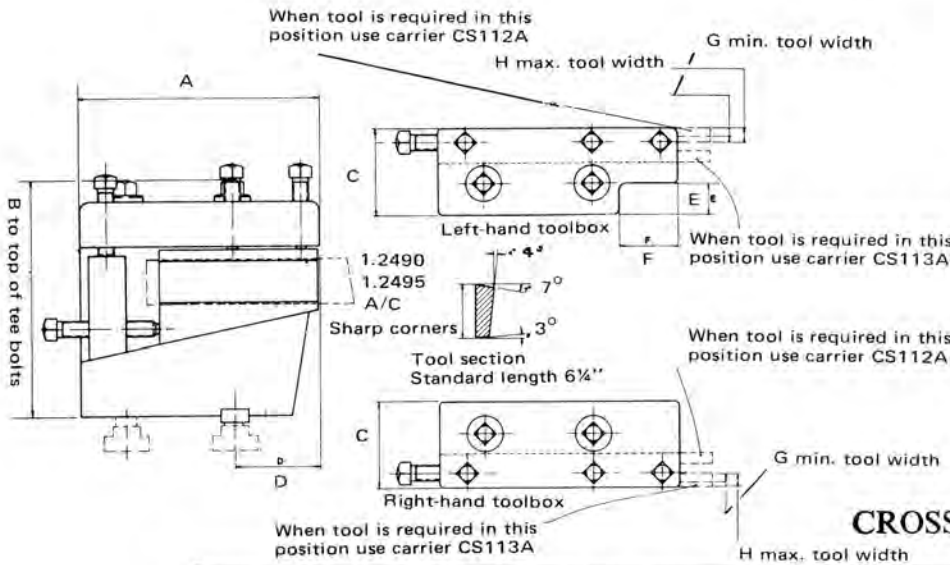
(RIGHT HAND AND LEFT HAND)



These toolholders, which accommodate blade type tools, have adjustment provided for setting the tool on centre and a back screw to absorb end thrust. Blade tools are ground with clearance on both sides for the full length and require end grinding only.

In addition to facing and forming operations this toolholder is also used for parting-off

Right- or left-hand holders can be supplied, state type required when ordering.



CROSS SLIDES

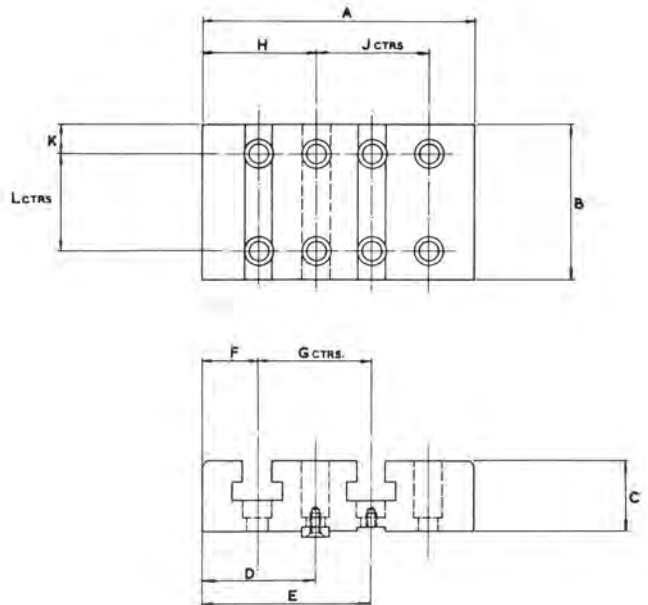
Machine	2 1/2", 3 1/2"—6 Bar 7 1/2"—6 Chucker		3 1/2", 4 1/2"—4 Bar 9"—4 Chucker							
Station	2, 3 & 5		2 & 4							
Drg. No.	Right Hand	W6—258—49R								
	Left Hand	W6—258—49L								
Dims.	Ins.		mm.							
A	6.69		170.0							
B	6.62		168.0							
C	2.37		60.5							
D	2.37		60.5							
E	0.87		22.0							
F	1.62		41.5							
G	0.12		3.0							
H	0.37		9.5							
COMPLETE RANGE OF STANDARD TOOL WIDTHS										
H.S.S. Tool Width	Ins.	0.12	0.16	0.19	0.22	0.25	0.28	0.31	0.34	0.37
	mm.	3.0	4.0	5.0	5.5	6.5	7.0	8.0	8.5	9.5
Drg. No.	Ins.	WSP.423/5	WSP.423/6	WSP.423/7	WSP.423/8	WSP.423/9	WSP.423/10	WSP.423/11	WSP.423/12	WSP.423/13
	mm.									
Wimet Tool Width	Ins.	0.16				0.19				
	mm.	4.0				5.0				
Drg. No.	AB.7				AB.8					

NOTE: When this toolholder is used on 9" 4-Chucker, Riser Plate W4—9—84 will be required.

RISER PLATES

(WIDE AND NARROW TYPE)

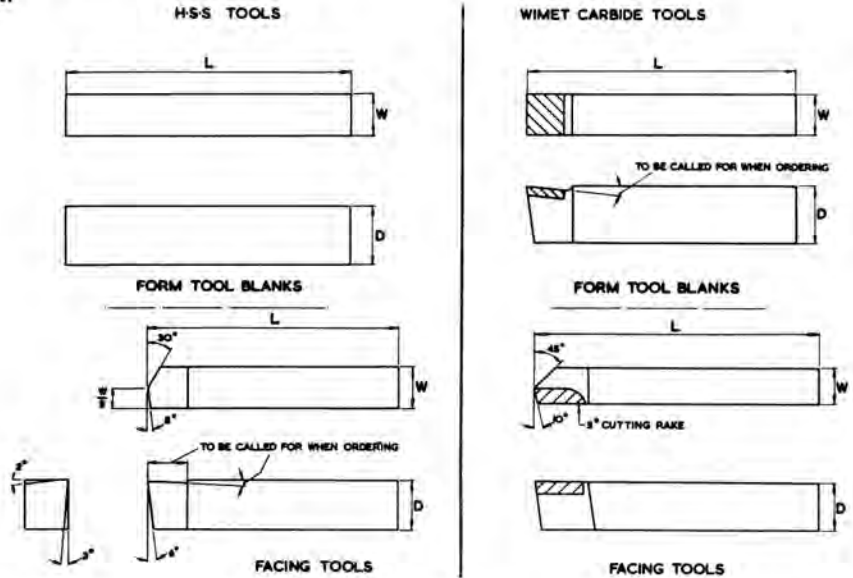
These plates are used in all stations to raise standard $2\frac{5}{8}$ "-6 bar machine cross slide toolholders to the centre height required on 9"-4 chucking machine.



Machine	9"-4 Chucker			
Station	All			
Type	Wide		Narrow	
Drg. No.	W4-9-85		W4-9-84	
Dims.	Ins.	mm.	Ins.	mm.
A	7.25	184.0	7.25	184.0
B	7.75	197.0	4.00	101.5
C	1.906	48.42	1.906	48.42
D	3.00	76.0	3.00	76.0
E	4.50	114.5	4.50	114.5
F	1.50	38.0	1.50	38.0
G	3.00	76.0	3.00	76.0
H	3.00	76.0	3.00	76.0
J	3.00	76.00	3.00	76.0
K	1.50	38.0	0.75	19.0
L	4.75	120.5	2.50	63.5

TOOL BLANKS AND FACING TOOLS

Flat tool blanks and facing tools to the following sizes, and suitable for various flat toolholders can be supplied from stock upon request.



Machine	FORM TOOL BLANKS — H.S.S.							FORM TOOL BLANKS — 'WIMET'								
	Tool Dimensions						Tool No.	Used in Holder No.	Tool Dimensions						Tool No.	Used in Holder No.
	D		W		L				D		W		L			
Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
1"—6 Bar	0.75	19.0	0.75	19.0	5.00	127.0	—	38, 39	0.75	19.0	0.50	12.5	4.75	120.5	AR.1	38, 39
1½"—5 Bar 5"—5 Chucker	0.87	22.0	0.75	19.0	5.00	127.0	—	38, 39	0.87	22.0	0.75	19.0	5.00	127.0	AR.3	38, 39
1½", 1½"—6 Bar* 5½"—6 Chucker*	0.87	22.0	1.00	25.5	5.00	127.0	—	38, 39	0.87	22.0	1.00	25.5	5.00	127.0	AR.4	38, 39
1½", 2½"—5 Bar* 6"—5 Chucker*																
1½"—8 Bar* 2½"—6 Bar* 6½"—6 Chucker*																
2½", 3½"—6 Bar 7½"—6 Chucker	1.25	32.0	1.25	32.0	5.62	143.0	—	38, 39	1.25	32.0	1.25	32.0	5.50	139.5	AR.6	38, 39
3½", 4½"—4 Bar 9"—4 Chucker	1.25	32.0	0.75	19.0	5.62	143.0	—	70, 71	1.25	32.0	0.75	19.0	5.50	139.5	AR.5	70, 71
FACING TOOLS — H.S.S.							FACING TOOLS — WIMET									
1"—6 Bar	0.75	19.0	0.75	19.0	5.00	127.0	WSP.439/4	38, 39	0.75	19.0	0.50	12.5	4.75	120.5	AF.1	48, 49
1½"—5 Bar	0.87	22.0	0.75	19.0	5.00	127.0	WSP.439/1	38, 39	0.87	22.0	0.52	16.0	5.00	127.0	AF.2	38, 39 48, 49
5"—5 Chucker	0.87	22.0	0.75	19.0	5.00	127.0	WSP.439/1	38, 39	0.87	22.0	1.0	25.5	5.00	127.0	AF.5	38, 39
1½", 1½"—6 Bar* 1½", 2½"—5 Bar* 1½"—8 Bar* 2½"—6 Bar*	0.87	22.0	1.00	25.5	5.00	127.0	WSP.439/2	38, 39	0.87	22.0	0.62	16.0	5.00	127.0	AF.2	48, 49
5½"—6 Chucker* 6"—5 Chucker* 6½"—6 Chucker*	0.87	22.0	1.00	25.5	5.00	127.0	WSP.439/2	38, 39	0.87	22.0	1.00	25.5	5.00	127.0	AF.5	38, 39
2½", 3½"—6 Bar 7½"—6 Chucker	1.25	32.0	1.25	32.0	5.50	139.5	WSP.439/3	38, 39	1.25	32.0	1.25	32.0	5.50	139.5	AF.6	38, 39
3½", 4½"—4 Bar 9"—4 Chucker	1.25	32.0	0.75	19.0	5.50	139.5	WSP.439/5	70, 71	1.25	32.0	0.75	19.0	5.50	139.5	AF.3	70, 71

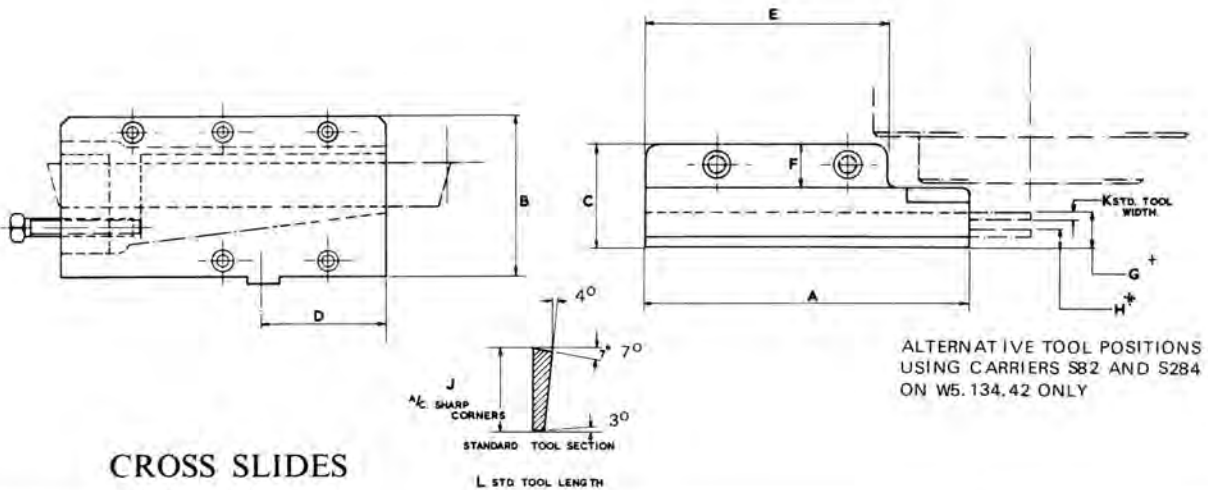
* Tool sizes for No. 38N and 39N type holders on these machines and equivalent chuckers are 1.00" x 1.00" x 5.00". Dimensions given in table are for No. 38 and 39 type holders.

PART-OFF TOOLHOLDER



The part-off tool is ground with clearance on both sides for its full length and requires end grinding only. The blade is usually carried in an adjustable holder but this can be replaced by a solid tool supported by a wedge. The solid tool is used for cut-off and chamfering small diameter work.

For parting off on the 2 $\frac{3}{8}$ " 3 $\frac{1}{4}$ "-6 and 3 $\frac{1}{2}$ " 4 $\frac{1}{8}$ "-4 bar machines use blade toolholders listed on pages 78 and 79



CROSS SLIDES

Machine	1"-6 Bar		1 $\frac{3}{8}$ "-5 Bar 1 $\frac{1}{2}$ "-5 Bar		1 $\frac{3}{8}$ ", 1 $\frac{1}{2}$ "-6 Bar		2 $\frac{1}{4}$ "-6 Bar	
	Station		Station		Station		Station	
Drq. No.	W6-1-42		W5-134-42		W6-138-42		W6-214-42	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
	A	5.62	143.0	5.56	141.0	6.37	162.0	7.37
B	2.94	74.5	3.31	84.0	3.37	85.5	3.62	92.0
C	1.81	46.0	2.56	65.0	2.00	51.0	2.06	52.5
D	2.12	54.0	2.31	58.5	2.62	66.5	3.50	89.0
E	4.19	106.5	4.37	111.0	4.50	114.0	5.50	139.5
F	0.75	19.0	1.56	39.5	0.87	22.0	1.19	30.0
G	0.75	19.0	0.69 [†]	17.5	0.75	19.0	0.62	16.0
H	0.31	8.0	0.41 [*]	10.5	0.41	10.5	0.34	8.5
J	0.750	19.05	0.900	22.86	0.900	22.86	0.900	22.86
K	0.12	3.0	0.16	4.0	0.16	4.0	0.16	4.0
L	7.00	177.8	7.00	177.8	7.00	177.8	7.00	177.8
Tool No. H.S.S.	WSP.423/17		WSP.423/18		WSP.423/18		WSP.423/18	
Carrier No.	CS.534		—		CS.618		DS.789	
Tool No. Wimet	AB.2		—		AB.6		—	

* This figure is obtained by using right hand carrier S.82.

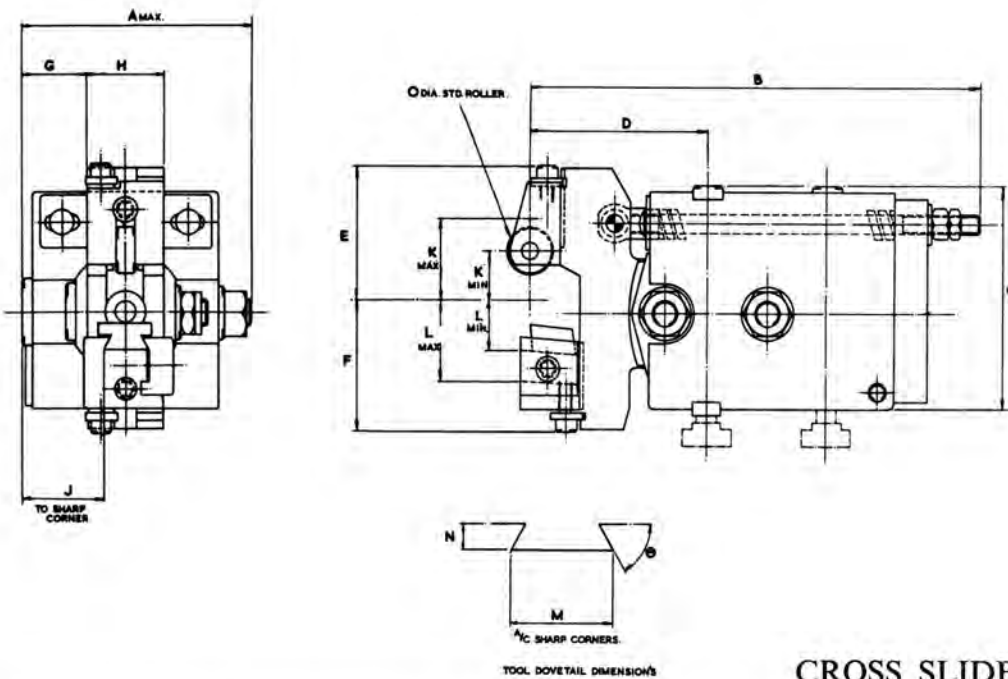
† This figure is obtained by using left hand carrier S.284.

Both right and left hand carriers can be replaced by a rectangular tool .44" wide x .937" deep x 5" long supported on a special wedge, S.851 on W5.134.42 only

SHAVING TOOLHOLDER

A shaving operation is used to maintain a close tolerance on a diameter.

A standard roller and tool assembly is supplied.



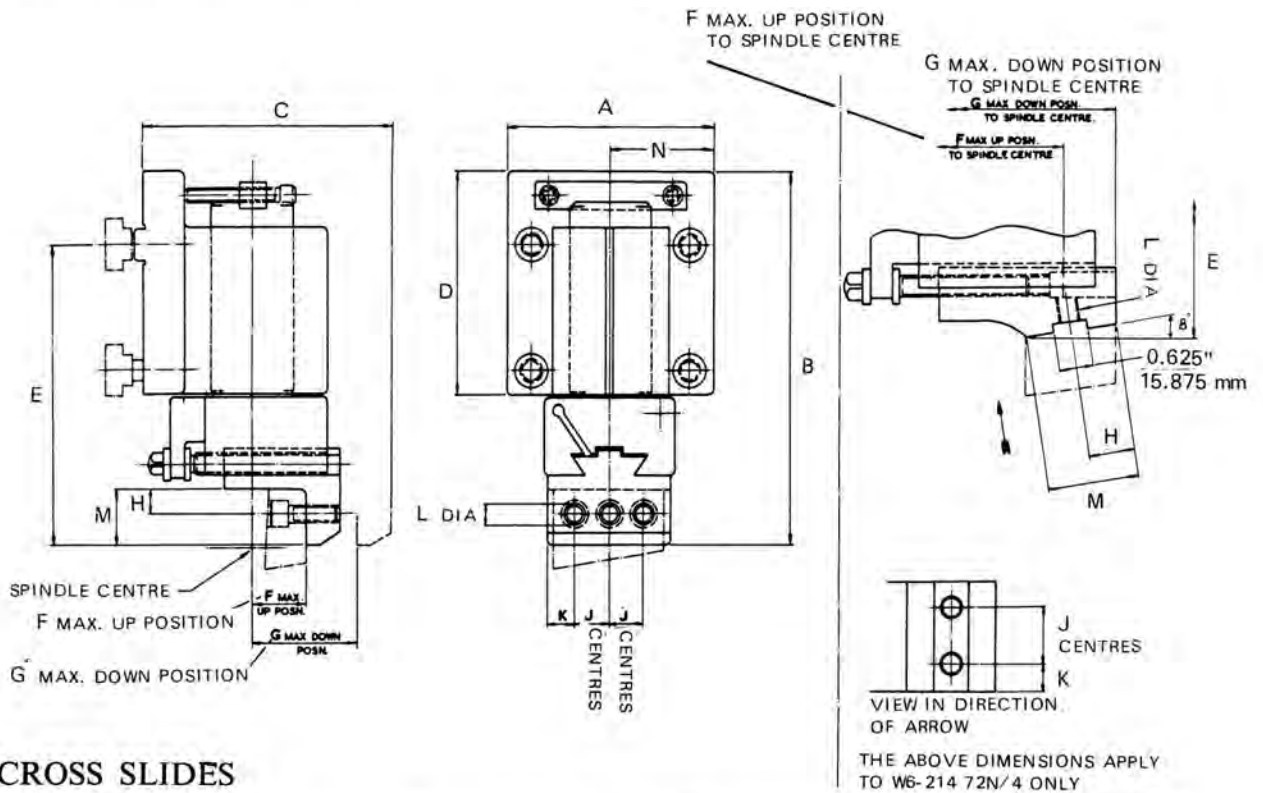
CROSS SLIDES

Machine	1"—6 Bar		1½", 1½"—6 Bar		1½", 2½"—5 Bar		1½"—8 Bar 2½"—6 Bar		2½", 3½"—6 Bar 3½", 4½"—4 Bar		
	4 & 5		4 & 5		3 & 4		5 & 6 1½"—8 Bar 4 & 5 2½"—6 Bar		5 & 4 2½"—6 Bar 3 3½"—4 Bar		
Org. No.	W6—1—73N		W6—138—73N		W5—134—73N		W6—214—73N		W6—258—73N		
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
A B C D E F G H J	4-31	109.5	4-69	119.0	4-69	119.0	4-75	120.5	5-00	127.0	
	8-50	216.0	10-19	258.5	10-19	258.5	11-56	293.5	11-62	295.5	
	4-12	104.5	4-37	111.0	4-37	111.0	5-06	128.5	6-25	158.5	
	3-37	85.5	4-75	120.5	4-75	120.5	5-62	143.0	4-94	125.5	
	2-50	63.5	2-69	68.5	2-69	68.5	3-69	93.5	3-50	89.0	
	2-44	62.0	3-12	79.5	3-12	79.5	3-44	87.5	3-50	89.0	
	1-22	31.0	1-37	35.0	0-56	14.0	1-37	35.0	0-69	17.5	
	1-44	36.5	1-44	36.5	2-00	51.0	1-44	36.5	2-12	54.0	
	1-53	39.0	1-66	42.0	0-91	23.0	1-59	40.5	1-12	28.5	
	K	Max.	0-94	24.0	1-25	31.5	1-25	31.5	1-81	46.0	2-00
Min.		0-37	9.5	0-37	9.5	0-37	9.5	0-56	14.5	0-56	14.5
L	Max.	1-06	27.0	1-69	43.0	1-69	43.0	2-06	52.5	2-25	57.0
	Min.	0-50	12.5	0-81	20.5	0-81	20.5	0-69	17.5	0-87	22.0
M N O	0-913	23.19	0-913	23.19	0-913	23.19	0-913	23.19	1-289	32.74	
	0-28	7.0	0-28	7.0	0-28	7.0	0-28	7.0	0-28	7.0	
	0-87	22.0	1-00	25.5	1-00	25.5	1-12	28.5	1-12	28.5	
θ	60°		60°		60°		60°		60°		

SKIING TOOLHOLDER



The skiing operation is used to produce a good finish on a diameter, where finish is more important than size.

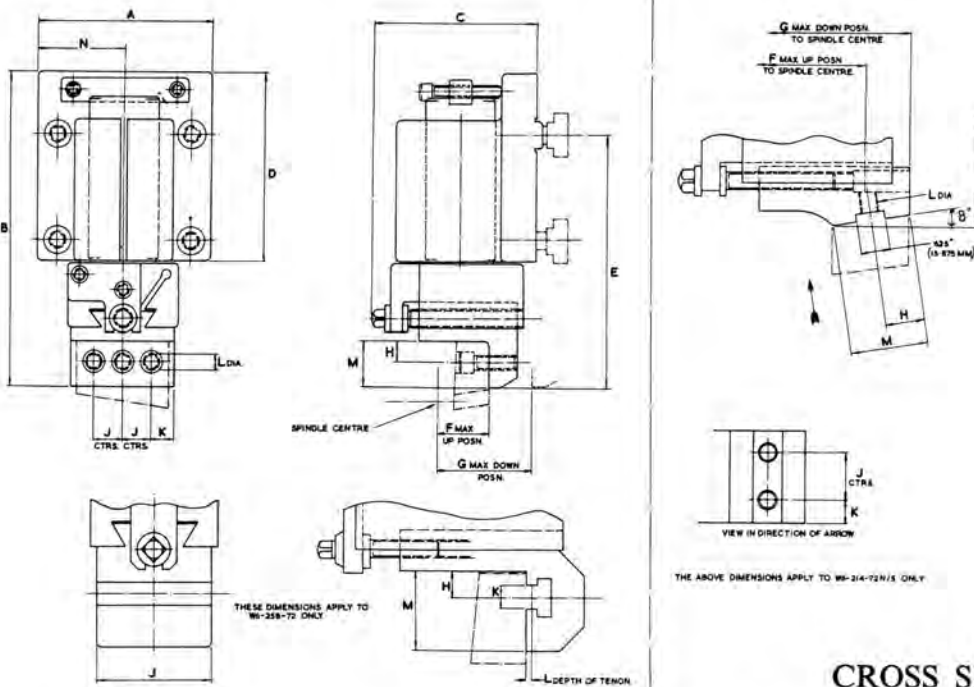


CROSS SLIDES

Machine	1"—6 Bar		1½", 1¾"—6 Bar		1¾", 2¼"—5 Bar		2¼"—6 Bar	
Station	4		4		3		4	
Dr. No.	W6—1—72/4		W5—134—72/3				W6—214—72N/4	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	3.75	95.0	3.50	89.0	—	—	4.62	117.5
B	6.75	171.5	8.00	203.0	—	—	8.00	203.0
C	3.87	98.5	5.56	141.5	—	—	—	—
D	4.00	101.5	4.75	120.5	—	—	5.50	139.5
E	5.44	138.0	6.69	170.0	—	—	6.37	162.0
F	0.75	19.0	1.00	25.5	—	—	1.94	49.0
G	1.25	31.5	1.75	44.5	—	—	2.87	73.0
H	0.44	11.0	0.31	8.0	—	—	0.81	20.5
J	0.625	15.87	0.687	17.46	—	—	1.250	31.75
K	0.50	12.5	0.50	12.5	—	—	0.62	16.0
L	⅜" BSF	—	⅜" BSF	—	—	—	⅜" BSF	—
M	1.00	25.5	0.87	22.0	—	—	1.62	41.5
N	1.87	47.5	1.56	39.5	—	—	2.31	58.5

SKIVING TOOLHOLDER

Used for obtaining a good finish, where finish is more important than size.



CROSS SLIDES

Machine	1"—6 Bar		1 3/8", 1 1/2"—6 Bar		1 3/4", 2 1/4"—5 Bar		2 1/4"—6 Bar		2 3/8", 3 1/4"—6 Bar	
Station	5		5	4		5		4 & 5		
Drg. No.	W6—1—72/5		W5—134—72/4				W6—214—72/5		W6—258—72	
Dims.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.
A	3.75	95.0	3.56	90.5	4.62	117.5	6.25	158.5		
B	6.65	169.0	6.72	170.5	7.94	201.5	9.31	236.5		
C	3.50	89.0	3.69	93.5	4.62	117.5	5.60	142.0		
D	4.00	101.5	4.00	101.5	5.50	139.5	5.69	144.5		
E	5.34	135.5	6.22	158	6.31	160.5	4.44	112.5		
F	0.75	19.0	0.75	19.0	2.12	54.0	1.69	43.0		
G	1.25	31.5	1.75	31.5	2.87	73.0	2.31	58.5		
H	0.44	11.0	0.31	8.0	0.81	20.5	0.53	13.5		
J	0.625	15.87	0.687	17.46	1.250	31.75	2.50	63.5		
K	0.50	12.5	0.50	12.5	0.62	16.0	0.500	12.70		
L	5/16" BSF	—	5/16" BSF	—	3/8" BSF	—	0.09	2.5		
M	1.00	25.5	0.87	22.0	1.62	41.5	1.69	43.0		
N	1.87	47.5	1.56	39.5	2.31	58.5	3.12	79.5		



SECTION 3

COLLETS • FEED FINGERS • CHUCKS

COLLETS AND FEED FINGERS for WICKMAN BAR AUTOMATICS



The collets illustrated, for the Bar Automatics, are as follows :—

The Solid Spring Collet (A) and Solid Spring Feed Finger (B) are for use in the manufacture of large batches of components from the same size stock.

The Master Collet (E) and Master Feed Finger (C), with their changeable pads (F) and (D), are especially useful in the production of small quantities of components from different sizes of stock.

The Master Collet and Master Feed Finger can also be used on long runs if required. The pads are easily changed without removing the collet from the machine.

REFERENCE CHART · COLLET EQUIPMENT

Part Name	1" — 6 Machine					1 3/8" — 5 & 1 1/2" — 6 Machines					1 3/4" — 5 & 1 3/4" — 6 Machines					
	Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			
			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F	
Solid Spring Collet	CS.147A	6	1-00	0-86	0-70	B.1674	5	1-37	1-19	0-94	B.1671	5	1-75	1-50	1-19	Ins.
			25-5	22-0	18-0		6	35-0	30-0	24-0		6	44-5	38-0	30-0	mm.
Solid Finger Finger	CS.148B	6	1-00	0-86	0-70	C.3090D	5	1-37	1-19	0-94	C.3061	5	1-75	1-50	1-19	Ins.
			25-5	22-0	18-0		6	35-0	30-0	24-0		6	44-5	38-0	30-0	mm.
Master Collet	CS.149A	6	—	—	—	B.3128	5	—	—	—	B.3124	5	—	—	—	
			6	—	—		—	6	—	—		—	6	—	—	—
Master Collet Pads	SFX.904	6 x 3	0-87	0-75	0-62	C.6227	5 x 3	1-31	1-12	0-90	C.6228	5 x 3	1-62	1-40	1-16	Ins.
			22-0	19-0	16-0		6 x 3	33-5	28-5	23-0		6 x 3	41-0	35-5	29-5	mm.
Collet Pad Fixing Screw	SFX.907	6 x 3	—	—	—	D.20389	5 x 3	—	—	—	D.20390	5 x 3	—	—	—	
			6 x 3	—	—		—	6 x 3	—	—		—	6 x 3	—	—	—
Master Feed Finger	CS.150A	6	—	—	—	B.31293	5	—	—	—	B.3125	5	—	—	—	
			6	—	—		—	6	—	—		—	6	—	—	—
Master Feed Finger Pads	CS.631	6 x 2	0-69	0-62	0-59	C.6226	5 x 2	1-12	0-94	0-75	C.6229A	5 x 3	1-37	1-19	0-97	Ins.
			17-5	15-5	15-0		6 x 2	28-5	24-0	19-0		6 x 3	35-0	30-0	24-5	mm.
Feed Finger Pad Fixing Screw			—	—	—		5 x 3	—	—	—	DS.1335	5 x 3	—	—	—	
			6 x 3	—	—		—	6 x 3	—	—		—	6 x 3	—	—	—
Stock Tube Steady Bush, Steel or 'Tufnol'	† SL	—	—	—	—	D.11209	5	—	—	—	D.11176A	5	—	—	—	
			6	—	—		—	6	—	—		—	6	—	—	—
Feed Tube Steady Bush	DS.252A	6	—	—	—	D.11209A	5	—	—	—	D.11177A	5	—	—	—	
			6	—	—		—	6	—	—		—	6	—	—	—
High Speed Drilling Collet	190.Y.105	1	0-44	—	—	S.248A	1	0-56	—	—	S.248A	1	0-56	—	—	Ins.
			11-0	—	—		14-0	—	—	14-0		—	—	—	—	mm.
Pick-Up Attach. Collet	C.18547C*	1	0-75	—	—	B.8164F‡	1	1-31	—	—	B.8164F‡	1	1-31	—	—	Ins.
			19-0	—	—		33-5	—	—	33-5		—	—	33-5	—	—

* On dias. above 0-75" up to and including 0-94" depth of insertion of component in collet is limited to 0-75".

† SL — Spring Lined Tubes. Bushes not required.

‡ Pick-Up Attachment is fitted to the 6-Sp. machines only.

On dias. above 1-31" up to and including 1-75" depth of insertion of component in collet is limited to 1-12".

Hex. and Square bore pick-up collets can be supplied to special order.

REFERENCE CHART • COLLET EQUIPMENT

Part Name	1½" — 8 Machine					2" — 6 Machine					
	Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			
			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F	
Solid Spring Collet	B.1671	8	1.75	1.50	1.25	CS.575	6	2.00	1.69	1.37	Ins.
			44.5	38.0	31.5			50.5	42.5	35.0	mm.
Solid Feed Finger	C.3061	8	1.75	1.50	1.25	CS.576	6	2.00	1.69	1.37	Ins.
			44.5	38.0	31.5			50.5	42.5	35.0	mm.
Master Collet	B.3124	8	—	—	—	CS.577	6	—	—	—	
Master Collet Pad	C.6228	8 x 3	1.62	1.40	1.16	CS.578	6 x 3	2.00	1.72	1.40	Ins.
			41.0	35.5	29.5			50.5	43.5	35.5	mm.
Collet Pad Fixing Screw	D.20390	8 x 3	—	—	—	DS.773	6 x 3	—	—	—	
Master Feed Finger	B.3125	8	—	—	—	CS.579	6	—	—	—	
Master Feed Finger Pads	C.6229	8 x 3	1.37	1.19	0.97	CS.580	6 x 3	1.62	1.40	1.14	Ins.
			35.0	30.0	24.5			41.0	35.5	29.0	mm.
Feed Finger Pad Fixing Screw	D.20393	8 x 3	—	—	—	BS.147/1/22	6 x 3	—	—	—	
Stock Tube Steady Bush	D.11176A	8	—	—	—	—	—	—	—	—	
Feed Tube Steady Bush	D.11177A	8	—	—	—	DS.772A	6	—	—	—	
High Speed Drilling Collet	S.248A	1	0.56	—	—	S.248A	1	0.56	—	—	Ins.
			14.0	—	—			14.0	—	—	mm.
Pick-Up Attach. Collet	—	—	—	—	—	B.8784A	1	1.56*	—	—	Ins.
			—	—	—			39.5	—	—	mm.

90 * On dias. above 1.56" up to and including 2.25" dia. depth of insertion of component in collet is limited to 1.31" max. Hex. and Square bore pick-up collets can be supplied to special order.

REFERENCE CHART · COLLET EQUIPMENT

Part Name	2 $\frac{1}{4}$ "—6 Machine					2 $\frac{1}{2}$ "—5 Machine					2 $\frac{5}{8}$ "—6 Machine					
	Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			
			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F	
Solid Spring Collet	BS.615	6	2-25	1-94	1-56	B.1706C	5	2-25	1-94	1-56	BS.106A	6	2-62	2-26	1-86	Ins.
			57-0	49-0	39-5			57-0	49-0	39-5			66-5	57-5	47-5	mm.
Solid Feed Finger	BS.616	6	2-25	1-94	1-56	BS.573	5	2-25	1-94	1-56	BS.108	6	2-62	2-26	1-86	Ins.
			57-0	49-0	39-5			57-0	49-0	39-5			66-5	57-5	47-5	mm.
Master Collet	BS.611	6	—	—	—	B.3120	5	—	—	—	BS.107	6	—	—	—	
Master Collet Pads	CS.578	6 x 3	2-00	1-72	1-40	C.6224	5 x 3	2-25	1-94	1-56	CS.101	6 x 4	2-62	2-25	1-84	Ins.
			50-5	43-5	35-5			57-0	49-0	39-5			66-5	57-0	46-5	mm.
Collet Pad Fixing Screw	DS.773	6 x 3	—	—	—	D.20391	5 x 3	—	—	—	DS.128	6 x 4	—	—	—	
Master Feed Finger	BS.612	6	—	—	—	BS.574	5	—	—	—	BS.109	6	—	—	—	
Master Feed Finger Pads	BS.617	6 x 3	1-87	1-62	1-31	C.6225	5 x 3	2-00	1-72	1-40	CS.102A	6 x 3	2-25	1-94	1-59	Ins.
			47-5	41-0	33-0			50-5	43-5	35-5			57-0	49-0	40-5	mm.
Feed Finger Pad Fixing Screws	BS.147/1/22	6 x 3	—	—	—	D.20392A	5 x 3	—	—	—	BS.147/1/6	6 x 3	—	—	—	
Stock Tube Steady Bush	SL	—	—	—	—	D.11340A	5	—	—	—	To order	—	—	—	—	
Feed Tube Steady Bush	DS.772A	6	—	—	—	D.11341A	5	—	—	—	DS.129	6	—	—	—	
High Speed Drilling Collet	S.248A	1	0-56	—	—	S.248A	1	0-56	—	—	590.Y.140	1	0-75	—	—	Ins.
			14-0	—	—			14-0	—	—			19-0	—	—	mm.
Pick-Up Attachmt. Collet	B.8784A	1	1-56 [†]	—	—	—	—	—	—	—	—	—	—	—	—	Ins.
			39-5	—	—	—	—	—	—	—	—	—	—	—	—	mm.

[†] On dia. above 1-56" up to and including 2-25" dia. depth of insertion of component in collet is limited to 1-31" maximum.

Hex. and square bore pick-up collets can be supplied to special order.

† SL. Spring Lined Tubes. Bushes not required.

REFERENCE CHART · COLLET EQUIPMENT

Part Name	3¼" — 6 Machine					3½" — 4 Machine					4½" — 4 Machine					
	Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			Drg. No.	Qty per Set	Capacity			
			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F			Rd.	Hex. A/F	Sq. A/F	
Solid Spring Collet	BS.645	6	3-25	2-81	2-31	BS.117	4	3-50	3-00	2-48	BS.651	4	4-12	3-56	2-92	Ins.
			82-5	71-5	58-5			89-0	76-0	63-0			105-0	90-5	74-0	mm.
Solid Feed Finger	BS.646A	6	3-12	2-75	2-25	BS.120	4	3-28	2-87	2-34	BS.652	4	3-94	3-40	2-78	Ins.
			79-5	70-0	57-0			83-5	73-0	59-5			100-0	86-5	70-5	mm.
	BS.659	6	3-25	2-81	2-31	If maximum capacity is required use BS.119					BS.662	4	4-12	3-56	2-92	Ins.
			82-5	71-5	58-5								105-0	90-5	74-0	mm.
Master Collet	BS.647	6	—	—	—	BS.118A	4	—	—	—	BS.653	4	—	—	—	
Master Collet Pads	BS.648	6 x 3	2-87	2-50	2-03	CS.107	4 x 3	3-12	2-69	2-22	BS.654	4 x 3	3-87	3-37	2-75	Ins.
			73-0	63-5	51-5			79-5	68-0	56-5			98-5	85-5	70-0	mm.
Collet Pad Fixing Screw	BS.147/9	6 x 3	—	—	—	BS.147/10	4 x 3	—	—	—	BS.147/9	4 x 3	—	—	—	
Master Feed Finger	BS.649	6	—	—	—	BS.121	4	—	—	—	BS.655	4	—	—	—	
Master Feed Finger Pads	BS.650	6 x 3	2-87	2-50	2-03	CS.108A	4 x 3	3-12	2-69	2-22	BS.656	4 x 3	3-69	3-19	2-62	Ins.
			73-0	63-5	51-5			79-5	68-0	56-5			93-5	81-0	66-5	mm.
Feed Finger Pad Fixing Screw	BS.147/1/6	6 x 3	—	—	—	BS.147/1/6	4 x 3	—	—	—	BS.147/1/23	4 x 3	—	—	—	
Stock Tube Steady Bush						To order										
Feed Tube Steady Bush	DS.1043	6	—	—	—	DS.183	—	—	—	—	DS.1044	—	—	—	—	
High Speed Drilling Collet	590.Y.140	1	0-75	—	—	590.Y.140	1	0-75	—	—	590.Y.140	1	0-75	—	—	Ins.
			19-0	—	—			19-0	—	—			19-0	—	—	mm.

CHUCKS *for* WICKMAN AUTOMATICS

There are two types of chuck jaws, one hardened and serrated and the other soft for machining out to any desired dimension. It is advisable to use hard jaws when holding on the rough surface of castings or stampings and to have sharp points to the tops of the serrations which will bite into the rough component and ensure a reliable drive. The gripping surface should not be wide as there may then be a tendency to grip only on two jaws.

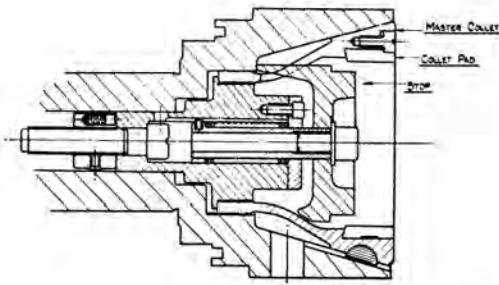
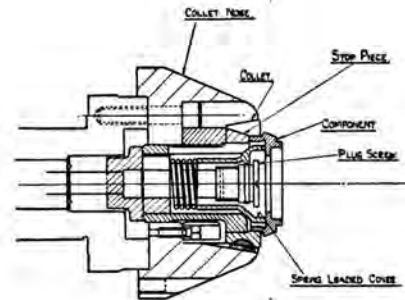
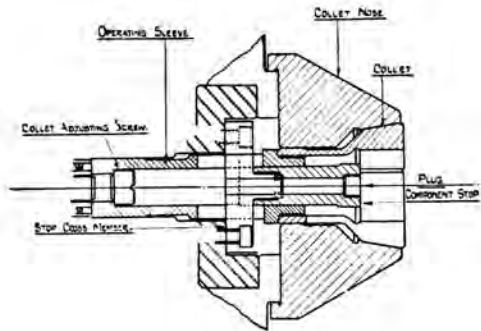
Soft jaws are most commonly used for second operation work. They are clamped exactly as the hardened type and are mainly bored out in position. The grip and drive from this type of jaw comes from its wide surface, as in most cases no serrations are permissible. The concentricity of the jaws to the chuck and the base jaw should be checked constantly when work with close limits is being machined.



When these jaws are changed they should be marked in their order in relation to the bottom jaws, and the spindle number should be indicated. Where this has been done, the jaws only need to be skimmed out very slightly to true them up when they are to be used again. Where large quantities of components are to be made, the soft jaws are sometimes hardened after truing and ground out after hardening. This is done by using a narrow torque ring at the back of the jaws, and locking the jaws.

When chucking thin or fragile section parts, use chuck jaws with wide gripping faces to spread the weight of the grip, or where possible arrange two-jaw chucks to grip across a more substantial cross section of the component.

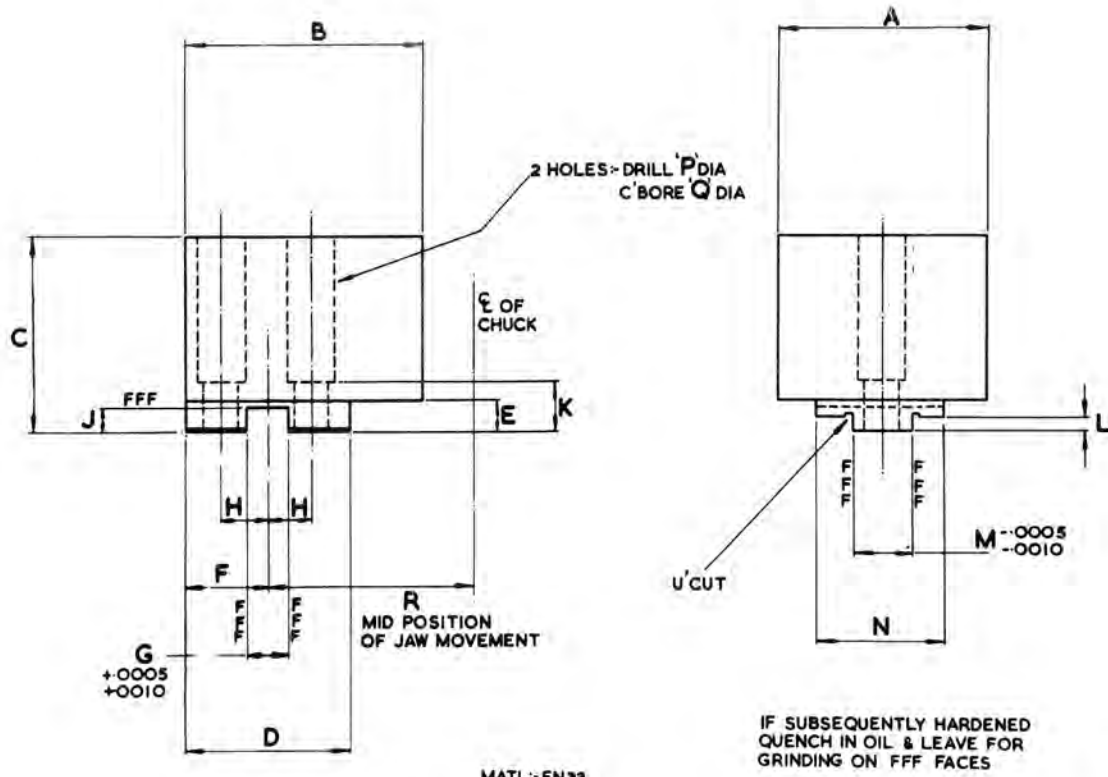
COLLETS for use on WICKMAN CHUCKING AUTOMATICS



It is often convenient on the Chucking Machine to use the collet principle of holding the component and to operate it by means of the draw-bar. Some typical examples of design are given above.

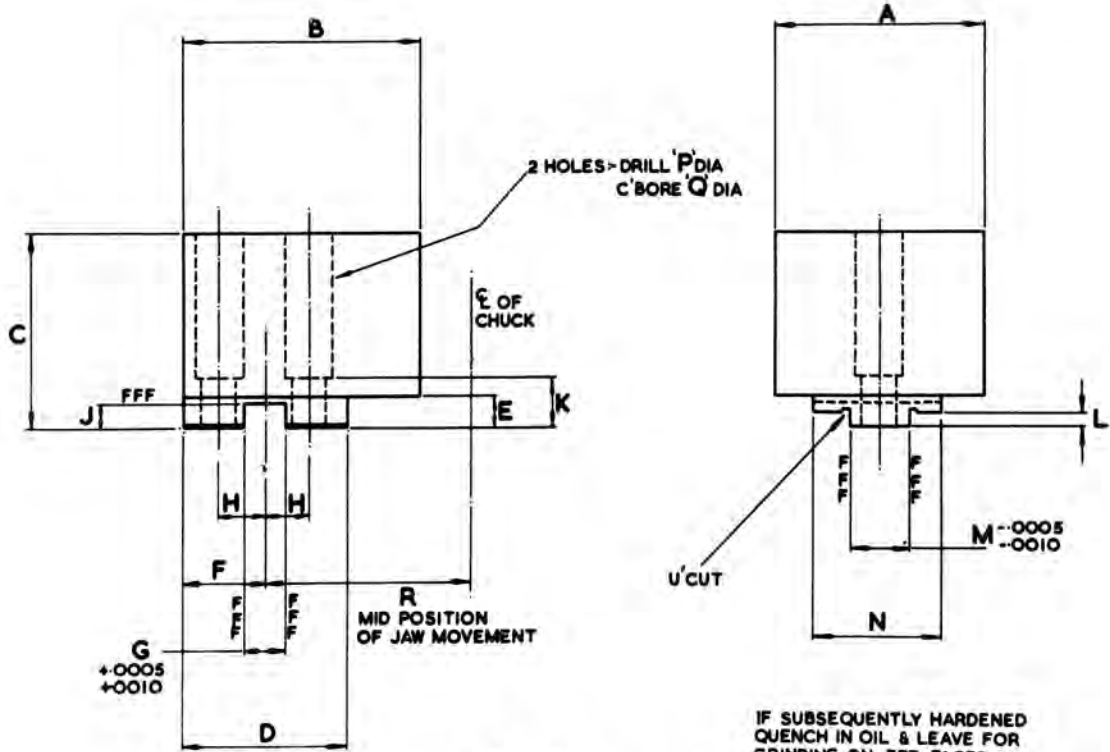
As a rule these collets are designed for a particular component, but by the use of master collets and pads they can be made to accommodate a range of sizes.

CHUCK JAW BLANKS



Machine	5"-5	5"-5	6"-5	6"-5	7 1/2"-6	7 1/2"-6	9"-4	6 1/2"-6	6 1/2"-6	5 1/2"-6	5 1/2"-6	
W.S.P. No.	440/1A	440/2	440/3A	440/4	440/5	440/6	440/7	440/3A	440/4	440/1A	440/2	
Replaces Original Drg.	C.5862A Ref. 1	C.5862A Ref. 2	C.5863A Ref. 1	C.5863A Ref. 2	C.16803 Ref. 1	C.16803 Ref. 2	C.16804 Ref. 1	C.5863A Ref. 1	C.5863A Ref. 2	C.5862A Ref. 1	C.5862A Ref. 2	
A	Ins.	1.37	2.00	1.37	2.00	2.25	3.50	3.50	1.37	2.00	1.37	2.00
	mm.	35.0	50.5	35.0	50.5	57.0	89.0	89.0	35.0	50.5	35.0	50.5
B	Ins.	2.69	2.44	2.94	2.62	3.00	2.50	3.50	2.94	2.62	2.69	2.44
	mm.	68.0	62.0	74.5	66.5	76.00	63.50	89.0	74.5	66.5	68.0	62.0
C	Ins.	2.25	2.25	2.25	2.25	3.00	3.50	3.50	2.25	2.25	2.25	2.25
	mm.	57.0	57.0	57.0	57.0	76.0	89.0	89.0	57.0	57.0	57.0	57.0
D	Ins.	1.50	1.50	1.69	1.69	2.19	2.19	2.69	1.69	1.69	1.50	1.50
	mm.	38.0	38.0	43.0	43.0	55.5	55.5	68.0	43.0	43.0	38.0	38.0
E	Ins.	0.25	0.25	0.28	0.28	0.31	0.31	0.31	0.28	0.28	0.25	0.25
	mm.	6.5	6.5	7.0	7.0	8.0	8.0	8.0	7.0	7.0	6.5	6.5
F	Ins.	0.75	0.75	0.84	0.84	1.16	1.16	1.44	0.84	0.84	0.75	0.75
	mm.	19.0	19.0	21.5	21.5	29.5	29.5	36.5	21.5	21.5	19.0	19.0
G	Ins.	0.3937	0.3937	0.4724	0.4724	0.5000	0.5000	0.5000	0.4724	0.4724	0.3937	0.3937
	mm.	10.00	10.00	12.00	12.00	12.70	12.70	12.70	12.00	12.00	10.00	10.00
H	Ins.	0.406	0.406	0.472	0.472	0.562	0.562	0.812	0.472	0.472	0.406	0.406
	mm.	10.32	10.32	12.00	12.00	14.29	14.29	20.64	12.00	12.00	10.32	10.32

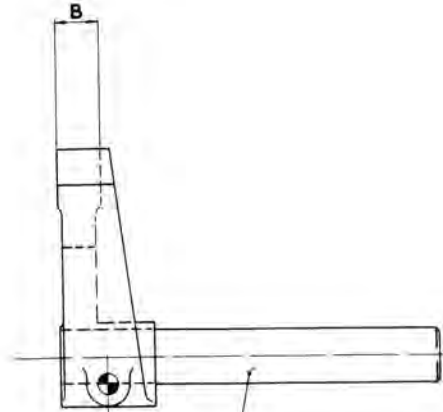
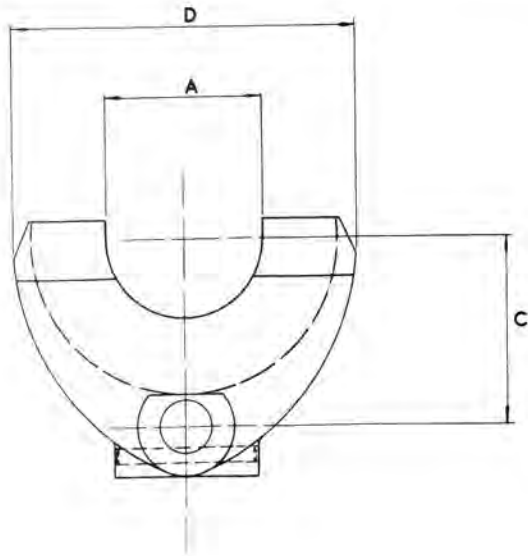
CHUCK JAW BLANKS



MATL:-EN33

Machine	5"-5	5"-5	6"-5	6"-5	7½"-6	7½"-6	9"-4	6½"-6	6½"-6	5½"-6	5½"-6
W.S.P. No.	440/1A	440/2	440/3A	440/4	440/5	440/6	440/7	440/3A	440/4	440/1A	440/2
Replaces Original Drg.	C.5862A Ref. 1	C.5862A Ref. 2	C.5863A Ref. 1	C.5863A Ref. 2	C.16803 Ref. 1	C.16804 Ref. 2	C.16804 Ref. 1	C.5863A Ref. 1	C.5863A Ref. 2	C.5862A Ref. 1	C.5862A Ref. 2
J	Ins.	0.22	0.22	0.25	0.25	0.28	0.28	0.28	0.25	0.25	0.22
	mm.	5.5	5.5	6.5	6.5	7.0	7.0	7.0	6.5	6.5	5.5
K	Ins.	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50	0.50
	mm.	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5
L	Ins.	0.06	0.06	0.09	0.09	0.12	0.12	0.12	0.09	0.09	0.06
	mm.	1.5	1.5	2.5	2.5	3.0	3.0	3.0	2.5	2.5	1.5
M	Ins.	0.4724	0.4724	0.5905	0.5905	0.6250	0.6250	0.6250	0.5905	0.5905	0.4724
	mm.	12.00	12.00	15.00	15.00	15.87	15.87	15.87	15.00	15.00	12.00
N	Ins.	1.00	1.00	1.37	1.37	1.37	1.37	1.37	1.37	1.37	1.00
	mm.	25.5	25.5	35.0	35.0	35.0	35.0	35.0	35.0	35.0	25.5
P	Ins.	0.34	0.34	0.39	0.39	0.47	0.47	0.47	0.39	0.39	0.34
	mm.	8.5	8.5	10.0	10.0	12.0	12.0	12.0	10.0	10.0	8.5
Q	Ins.	0.47	0.47	0.59	0.59	0.65	0.65	0.65	0.59	0.59	0.47
	mm.	12.0	12.0	15.0	15.0	16.5	16.5	16.5	15.0	15.0	12.0
R	Ins.	1.772	1.772	2.062	2.062	2.350	2.350	2.920	2.230	2.230	1.836
	mm.	45.00	45.00	52.39	52.39	59.69	59.69	74.17	56.64	56.64	46.63

DIEHEADS AND DIEHEAD YOKES

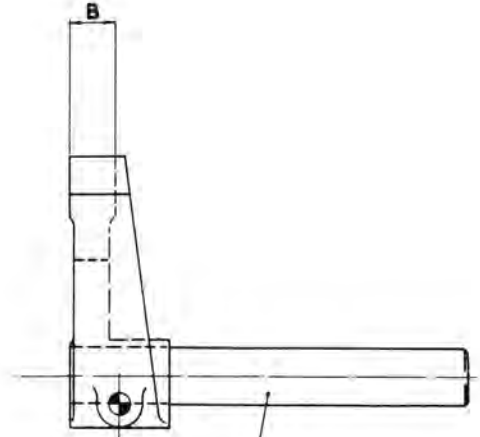
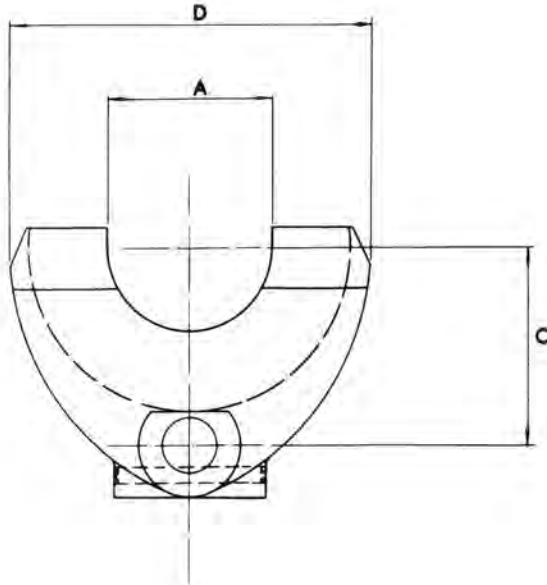


YOKES SLEEVE SUPPLIED AS A SEPARATE ITEM ON ALL 6 SPINDLE MACHINES
YOKES SLEEVE IS INTEGRAL WITH YOKES ON ALL 5 SPINDLE MACHINES

DIE-HEAD YOKES

Machine	1" -6 Bar		Stations 3, 4, 5 & 6				1.000 ins. Attachment Bore 25.40 mm. dia.						Diehead Shank Modifications i.e. Bush Required Std. or Special Shank	
	Diehead Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D		
		Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.		mm.
Landex	1/2 JN	1.00	25.40	C.16349	186.X.128	2.13	54.0	0.370	9.40	2.422	60.52	3.63	92.0	Std. Shank 1.000" dia. Bush to 1.000" dia. Std. Shank 1.000" dia.
	1/2 LLL	0.750	19.05	C.16965		2.16	55.0	0.284	7.21	2.422	60.52	3.63	92.0	
	5/8 LLL	1.000	25.40	C.16966		2.53	64.5	0.378	9.60	2.422	60.52	3.63	92.0	
Namco	9/16 DR	1.500	38.10	B.6044	186.X.128	1.87	47.5	0.547	13.89	2.422	60.52	3.50	89.0	Special Shank 1.000" dia.
	13/16 DR	1.500	38.10	C.17206		1.96	50.0	0.547	13.89	2.422	60.52	4.25	108.0	Special Shank 1.000" dia.
Coventry	1/2 CH5	1.000	25.40	186.X.127A	186.X.128	2.53	64.5	0.370	9.40	2.422	60.52	3.50	89.0	Std. Shank 1.000" dia.
	3/4 CH	1.500	38.10	C.16347		3.47	88.0	0.525	13.33	2.422	60.52	4.75	120.5	Special Shank 1.000" dia.
Machine	1 1/2"-5 Bar 5"-5 Chucker		Stations 3, 4 & 5				1.250 ins. Attachment Bore 31.75 mm. dia.						Diehead Shank Modifications i.e. Bush Required Std. or Special Shank	
Diehead Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D			
	Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.		
Landex	1/2 JN	1.000	25.40	S.895	Sleeve is Integral with Yoke	2.13	54.0	0.370	9.40	2.406	61.12	3.12	79.5	Bush to 1.250" dia. Bush to 1.250" dia. Special Shank 1.250" dia. Special Shank 1.250" dia.
	5/8 LLL	1.000	25.40	D.20052A		2.50	63.5	0.378	9.60	2.406	61.12	3.50	89.0	
	13/16 JN	1.500	38.10	S.775/1		3.00	76.0	0.500	12.70	2.406	61.12	4.00	101.5	
	7/8 LLL	1.500	38.10	C.11825		3.38	85.5	0.441	11.20	2.406	61.12	4.25	108.0	
Namco	9/16 DR	1.500	38.10	C.9802	Sleeve is Integral with Yoke	1.91	48.5	0.557	14.15	2.406	61.12	2.75	70.0	Special Shank 1.250" dia. Special Shank 1.250" dia. Special Shank 1.250" dia. Special Shank 1.250" dia.
	13/16 DR	1.500	38.10	C.9803		2.00	51.0	0.557	14.15	2.406	61.12	3.50	89.0	
	1" DR	1.500	38.10	C.10409		2.06	52.5	0.557	14.15	2.406	61.12	3.50	89.0	
	1.1/16	1.500	38.10	C.10409		2.06	52.5	0.557	14.15	2.406	61.12	3.50	89.0	
Coventry	1/2 CH	1.000	25.40	S.850	Sleeve is Integral with Yoke	2.56	65.0	0.373	9.47	2.406	61.12	3.50	89.0	Bush to 1.250" dia.
	3/4 CH	1.500	38.10	C.6446		3.50	89.0	0.500	12.70	2.406	61.12	4.50	114.5	Special Shank 1.250" dia.

DIEHEADS AND DIEHEAD YOKES

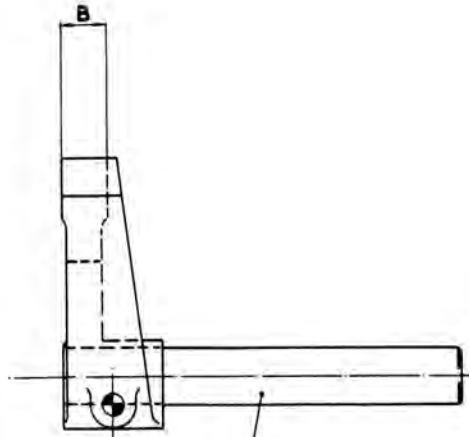
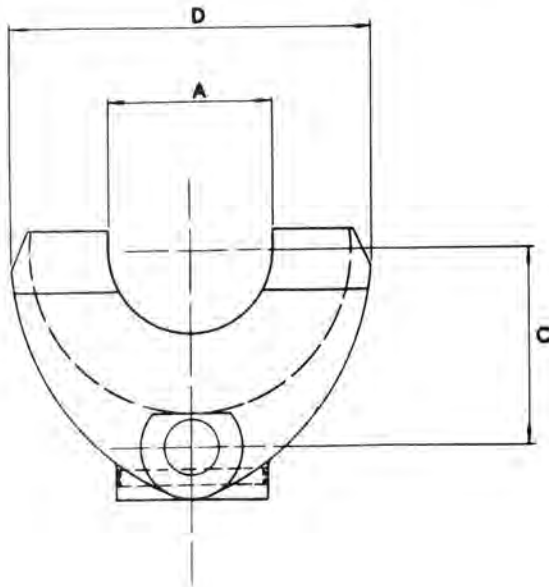


YOKE SLEEVE SUPPLIED AS A SEPARATE ITEM ON ALL 6 SPINDLE MACHINES
YOKE SLEEVE IS INTEGRAL WITH YOKES ON ALL 5 SPINDLE MACHINES.

DIE-HEAD YOKES

Machine	1 1/2", 2 1/2"—5 Bar 6"—5 Chucker		Stations 3, 4 & 5				1.250 ins. Attachment Bore 31.75 mm. dia.				Diehead Shank Modifications i.e. Bush Required Std. or Special Shank			
	Diehead Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D		
		Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.			mm.	
Landex	1/2 JN	1-000	25-40	C.5826/1	Sleeve is Integral with Yoke	2-13	54-0	0-370	9-40	2-875	73-03	3-19	81-0	Bush to 1-250" dia. Bush to 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	5/8 LLL	1-000	25-40	C.10443		2-56	65-0	0-373	9-47	2-875	73-03	3-50	89-0	
	13/16 JN	1-500	38-10	C.2889/1		3-00	76-0	0-495	12-57	2-875	73-03	4-00	101-5	
	7/8 LLL	1-500	38-10	C.16964		3-41	86-5	0-437	11-11	2-875	73-03	4-13	105-0	
Namco	9/16 DR	1-500	38-10	C.16840		1-87	47-5	0-557	14-15	2-875	73-03	3-00	76-0	Special Shank 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	13/16 DR	1-500	38-10	C.5731		2-06	52-5	0-557	14-15	2-875	73-03	3-50	89-0	
	1" DR	1-500	38-10	C.5731		2-06	52-5	0-557	14-15	2-875	73-03	3-50	89-0	
	1-1/16 DR	1-500	38-10	C.5731		2-06	52-5	0-557	14-15	2-875	73-03	3-50	89-0	
Coventry	1/2 CHS	1-000	25-40	C.10443		2-56	65-0	0-373	9-47	2-875	73-03	3-50	89-0	Bush to 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	3/4 CHS	1-500	38-10	S.81		3-50	89-0	0-500	12-70	2-875	73-03	4-50	114-5	
	1" CHS	1-750	44-45	C.16203		4-06	103-0	0-496	12-60	2-875	73-03	4-91	124-5	
Machine	1 3/4", 1 1/2"—6 Bar, 5 3/8"—6 Chucker		Stations 3, 4, 5 & 6				1.250 ins. Attachment Bore 31.75 mm. dia.				Diehead Shank Modifications i.e. Bush Required Std. or Special Shank			
Diehead Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C			D		
	Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.				
Landex	1/2 LLL	0-7500	19-05	C.18550/7	D.53620	2-13	54-0	0-370	9-40	3-187	80-96	3-37	85-5	Bush to 1-250" dia. Bush to 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	5/8 LLL	1-000	25-40	C.18550/10		2-53	64-5	0-378	9-60	3-187	80-96	3-63	92-0	
	13/16 JN	1-500	38-10	C.18550/1		3-00	76-0	0-498	12-64	3-187	80-96	4-37	111-0	
	7/8 LLL	1-500	38-10	C.18550/2		3-44	87-5	0-437	11-11	3-187	80-96	4-75	120-5	
Namco	9/16 DR	1-500	38-10	C.18550/11		1-87	47-5	0-557	14-15	3-187	80-96	3-50	89-0	Special Shank 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	13/16 DR	1-500	38-10	C.18550/8		1-96	50-0	0-557	14-15	3-187	80-96	4-25	108-0	
	1" DR	1-500	38-10	C.19637		2-06	52-5	0-557	14-15	3-187	80-96	3-50	89-0	
	1-1/16 DR	1-500	38-10	C.18550/12		2-03	51-5	0-557	14-15	3-187	80-96	4-37	111-0	
Coventry	1/2 CHS	1-000	25-40	C.18550/5		2-53	64-5	0-370	9-40	3-187	80-96	3-50	89-0	Bush to 1-250" dia. Special Shank 1-250" dia. Special Shank 1-250" dia.
	3/4 CH	1-500	38-10	C.18550/4		3-47	88-0	0-525	13-33	3-187	80-96	4-50	114-5	
	1" CHS	1-750	44-45	C.18550/9		4-03	102-5	0-498	12-64	3-187	80-96	5-13	130-0	

DIEHEADS AND DIEHEAD YOKES



YOKE SLEEVE SUPPLIED AS A SEPARATE ITEM ON ALL 6 SPINDLE MACHINES.
YOKE SLEEVE IS INTEGRAL WITH YOKE ON ALL 5 SPINDLE MACHINES.

DIE-HEAD YOKE

Machine	2 1/4" - 6 Bar, 6 1/2" - 6 Chucker				Stations 3, 4, 5 & 6				1.500 ins. Attachment Bore 38.10 mm. dia.				Diehead Shank Modifications i.e. Bush Required Std. or Special Shank				
Diehead	Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D					
		Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.						
Landex	13/16 JN	1-500	38-10	C.17136A/1	D.48711	3-00	76-0	0-498	12-64	3-375	85-73	4-50	114-5	Std. Shank 1-500" dia.			
	7/8 LLL	1-500	38-10	C.21476		3-44	87-5	0-441	11-20	3-375	85-73	4-50	114-5	Std. Shank 1-500" dia.			
Namco	13/16 DR	1-500	38-10	C.18136		2-00	51-0	0-557	14-15	3-375	85-73	4-25	108-0	Std. Shank 1-500" dia.			
	1" DR	1-500	38-10	C.18665		2-06	52-5	0-557	14-15	3-375	85-73	4-63	117-5	Std. Shank 1-500" dia.			
Coventry	3/4 CH	1-500	38-10	C.17136A/3	3-50	89-0	0-498	12-64	3-375	85-73	4-50	114-5	Std. Shank 1-500" dia.				
Machine	2 1/4", 3 1/4" - 6 Bar, 7 1/4" - 6 Chucker				Stations 4 & 5				3 1/2", 4 1/2" - 4 Bar, 9" - 4 Chucker				Stations 3 & 4				2.125 ins. Attachment Bore 53.97 mm. dia.
Diehead	Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D					
		Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.						
Landex	1.1/4 JN	2-125	53-97	B.6613	586.X.139	4-44	112-5	0-429	10-89	3-719	94-46	5-75	146-0	Std. Shank 2-125" dia.			
	13/16 JN	1-500	38-10	C.17416		3-00	76-0	0-498	12-64	3-688	93-66	4-63	117-5	Bush to 2-125" dia.			
Namco	1" DR	1-500	38-10	B.8903		2-06	52-5	0-560	14-22	3-688	93-66	4-50	114-5	Bush to 2-125" dia.			
	1.5/8 DR	2-750	69-85	B.6712		3-56	90-5	0-742	18-85	3-688	93-66	5-13	130-0	Special Shank 2-125" dia.			
Coventry	2" DR	2-750	69-85	B.7537	3-56	90-5	0-742	18-85	3-688	93-66	5-38	136-5	Special Shank 2-125" dia.				
Coventry	1.1/4 CH	2-125	53-97	B.9635	4-69	119-0	0-492	12-50	3-688	93-66	5-75	146-0	Std. Shank 2-125" dia.				
Machine	2 1/4", 3 1/4" - 6 Bar, 7 1/4" - 6 Chucker				Stations 3 & 6				2.125 ins. Attachment Bore 53.97 mm. dia.								
Diehead	Type	Makers Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D					
		Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.						
Landex	13/16 JN	1-500	38-10	587.Y.140A	586.X.139	3-00	76-0	0-492	12-50	3-375	85-72	4-00	101-5	Bush to 2-125" dia.			
	1.1/4 JN	2-125	53-97	B.9657		4-44	112-5	0-429	10-89	3-375	85-72	5-75	146-0	Std. Shank 2-125" dia.			
Namco	1" DR	1-500	38-10	B.8904		2-06	52-5	0-560	14-22	3-375	85-72	4-13	104-5	Bush to 2-125" dia.			
Coventry	1.1/4 CH	2-125	53-97	B.9635		4-69	119-0	0-492	12-50	3-375	85-72	5-87	149-0	Std. Shank 2-125" dia.			



**TOOLHOLDERS
&
COLLET EQUIPMENT
FOR
 $\frac{5}{8}$ 6-SPINDLE AUTOMATIC**

W254 500 8.66 (Supplement to W170 1964)

5/8 - 6 index

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TOOLHOLDER ORDERING INSTRUCTIONS

When ordering toolholders state:

TOOLHOLDER NAME & DRAWING NUMBER

MACHINE SERIAL & INSPECTION NUMBERS

MACHINE SIZE & NUMBER OF SPINDLES

STATION on which toolholder will be used.

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SECTION 1

ENDWORKING TOOLHOLDERS

TOOLHOLDER for WICKMAN AUTOMATICS

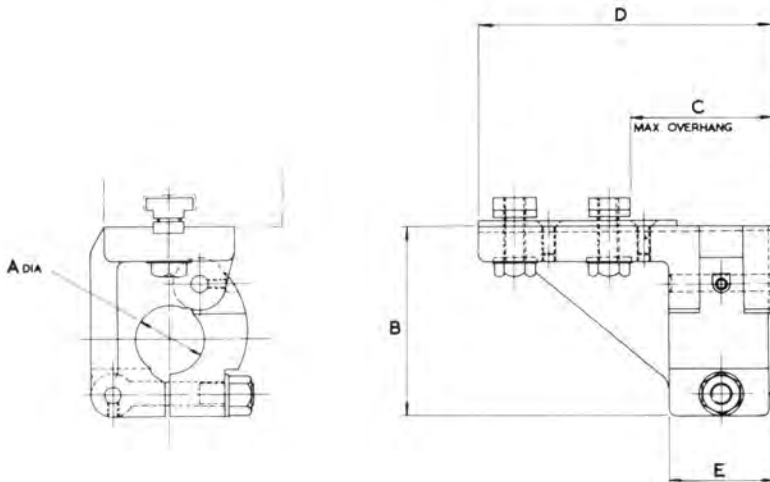
BRACKET TOOLHOLDER

(OVERHANGING TYPE)



The bracket toolholder bore accommodates shank type tools such as drills, reamers, etc. This holder can also be used for carrying boring bars and other shank-type toolholders and steadies.

See pages 7 and 8 for other types of bracket toolholder.



INDEPENDENT SLIDE MOUNTED STATION 4 ONLY

Drg. No.	W6-058-33/4	
Dims.	Ins.	mm.
A dia.	1.000	25.40
B	2.75	70.0
C	2.06	52.5
D	4.25	108.0
E	1.50	38.0

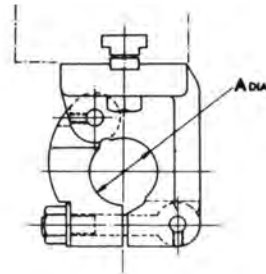
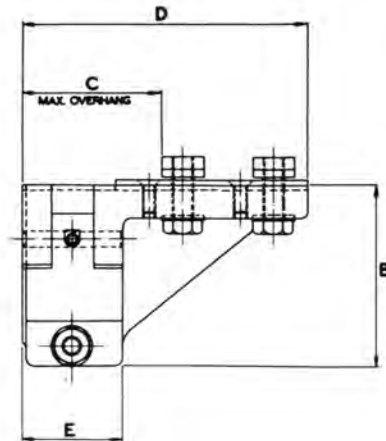
TOOLHOLDER for WICKMAN AUTOMATICS

BRACKET TOOLHOLDER

(OVERHANGING TYPE)

This toolholder is designed primarily for use on the independent slides, but can also be used on all centre block positions. Accommodates shank-type tools and toolholders.

See pages 6 and 8 for other types of bracket toolholder.



INDEPENDENT SLIDE MOUNTED STATION 5 ONLY

Drq. No.	V6—058—33/5	
Dims.	Ins.	mm.
A dia.	1.000	25.40
B	2.75	70.0
C	2.06	52.5
D	4.25	108.0
E	1.50	38.0

TOOLHOLDER for WICKMAN AUTOMATICS

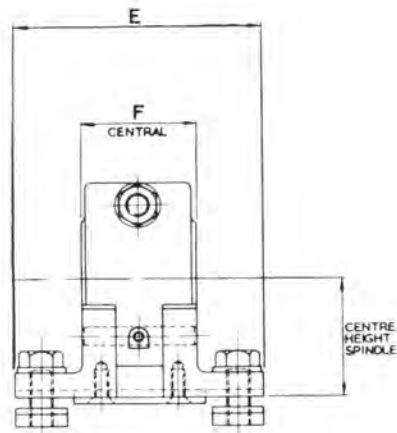
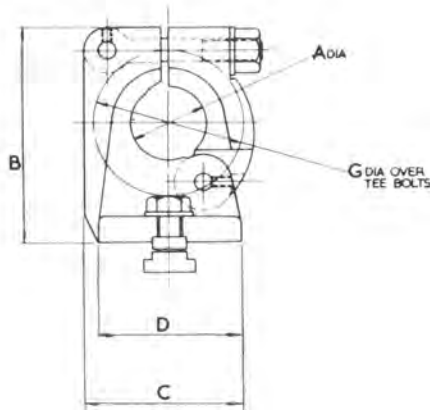
BRACKET TOOLHOLDER

(HINGED TYPE)



The toolholder bore accommodates shank-type tools such as drills, reamers, etc. The holder can also be used for carrying boring bars and other shank-type toolholders and steadies.

See pages 6 and 7 for other types of bracket toolholder.



CENTRE BLOCK MOUNTED ALL STATIONS

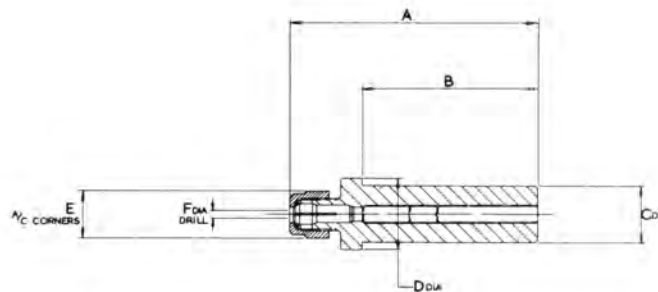
Drsg. No.	W6-058-60	
Dims.	Ins.	mm.
A dia.	1.000	25.40
B	2.87	73.0
C	2.06	52.5
D	1.87	47.5
E	3.25	82.5
F	1.50	38.0
G	2.00	51.0

DRILL HOLDER

(ERICKSON TYPE)

This holder will accommodate drills and straight shank tools. Used in conjunction with a bracket toolholder, the drill holder has an adjusting screw for backing up tools against end thrust.

See pages 10 and 11 for other types of drill holder.



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6—058—26/1		Collet Capacity and Number*			
	Ins.	mm.	F dia.	max.	0.250	6-35
A	4.25	108.0		min.	0.045	1-143
B	3.00	76.0	Collet No. 300 Series			
C dia.	1.000	25.40				
D dia.	1.25	31.5				
E	0.81	20.5				

*Collets are listed in actual, uncollapsed size. Each of the collets collapses over a range of $\frac{1}{32}$ "

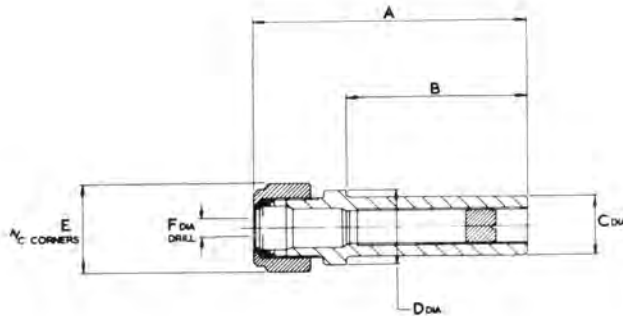
DRILL HOLDER

(ERICKSON TYPE)



This holder will accommodate drills and straight shank tools. Used in conjunction with a bracket toolholder, the drill holder has an adjusting screw for backing up tools against end thrust.

See pages 9 and 11 for other types of drill holder.



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6—058—26/2		Collet Capacity and Number*			
	Ins.	mm.	F dia.	max.	0.563	14.28
A	4.56	116.0			min.	0.25
B	3.00	76.2	Collet No.		100 Series	
C dia.	1.000	25.40				
D dia.	1.25	31.5				
E	1.50	38.0				

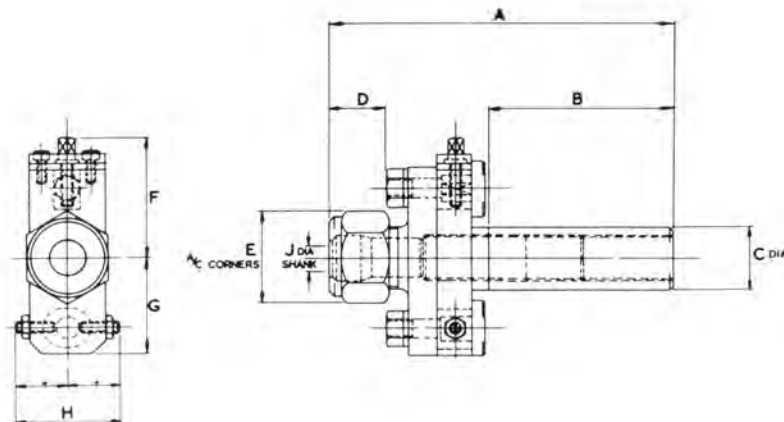
*Collets are listed in actual, uncollapsed size. Each of the collets collapses over a range of $\frac{1}{32}$ ".

DRILL HOLDER

(ERICKSON TYPE, ADJUSTABLE)

Drills, reamers, and other shank-type tools can be held in a collet. Any slight misalignment of the tool can be corrected by adjustment of the front flange of the toolholder.

See pages 9 and 10 for other types of toolholder.



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	WV6—058—30		Collet Capacity and Number*				
	Dims.	Ins.	mm.	J dia.	max.	0.563	14-28
A	5.50	140.0		min.	0.25	6-35	
B	2.87	73.0		Collet No.			100 Series
C dia.	1.000	25.40					
D	0.87	22.0					
E	1.50	38.0					
F	1.94	49.5					
G	1.56	40.0					
H	1.69	43.0					

From 0.218 (5.5 mm.) diameter to .05 (1.27 mm.) diameter use Collet No. "100 Special Series".
*Collets are listed in actual, uncollapsed size. Each of the collets collapses over a range of $\frac{1}{32}$ ".

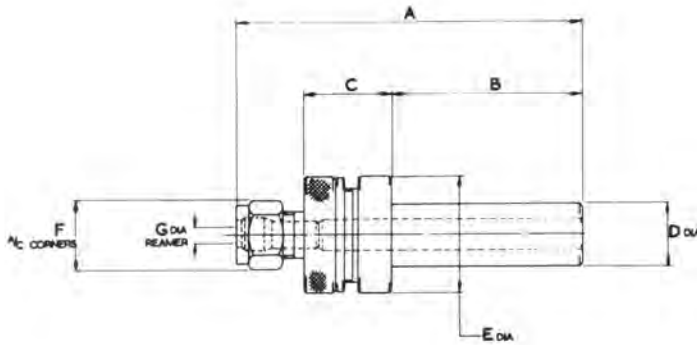
REAMER HOLDER

(ERICKSON TYPE, FLOATING)



For use in all end-working positions and also with the accelerated reaming attachment. Reamers are held in a collet.

One bush, bored to customer's order or blank, is supplied with each holder.



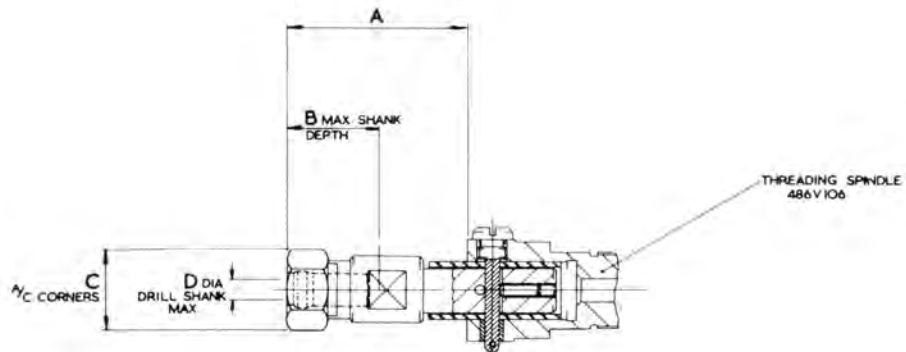
CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6—058—29		Collet Capacity and Number*			
	Ins.	mm.	G dia.	max.	0.375	9.52
A	5.44	138.0			min.	0.125
B	3.00	76.0	Collet No. 200 Series			
C	1.38	35.0				
D dia.	1.000	25.40				
E dia.	1.88	47.5				
F	1.13	28.5				

TAP HOLDER

(ERICKSON TYPE)

Used for adapting and driving taps in conjunction with full screwing attachments. Taps are held in a collet. This holder incorporates a positive compensating driver.



MOUNTED INTO THREADING SPINDLE ALL THREADING STATIONS

Drg. No.	W6—058—34		Collet Capacity and Number*			
Dims.	Ins.	mm.	D dia.	max.	0.384	9.75
				min.	0.128'	3.25
A	2.31	58.5	Collet No. E.09 Series			
B	1.37	35.0				
C	1.13	28.5				

*Collets are listed in actual, uncollapsed size. Each of the collets collapses over a range of $\frac{1}{32}$ ".

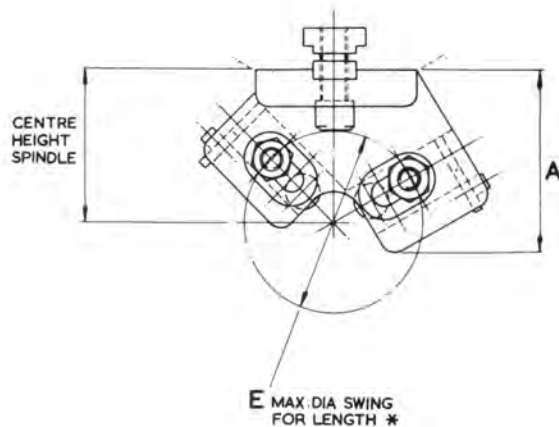
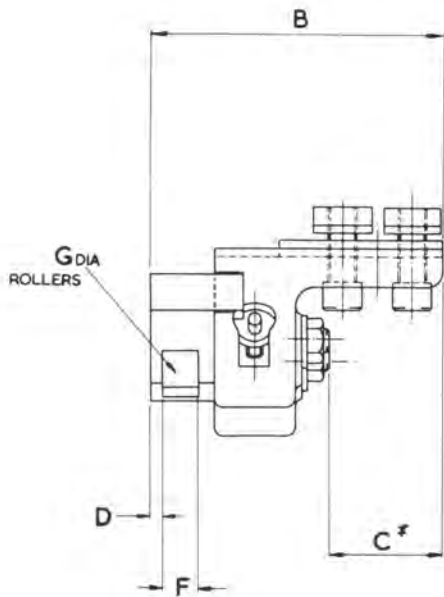
ROLLER STEADY

(CENTRE BLOCK MOUNTED)



Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

See pages 15 and 16 for roller steady used in stations 2, 3, 4, and 5.



0.62" (16.0mm) MAX DIA STEADIED
 0.094" (2.38mm) MIN DIA STEADIED

CENTRE BLOCK MOUNTED STATION 1 ONLY

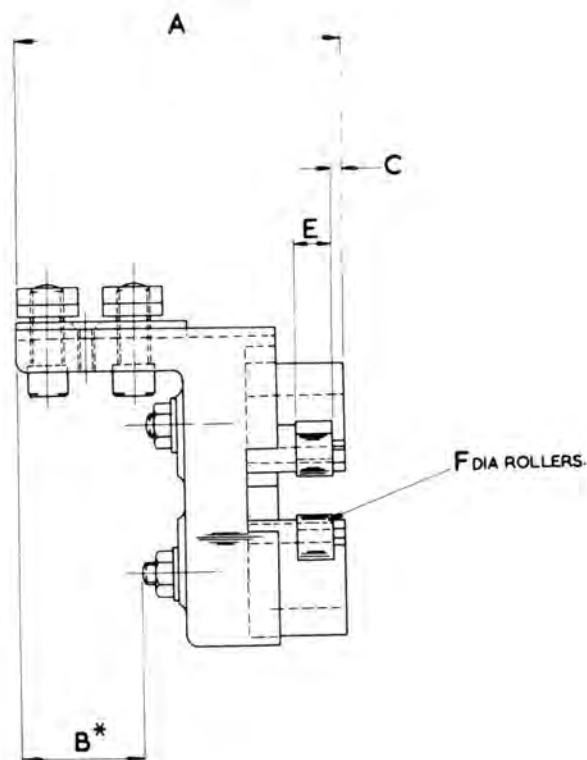
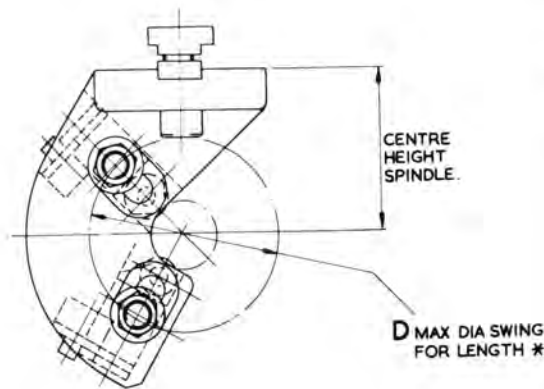
Drg. No.	W6-058-23		Roller Assembly Details and Capacity			
Dims.	Ins.	mm.	F	0.37	9.5	
A	2.00	51.0	G dia.	0.375	9.52	
B	3.12	79.5	Capacity	max.	0.62	16.0
C	1.16	29.5		min.	0.09	2.5
D	0.12	3.0	Drg. No.	DS.1488		
E dia.	1.87	47.5				

TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER STEADY
(CENTRE BLOCK MOUNTED)

Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

See pages 14 and 16 for roller steady used in stations 1, 4 and 5.



○ 0.62 (16.0MM) MAX DIA STEADIED
○ 0.094 (2.38MM) MIN DIA STEADIED

CENTRE BLOCK MOUNTED STATIONS 2 & 3

Drg. No.	W6—058—24		Roller Assembly Details and Capacity		
	Ins.	mm.	E		
A	3.12	79.5	F dia.	0.375	9.52
B	1.16	29.5	Capacity	max.	16.0
C	0.12	3.0		min.	2.5
D dia.	1.8	47.5	Drg. No.	DS.1488	

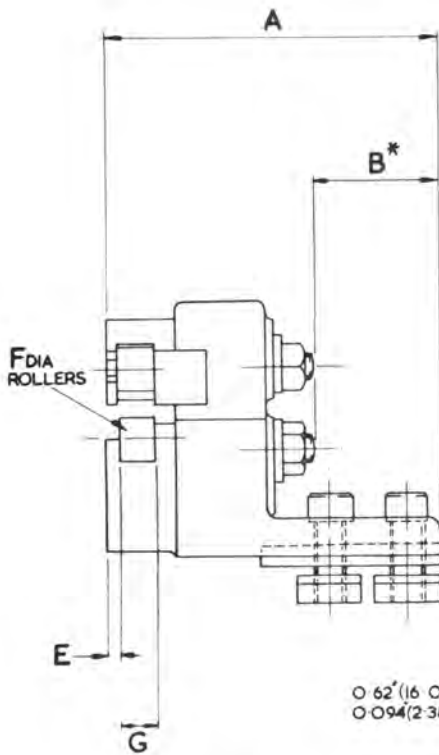
ROLLER STEADY

(CENTRE BLOCK MOUNTED)

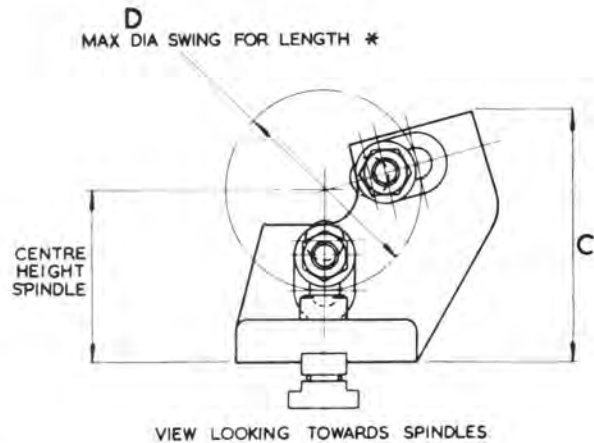


Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming, cross drilling, etc.

See pages 14 and 15 for roller steady used in stations 1, 2 and 3.



Ø 62⁺(16 0MM) MAX DIA STEADIED
 Ø 09⁺(2.38MM) MIN DIA STEADIED



CENTRE BLOCK MOUNTED STATIONS 4 & 5 ONLY

Drg. No.	W6-058-47		Roller Assembly Details and Capacity		
Dims.	Ins.	mm.	F dia.		
A	3.25	82.5	G	0.37	9.5
B	1.31	33.5		0.375	9.52
C	2.37	60.5	Capacity	max.	0.62
D dia.	1.87	47.5		min.	0.09
E	0.12	3.0	Drg. No.	DS.1488	

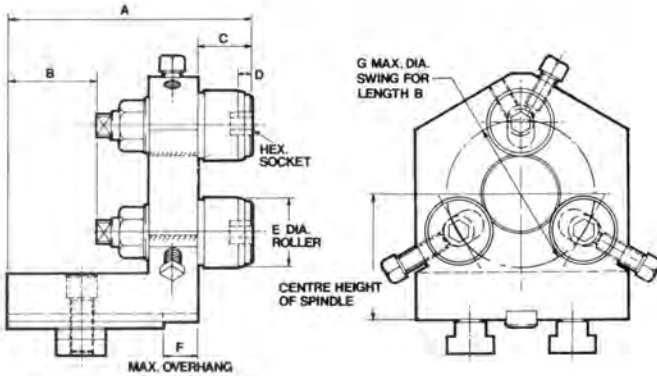
ROLLER STEADY

(THREE ROLLS)

Clamped on the centre block, the roller steady supports the work when forming from the cross slide. Alignment and concentricity of long work is maintained against the thrust from heavy forming cross drilling, etc.

Large roller assemblies are fitted as standard; small roller assemblies are available as an optional extra.

Capacity of Roller Assembly designated by toolholder No.



CENTRE BLOCK AND
INDEPENDENT SLIDES
ALL STATIONS

MACHINE		$\frac{3}{8}$ " -6 Spindle Bar																Roller Assm. No.	Base Assm. No.
Toolholder	Capacity	A		B		C		D		E dia.		F		G dia.					
		Ins.	Mm.	Ins.	Mm.	Ins.	Mm.	Ins.	Mm.	Ins.	Mm.	Ins.	Mm.	Ins.	Mm.	Ins.	Mm.		
W6-058-88/1	Max.	0.22	5.5	3.16	80.0	1.44	36.5	0.66	16.5	0.19	5.0	0.44	11.0	0.75	19.0	1.94	49.0	DS1821	DS1825
	Min.	0.09	2.5																
W6-058-88/2	Max.	0.50	12.5	3.37	85.5	1.00	25.5	0.87	22.0	0.25	6.5	0.75	19.0	0.75	19.0	1.94	49.0	DS1804	DS1884
	Min.	0.19	5.0																
W6-058-88/3	Max.	0.65	16.5	3.37	85.5	1.00	25.5	0.87	22.0	0.25	6.5	0.75	19.0	0.75	19.0	1.94	49.0	DS1804	DS1885
	Min.	0.34	8.5																

TOOLHOLDER for WICKMAN AUTOMATICS

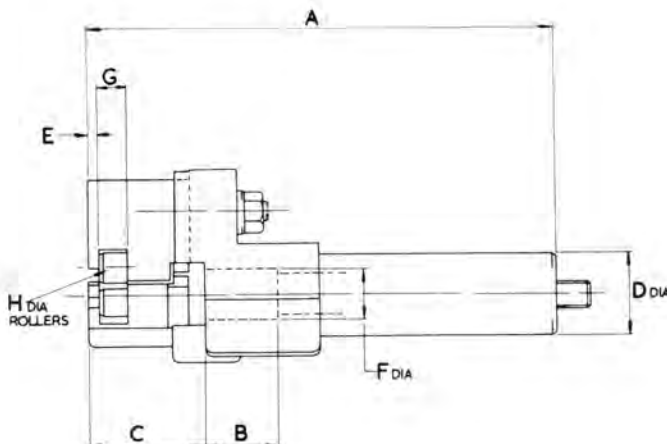
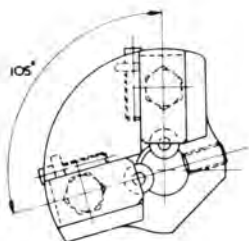
ROLLER STEADY

(SHANK TYPE)

Mounted in a bracket toolholder, the roller steady is used for steadying work when forming, skiving, and long turning on weak or overhanging parts.



CAPACITY
 O 02 (16 0MM) MAX DIA
 O 094 (2 38 MM) MIN DIA



BUSH DS.1462 AVAILABLE FOR USE WITH DRILL IF REQUIRED.

CENTRE BLOCK & INDEPENDENT SLIDE MOUNTED ALL STATIONS

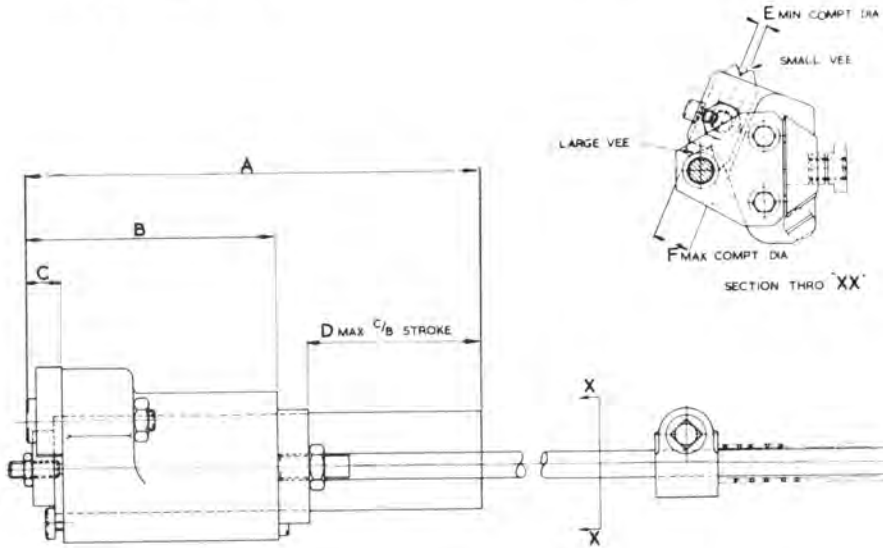
Drg. No.	W6—058—55		Roller Assembly Details and Capacity			
Dims.	Ins.	mm.	G	0.375	9.52	
A	5.76	146.5	H dia.	0.37	9.5	
B	0.87	22.0	Capacity	max.	0.62	16.0
C	1.39	35.3		min.	0.09	2.5
D dia.	1.000	25.40	Drg. No.	DS.1495		
E	0.12	3.0				
F dia.	0.625	15.87				

Bush DS.1462 is available for holding drill in shank if required.
 Capacity 0.50" (12.5 mm.) dia.
 0.12" (3.0 mm.) dia.

VEE STEADY

(ARRESTED TYPE)

Used for steadying work when all slides have a working feed stroke and a steady is required to remain in a set position. Spring pressure maintains the steady position on vee-ways, while the base returns at the end of each feed stroke. A reversible steady block is supplied to accommodate large or small diameter bar.



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6-058-56	
Dims.	Ins.	mm.
A	6.00	152.5
B	3.50	89.0
C	0.50	13.0
D	2.00	51.0

VEE CAPACITY

Stations		Large Vee		Small Vee	
		Ins.	mm.	Ins.	mm.
1 & 6	max.	0.50	13.0	0.28	7.0
	min.	0.47	12.0	0.25	6.5
2, 3, 4 & 5	max.	0.50	13.0	0.28	7.0
	min.	0.22	5.5	0.09	2.5

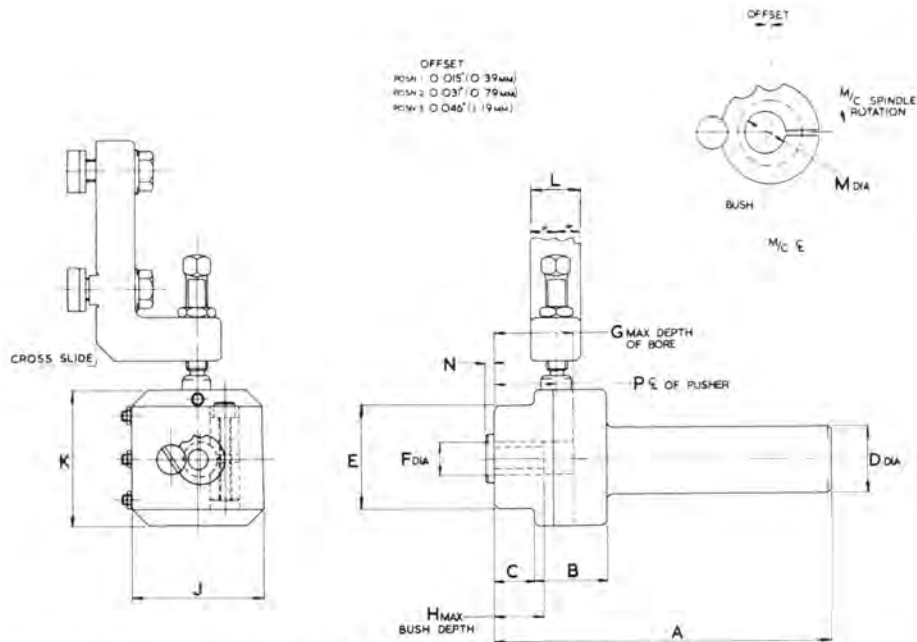
TOOLHOLDER for WICKMAN AUTOMATICS

RECESSING SLIDE

(SHANK TYPE, CROSS SLIDE OPERATED)

Mounted in a bracket toolholder and operated from a pusher bracket on an adjoining cross slide, this toolholder is used for recessing, forming, or facing the base of an internal bore. Cutters can be accommodated either directly, or with an eccentric bush which reduces tool offset in 1/64" steps.

See page 20 for another type of recessing slide.



CENTRE BLOCK & INDEPENDENT SLIDE MOUNTED ALL STATIONS

Drg. No.	W6-058-54		Drg. No.	W6-058-54	
Dims.	Ins.	mm.	Dims	Ins.	mm.
A	5-12	130-0	J	2-00	50-8
B	1-10	28-0	K	2-00	50-8
C	0-59	15-0	L	0-75	19-0
D dia.	1-000	25-40	M dia.	0-313	7-93
E	1-50	38-0	N	0-12	3-0
F dia.	0-500	12-70	P	0-94	24-0
G	1-19	30-0	Max. Tool Movement	0-37	9-5
H	0-75	19-0	Bush No.	DS.1442	

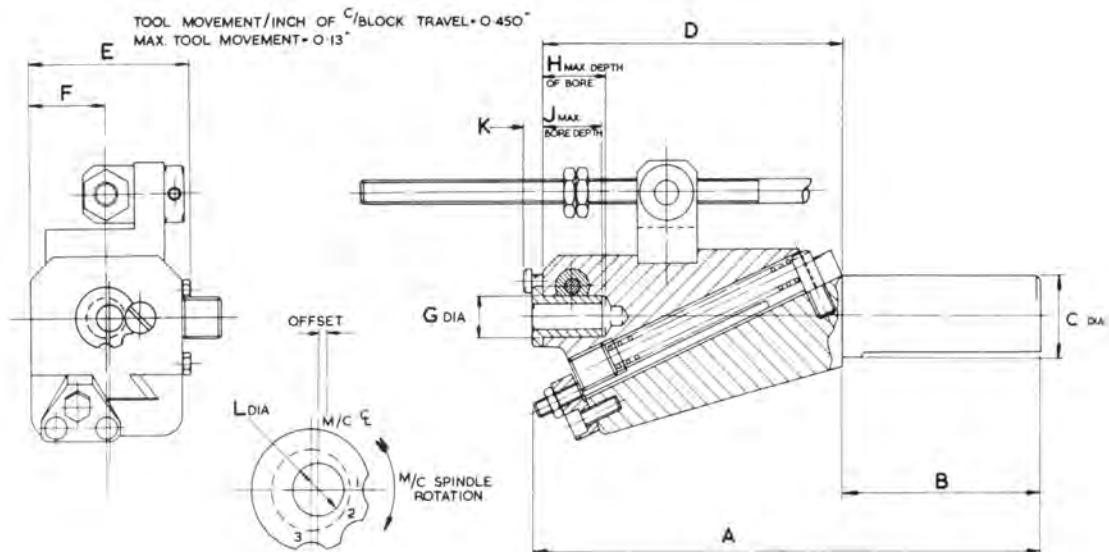
RECESSING SLIDE

(RAMP TYPE)



This holder is used for making recess cuts, boring, or facing the base of an internal bore. On commencement of the feed stroke, the upper section carrying the tool is arrested in the recessing position. The ramp (lower section) continues forward, raising the upper section and tool for the recessing cut.

See page 19 for another type of recessing slide.



BUSH OFFSET POSNS
 POSN 1 GIVES 0.016 (0.4MM) OFFSET TO TOOL
 POSN 2 GIVES 0.031 (0.8MM) OFFSET TO TOOL
 POSN 3 GIVES 0.045 (1.1MM) OFFSET TO TOOL

CENTRE BLOCK MOUNTED ALL STATIONS

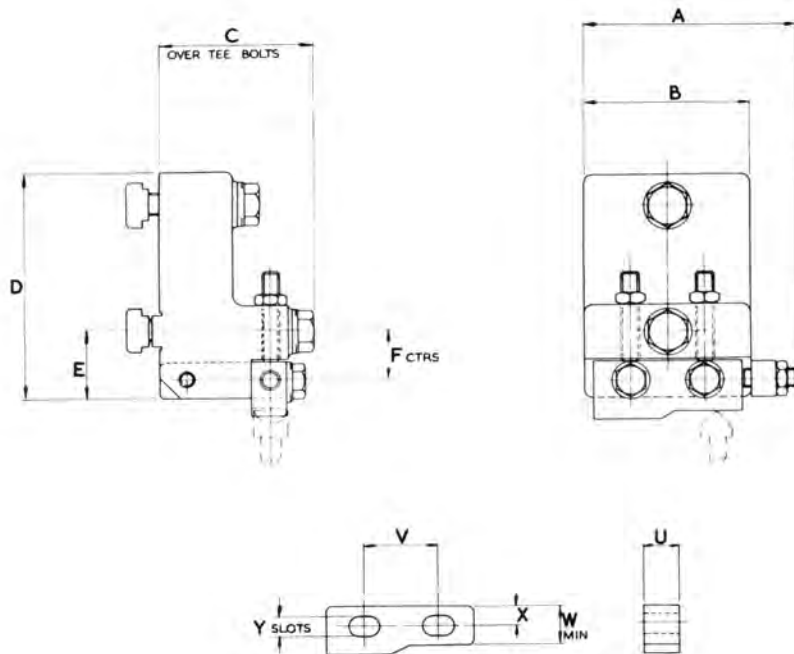
Drg. No.	W6-058-28	
Dims.	Ins.	mm.
A	6.37	162.0
B	2.50	63.5
C dia.	1.000	25.40
D	3.75	95.0
E	1.06	27.0
F	0.94	24.0
G dia.	0.500	12.70
H	0.78	20.0
J	0.75	19.0
K	0.22	5.5
L dia.	0.312	7.93

FORMER BLOCK ASSEMBLY

(FOR USE WITH SHANK TYPE RECESSING SLIDE)



The former block can be designed as a master to guide the recessing tool to give a required form.



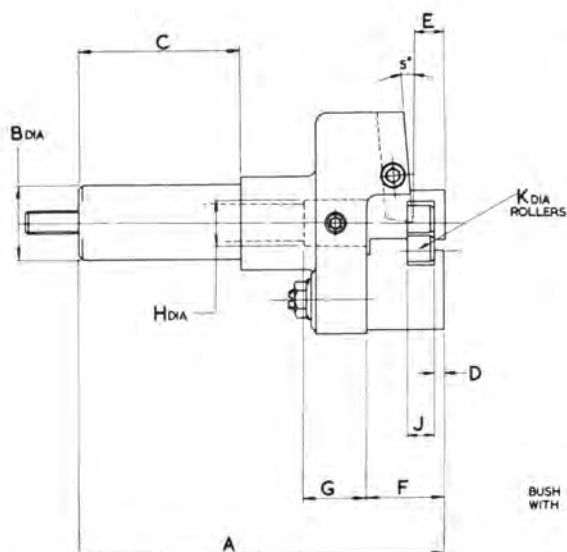
CROSS SLIDE MOUNTED

Drg. No.	W6-058-83		Former Block Blank Details		
Dims.	Ins.	mm.	U		
A	2.87	73.0	V	1.00	25.4
B	2.25	57.0	W	0.56	14.5
C	2.12	54.0	X	0.28	7.0
D	3.12	79.5	Y	0.28	7.0
E	0.94	24.0			
F	0.69	17.5			

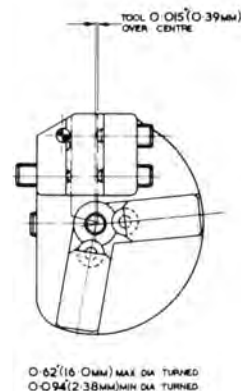
ROLLER ENDING BOX (SHANK TYPE)



Roller support is given to the bar during ending operations. This holder is used mounted in a bracket toolholder.



TOOL SECTION
0.37(9.5mm) SQUARE
LENGTH TO SUIT



BUSH DS.1462 AVAILABLE FOR USE
WITH DRILL IF REQUIRED

CENTRE BLOCK & INDEPENDENT SLIDE MOUNTED ALL STATIONS

Drg. No.	W6-058-68		Roller Assembly Details and Capacity			
Dims.	Ins.	mm.	J	0.375	9.52	
A	4.92	125.0	K dia.	0.37	9.5	
B dia.	1.000	25.4	Capacity	max.	0.62	16.0
C	2.19	55.5		min.	0.09	2.5
D	0.12	3.0	Drg. No.	DS.1495		
E	0.39	10.0				
F	1.06	27.0				
G	0.87	22.0				
H	0.625	15.87				

Bush DS.1462 is available for holding drill in shank if required.
Capacity 0.50" (12.5 mm.) dia.
0.12" (3.0 mm.) dia.

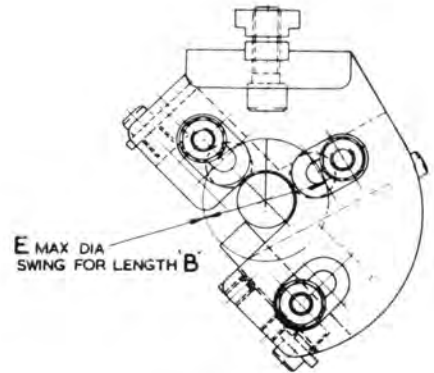
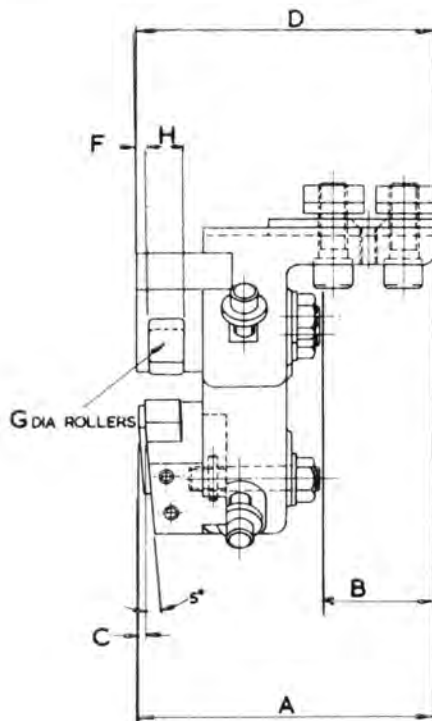
TOOLHOLDER for WICKMAN AUTOMATICS

ROLLER TURNER

(CENTRE BLOCK MOUNTED)

Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position. When turning shaft-type components the use of advanced rollers is recommended. The Wimet series AT tools have been specially developed for this application.

See pages 24 and 25 for other types of roller turner.



0.62 (16.0MM) MAX DIA TURNED
0.094 (2.38MM) MIN DIA TURNED

TOOL SECTION
0.37 (9.5MM) SQUARE LENGTH TO SUIT

CENTRE BLOCK MOUNTED STATION 1 ONLY

Drg. No.	W6-058-21		Roller Assembly Details and Capacity			
Dims.	Ins.	mm.	G dia.	0.37	9.5	
A	3.09	78.5	H	0.375	9.52	
B	1.25	31.5	Capacity	max.	0.62	16.0
C	0.09	2.5		min.	0.09	2.5
D	3.12	79.5	Drg. No.		DS.1488	
E dia.	1.87	47.5	Tool	HSS	WIMET	
F	0.13	3.0	Nos.	WSP436/9	ATT/5	ATC/14

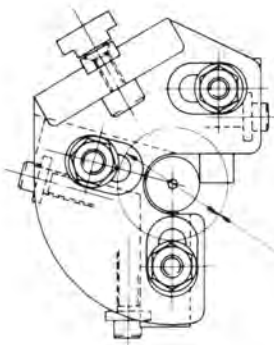
ROLLER TURNER

(CENTRE BLOCK MOUNTED)



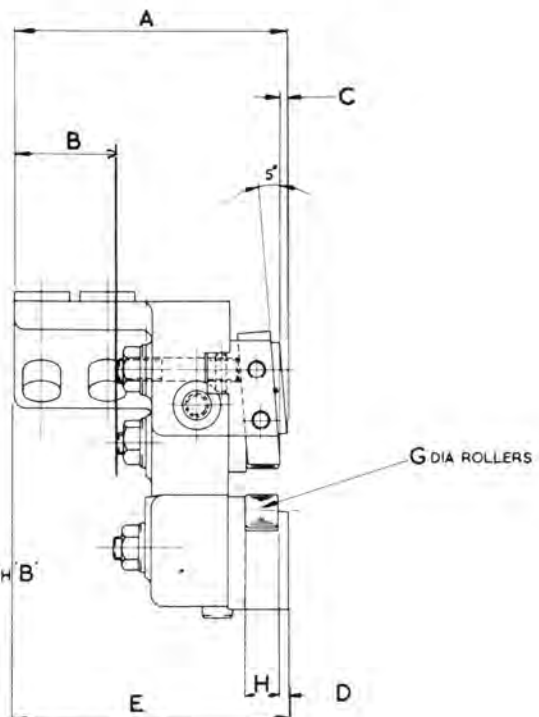
Rollers provide support for the work against the thrust of the turning tool. The holder is designed to allow forming to be carried out from the adjoining cross slide position. When turning shaft-type components the use of advanced rollers is recommended. The Wimet series AT tools have been specially developed for this application.

See pages 23 and 25 for other types of roller turner.



Ø 62 (16.0MM) MAX DIA TURNED
Ø 0.94 (2.38MM) MIN DIA TURNED

F MAX DIA SWING FOR LENGTH B



STD. TOOL SECTION Ø 37 (9.5MM) SQUARE
LENGTH TO SUIT

CENTRE BLOCK MOUNTED STATIONS 2 & 3

Drg. No.	WV6—058—22		Roller Assembly Details and Capacity			
	Ins.	mm.	G dia.	0.37	9.5	
A	3.09	78.5	H	0.375	9.52	
B	1.25	31.5	Capacity	max.	0.62	16.0
C	0.09	2.5		min.	0.09	2.5
D	0.13	3.0	Drg. No.	DS.1488		
E	3.13	79.5	Tool	HSS WIMET		
F dia.	1.87	47.5	No.	WSP436/9	ATT/5	ATC/14

ROLLER TURNER

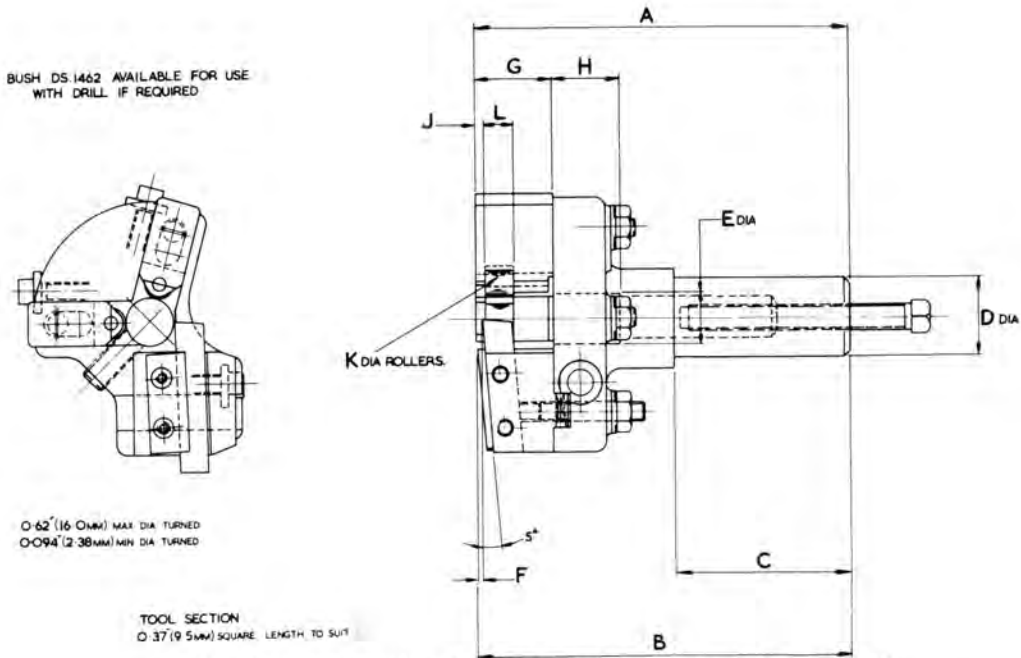
(SHANK)



This roller turner carries one tool and gives roller support to the work. The turner is usually mounted in a bracket toolholder.

When turning shaft-type components the use of advanced rollers is recommended. The Wimet series AT tools have been specially developed for this application.

See pages 23 and 24 for other types of roller turner.



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6—058—45		Roller Assembly Details and Capacity			
Dims.	Ins.	mm.	K dia.	0.375	9.52	
A	4.82	123.5	L	0.37	9.5	
B	4.78	121.5	Capacity	max.	0.62	16.0
C	2.25	57.0		min.	0.09	2.5
D dia.	1.000	25.4	Drg. No.		DS.1495	
E dia.	0.625	15.87	Tool	H.S.S.	WIMET	
F	0.06	1.5	No.	WSP436/9	ATT/5	ATC14
G	1.00	25.0				
H	0.81	20.5				
J	0.13	3.0				

KNEE TURNER

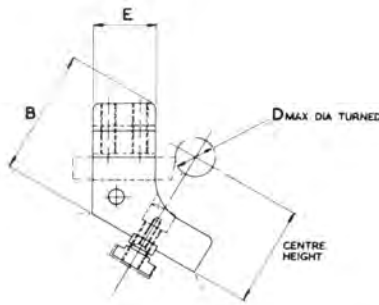
(STANDARD)



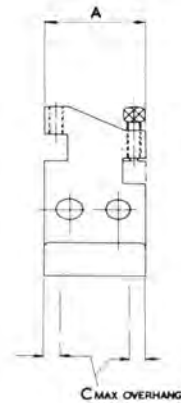
Turning, chamfering and trepanning operations are carried out with this holder. The toolholder is reversible, to assist tool layout and clearance. The knee turner is used mainly for rough turning or facing on short work, and removing metal and scale before forming cuts.

See pages 27 and 28 for other types of knee turner.

See page 29 for tools.



TOOL SECTION - F50 X LENGTH TO SUIT



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6-058-25	
Dims.	Ins.	mm.
A	1.62	41.5
B	2.06	52.5
C	0.25	6.5
D dia.	0.62	16.0
E	1.00	25.5
F	0.37	9.5

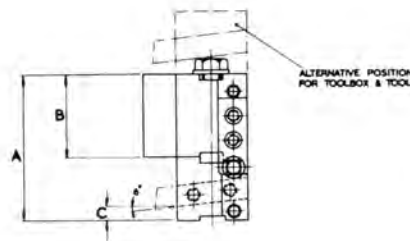
TOOLHOLDER for WICKMAN AUTOMATICS

KNEE TURNER

(TANGENTIAL)

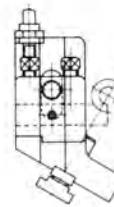
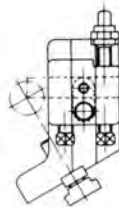
Using tangential tools, this holder can be used to perform a variety of turning operations such as chamfering, etc.

See pages 26 and 28 for other types of knee turner.



TOOL SECTION
 O 37.0 SHANK SQUARE
 LENGTH R3 BUT

D DIA TURNED



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.		W6—058—50	
Dims.		Ins.	mm.
A		2.62	66.5
B		1.50	38.0
C		0.25	6.5
D dia. Turned	max.	0.62	16.0
	min.	To Centre	
Tool No.	H.S.S.	WIMET	
	WSP436/9	ATT/5	ATC/14

KNEE TURNER

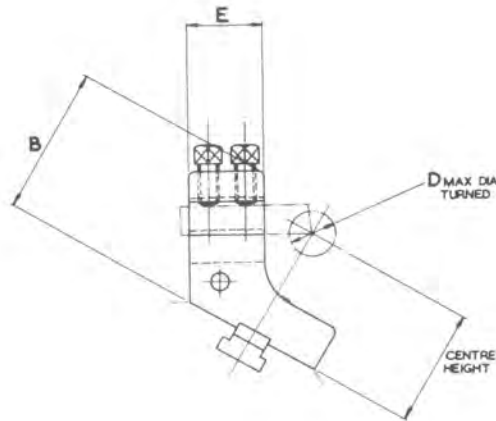
(WIDE)



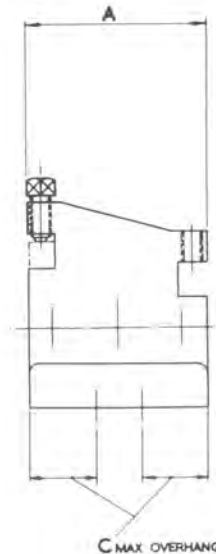
Turning, chamfering, and trepanning operations are carried out with this holder. The holder is reversible to assist tool layout and clearances. The wide-type knee turner is so designed that it can overhang the front of the centre-block, to enable cuts to be taken close to the collet nose. Additional tools are available for this holder. These tools have differing approach angles and are manufactured in H.S.S. or Wimet carbide. When ordering Wimet tools state grade required.

See pages 26 and 27 for other types of knee turner.

See page 29 for tools.



TOOL SECTION
F SQ x LENGTH TO SUIT



CENTRE BLOCK MOUNTED ALL STATIONS

Drg. No.	W6-058-80	
Dims.	Ins.	mm.
A	2.37	60.5
B	2.06	52.5
C	0.87	22.0
D dia.	0.62	16.0
E	1.00	25.5
F	0.37	9.5

TOOLHOLDER *for* WICKMAN AUTOMATICS

TOOLS FOR KNEE TURNERS NO's 25 AND 80



The tools listed below are for use in knee turners described on pages 26 and 28.

Tool Size		Tool Nos. H.S.S.				Tool Nos. Wimet		
Ins.	0.37 × 0.37 × 3.00	Approach Angle				Approach Angle		
		0	15	30	45	0	15	45
mm.	9.5 × 9.5 × 76.0	WSP 424/1	WSP 424/2	WSP 424/3	WSP 424/4	AK70	AK71	AK72

LONG TURNING SLIDE

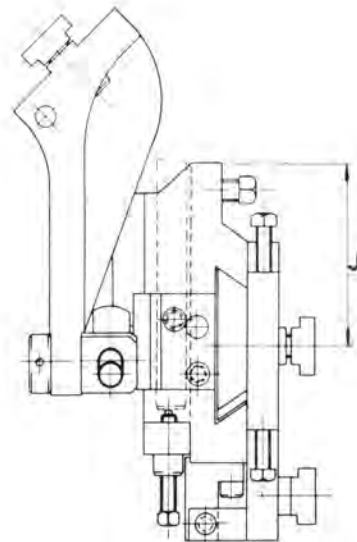
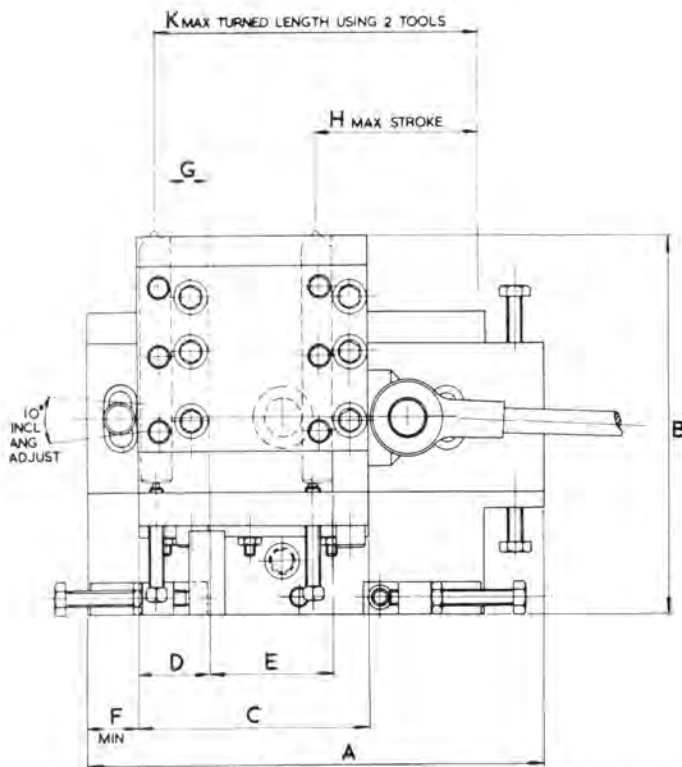
(STANDARD TYPE)



This toolholder can be used for operations such as shaft turning, light turning behind a shoulder, and taper turning up to a 10 degree included angle. Mounted on the cross slide, the toolholder can be operated by a pusher rod from either the centre block or independent slide.

See page 31 for long turning slide used in stations 2 and 5.

See page 32 for tools.



TOOL SECTION
0.37(9.5MM) SQUARE X 3.00(76.2MM) LONG

CROSS SLIDE MOUNTED STATIONS 1 & 4

Drg. No.	W6-058-66		Pusher and Toolbox Bracket Details				
	Dims.	Ins.	mm.	Station	Pusher Bracket	Toolbox Bracket	
A	5.56	141.0	Centre Block	1	CS.758	DS.1533	
B	4.50	114.5		4	CS.764	DS.1538	
C	2.81	71.5		Ind. Slide	4	DS.1544	DS.1538
D	0.87	22.0			Tool Size	Ins.	0.37 x 0.37 x 3.0
E	1.50	38.0	mm.	9.5 x 9.5 x 76.0			
F min.	0.41	10.5					
G	0.44	11.0					
H	2.0	51.0					
J	2.19	55.5					
K	3.94	100.0					

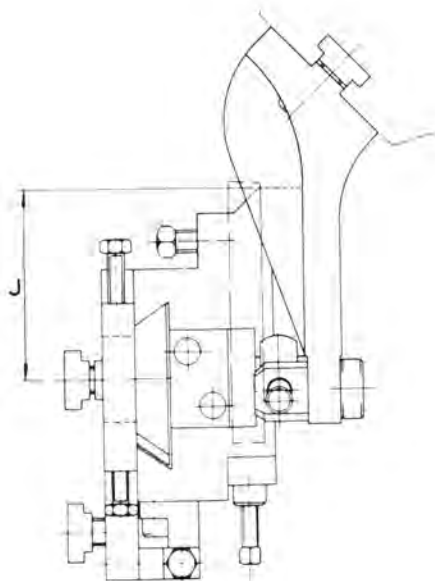
TOOLHOLDER for WICKMAN AUTOMATICS

LONG TURNING SLIDE

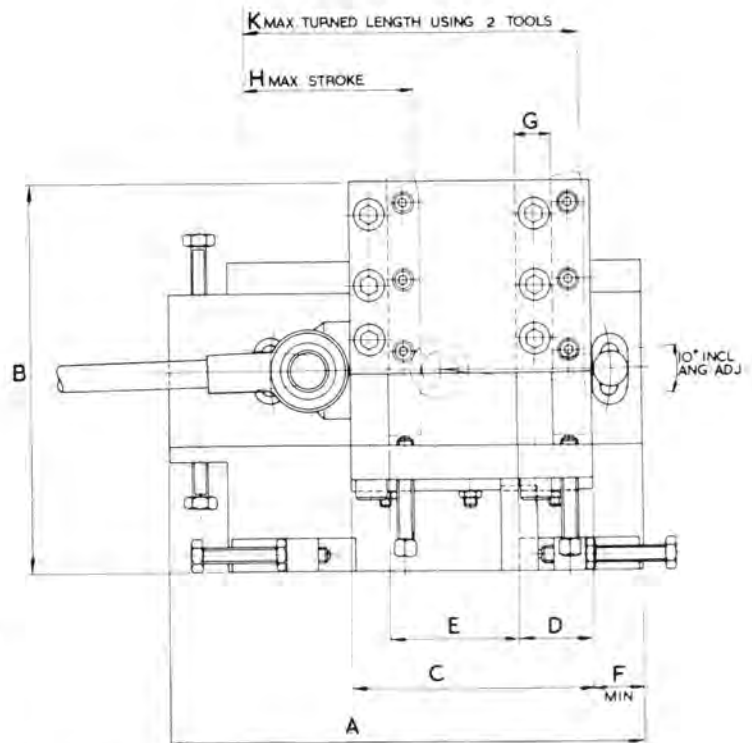
(STANDARD TYPE)

This toolholder can be used for operations such as shaft turning, light turning behind a shoulder, and taper turning up to a 10 degree angle. Mounted on the cross slide, the toolholder can be operated by a pusher rod from either the centre block or independent slide. See page 30 for long turning slide used in stations 1 and 4.

See page 32 for tools.



TOOL SECTION
0.37 (9.5MM) SQUARE x 3.00 (76.2MM) LONG



CROSS SLIDE MOUNTED STATIONS 2 & 5

Drg. No.	W6—058—67		Pusher and Toolbox Bracket Details			
	Dims.	Ins.	mm.	Station	Pusher Bracket	Toolbox Bracket
A	5.56	141.0	Centre Block	2	CS.758	DS.1533
B	4.50	114.5		5	CS.764	DS.1538
C	2.81	71.5	Ind. Slide	5	DS.1544	DS.1538
D	0.87	22.0				
E	1.50	38.0	Tool Size	Ins.	0.37 x 0.37 x 3.0	
F	0.41	10.5		mm.	9.5 x 9.5 x 76.0	
G	0.44	11.0				
H	2.00	51.0				
J	2.19	55.5				
K	3.94	100.0				



TOOLHOLDER *for* WICKMAN AUTOMATICS

TURNING TOOLS FOR LONG TURNING SLIDES NO's 66 AND 67

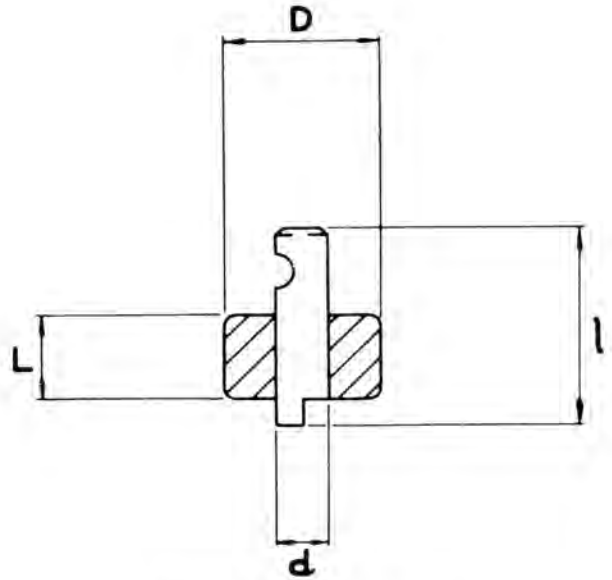
The tools listed below are for use in the long turning slides described on pages 30 and 31.

Tool Size		Tool Nos. HSS			Tool Nos. WIMET		
		Approach Angle			Approach Angle		
Ins.	0.37 × 0.37 × 3.00	0	15	45	0	15	45
mm.	9.5 × 9.5 × 76.0	WSP 424/22	WSP 424/23	WSP 424/24	AK73	AK74	AK75

TOOLHOLDER *for* WICKMAN AUTOMATICS

WIMET CARBIDE ROLLERS AND PINS FOR ROLLER BOX TOOLHOLDERS

Wimet carbide rollers and pins can be used in all Wickman roller turners and roller steadies when high surface speeds make the use of standard steel rollers and pins unsuitable. The Wimet rollers and pins are completely interchangeable with the equivalent steel rollers and pins.



STANDARD ROLLER

Roller M.S.R. 4s.

Pin M.S.P. 15s.



SECTION 2

CROSS SLIDE TOOLHOLDERS

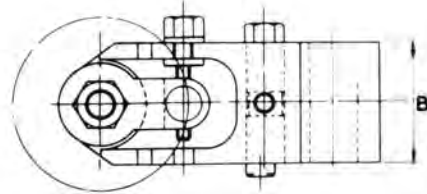
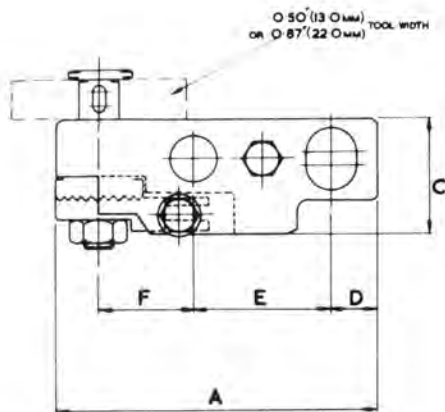
CIRCULAR FORM TOOLHOLDER (STANDARD TYPE)



The holder is designed with adjustment for setting the tool on centre, and also a secondary adjustment for obtaining maximum tool life. Complete interchangeability of the holder between all cross slide positions is achieved by provision of differing bases. When ordering holder state width of form tool, to enable correct clamping bolt to be supplied.

See pages 37 and 38 for details of interchangeable bases.

See page 39 for tool and clamping bolt details.



CROSS SLIDE MOUNTED STATIONS 1, 2, 3, 4 & 5

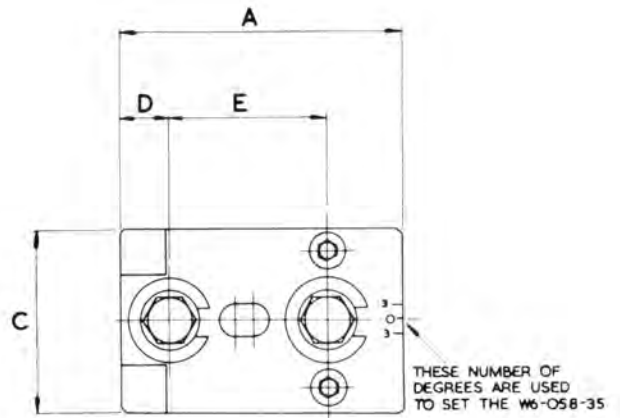
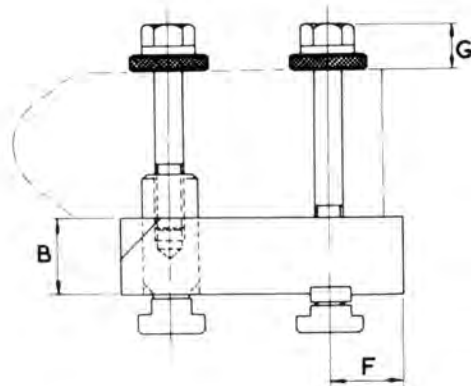
Drg. No.	W6—058—35	
Dims.	Ins.	mm.
A	4.12	105.0
B	1.56	39.5
C	1.50	38.0
D	0.62	16.0
E	1.75	44.5
F	1.19	30.0

TOOLHOLDER for WICKMAN AUTOMATICS

CIRCULAR FORM TOOLHOLDER BASE

The base is designed for use with the circular form toolholder on page 36. The toolholder is quickly released from the base by removal of two slip washers.

See page 38 for base used in stations 2, 3 and 5.



CROSS SLIDE MOUNTED STATIONS 1 & 4 ONLY

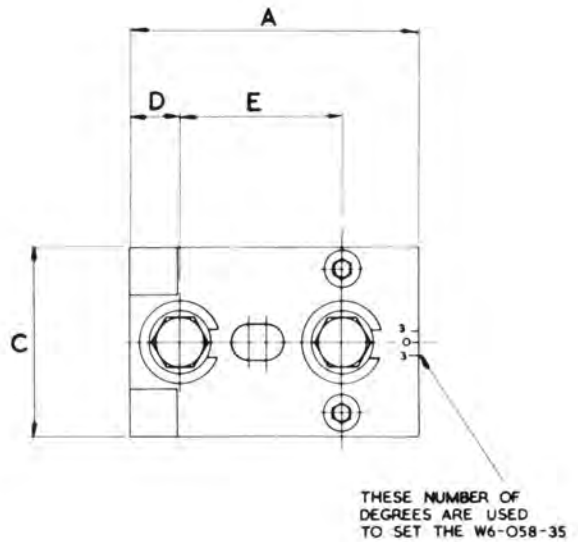
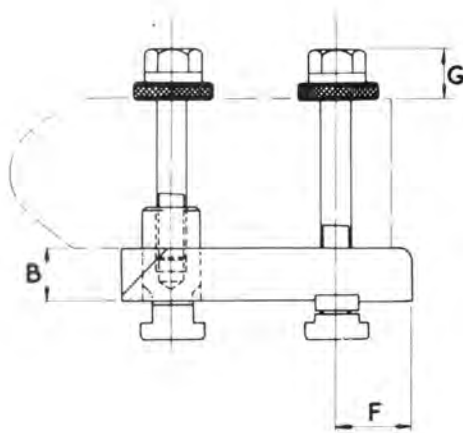
Drg. No.	W6-058-36	
Dims.	Ins.	mm.
A	3.12	79.5
B	0.87	22.0
C	2.00	51.0
D	0.56	14.5
E	1.75	44.5
F	0.81	20.5
G	0.53	13.5

CIRCULAR FORM TOOLHOLDER BASE



The base is designed for use with the circular form toolholder on page 36. The toolholder is quickly released from the base by removal of two slip washers.

See page 37 for base used in stations 1 and 4.



CROSS SLIDE MOUNTED STATIONS 2, 3* & 5

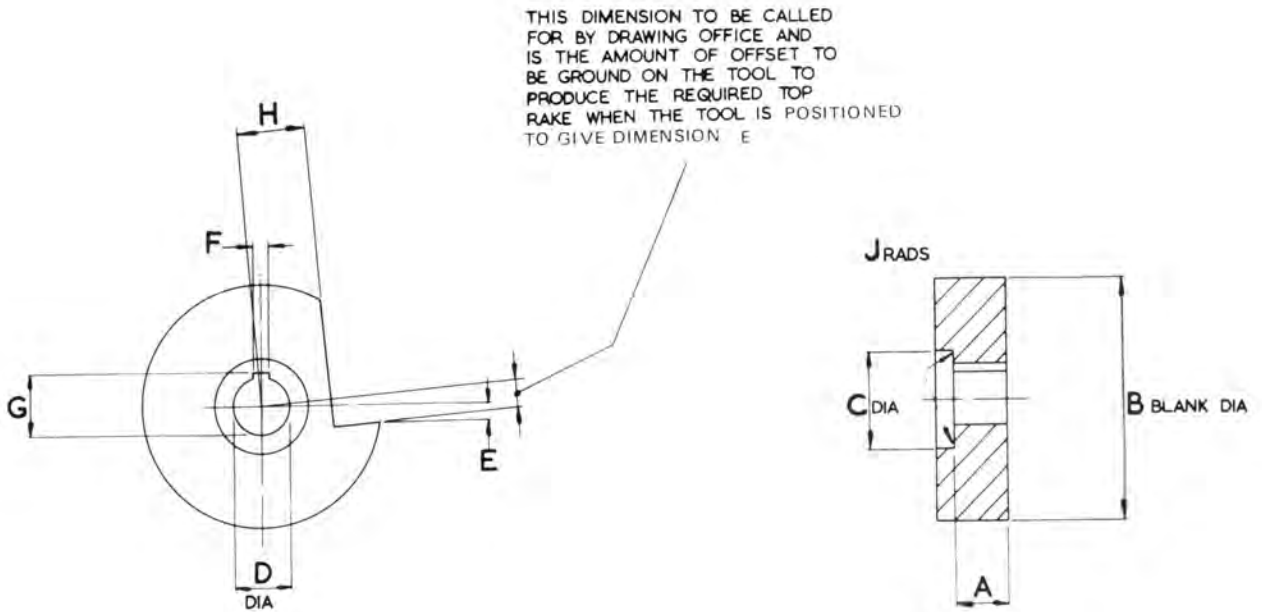
Drg. No.	W6-058-37	
Dims.	Ins.	mm.
A	3-12	79-5
B	0-56	14-5
C	2-00	51-0
D	0-56	14-5
E	1-75	44-5
F	0-81	20-5
G	0-53	13-5

CIRCULAR FORM TOOLS



Circular form tools for use in the holder described on page 36 can be supplied to special order.

Alternative clamping bolts to suit two sizes of form tools are available and are described below.



When using 0.50" (13 mm.) wide Tool use Clamping Bolt DS.1481/1.
 When using 0.87" (22 mm.) wide Tool use Clamping Bolt DS.1481/2.

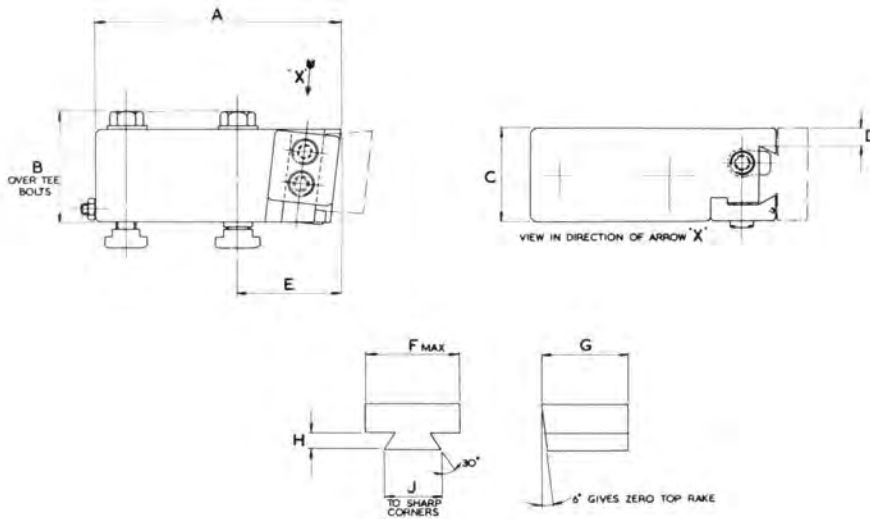
Dims.		Ins.	mm.
A	Ref. 1	0.50	13.0
	Ref. 2	0.87	22.0
B dia.		2.25	57.0
C dia.		0.87	22.0
D dia.		0.500	12.70
E		0.16	4.0
F		0.186	4.72
G		0.584	14.85
H		0.62	16.0
J rads.		0.015	0.4

DOVETAIL FORM TOOLHOLDER



The holder, which accommodates prismatic form tools, is used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.

See page 41 for toolholder used in stations 2, 3 and 5.



CROSS SLIDE MOUNTED STATIONS 1 & 4

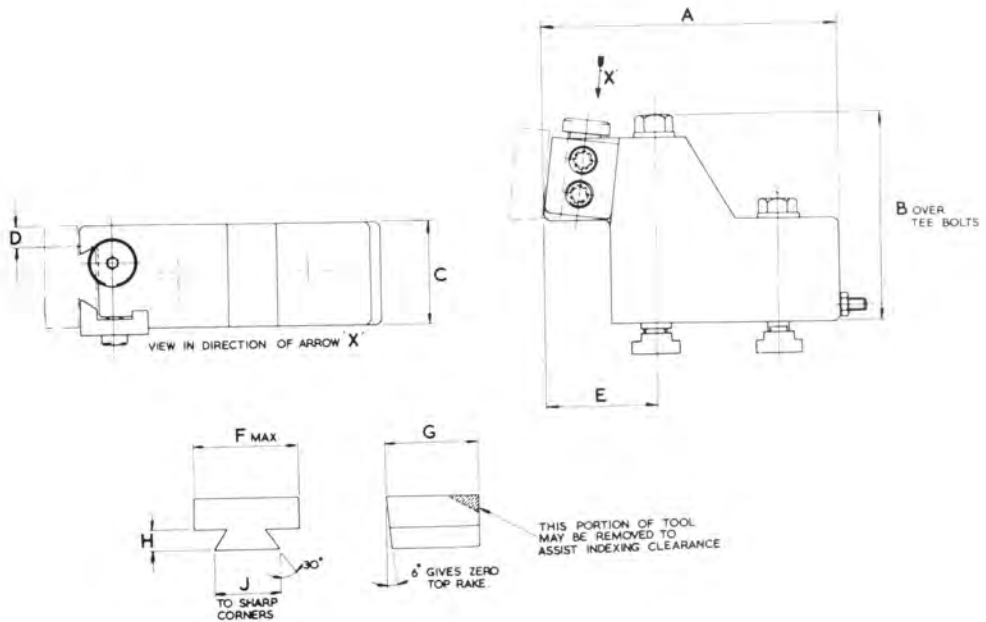
Drg. No.	W6—058—40	
Dims.	Ins.	mm.
A	3.87	98.5
B	1.78	45.0
C	1.50	38.0
D	0.28	7.0
E	1.62	41.5
F max.	1.50	38.0
G	1.37	35.0
H	0.29	7.5
J	0.951	24.15

TOOLHOLDER for WICKMAN AUTOMATICS

DOVETAIL FORM TOOLHOLDER

The holder, which accommodates prismatic form tools, is used when taking roughing or finishing cuts. An adjustment is provided for setting tool height.

See page 40 for toolholder used in stations 1 and 4.



CROSS SLIDE MOUNTED STATIONS 2, 3 & 5

Drg. No.	W6—058—41	
Dims.	Ins.	mm.
A	4.25	108.0
B	3.00	76.0
C	1.50	38.0
D	0.28	7.0
E	1.62	41.5
F max.	1.50	38.0
G	1.37	35.0
H	0.29	7.5
J	0.951	24.15

FLAT FORM TOOLHOLDER

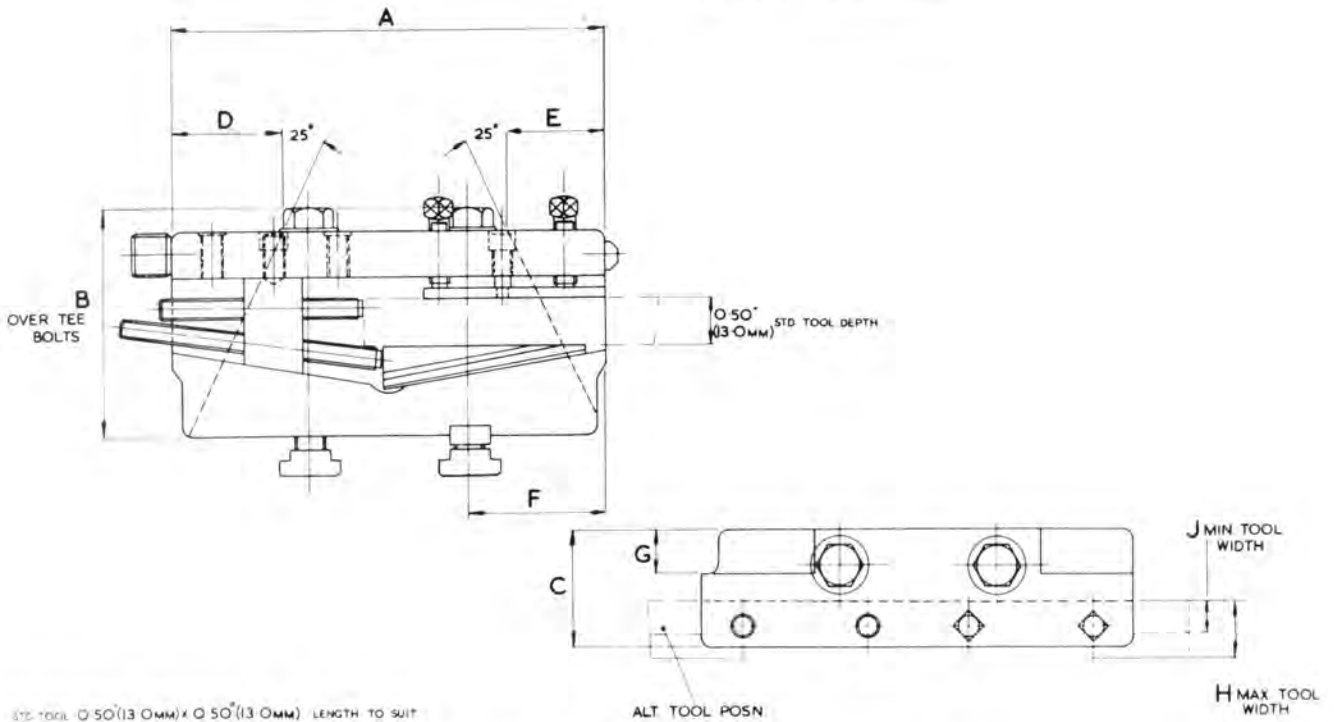
(REVERSIBLE)



Accommodating flat form tools, the holder is reversible for right or left-hand use. Ample adjustment is provided for bringing the tool on centre, and a back-up screw is incorporated to absorb end thrust.

See pages 43, 44 and 45 for other types of flat form toolholder.

See page 51 for tools.



CROSS SLIDE MOUNTED STATIONS 1 & 4

Drg. No.	W6-058-38	
Dims.	Ins.	mm.
A	4.75	120.5
B	2.56	65.0
C	1.31	33.5
D	1.25	31.5
E	1.06	27.0
F	1.50	38.0
G	0.50	13.0
Tool Widths		Length to Suit
H max.	0.62	16.0
J min.	0.37	9.5

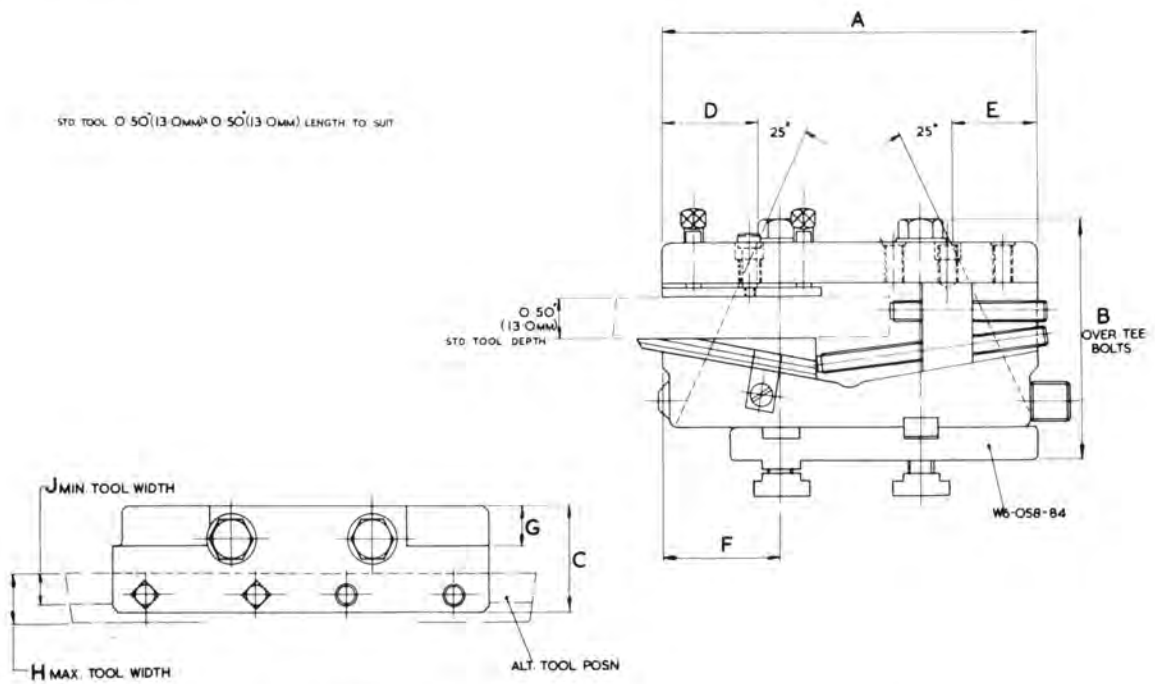
FLAT FORM TOOLHOLDER (REVERSIBLE)



Accommodating flat form tools, the holder is reversible for right or left-hand use. Ample adjustment is provided for bringing the tool on centre, and a back-up screw is incorporated to absorb end thrust. This toolholder consists of 1—off W6-058-38 with riser plate W6-058-84.

See pages 42, 44 and 45 for other types of flat form toolholder.

See page 51 for tools.



CROSS SLIDE MOUNTED STATIONS 2, 3 & 5

Drg. No.	W6-058-39	
Dims.	Ins.	mm.
A	4.75	120.5
B	2.96	75.5
C	1.31	33.5
D	1.25	31.5
E	1.06	27.0
F	1.50	38.0
G	0.50	13.0
Tool Widths Length to Suit		
H max.	0.62	16.0
J min.	0.37	9.5

FLAT FORM TOOLHOLDER

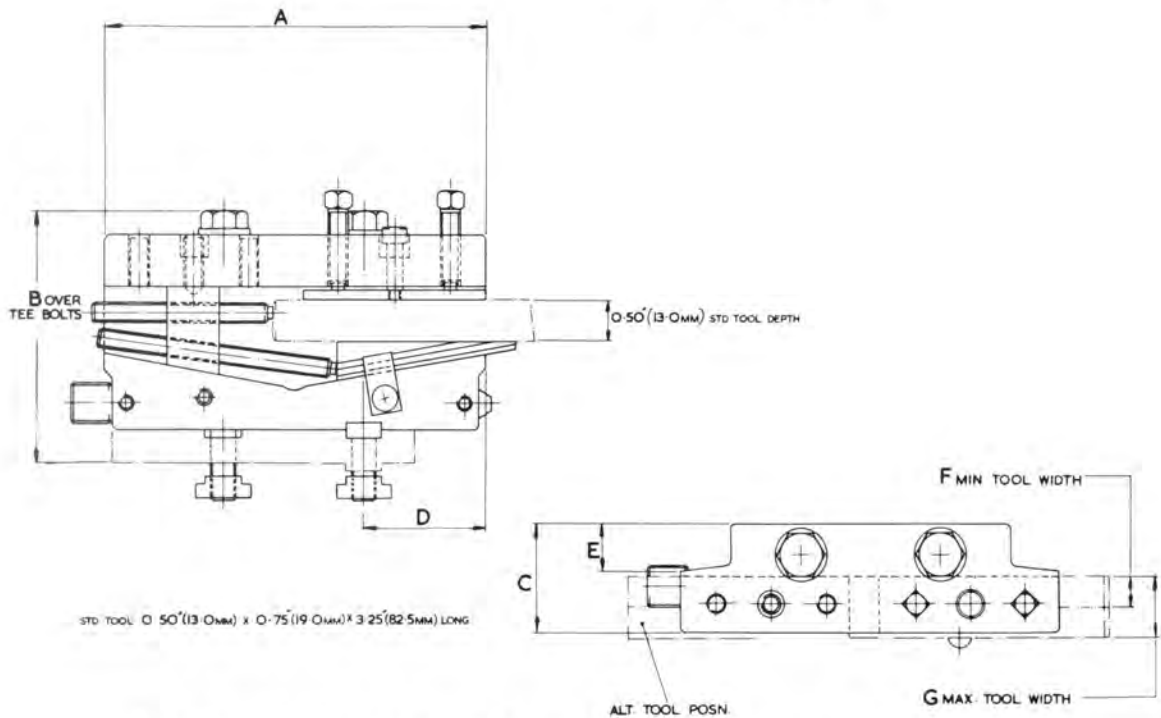
(WIDE REVERSIBLE TYPE)



For accommodating flat form tools wider than standard No. 39 Toolholder. Ample adjustment is provided for bringing the tool on centre, and a back-up screw is incorporated to absorb end thrust. This toolholder consists of 1—off W6-058-93 with riser plate W6-058-84.

See pages 42, 43 and 45 for other types of flat form toolholder.

See page 51 for tools.



CROSS SLIDE MOUNTED STATIONS 2, 3 & 5

Drg. No.	W6-058-89	
Dims.	Ins.	mm.
A	4.75	120.5
B	3.08	78.0
C	1.31	33.5
D	1.50	38.0
E	0.56	14.5
F	0.50	13.0
G	0.87	22.0

FLAT FORM TOOLHOLDER

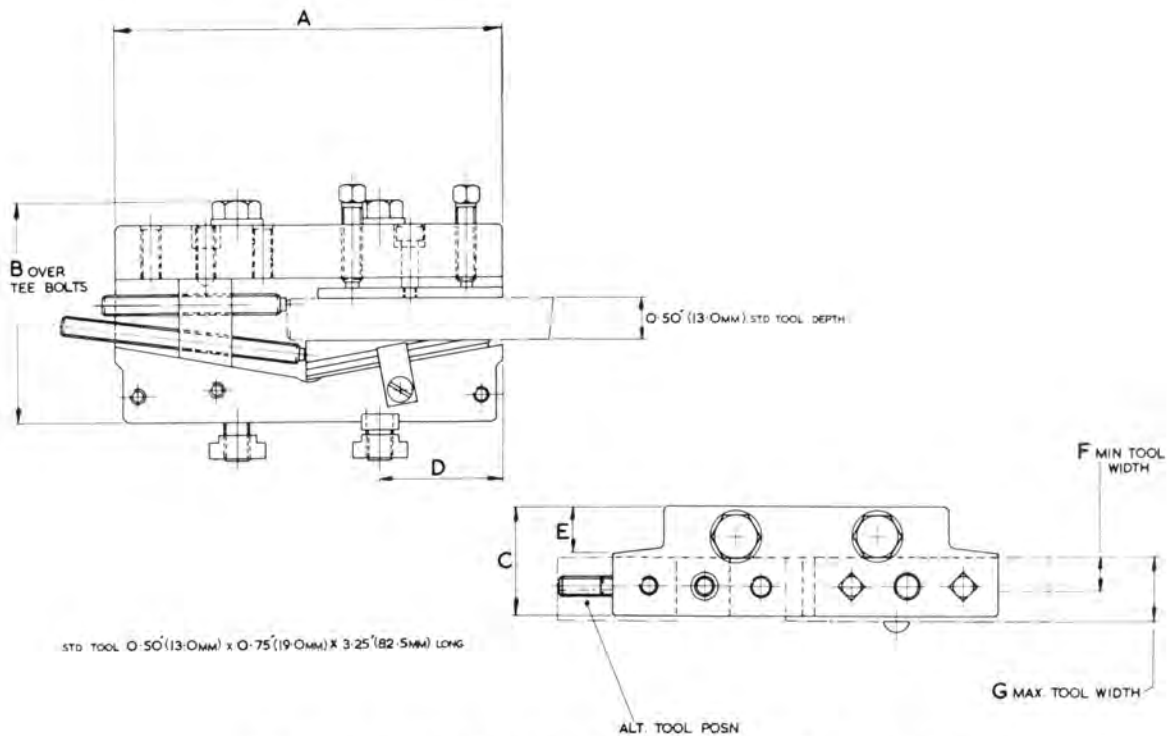
(WIDE REVERSIBLE TYPE)



For accommodating flat form tools wider than Standard No. 38 Toolholder. Ample adjustment is provided for bringing the tool on centre, and a back-up screw is incorporated to absorb end thrust.

See pages 42, 43 and 44 for other types of flat form toolholder.

See page 51 for tools.



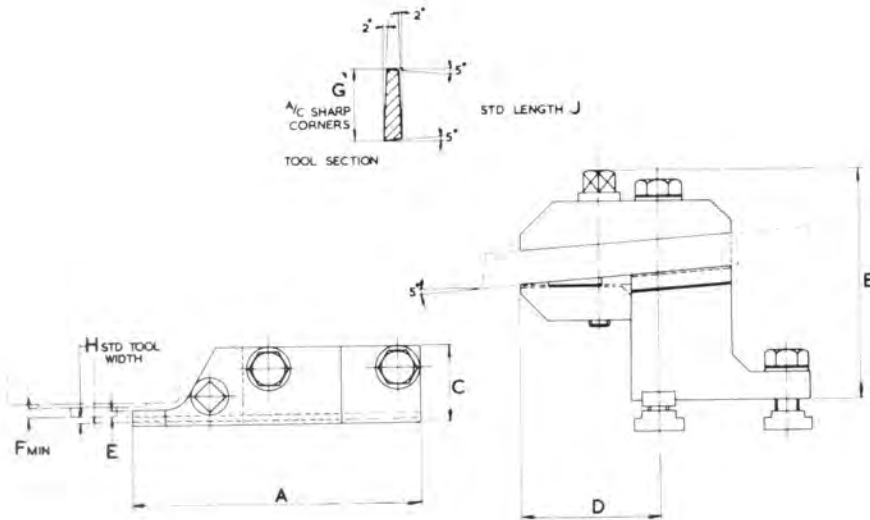
CROSS SLIDE MOUNTED STATIONS 1 & 4

Drg. No.	W6—058—93	
Dims.	Ins.	mm.
A	4.75	120.5
B	2.68	68.0
C	1.31	33.5
D	1.50	38.0
E	0.56	14.5
F	0.50	13.0
G	0.87	22.0

BLADE TOOLHOLDER



This toolholder accommodates blade-type tools. The tools are ground with clearance on both sides of the full length and require end grinding only. A 5 degree rake angle is machined into the toolholder.



CROSS SLIDE MOUNTED STATIONS 2, 3 & 5

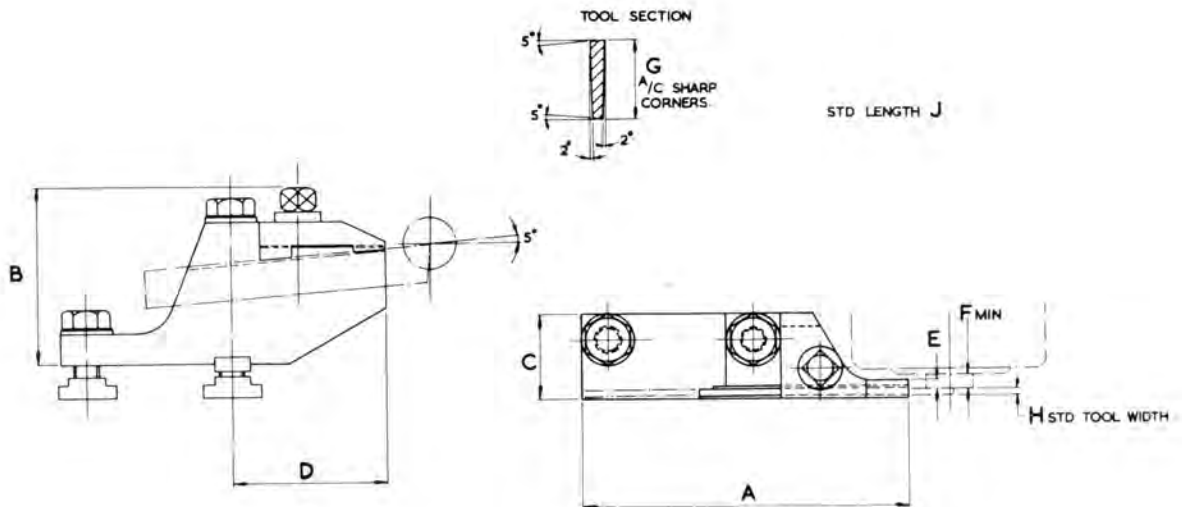
Drg. No.	W6-058-49	
Dims.	Ins.	mm.
A	3.94	100.0
B	3.19	81.0
C	1.06	27.0
D	1.87	47.5
E	0.09	2.5
F min.	0.12	3.0
G	0.500	12.70

STANDARD H.S.S. TOOLS

Drg. No.	H Width		J Length	
	Ins.	mm.	Ins.	mm.
WSP423/1	0.08	2.0	3.50	89.0
WSP423/2	0.08	2.0	4.50	114.0
WSP423/3	0.12	3.0	3.50	89.0
WSP423/4	0.12	3.0	4.50	114.0

PART-OFF TOOLHOLDER

This toolholder accommodates blade-type tools. The tools are ground with clearance on both sides of the full length and require end grinding only. A 5 degree rake angle is machined into the toolholder.



CROSS SLIDE MOUNTED STATIONS 1, 4 & 6

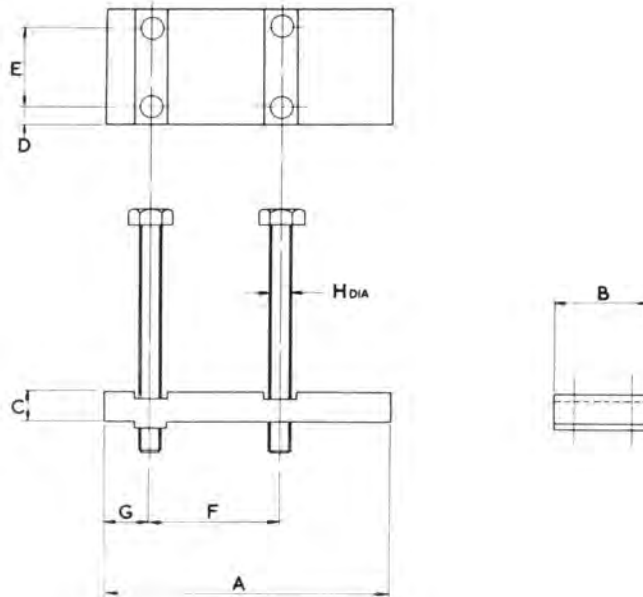
Dr. No.	W6-058-42	
Dims.	Ins.	mm.
A	3.94	100.0
B	2.19	55.5
C	1.06	27.0
D	1.87	47.5
E	0.09	2.5
F min.	0.12	3.0
G	0.500	12.70

STANDARD H.S.S. TOOLS

Dr. No.	H Width		J Length	
	Ins.	mm.	Ins.	mm.
WSP423/1	0.08	2.0	3.50	89.0
WSP423/2	0.08	2.0	4.50	114.0
WSP423/3	0.12	3.0	3.50	89.0
WSP423/4	0.12	3.0	4.50	114.0

RISER PLATE

This plate is used on stations 2, 3 and 5 to raise No. 38 and No. 93 Toolholders to the required centre height.



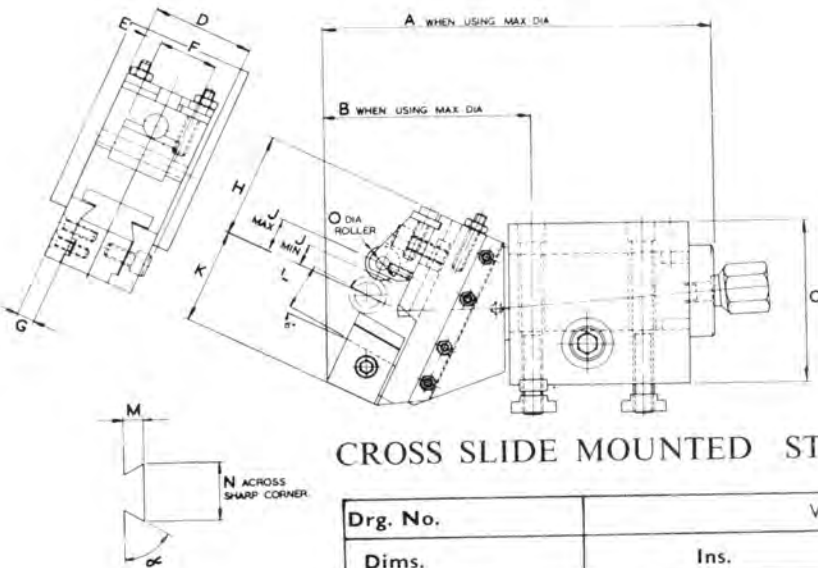
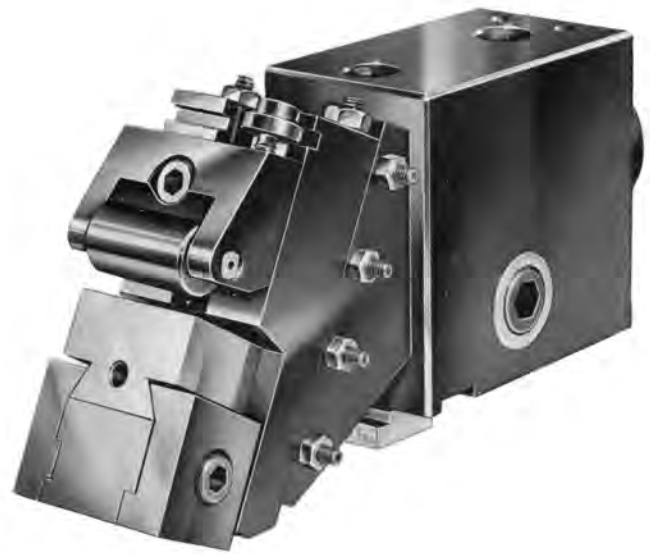
CROSS SLIDE MOUNTED STATIONS 2, 3 & 5

Drg. No.	W6-058-84	
Dims.	Ins.	mm.
A	3.87	98.5
B	1.31	33.5
C	0.406	10.32
D	0.37	9.5
E	0.56	14.5
F	1.75	44.5
G	0.62	16.0
H dia.	$\frac{5}{16}$ " BSF	

TOOLHOLDER for WICKMAN AUTOMATICS

SHAVING TOOLHOLDER

A shaving toolholder is used to maintain a close tolerance on a diameter. Large roller assemblies are fitted as standard, small roller assemblies are available as an optional extra.



CROSS SLIDE MOUNTED STATIONS 2, 3, 4 & 5

Drg. No.		W6-058-73	
Dims.	Ins.	mm.	
A	6.18	157.0	
B	3.31	84.0	
C	2.63	67.0	
D	1.56	39.5	
E (Small Roller Assembly)	0.25	6.5	
E (Large Roller Assembly)	0.31	8.0	
F	1.000	25.40	
G	0.28	7.0	
H	1.69	43.0	
K	1.56	39.5	
L	0.78	20.0	
M	0.28	7.0	
N	0.913	23.19	
		60°	

ROLLER ASSEMBLIES AND CAPACITY

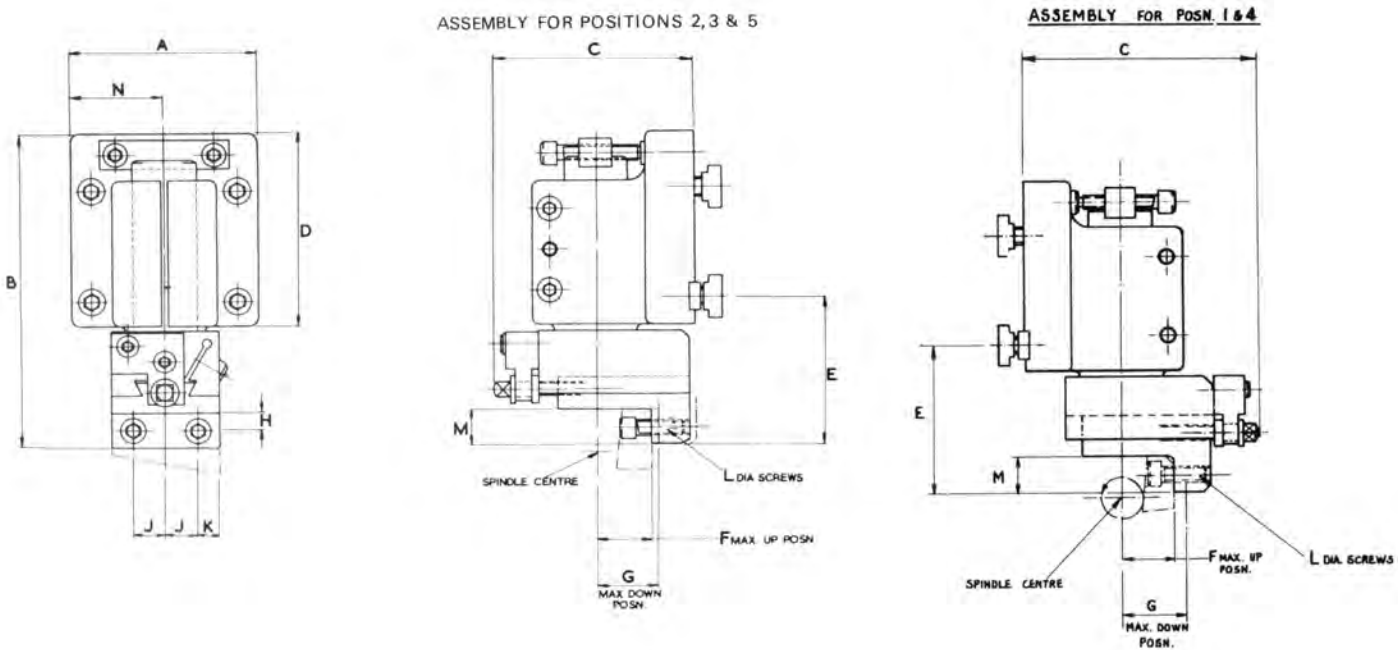
Large Roller Assembly				Small Roller Assembly			
Drg. No.		DS.1643		Drg. No.		DS.1647	
Dims.		Ins.	mm.	Dims.		Ins.	mm.
J	max.	0.56	14.0	J	max.	0.37	9.5
	min.	0.42	10.5		min.	0.23	6.0
O dia.		0.562	14.29	O dia.		0.375	9.52
Capacity	max.	0.56	14.0	Capacity	max.	0.37	9.5
	min.	0.28	7.0		min.	0.09	2.5



TOOLHOLDER for WICKMAN AUTOMATICS

SKIVING TOOLHOLDER

The skiving operation is used to produce a good finish on a diameter where finish is more important than size.

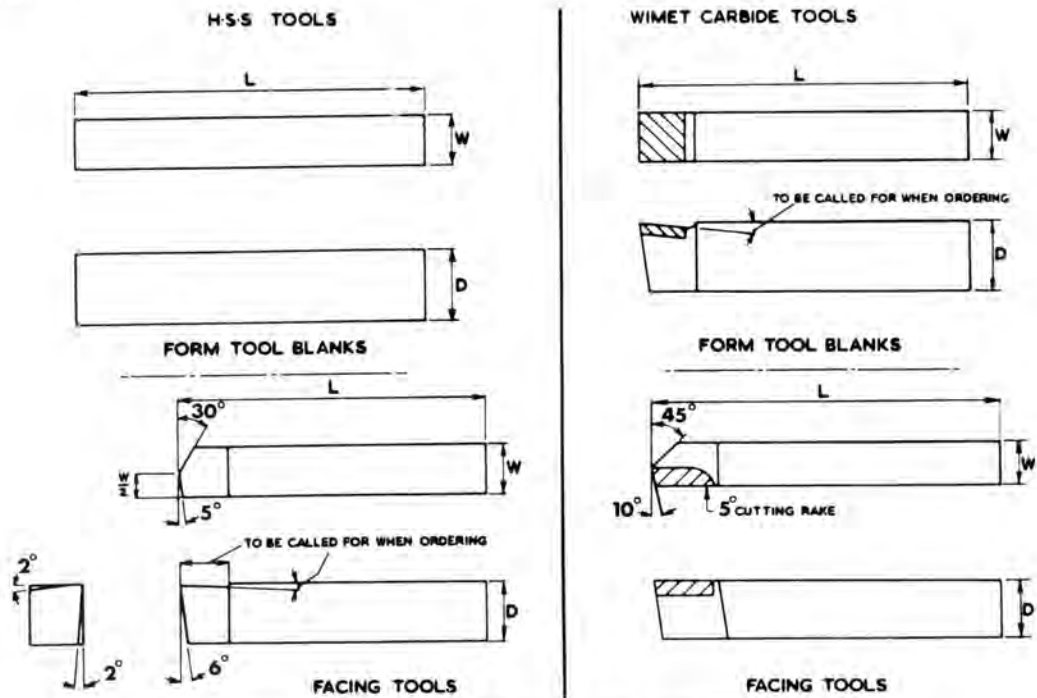


CROSS SLIDE MOUNTED STATIONS 1, 2, 3, 4 & 5

Drg. No.	W6-058-72	
Dims.	Ins.	mm.
A	2.87	73.0
B	4.94	125.5
C	3.06	77.5
D	3.06	77.5
E	2.31	58.5
F	0.56	14.5
G	0.94	24.0
H	0.28	7.0
J	0.50	13.0
K	0.34	8.5
L dia.	1/4" BSF	—
M	0.56	14.5
N	1.44	36.5

TOOL BLANKS AND FACING TOOLS

Flat tool blanks and facing tools, suitable for various flat toolholders, can be supplied from stock in the following sizes.



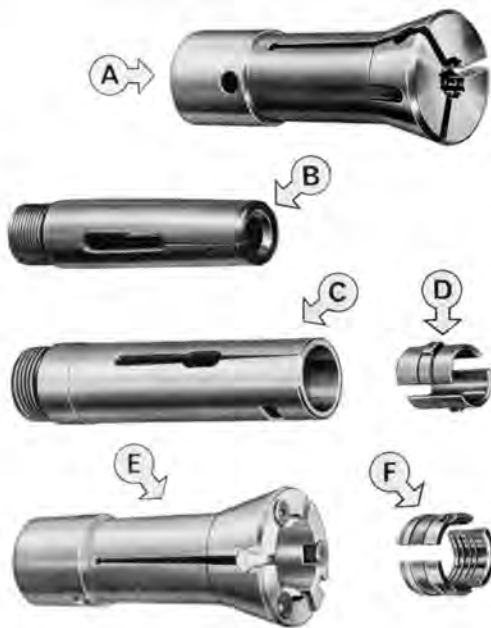
Matl.	Tool No.	Form Tool Blank						Used in Holder No.
		D		W		L		
		Ins.	mm.	Ins.	mm.	Ins.	mm.	
H.S.S.	WSP 410/080828	0.50	12.5	0.50	12.5	3.50	89.0	38 & 39
WIMET	AR11	0.50	12.5	0.50	12.5	3.50	89.0	38 & 39
H.S.S.	WSP 410/081228	0.50	12.5	0.75	19.0	3.50	89.0	89 & 93
WIMET	AR12	0.50	12.5	0.75	19.0	3.50	89.0 F	89 & 93
Matl.	Tool No.	Facing Tool						Used in Holder No.
		D		W		L		
		Ins.	mm.	Ins.	mm.	Ins.	mm.	
H.S.S.	WSP 439/6	0.50	12.5	0.50	12.5	3.50	89.0	38 & 39
WIMET	AF9	0.50	12.5	0.63	16.0	3.50	89.0	38 & 39
H.S.S.	WSP 439/6	0.50	12.5	0.50	12.5	3.50	89.0	89 & 93
WIMET	AF9	0.50	12.5	0.63	16.0	3.50	89.0	89 & 93



SECTION 3

**COLLETS, FEED FINGERS ETC.,
DIEHEADS, & DIEHEAD YOKES**

COLLETS AND FEED FINGERS FOR WICKMAN BAR AUTOMATICS



The collets illustrated (for the Bar Automatics) are:

- A. Solid Spring Collet
- B. Solid Spring Feed Finger
- C. Master Feed Finger
- D. Changeable Pad for Master Feed Finger
- E. Master Collet
- F. Changeable Pad for Master Collet

For use in the manufacture of large batches of components from the same size stock.

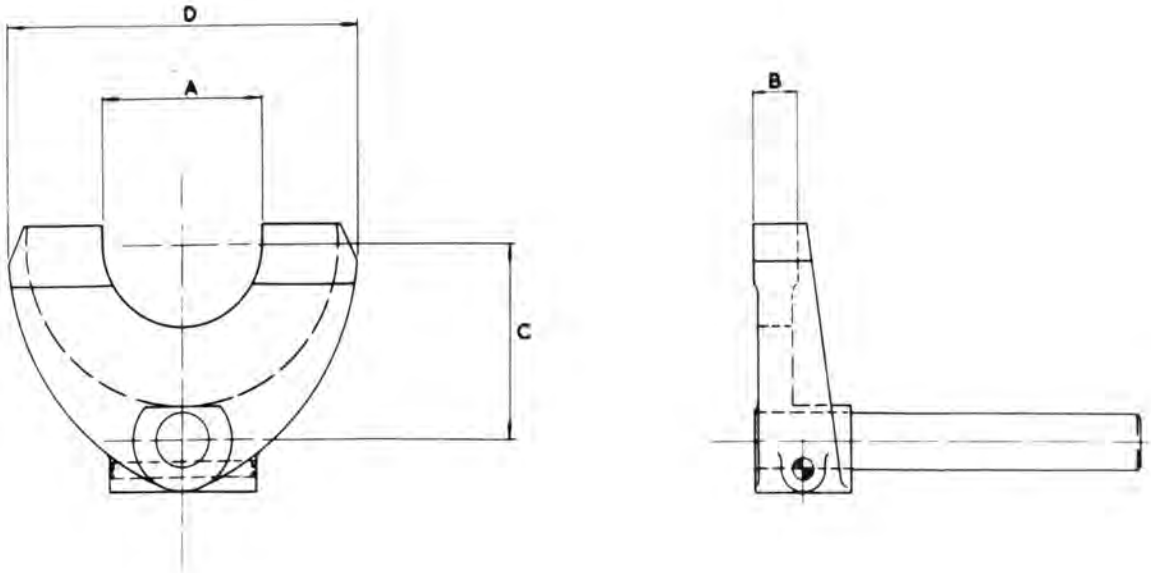
For use in the manufacture of small quantities of components from different sizes of stock.

The Master Collet and Master Feed Finger can also be used on long runs if required. The pads are easily changed without removing the collet from the machine.

Part Name	Drg. No.	Qty. Per Set	Capacity		
			Rd.	Hex. A/F	Sq. A/F
Solid Spring Collet	CS.666A	6	0.62	0.54	0.42
			15.5	14.0	10.5
Solid Feed Finger	CS.667A	6	0.62	0.54	0.42
			15.5	14.0	10.5
Master Collet	CS.831	6	—	—	—
			—	—	—
Master Collet Pads	DS.1771	6 × 3	0.56	0.50	0.41
			14.5	12.5	10.5
Master Collet Pad Screw	DS.1772	6 × 3	—	—	—
			—	—	—
Master Feed Finger Style 'B'	CS.832	6	—	—	—
			—	—	—
Master Feed Finger Pads	DS.1773	6 × 2	0.50	0.44	0.36
			12.5	11.0	9.0
Feed Tube Steady Bush	DS.1146	6	—	—	—
			—	—	—
High Speed Drilling Collet	Erickson 300 Series	1	max.	0.25	6.5
			min.	0.015	0.40
Pick-up Attach Collet	CS.775A/1	1	Up to	0.50	12.5
	CS.775A/2	1	From .5	To 0.62	15.5

DIEHEADS AND DIEHEAD YOKES

The yoke sleeve is supplied as a separate item.



DIE-HEAD YOKE

Diehead Size and Type	Stations 1, 2, 3, 4, 5 & 6						Attachment Bore 0.750 ins. 19.05 mm. dia.						Diehead Modification i.e., Std. Shank or Special
	Maker's Shank Dia.		Yoke No.	Sleeve No.	A		B		C		D		
	Ins.	mm.			Ins.	mm.	Ins.	mm.	Ins.	mm.	Ins.	mm.	
1/2" LANDEX	0.750	19.05	486 x 156	486 x 149A	2.130	53.97	0.280	7.11	1.969	50.00	2.94	74.6	Std.
3/8" LANDEX	1.000	25.40	486 x 155		2.505	63.63	0.370	9.40	1.969	50.00	3.31	84.0	Special
7/16" NAMCO	0.750	19.05	486 x 150		1.380	35.05	0.370	9.40	1.969	50.00	2.25	57.15	Std.
5/16" NAMCO	1.500	38.10	486 x 151		1.849	46.96	0.560	14.22	1.969	50.00	2.75	69.85	Special
1/4" CHS COVENTRY	0.625	15.87	486 x 152		1.505	38.23	0.185	4.70	1.969	50.00	2.31	58.6	Special
1/2" CHS COVENTRY	1.000	25.40	486 x 155		2.505	63.63	0.370	9.40	1.969	50.00	3.31	84.0	Special