

# WICKMAN

**Multi Spindle Autos  
Speeds, Feeds and Capacities**



## BAR MACHINES

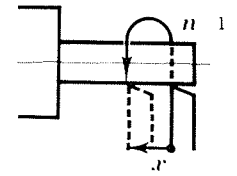
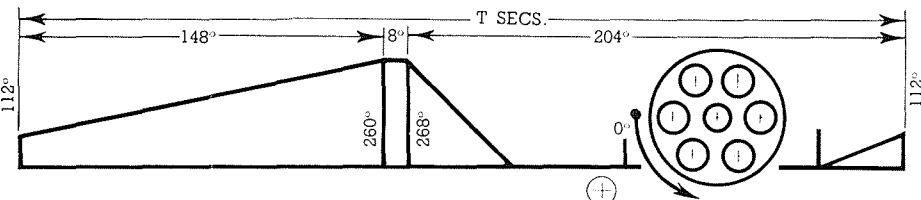
Machine	Chart	Page No.	Machine	Chart	Page No.
5/8"-6	Standard Speed & Feed Chart	4.1	2.1/4"-6	Standard Feed & Speed Chart	3.1
	Standard Spindle Stopping	4.2		Standard Long Bar Feed	3.2
	Capacity Chart	4.10		Capacity Chart	3.10
1"-6	Standard Feed & Speed Chart	1.1	2.5/8"-6	Capacity Chart	3.11
	Special Fast Index	1.2		Standard Feed & Speed Chart	5.2
	Standard Long Bar Feed	1.3		Capacity Chart	5.12
	Standard Spindle Stopping	1.4	Capacity Chart	5.13	
	Spindle Stopping Fast Index	1.5	3.1/4"-6	Standard Feed & Speed Chart	5.3
	Capacity Chart	1.10		Capacity Chart	5.12
1"-8	Capacity Chart	1.11	Capacity Chart	5.13	
	Standard Feed & Speed Chart	2.15	3.1/2"-4	Standard Feed & Speed Chart	5.4
	Standard Spindle Stopping	2.16		Capacity Chart	5.14
	Capacity Chart – English & Metric	2.17 & 18		Capacity Chart	5.15
	Capacity Chart – English & Metric	2.19 & 20			
	Capacity Chart	2.21	4.1/8"-4	Standard Feed & Speed Chart	5.5
1/3/8"-6	Standard Feed & Speed Chart	2.1		Capacity Chart	5.14
	Standard Long Bar Feed	2.2		Capacity Chart	5.15
	Capacity Chart	2.10	1.3/4"-5	Standard Feed & Speed Chart	6.1
	Capacity Chart	2.11		Capacity Chart	6.10
1.3/4"-6	Standard Feed & Speed Chart	2.4	Capacity Chart	6.11	
	Standard Long Bar Feed	2.5	2.1/4"-5	Standard Feed & Speed Chart	6.2
	Capacity Chart	2.10		Capacity Chart	6.10
	Capacity Chart	2.11		Capacity Chart	6.11
1.3/4"-8	Standard Feed & Speed Chart	5.1			
	Capacity Chart	5.10			
	Capacity Chart	5.11			

## CHUCKING MACHINES

Machine	Chart	Page No.
5.5/8"-6	Standard Feed & Speed Chart	2.8
	Double Index	2.9
	Capacity Chart	2.12
	Capacity Chart	2.13
6.5/8"-6	Standard Feed & Speed Chart –	
	960 r.p.m. Motor	3.3
	1450 r.p.m. Motor	3.4
	Double Index Speed & Feed Chart	3.5
	Capacity Chart	3.12
	Capacity Chart	3.13
7.1/4"-6	Standard Feed & Speed Chart –	
	960 r.p.m.	5.6
	1450 r.p.m. Motor	5.7
	Capacity Chart	5.16
	Capacity Chart	5.17
9"-4	Standard Feed & Speed Chart –	
	960 r.p.m. Motor	5.8
	1450 r.p.m. Motor	5.9
	Capacity Chart	5.18
	Capacity Chart	5.19
6"-5	Standard Feed & Speed Chart	6.5
	Slow Feed & Speed Chart	6.6
	Capacity Chart	6.12
	Capacity Chart	6.13
6"-8	Standard Feed & Speed Chart – 1450 r.p.m. Motor	5.20
	Special Feed & Speed Chart – 960 r.p.m. Motor	5.21
	Double Index Speed & Feed Chart	5.22
	Capacity Chart	5.23
	Capacity Chart	5.24

# Wickman 1"-6

A		58	56	54	51	49	46	44	41	39	36	34	32	B		58	56	54	51	49	46	44	41	39	36	34	32	n(148°)		n(8°)		L			
B		32	34	36	39	41	44	46	49	51	54	56	58	n(148°)		n(8°)		L		r (0.01 M.M.)		r (0.001")													
N MIN		3030	2750	2510	2190	2000	1750	1600	1400	1280	1115	1015	923	n(148°)		n(8°)		L		r (0.01 M.M.)		r (0.001")													
		2.5	5	7.5	10	20	25	60	MM		r (0.01 M.M.)		r (0.001")																						
		1/4	1/2	3/4	1	2	2 1/2	INS		r (0.01 M.M.)		r (0.001")																							
64	21			2.5	2.7	2.8	3.0	3.2	3.4	3.6	3.9	4.2	4.4	4.9	5.2	5.6	6.2	6.7	7.4	8.0	8.9	9.6	10.8	11.8	12.8	45	2.4	5.6	11.2	16.8	22	45	56	134	
61	23	2.4	2.6	2.7	2.9	3.0	3.2	3.4	3.7	3.9	4.3	4.6	4.9	5.4	5.8	6.2	6.9	7.4	8.3	9.0	10.0	10.9	12.3	13.3	14.5	51	2.8	4.9	9.7	14.6	20	39	49	117	
59	25	2.6	2.7	2.8	3.0	3.2	3.5	3.7	4.0	4.2	4.7	5.0	5.3	5.9	6.3	6.8	7.6	8.2	9.2	9.9	11.1	12.0	13.6	14.8	16.2	58	3.1	4.3	8.7	13.0	17.3	35	43	104	
56	27	2.7	2.9	3.0	3.3	3.5	3.8	4.0	4.3	4.6	5.1	5.5	5.9	6.5	7.0	7.6	8.5	9.1	10.3	11.1	12.5	13.5	15.3	16.7	18.2	66	3.6	3.8	7.6	11.4	15.2	31	38	91	
54	30	3.0	3.1	3.3	3.6	3.8	4.1	4.4	4.8	5.1	5.7	6.1	6.6	7.3	7.9	8.5	9.6	10.3	11.6	12.6	14.2	15.4	17.4	19.0	21	76	4.1	3.3	6.6	9.9	13.2	26	33	79	
51	32	3.2	3.3	3.5	3.9	4.1	4.5	4.8	5.2	5.6	6.2	6.7	7.2	8.0	8.7	9.4	10.6	11.5	12.9	14.0	15.8	17.2	19.5	21	23	86	4.6	2.9	5.8	8.8	11.7	23	29	70	
49	35	3.4	3.6	3.8	4.2	4.5	4.9	5.2	5.8	6.2	6.9	7.4	8.0	9.0	9.7	10.5	11.9	12.9	14.5	15.7	17.8	19.3	22	24	26	97	5.3	2.6	5.1	7.7	10.3	21	26	62	
46	38	3.7	4.0	4.2	4.6	4.9	5.4	5.8	6.5	6.9	7.8	8.4	9.1	10.1	11.0	12.0	13.5	14.7	16.6	18.0	20	22	25	28	30	113	6.1	2.2	4.4	6.7	8.9	17.8	22	53	
43	41	4.1	4.4	4.7	5.1	5.5	6.1	6.5	7.3	7.8	8.8	9.5	10.3	11.5	12.5	13.6	15.4	16.7	18.9	21	23	25	29	32	35	130	7.0	1.9	3.9	5.8	7.7	15.4	19.2	46	
41	43	4.4	4.7	5.0	5.5	5.9	6.5	7.0	7.8	8.4	9.5	10.3	11.2	12.5	13.6	14.8	16.8	18.3	21	23	26	28	32	35	38	143	7.7	1.8	3.5	5.3	7.0	14.0	17.5	42	
38	46	4.8	5.2	5.5	6.1	6.6	7.3	7.9	8.8	9.5	10.7	11.7	12.7	14.2	15.5	16.9	19.2	21	24	26	29	32	36	40	44	165	8.9	1.5	3.0	4.6	6.1	12.1	15.2	36	
35	49	5.4	5.8	6.2	6.9	7.4	8.3	8.9	10.0	10.8	12.2	13.3	14.5	16.2	17.7	19.3	22	24	27	30	34	37	42	46	50	191	10.3	1.3	2.6	3.9	5.2	10.5	13.1	32	
32	51	5.9	6.4	6.9	7.7	8.2	9.2	10.0	11.2	12.1	13.7	14.9	16.3	18.3	20	22	25	27	31	33	38	42	47	52	57	217	11.7	1.2	2.3	3.5	4.6	9.2	11.5	28	
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27	56	7.3	7.9	8.5	9.6	10.3	11.6	12.6	14.1	15.4	17.4	19.0	21	23	26	28	32	35	40	43	49	54	61	67	74	283	15.3	.9	1.8	2.7	3.5	7.1	8.9	21	
25	59	8.1	8.8	9.5	10.7	11.6	13.0	14.1	15.9	17.3	19.6	21	23	26	29	32	36	39	45	49	56	61	70	76	84	322	17.4	.8	1.6	2.3	3.1	6.2	7.8	18.7	
23	61	8.9	9.7	10.5	11.8	12.8	14.4	15.7	17.7	19.2	22	24	26	30	32	35	40	44	50	55	62	68	78	85	94	361	19.5	.7	1.4	2.1	2.8	5.5	6.9	16.6	
21	64	10.0	10.9	11.8	13.4	14.5	16.4	17.8	20	22	25	27	30	34	37	41	46	51	58	63	72	78	89	98	108	415	23	.6	1.2	1.8	2.4	4.8	6.0	14.5	
18	66	11.8	12.8	14.0	15.8	17.2	19.5	21	24	27	30	33	36	40	44	48	55	60	69	75	86	94	107	118	129	500	27	.5	1.0	1.5	2.0	4.0	5.0	12.0	
F	H	T SECS.																								n(148°)		n(8°)		L		r (0.01 M.M.)		r (0.001")	



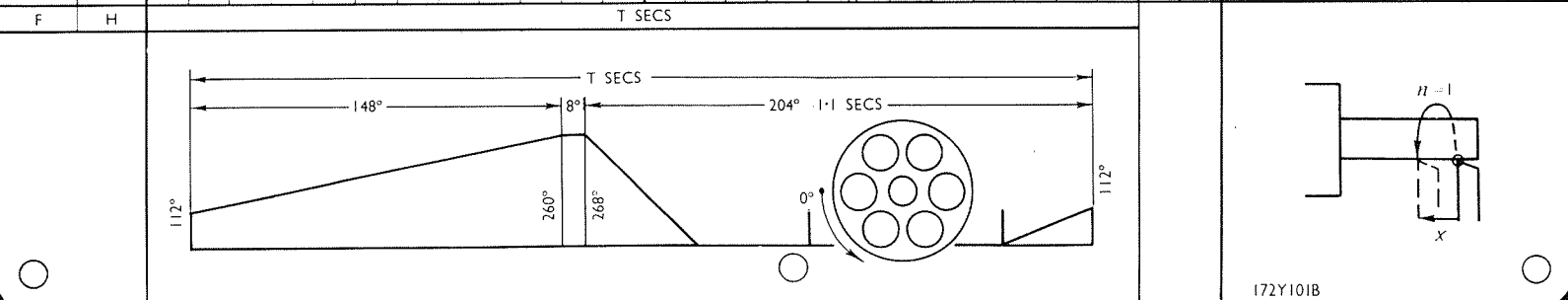
Standard Machine

172Y103

# Wickman

# 1"-6

A		N/MIN																N (148°)		N (8°)		L							mm.		ins.					
B		N/MIN																N (148°)		N (8°)		L							mm.		ins.					
N/MIN		N/MIN																N (148°)		N (8°)		L							mm.		ins.					
N/MIN		N/MIN																N (148°)		N (8°)		L							mm.		ins.					
64	21	2-1	2-2	2-3	2-5	2-6	2-8	3-0	3-2	3-4	3-7	4-0	4-3	4-7	5-1	5-5	6-1	6-6	7-4	7-9	8-9	9-6	10-9	11-9	12-9	46	2-5	5-4	10-8	16-3	22	43	54	130		
61	23	2-2	2-3	2-5	2-7	2-8	3-1	3-2	3-5	3-8	4-1	4-4	4-8	5-3	5-7	6-1	6-9	7-4	8-3	9-0	10-1	10-9	12-4	13-5	14-7	53	2-9	4-7	9-4	14-2	18-9	38	47	113		
59	25	2-4	2-5	2-6	2-9	3-0	3-3	3-5	3-8	4-1	4-5	4-8	5-2	5-8	6-2	6-7	7-6	8-2	9-2	9-9	11-2	12-1	13-8	15-0	16-4	60	3-2	4-2	8-4	12-6	16-8	34	42	101		
56	27	2-5	2-7	2-8	3-1	3-3	3-6	3-8	4-2	4-5	5-0	5-4	5-8	6-4	6-9	7-5	8-5	9-1	10-3	11-1	12-6	13-6	15-5	16-9	18-5	68	3-7	3-7	7-4	11-1	14-8	30	37	89		
54	30	2-8	2-9	3-1	3-4	3-6	4-0	4-2	4-7	5-0	5-6	6-0	6-5	7-2	7-8	8-5	9-6	10-4	11-7	12-7	14-3	15-6	17-7	19-3	21	78	4-2	3-2	6-4	9-6	12-8	26	32	77		
51	32	3-0	3-2	3-4	3-7	3-9	4-3	4-6	5-1	5-5	6-1	6-6	7-2	8-0	8-7	9-4	10-7	11-6	13-0	14-1	16-0	17-4	19-8	22	24	88	4-8	2-8	5-7	8-5	11-4	23	28	68		
49	35	3-2	3-4	3-7	4-0	4-3	4-8	5-1	5-7	6-1	6-8	7-4	8-0	9-0	9-7	10-6	12-0	13-0	14-7	16-0	18-1	20	22	24	27	100	5-4	2-5	5-0	7-5	10	20	25	60		
46	38	3-6	3-8	4-1	4-5	4-8	5-3	5-7	6-4	6-9	7-7	8-4	9-1	10-2	11-1	12-1	13-7	14-9	16-8	18-3	21	23	26	28	31	116	6-3	2-2	4-3	6-5	8-6	17-2	22	52		
43	41	3-9	4-2	4-5	5-0	5-4	6-0	6-4	7-2	7-8	8-7	9-5	10-3	11-6	12-6	13-7	15-6	17-0	19-2	21	24	26	30	32	35	134	7-2	1-9	3-7	5-6	7-5	14-9	18-7	45		
41	43	4-2	4-5	4-9	5-4	5-8	6-5	7-0	7-8	8-4	9-5	10-3	11-2	12-6	13-8	15-0	17-1	18-6	21	23	26	28	32	35	39	147	8-0	1-7	3-4	5-1	6-8	13-6	17	41		
38	46	4-7	5-0	5-4	6-1	6-5	7-3	7-9	8-8	9-6	10-8	11-7	12-8	14-4	15-7	17-2	19-5	21	24	26	30	33	37	41	45	170	9-2	1-5	2-9	4-4	5-9	11-8	14-7	35		
35	49	5-2	5-7	6-1	6-8	7-4	8-3	8-9	10-0	10-9	12-3	13-4	14-6	16-5	18-0	19-7	22	24	28	30	34	38	43	47	52	197	10-6	1-3	2-5	3-8	5-1	10-2	12-7	31		
32	51	5-8	6-3	6-8	7-6	8-2	9-2	10-0	11-3	12-2	13-8	15-1	16-5	18-6	20	22	25	28	31	34	39	43	49	53	59	224	12-1	1-1	2-2	3-4	4-5	8-9	11-2	27		
30	54	6-4	6-9	7-5	8-5	9-1	10-3	11-1	12-6	13-6	15-5	16-9	18-5	21	23	25	29	31	35	39	44	48	55	60	66	253	13-7	1-0	2-0	3-0	4-0	7-9	9-9	24		
27	56	7-2	7-8	8-5	9-6	10-4	11-7	12-7	14-3	15-6	17-7	19-3	21	24	26	29	33	36	41	44	50	55	63	69	76	292	15-8	-9	1-7	2-6	3-4	6-9	8-6	21		
25	59	8-1	8-8	9-5	10-7	11-6	13-1	14-3	16-1	17-5	20	22	24	27	30	32	37	40	46	50	57	62	71	78	86	332	18	-8	1-5	2-3	3-0	6-0	7-5	18		
23	61	8-9	9-7	10-5	11-9	12-9	14-6	15-9	18-0	19-6	22	24	27	30	33	36	41	45	52	56	64	70	80	88	97	373	20	-7	1-3	2-0	2-7	5-4	6-7	16		
21	64	10-1	11-0	11-9	13-5	14-7	16-6	18-1	21	22	25	28	31	35	38	42	47	52	59	64	73	80	92	101	111	428	23	-6	1-2	1-8	2-3	4-7	5-8	14		
18	66	11-9	13-0	14-1	16-0	17-4	19-8	22	24	27	30	33	37	41	45	50	56	62	71	77	88	96	110	121	133	516	28	-5	1-0	1-5	1-9	3-9	4-9	11.6		

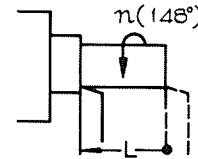
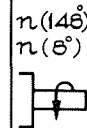
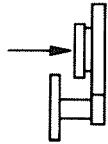
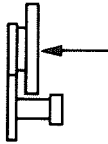
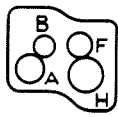


Special  
Fast Index  
1.1 secs

1.2

172Y101B

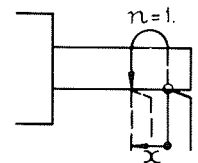
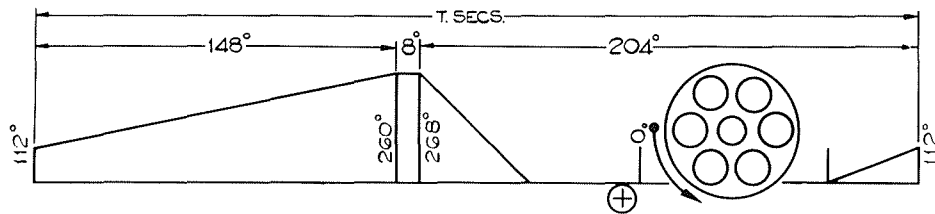
# Wickman 1"-6



A		58	56	54	51	49	46	44	41	39	36	34	32	58	56	54	51	49	46	44	41	39	36	34	32	n(148°) n(8°)		L.							
B		32	34	36	39	41	44	46	49	51	54	56	58	32	34	36	39	41	44	46	49	51	54	56	58	n(148°)	n(8°)	2.5	5	7.5	10	20	25	60	M.M.
N/MIN.		3030	2750	2510	2190	2000	1750	1600	1400	1260	1115	1015	923	612	737	672	566	535	466	426	374	342	299	272	247			1/4	1/2	3/4	1	2	2 1/2		INS.
64	21	X	X	X	3.5	3.6	3.9	4.0	4.3	4.6	5.0	5.3	5.6	6.1	6.5	7.0	7.7	8.2	9.2	9.8	11.0	11.8	13.3	14.4	15.6	53	2.9	4.7	9.4	14.0	19.0	37	47	112	
61	23	X	X	3.5	3.7	3.9	4.2	4.4	4.7	5.0	5.4	5.8	6.1	6.7	7.2	7.7	8.6	9.2	10.2	11.0	12.3	13.3	14.9	16.2	17.6	61	3.3	4.1	8.1	12.2	16.3	33	41	98	
59	25	X	3.5	3.7	3.9	4.1	4.4	4.7	5.1	5.3	5.8	6.2	6.7	7.3	7.9	8.4	9.4	10.1	11.3	12.1	13.6	14.7	16.5	18.0	19.6	69	3.7	3.6	7.3	10.9	14.5	29	36	87	
56	27	3.6	3.7	3.9	4.2	4.4	4.8	5.0	5.5	5.8	6.4	6.8	7.3	8.1	8.7	9.3	10.4	11.2	12.5	13.5	15.2	16.4	18.6	20	22	78	4.2	3.2	6.4	9.6	12.7	25	32	76	
54	30	3.8	4.0	4.2	4.6	4.8	5.2	5.5	6.0	6.4	7.1	7.6	8.1	9.0	9.7	10.5	11.7	12.6	14.2	15.3	17.2	18.6	21	23	25	90	4.9	2.8	5.5	8.3	11.1	22	28	66	
51	32	4.1	4.3	4.5	4.9	5.2	5.6	6.0	6.6	7.0	7.7	8.3	8.9	9.9	10.7	11.6	13.0	14.0	15.7	17.0	19.2	21	24	26	28	102	5.5	2.4	4.9	7.3	9.8	19.6	25	59	
49	35	4.4	4.6	4.9	5.3	5.6	6.1	6.5	7.2	7.7	8.5	9.2	9.9	11.0	11.9	12.9	14.5	15.7	17.6	19.1	22	24	27	29	32	116	6.3	2.2	4.3	6.5	8.6	17.2	22	52	
46	38	4.7	5.0	5.3	5.8	6.2	6.8	7.3	8.0	8.6	9.6	10.3	11.2	12.4	13.5	14.6	16.5	17.8	20	22	25	27	31	33	37	134	7.3	1.9	3.7	5.6	7.4	14.9	18.6	45	
43	41	5.2	5.5	5.8	6.4	6.8	7.6	8.1	9.0	9.6	10.7	11.6	12.6	14.0	15.2	16.6	18.7	20	23	25	28	31	35	38	42	155	8.4	1.6	3.2	4.8	6.4	12.9	16.1	39	
41	43	5.5	5.9	6.2	6.9	7.3	8.1	8.7	9.6	10.4	11.6	12.6	13.6	15.2	16.6	18.0	21	22	25	27	31	34	38	42	46	171	9.2	1.5	2.9	4.4	5.9	11.7	14.6	35	
38	46	6.0	6.5	6.9	7.6	8.2	9.1	9.7	10.8	11.7	13.1	14.2	15.4	17.3	18.8	21	23	25	29	31	35	38	44	48	53	197	10.7	1.3	2.5	3.8	5.1	10.2	12.7	30	
35	49	6.7	7.2	7.7	8.5	9.1	10.2	10.9	12.2	13.2	14.9	16.1	17.6	19.7	22	24	27	29	33	36	41	44	50	55	60	228	12.3	1.1	2.2	3.3	4.4	8.8	11.0	26	
32	51	7.4	7.9	8.5	9.4	10.1	11.3	12.2	13.7	14.8	16.6	18.1	19.7	22	24	27	30	33	37	40	46	50	57	62	68	259	14.0	1.0	1.9	2.9	3.9	7.7	9.6	23	
30	54	8.0	8.7	9.3	10.4	11.2	12.5	13.5	15.2	16.4	18.6	20	22	25	27	30	34	37	42	45	52	56	64	70	77	293	15.8	.9	1.7	2.6	3.4	6.8	8.5	20	
27	56	9.0	9.7	10.4	11.7	12.6	14.1	15.3	17.2	18.6	21	23	25	28	31	34	39	42	48	52	59	64	74	81	89	337	18.2	.7	1.5	2.2	3.0	5.9	7.4	18	
25	59	9.9	10.8	11.6	13.0	14.1	15.8	17.1	19.3	21	24	26	28	32	35	38	44	47	54	59	67	73	83	91	100	384	21	.7	1.3	2.0	2.6	5.2	6.5	15.6	
23	61	10.8	11.8	12.8	14.4	15.6	17.5	19.0	22	23	27	29	32	36	39	43	49	53	60	66	75	82	94	102	113	432	23	.6	1.2	1.7	2.3	4.6	5.8	13.8	
21	64	12.3	13.3	14.4	16.3	17.6	20	22	25	27	30	33	36	41	45	49	56	61	69	75	86	94	107	117	129	496	27	.5	1.0	1.5	2.0	4.0	5.0	12.1	
18	66	14.4	15.6	17.0	19.2	21	24	26	29	32	36	39	43	49	53	58	67	73	83	90	103	112	129	141	155	597	32	.4	.8	1.3	1.7	3.4	4.2	10.1	

F H

T SECS.



160.Y.135.

Standard Long Bar Feed

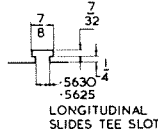
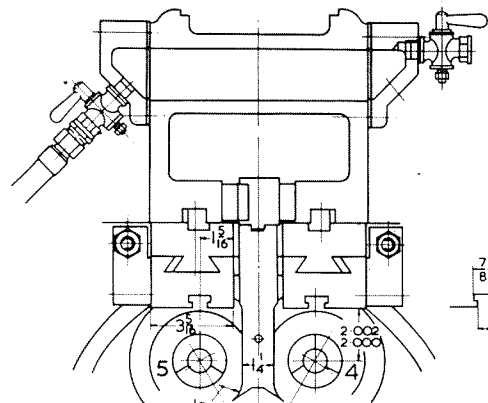


# Wickman 1-6 S

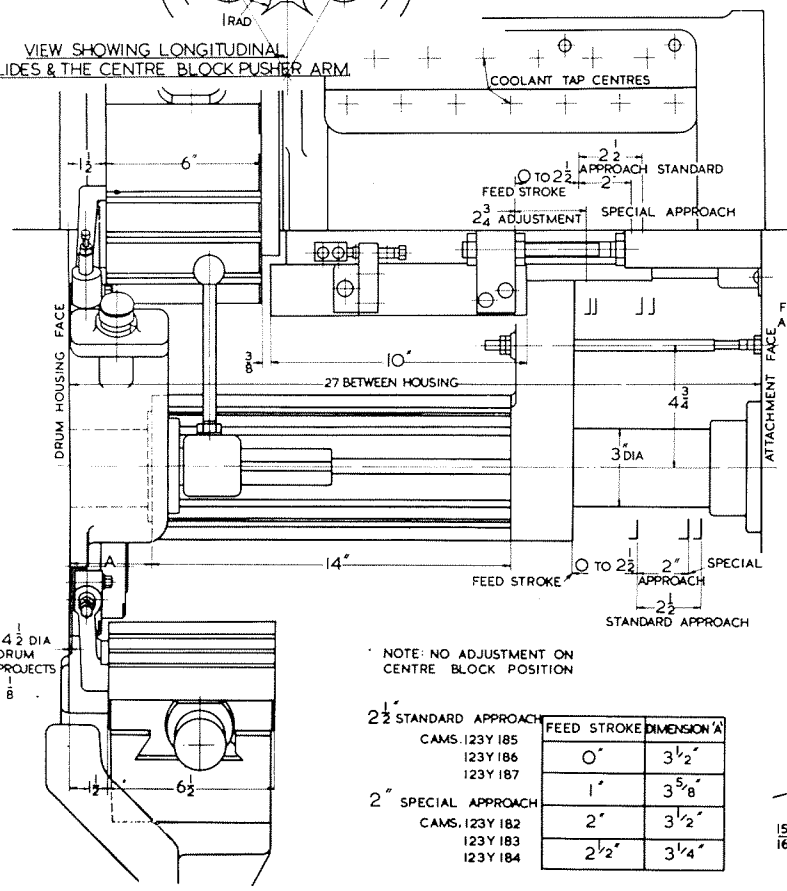
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N/MIN		L																N (148°)		N (8°)														
N/MIN		L																N (148°)		N (8°)														
N/MIN		L																N (148°)		N (8°)														
N/MIN		L																N (148°)		N (8°)														
64	21	2.1	2.2	2.3	2.5	2.6	2.8	3.0	3.2	3.4	3.7	4.0	4.3	4.7	5.1	5.5	6.1	6.6	7.4	7.9	8.3	9.6	10.3	11.9	12.9	41	22	6.1	12	18	24	49	61	146
61	23	2.2	2.3	2.5	2.7	2.8	3.1	3.2	3.5	3.8	4.1	4.4	4.8	5.3	5.7	6.1	6.9	7.4	8.3	9.0	10.1	10.9	12.4	13.5	14.7	47	25	5.3	11	16	21	42	53	127
59	25	2.4	2.5	2.6	2.9	3.0	3.3	3.5	3.8	4.1	4.5	4.8	5.2	5.8	6.2	6.7	7.6	8.2	9.2	9.9	11.2	12.1	13.8	15.0	16.4	53	29	4.7	9.4	14	19	38	47	113
56	27	2.5	2.7	2.8	3.1	3.3	3.6	3.8	4.2	4.5	5.0	5.4	5.8	6.4	6.9	7.5	8.5	9.1	10.3	11.1	12.6	13.6	15.5	16.9	18.5	60	33	4.2	8.3	12	17	33	42	100
54	30	2.8	2.9	3.1	3.4	3.6	4.0	4.2	4.7	5.0	5.6	6.0	6.5	7.2	7.8	8.5	9.6	10.4	11.7	12.7	14.3	15.6	17.7	19.3	21	39	3.8	3.6	7.2	11	14	29	36	86
51	32	3.0	3.2	3.4	3.7	3.9	4.3	4.6	5.1	5.5	6.1	6.6	7.2	8.0	8.7	9.4	10.7	11.6	13.0	14.1	16.0	17.4	19.8	22	24	78	4.2	3.2	6.4	9.6	13	26	32	77
49	35	3.2	3.4	3.7	4.0	4.3	4.8	5.1	5.7	6.1	6.8	7.4	8.0	9.0	9.7	10.6	12.0	13.0	14.7	16.0	18.1	20	22	24	27	89	4.8	2.8	5.6	8.4	11	22	28	67
46	38	3.6	3.8	4.1	4.5	4.8	5.3	5.7	6.4	6.9	7.7	8.4	9.1	10.2	11.1	12.1	13.7	14.9	16.8	18.3	21	23	26	28	31	103	5.6	2.4	4.8	7.3	10	19	24	58
43	41	3.9	4.2	4.5	5.0	5.4	6.0	6.4	7.2	7.8	8.7	9.5	10.3	11.6	12.6	13.7	15.6	17.0	19.2	21	24	26	30	32	35	119	6.4	2.1	4.2	6.3	8.4	17	21	50
41	43	4.2	4.5	4.9	5.4	5.8	6.5	7.0	7.8	8.4	9.5	10.3	11.2	12.6	13.8	15.0	17.1	18.6	21	23	26	28	32	35	39	130	7	1.9	3.9	5.8	7.7	15	19	46
38	46	4.7	5.0	5.4	6.1	6.5	7.3	7.9	8.8	9.6	10.8	11.7	12.8	14.4	15.7	17.2	19.5	21	24	26	30	33	37	41	45	151	8.2	1.7	3.3	5	6.6	13	17	40
35	49	5.2	5.7	6.1	6.8	7.4	8.3	8.9	10.0	10.9	12.3	13.4	14.6	16.5	18.0	19.7	22	24	28	30	34	38	43	47	52	175	9.5	1.4	2.9	4.3	5.7	11	14	34
32	51	5.8	6.3	6.8	7.6	8.2	9.2	10.0	11.3	12.2	13.8	15.1	16.5	18.6	20	22	25	28	31	34	39	43	49	53	59	199	11	1.3	2.5	3.8	5	10	13	30
30	54	6.4	6.9	7.5	8.5	9.1	10.3	11.1	12.6	13.6	15.5	16.9	18.5	21	23	25	29	31	35	39	44	48	55	60	66	225	12	1.1	2.2	3.3	4.5	8.9	11	27
27	56	7.2	7.8	8.5	9.6	10.4	11.7	12.7	14.3	15.6	17.7	19.3	21	24	26	29	33	36	41	44	50	55	63	69	76	259	14	1	1.9	2.9	3.9	7.7	10	23
25	59	8.1	8.8	9.5	10.7	11.6	13.1	14.3	16.1	17.5	20	22	24	27	30	32	37	40	46	50	57	62	71	78	86	295	16	.9	1.7	2.5	3.4	6.8	8.5	20
23	61	8.9	9.7	10.5	11.9	12.9	14.6	15.9	18.0	19.6	22	24	27	30	33	36	41	45	52	56	64	70	80	88	97	331	18	.8	1.5	2.3	3	6	7.6	18
21	64	10.1	11.0	11.9	13.5	14.7	16.6	18.1	21	22	25	28	31	35	38	42	47	52	59	64	73	80	92	101	111	381	21	.7	1.3	2	2.6	5.3	6.6	16
18	66	11.9	13.0	14.1	16.0	17.4	19.8	22	24	27	30	33	37	41	45	50	56	62	71	77	88	96	110	121	133	458	25	.5	1.1	1.6	2.2	4.4	5.5	13
F		H		T SECS																														
F		H		T SECS																														

Spindle Stopping Non-Standard Index 1.1 secs





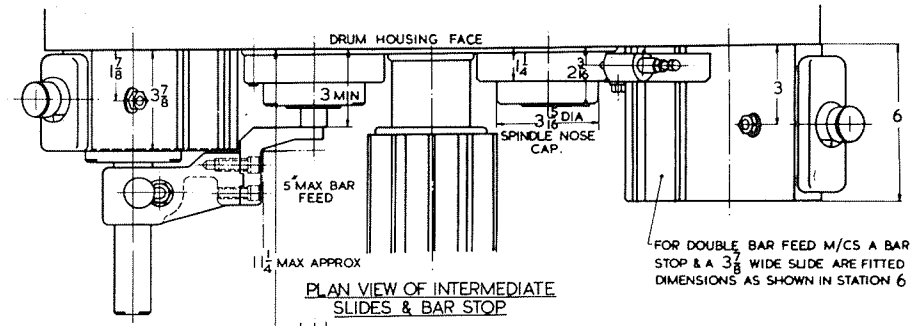
VIEW SHOWING LONGITUDINAL SLIDES & THE CENTRE BLOCK PUSHER ARM



NOTE: NO ADJUSTMENT ON CENTRE BLOCK POSITION

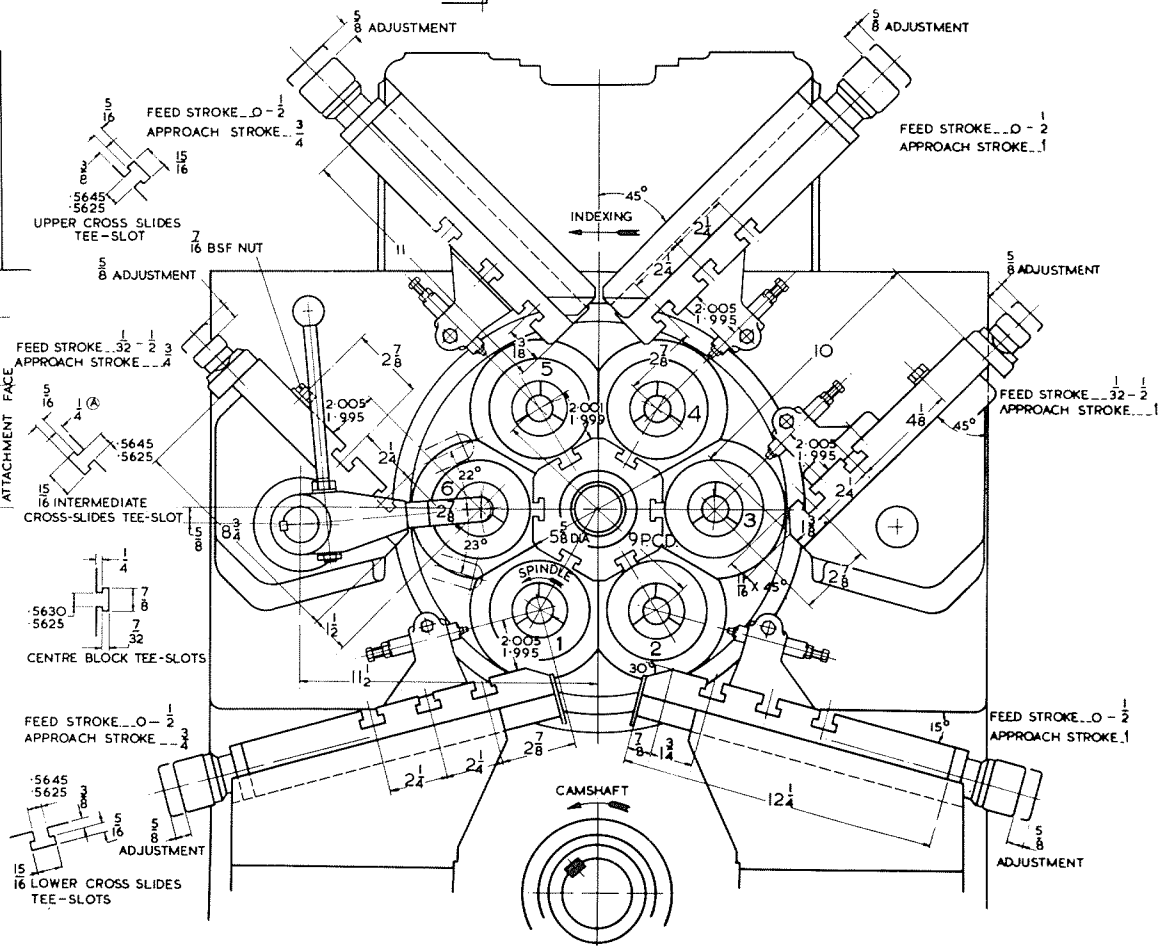
STANDARD APPROACH	FEED STROKE	DIMENSION 'A'
CAMS. 123Y 185 123Y 186 123Y 187	0"	3 1/2"
2" SPECIAL APPROACH CAMS. 123Y 182 123Y 183 123Y 184	1" 2" 2 1/2"	3 5/8" 3 1/2" 3 1/4"

NOTE: ALL SLIDES SHOWN IN FULLY FORWARD POSITION



PLAN VIEW OF INTERMEDIATE SLIDES & BAR STOP

FOR DOUBLE BAR FEED M/C'S A BAR STOP & A 3/8" WIDE SLIDE ARE FITTED DIMENSIONS AS SHOWN IN STATION 6



COMMENCING ON MACHINE No. 9633.

**Capacity Chart for 1" - 6 Bar Automatic**

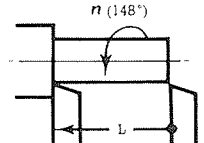
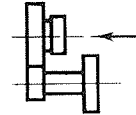
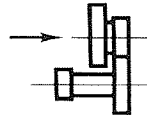
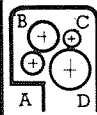
**1.10.1.**



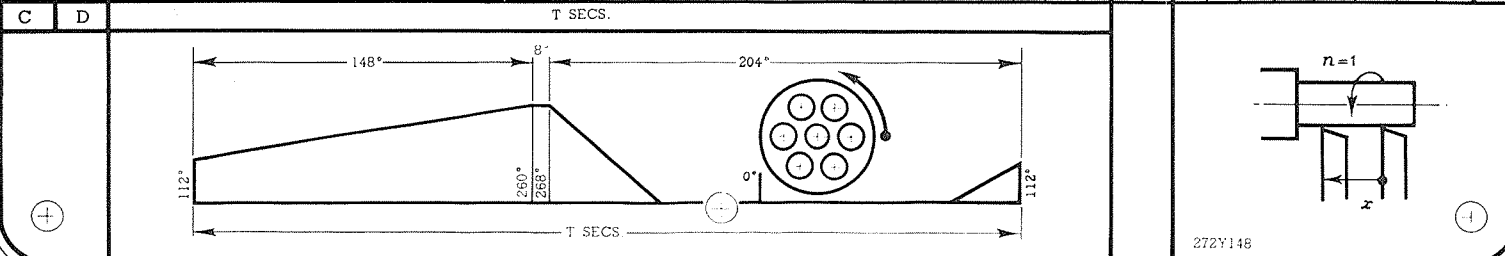




# Wickman 1 $\frac{3}{4}$ -6



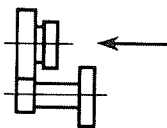
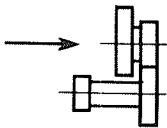
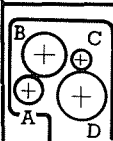
A		54	52	49	46	43	40	38	36	34	32	30	28	58	56	54	52	49	46	43	40	38	36	34	32	30	28										
B		38	40	43	46	49	52	54	56	58	60	62	64	34	36	38	40	43	46	49	52	54	56	58	60	62	64										
N/MIN.		1667	1525	1337	1173	1029	902	825	754	688	626	568	514	514	469	428	392	343	301	264	232	212	194	177	161	146	132										
		L																																			
		2	5	7-5	10	20	30	35	89	MM.																			INS.								
		$\frac{1}{4}$	$\frac{1}{2}$	$\frac{3}{4}$	1	2	3	3 $\frac{1}{2}$																													
71	27	4-3	4-5	4-8	5-2	5-7	6-2	6-6	7-0	7-5	8-0	8-6	9-3	9-3	10-0	10-8	11-6	12-9	14-4	16-2	18-1	19-6	21-3	23	25	28	31	59	3-2	4-2	8-5	12-7	17	34	51	59	151
69	30	4-6	4-8	5-2	5-7	6-3	6-8	7-2	7-7	8-2	8-9	9-6	10-3	10-3	11-2	12-0	12-9	14-5	16-2	18-2	21	22	24	26	29	32	35	67	3-6	3-7	7-4	11-1	14-8	30	44	52	132
66	32	4-9	5-2	5-6	6-1	6-7	7-3	7-8	8-4	9-0	9-7	10-4	11-3	11-3	12-2	13-2	14-2	15-9	17-8	20	23	25	27	29	32	35	38	75	4-1	3-3	6-6	10	13-3	27	40	46	118
64	35	5-3	5-6	6-1	6-6	7-3	8-0	8-5	9-2	9-8	10-6	11-5	12-5	12-5	13-5	14-6	15-7	17-7	19-9	23	25	28	30	33	36	39	43	85	4-6	2-9	5-9	8-8	11-8	24	35	41	105
61	38	5-7	6-0	6-6	7-3	8-0	8-8	9-4	10-2	10-9	12-0	12-8	13-9	13-9	15-1	16-3	17-7	19-9	23	25	29	31	34	37	40	44	49	97	5-2	2-6	5-2	7-8	10-3	21	31	36	92
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53	46	7-1	7-6	8-4	9-3	10-3	11-5	12-4	13-3	14-4	15-7	17-0	18-6	18-6	20	22	24	27	30	34	39	42	46	50	55	61	67	135	7-3	1-9	3-7	5-6	7-4	14-8	22	26	66
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49	50	8-0	8-6	9-5	10-6	11-8	13-1	14-2	15-3	16-6	18-1	19-7	22	22	24	26	28	31	35	40	45	49	54	59	65	71	78	158	8-6	1-6	3-2	4-7	6-3	12-6	18-9	22	56
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41	58	10-4	11-1	12-4	13-9	15-5	17-4	18-9	21	22	24	27	29	29	32	35	38	43	48	55	62	68	72	81	89	97	108	220	12	1-1	2-3	3-4	4-6	9-1	13-7	15-9	41
38	61	11-5	12-4	13-8	15-5	17-4	19-5	21	23	25	27	30	33	33	36	39	42	48	55	62	70	77	84	91	100	110	122	249	14	1-0	2-0	3-0	4-0	8-0	12-0	14-0	36
35	64	12-8	13-8	15-5	17-4	19-5	22	24	26	28	31	34	37	37	41	44	49	54	62	70	80	87	95	104	114	125	138	284	15	0-8	1-8	2-6	3-5	7-0	10-6	12-3	31
32	66	14-2	15-3	17-2	19-3	22	25	27	29	32	35	38	42	42	45	50	54	61	69	79	90	98	107	117	128	141	156	320	17	0-7	1-6	2-3	3-1	6-2	9-4	10-9	28
30	69	15-6	16-8	18-9	21	24	27	30	32	35	38	42	46	46	50	55	60	68	77	88	100	100	119	130	143	157	173	357	19	0-7	1-4	2-1	2-8	5-6	8-4	9-8	25
27	71	17-5	19	22	24	27	31	33	36	40	43	48	52	52	57	63	68	77	88	100	114	124	135	148	163	179	198	408	22	0-6	1-2	1-8	2-4	4-9	7-3	8-6	22
25	74	19-5	21	24	27	30	34	37	41	45	49	53	59	59	64	70	76	87	99	112	128	139	152	167	183	202	223	460	25	0-5	1-1	1-6	2-2	4-4	6-5	7-6	19-4
23	76	22	23	26	30	34	38	42	45	49	54	59	65	65	71	78	85	97	110	125	142	155	170	186	204	225	248	513	28	0-4	0-9	1-5	1-9	3-9	5-8	6-8	17-3
21	78	24	26	30	33	38	43	46	51	55	61	66	73	73	80	87	95	108	123	140	160	174	190	209	229	252	279	577	31	0-3	0-7	1-3	1-7	3-5	5-2	6-1	15-4
18	81	29	31	35	40	45	51	56	61	66	73	80	88	88	96	105	115	131	149	169	193	211	230	252	277	305	337	699	38	0-3	0-6	0-7	1-1	1-4	2-9	4-3	12-7



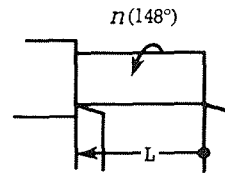
Standard Machine  
2.4.

272Y148

# Wickman 1 3/4"-6



$n(148^\circ)$   
 $n(8^\circ)$



A  
B

54	52	49	46	43	40	38	36	34	32	30	28	58	56	54	52	49	46	43	40	38	36	34	32	30	28
38	40	43	46	49	52	54	56	58	60	62	64	34	36	38	40	43	46	49	52	54	56	58	60	62	64

N/MIN.

1667	1825	1337	1173	1029	902	825	754	688	626	568	514	514	469	428	392	343	301	264	232	212	194	177	161	146	132
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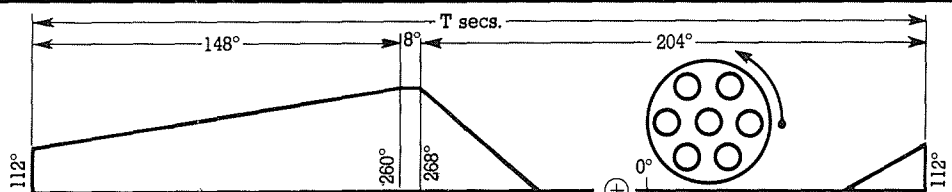
$n(148^\circ)$   
 $n(8^\circ)$

L									
2.5	5	7.5	10	20	30	35	89	MM.	
.25	.5	.75	1	2	3	3.5		INS.	

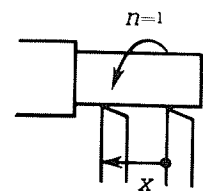
71	27	6.9	7.3	7.8	8.4	9.0	9.5	10.0	10.6	11.3	12.1	13.0	12.9	13.8	14.8	15.8	17.5	19.4	22	24	26	28	30	33	36	39	74	4.0	3.4	6.8	10.1	13.5	27	41	47	120	
69	30	7.0	7.3	7.8	8.4	9.0	9.8	10.3	10.9	11.6	12.4	13.3	14.3	14.2	15.2	16.3	17.5	19.4	22	24	27	29	32	34	37	41	45	85	4.6	3.0	5.9	8.9	11.8	24	36	42	105
66	32	7.4	7.7	8.3	8.9	9.6	10.5	11.1	11.7	12.5	13.4	14.4	15.5	15.4	16.6	17.8	19.1	21	24	27	30	32	35	38	41	45	49	94	5.1	2.7	5.3	8.0	10.6	21	32	37	94
64	35	7.9	8.2	8.9	9.6	10.4	11.3	12.0	12.8	13.6	14.6	15.7	16.9	16.9	18.2	20	21	24	26	29	33	36	39	42	46	50	55	106	5.8	2.4	4.7	7.1	9.4	18.8	28	33	84
61	38	8.4	8.9	9.6	10.4	11.3	12.3	13.1	14.0	15.0	16.1	17.3	18.8	18.7	20	22	24	26	29	33	37	40	44	47	52	57	62	121	6.6	2.1	4.1	6.2	8.3	16.5	25	29	74
58	41	9.0	9.6	10.3	11.2	12.3	13.5	14.4	15.4	16.5	17.7	19.2	21	21	23	24	26	29	33	37	42	45	49	53	58	64	70	138	7.4	1.8	3.7	5.5	7.3	14.5	22	26	65
56	43	9.5	10.0	10.9	11.9	13.0	14.3	15.3	16.4	17.6	18.9	21	22	22	24	26	28	32	35	40	45	49	53	58	63	69	76	150	8.1	1.7	3.4	5.0	6.7	13.4	20	24	60
53	46	10.2	10.8	11.8	12.9	14.2	15.7	16.8	18.0	19.4	21	23	25	25	27	29	31	35	39	44	50	54	59	64	70	77	85	169	9.2	1.5	3.0	4.5	5.9	11.9	17.8	21	53
50	49	11.1	11.7	12.9	14.1	15.6	17.2	18.5	20	22	23	25	27	27	30	32	35	39	44	50	56	61	66	72	79	87	95	191	10	1.3	2.6	3.9	5.3	10.5	15.7	18.4	47
49	50	11.4	12.1	13.2	14.5	16.0	17.8	19.1	21	22	24	26	28	28	31	33	36	41	46	51	58	63	69	75	82	90	99	199	11	1.3	2.5	3.8	5.0	10.1	15.1	17.6	45
46	53	12.3	13.1	14.4	15.9	17.6	20	21	23	25	27	29	32	32	34	37	40	45	51	58	65	71	77	84	92	101	112	224	12	1.1	2.2	3.4	4.5	8.9	13.4	15.6	40
43	56	13.4	14.3	15.8	17.5	19.4	22	23	25	27	30	32	35	35	38	41	45	51	57	65	73	80	87	95	104	114	126	254	14	1.0	2.0	3.0	4.0	7.9	11.8	13.8	35
41	58	14.3	15.2	16.9	18.7	21	23	25	27	29	32	35	38	38	41	45	48	55	62	70	79	86	94	103	112	123	136	275	15	.91	1.8	2.7	3.6	7.3	10.9	12.7	32
38	61	15.7	16.8	18.6	21	23	26	28	30	33	36	39	42	42	46	50	54	62	70	79	89	97	106	116	127	140	154	313	17	.80	1.6	2.4	3.2	6.4	9.6	11.2	29
35	64	17.3	18.6	21	23	26	29	31	34	37	40	44	48	48	52	57	61	70	79	89	101	110	120	131	144	158	175	356	19	.70	1.4	2.1	2.8	5.6	8.4	9.8	25
32	66	19.1	21	23	26	29	32	35	38	41	45	49	53	53	58	63	69	78	88	100	114	124	135	148	162	178	197	402	22	.62	1.3	1.9	2.5	5.0	7.5	8.7	22
30	69	21	23	25	28	31	35	38	42	45	49	54	59	59	64	70	76	86	98	111	126	137	150	164	180	198	219	448	24	.56	1.1	1.7	2.2	4.5	6.7	7.8	20
27	71	23	25	28	32	35	40	43	47	51	56	61	67	67	73	80	87	98	111	126	144	157	171	187	205	226	249	512	28	.49	.98	1.5	2.0	3.9	5.9	6.9	17.4
25	74	26	28	31	35	39	44	48	52	57	62	68	75	75	82	89	97	110	125	142	161	176	192	210	231	254	280	576	31	.44	.87	1.3	1.8	3.5	5.2	6.1	15.5
23	76	28	31	34	39	44	49	53	58	63	69	76	83	83	91	99	108	122	139	158	179	196	214	234	257	283	313	643	35	.39	.78	1.2	1.6	3.1	4.7	5.5	13.9
21	78	31	34	38	43	48	55	59	65	70	77	85	93	93	102	111	121	137	156	177	201	220	240	263	288	318	351	723	39	.35	.69	1.1	1.4	2.8	4.2	4.9	12.3
18	81	37	40	45	51	58	65	71	77	85	93	102	112	112	122	133	145	165	188	213	243	265	290	318	349	384	424	876	47	.29	.57	.86	1.2	2.3	3.4	4.0	10.2

C D

T secs.



$n=1$



260 Y. 135 A

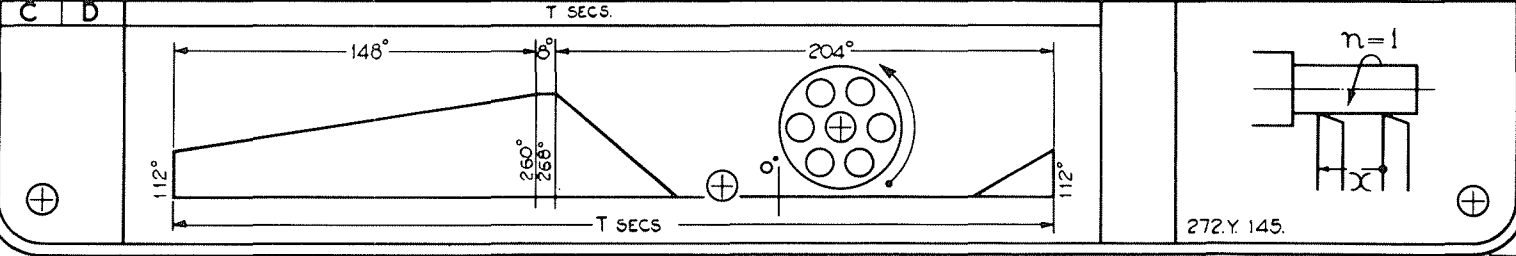
Long Bar Feed

2.5.



# Wickman 5<sup>5</sup>/<sub>8</sub>-6

A		N/MIN																												n(148°)		n(8°)						
B		L																												n(148°)		n(8°)						
N/MIN		L																												n(148°)		n(8°)						
N/MIN		L																												n(148°)		n(8°)						
N/MIN		L																												n(148°)		n(8°)						
71	27			6.1	6.5	7.0	7.5	7.9	8.3	8.8	9.4	10.0	10.7	11.4	12.2	13.1	14.5	16.1	17.9	19.9	22	23	25	28	30	33	61	3.3	4.1	5	7.5	10	20	30	35	59	M/M	
69	30			6.1	6.5	7.0	7.5	8.1	8.6	9.1	9.6	10.3	11.0	11.8	12.6	13.5	14.5	16.1	17.9	19.9	23	24	26	29	31	34	37	70	3.8	3.6	7.1	10.7	14.3	29	43	50		INS.
66	32	6.1	6.4	6.9	7.4	8.0	8.7	9.2	9.7	10.4	11.1	11.9	12.8	13.7	14.7	15.8	17.6	19.6	22	25	27	29	31	34	37	41	78	4.2	3.2	6.4	9.6	12.8	26	38	45			
64	35	6.5	6.8	7.4	7.9	8.6	9.4	9.9	10.6	11.3	12.1	13.0	14.1	14.1	15.1	16.2	17.4	19.4	22	24	27	30	32	35	38	42	46	88	4.8	2.8	5.7	8.5	11.4	23	34	40		
61	38	7.0	7.3	7.9	8.6	9.4	10.2	10.9	11.6	12.4	13.3	14.4	15.6	16.7	18.0	19.4	22	24	27	31	33	36	39	43	47	52	100	5.4	2.5	5.0	7.5	10.0	20	30	35			
58	41	7.5	7.8	8.6	9.3	10.2	11.2	11.9	12.7	13.7	14.7	15.9	17.2	17.2	18.6	20.0	22	24	27	31	34	37	41	44	48	53	58	114	6.2	2.2	4.4	6.6	8.8	17.5	26	31		
56	43	7.9	8.3	9.0	9.9	10.8	11.9	12.7	13.6	14.6	15.7	17.0	18.4	18.4	19.9	22	23	26	29	33	37	40	44	48	52	57	63	124	6.7	2.0	4.0	6.0	8.1	16.1	24	28		
53	46	8.5	9.0	9.8	10.7	11.8	13.0	13.9	14.9	16.1	17.3	18.8	21	21	22	24	26	29	33	37	42	45	49	53	58	64	71	140	7.6	1.8	3.5	5.4	7.1	14.2	21	25		
50	49	9.2	9.7	10.7	11.7	12.9	14.3	15.3	16.4	17.7	19.2	21	23	23	25	27	29	32	37	41	46	50	55	60	66	72	79	158	8.5	1.6	3.2	4.7	6.3	12.6	19.0	22		
49	50	9.4	10.0	11.0	12.0	13.3	14.7	15.8	17.0	18.3	19.8	22	24	24	26	28	30	34	38	43	48	52	57	62	68	75	82	165	8.9	1.5	3.0	4.5	6.1	12.1	18.2	21		
46	53	10.2	10.9	12.0	13.2	14.6	16.2	17.4	18.8	20	22	24	26	26	28	31	33	38	42	48	54	59	64	70	76	84	93	186	10	1.3	2.7	4.0	5.4	10.7	16.1	18.8		
43	56	11.1	11.9	13.1	14.5	16.1	17.9	19.3	21	23	25	27	29	29	32	34	37	42	47	54	61	66	72	79	86	94	104	210	11	1.2	2.4	3.6	4.8	9.5	14.3	16.7		
41	58	11.8	12.6	14.0	15.5	17.2	19.2	21	23	24	26	29	31	31	34	37	40	45	51	58	66	71	78	85	93	102	113	228	12	1.1	2.2	3.3	4.4	8.8	13.2	15.4		
38	61	13.0	13.9	15.4	17.1	19.1	22	23	25	27	30	32	35	35	38	42	45	51	58	65	74	81	88	96	105	116	128	259	14	.97	1.9	2.9	3.9	7.7	11.6	13.5		
35	64	14.4	15.4	17.1	19.1	21	24	26	28	30	33	36	40	40	43	47	51	58	65	74	84	91	100	109	119	131	145	295	16	.85	1.7	2.5	3.4	6.8	10.2	11.9		
32	66	15.6	17.0	18.9	21	24	27	29	31	34	37	40	44	44	48	52	57	65	73	83	94	103	112	122	134	148	163	333	18	.75	1.5	2.3	3.0	6.0	9.0	10.5		
30	69	17.3	18.6	21	23	26	29	32	34	37	41	45	49	49	53	58	63	72	81	92	105	114	124	136	149	164	181	371	20	.67	1.3	2.0	2.7	5.4	8.1	9.4		
27	71	19.3	21	23	26	29	33	36	39	42	46	51	56	56	61	66	72	81	92	105	119	130	142	155	170	187	207	424	23	.59	1.2	1.8	2.4	4.7	7.1	8.3		
25	74	21	23	26	29	33	37	40	43	47	52	57	62	62	68	74	80	91	104	118	134	146	159	174	191	210	232	477	26	.52	1.0	1.6	2.1	4.2	6.3	7.3		
23	76	24	25	29	32	36	41	44	48	52	57	63	69	69	75	82	89	101	115	131	149	162	177	194	213	234	259	533	29	.47	.94	1.4	1.9	3.8	5.6	6.6		
21	78	26	28	32	36	40	45	49	54	58	64	70	77	77	84	92	100	114	129	147	167	182	199	218	239	263	291	599	32	.42	.83	1.3	1.7	3.3	5.0	5.8		
18	81	31	33	38	42	48	54	59	64	70	77	84	93	93	101	111	121	137	156	177	201	220	240	263	289	318	352	725	39	.34	.69	1.0	1.4	2.8	4.1	4.8		

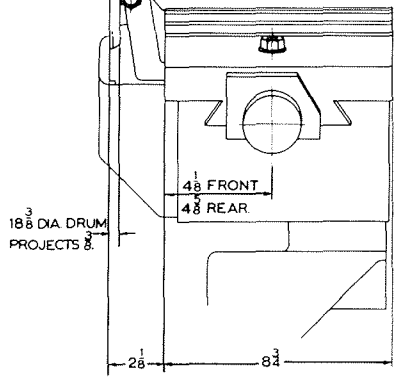
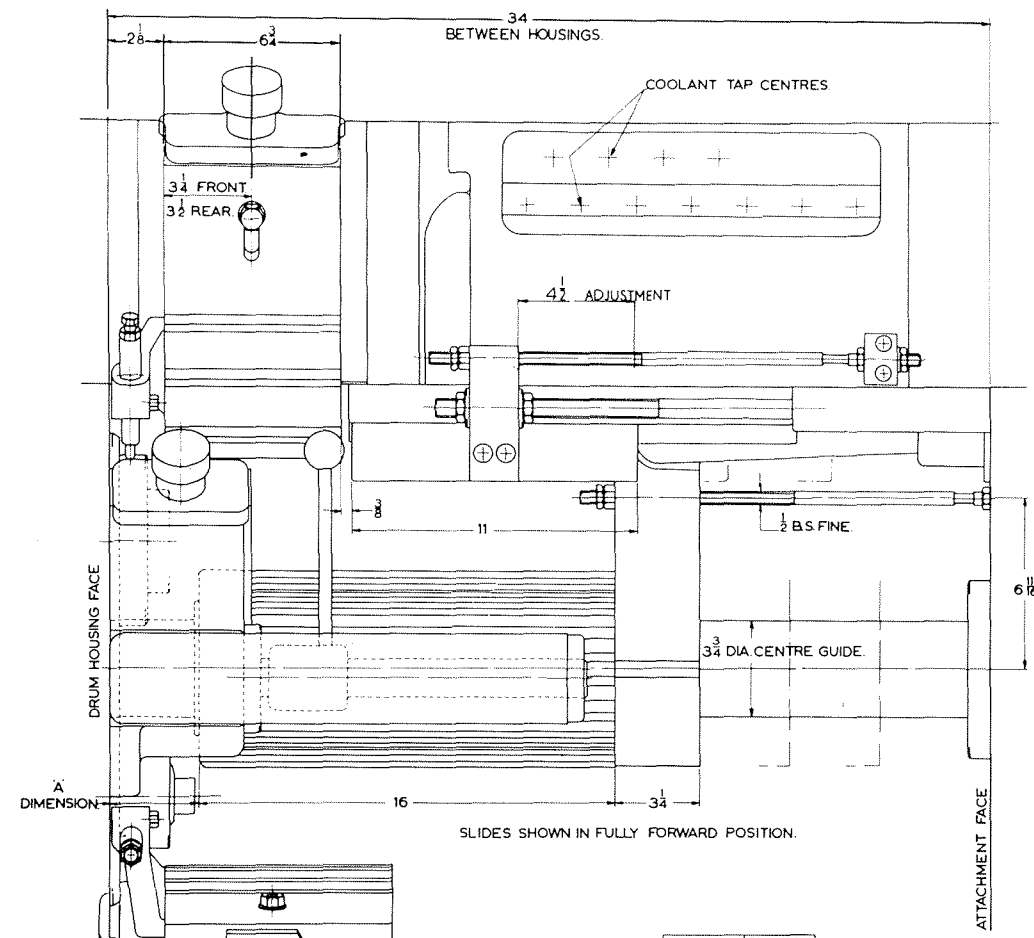


272.Y 145.

Double Index  
2.9.

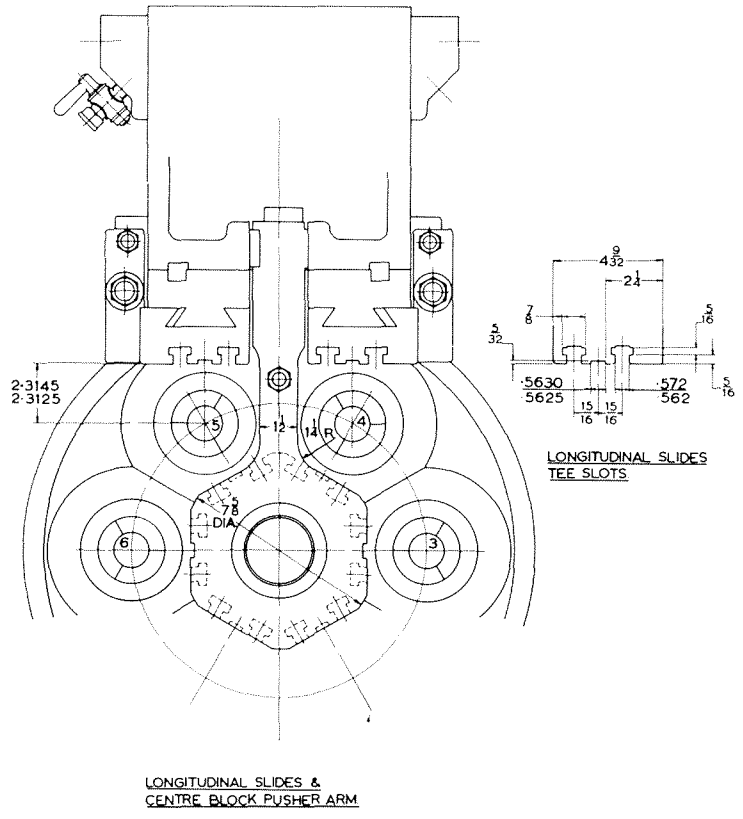




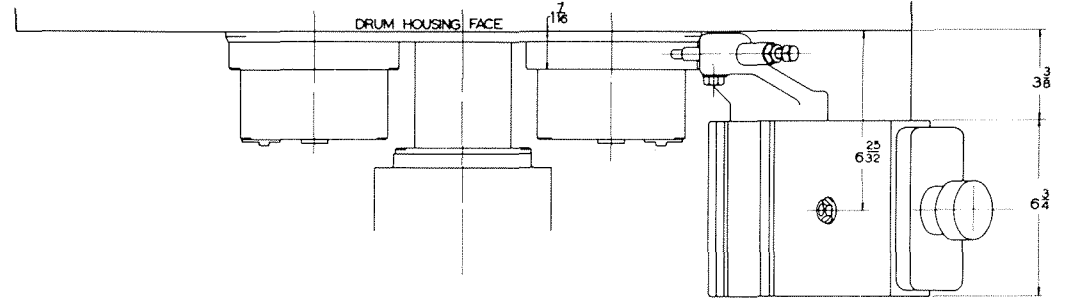


	CENTRE BLOCK	FRONT & REAR LONG SLIDES
APPROACH (SPECIAL)	2 1/2	2 1/2
APPROACH (STANDARD)	3 1/2	3 1/2
FEED STROKE	0-3 1/2	0-3 1/2

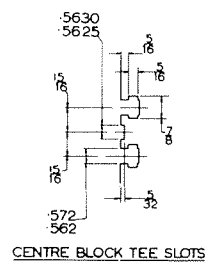
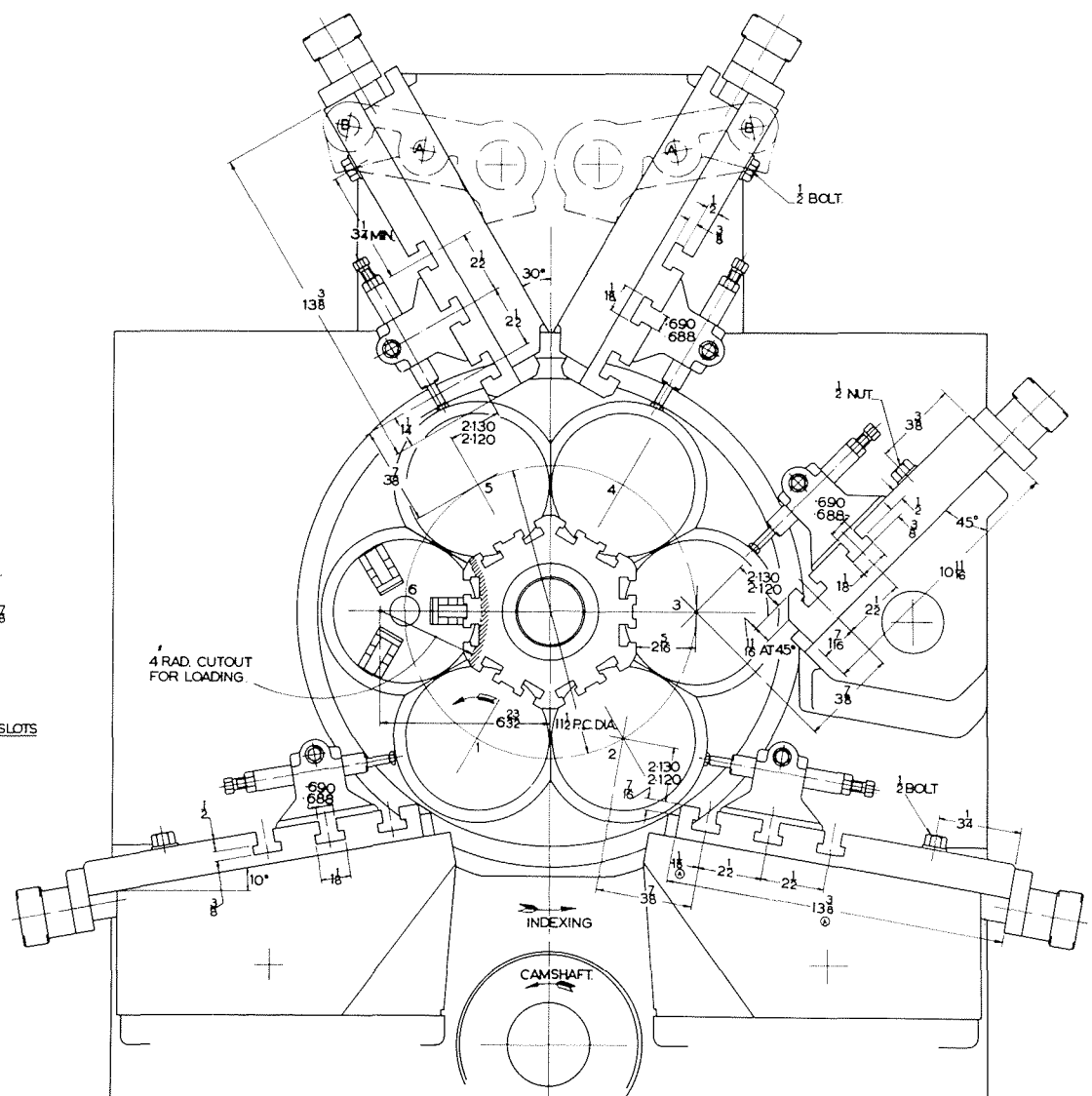
DRUM HOUSING FACE	DIMENSION A	FEED STROKE
	2 25/32	0
	3 3/32	1
	3 15/16	2
	4 3/32	1
	4 3/32	1 1/2
	3 31/32	2
	3 27/32	2 1/2
	3 21/32	3
	3 7/16	3 1/2



Capacity Chart for  
 1 3/8"-6  
 Bar Automatic  
 & 1 3/4"-6  
 Bar Automatic  
 (Commencing  
 M/C No. 9404)



PLAN VIEW OF INTERMEDIATE  
SLIDE & CHUCKS.



ALL CROSS-SLIDES SHOWN AT END OF FEED STROKE

STATION	CROSS-SLIDE STROKES						
	1	2	3	4		5	
				LEVER		POSITION	
				A	B	A	B
APPR STROKE AT MIN FEED STROKE	1 5/16	1 11/16	1 7/8	1 3/16	1 3/16	1 1/2	5/8
APPR STROKE AT MAX FEED STROKE	1 1/16	1 1/16	1 1/16	1/4	1/4	1 1/16	3/8
FEED STROKE	0-1/4	0-1/4	0-1/8	0-1/8	0-1/8	0-1/8	0-15/16
ADJUSTMENT FORWARD	3/8	3/8	3/8	3/8	3/8	3/8	3/8
ADJUSTMENT BACKWARD	7/8	7/8	7/8	1 1/8	1 1/8	1 1/8	1 1/8





# Wickman 1-8

A	58	56	54	52	49	46	43	40	38	36	34	32	30	58	56	54	52	49	46	43	40	38	36	34	32	30											
B	34	36	38	40	43	46	49	52	54	56	58	60	62	34	36	38	40	43	46	49	52	54	56	58	60	62											
N/MPH	2737	2496	2280	2086	1829	1605	1408	1234	1129	1032	941	856	776	703	641	586	536	470	412	362	317	290	265	242	220	199	n (148°)	n (8°)									
																											L										
																											2.5	5	7.5	10	20	30	35	89			
																											1/4	1/2	3/4	1	2	3	3 1/2				
71	27		3.7	3.9	4.1	4.4	4.7	5.1	5.4	5.7	6.1	6.5	7.0	7.5	8.0	8.6	9.2	10.2	11.3	12.6	14.1	15.2	16.5	17.9	19.4	21	61	3.3	4.1	8.3	12.4	16.5	33	50	58	147	
69	30		3.8	3.9	4.1	4.4	4.8	5.1	5.6	5.9	6.3	6.7	7.1	7.7	8.2	8.9	9.5	10.2	11.3	12.6	14.1	15.8	17.1	18.5	20	22	24	69	3.7	3.6	7.2	10.8	14.5	29	43	51	129
66	32	3.8	4.0	4.2	4.4	4.7	5.1	5.5	6.0	6.3	6.8	7.2	7.7	8.3	9.0	9.6	10.4	11.1	12.4	13.9	15.5	17.4	18.8	20	22	24	26	77	4.2	3.2	6.5	9.7	13.0	26	39	45	115
64	35	4.0	4.2	4.4	4.7	5.0	5.5	5.9	6.5	6.9	7.4	7.9	8.5	9.1	9.9	10.6	11.4	12.3	13.7	15.4	17.2	19.4	21	23	25	27	30	87	4.7	2.9	5.7	8.6	11.5	23	34	40	102
61	38	4.3	4.5	4.8	5.0	5.5	5.9	6.5	7.1	7.6	8.1	8.7	9.4	10.1	10.9	11.8	12.7	13.7	15.4	17.2	19.4	22	24	26	28	31	33	99	5.4	2.5	5.0	7.6	10.1	20	30	35	90
58	41	4.6	4.9	5.1	5.4	5.9	6.5	7.1	7.8	8.3	8.9	9.6	10.3	11.2	12.1	13.1	14.2	15.3	17.2	19.3	22	24	27	29	31	34	38	112	6.1	2.2	4.4	6.7	8.9	17.8	27	31	79
56	43	4.9	5.1	5.4	5.7	6.3	6.8	7.5	8.3	8.9	9.5	10.2	11.1	12.0	13.0	14.1	15.2	16.4	18.5	21	23	26	29	31	34	37	41	122	6.6	2.0	4.1	6.1	8.2	16.4	25	29	73
53	46	5.2	5.5	5.9	6.2	6.8	7.5	8.2	9.1	9.8	10.5	11.3	12.2	13.3	14.4	15.6	16.9	18.3	21	23	26	30	32	35	38	42	46	138	7.5	1.8	3.6	5.4	7.2	4.5	22	25	64
50	49	5.6	6.0	6.4	6.8	7.4	8.2	9.0	10.0	10.8	11.6	12.5	13.6	14.7	16.0	17.4	18.9	20	23	26	29	33	36	39	43	47	51	156	8.4	1.6	3.2	4.8	6.4	12.8	19.2	23	57
49	50	5.8	6.1	6.5	7.0	7.6	8.4	9.3	10.3	11.1	12.0	12.9	14.0	15.3	16.6	18.0	19.6	21	24	27	30	34	37	41	45	49	53	162	8.8	1.5	3.1	4.6	6.2	12.3	18.5	22	55
46	53	6.3	6.7	7.1	7.6	8.4	9.3	10.3	11.4	12.3	13.3	14.4	15.6	17.0	18.5	20	22	24	27	30	34	39	42	46	50	55	60	183	9.9	1.4	2.7	4.1	5.5	10.9	16.4	19	49
43	56	6.8	7.3	7.8	8.3	9.2	10.2	11.3	12.6	13.6	14.7	16.0	17.3	18.9	21	22	24	26	30	34	38	43	47	51	56	62	68	207	11	1.2	2.4	3.6	4.8	9.7	14.5	16.9	43
41	58	7.2	7.7	8.3	8.9	9.8	10.9	12.1	13.6	14.6	15.8	17.2	18.7	20	22	24	26	29	32	37	41	47	51	56	61	67	73	225	12	1.1	2.2	3.3	4.4	8.9	13.3	15.6	40
38	61	7.9	8.5	9.1	9.8	10.9	12.1	13.5	15.1	16.3	17.7	19.2	21	23	25	27	30	32	36	41	47	53	58	63	69	75	83	255	14	1.0	2.0	2.9	3.9	7.8	11.7	13.7	35
35	64	8.7	9.4	10.1	10.8	12.1	13.5	15.1	16.9	18.3	19.9	22	24	26	28	31	33	36	41	47	53	60	65	71	78	86	94	291	16	.86	1.7	2.6	3.4	6.9	10.3	12.0	31
32	66	9.6	10.3	11.1	12.0	13.4	15.0	16.8	18.8	20	22	24	26	29	32	34	37	41	46	52	59	67	74	80	88	96	106	328	18	.76	1.5	2.3	3.0	6.1	9.1	10.7	27
30	69	10.5	11.3	12.2	13.1	14.7	16.5	18.5	21	23	24	27	29	32	35	38	42	45	51	58	66	75	82	89	98	107	118	366	20	.68	1.4	2.0	2.7	5.5	8.2	9.6	24
27	71	11.7	12.6	13.6	14.7	16.5	18.5	21	23	25	28	30	33	36	40	43	47	51	58	66	75	85	93	102	112	122	135	418	23	.60	1.2	1.8	2.4	4.8	7.2	8.4	21
25	74	12.9	14.0	15.1	16.3	18.3	21	23	26	28	31	34	37	40	44	48	53	58	65	74	84	96	105	114	125	137	151	471	25	.53	1.1	1.6	2.1	4.2	6.4	7.4	18.9
23	76	14.2	15.3	16.6	18.0	20	23	26	29	31	34	37	41	45	49	54	59	64	73	83	94	107	117	127	140	153	169	525	28	.47	.95	1.4	1.9	3.8	5.7	6.7	16.9
21	78	15.7	17.0	18.4	19.9	22	25	29	32	35	38	42	46	50	55	60	66	72	82	93	105	120	131	143	157	172	189	591	32	.47	.85	1.3	1.7	3.4	5.1	5.9	15.1
18	81	18.6	20	22	24	27	30	34	39	42	46	50	55	60	66	73	79	87	98	112	127	145	158	173	189	208	229	716	39	.35	.70	1.0	1.4	2.8	4.2	4.9	12.4
C	D	T. SECONDS																																			
		T. SECONDS																																			

Special Machine  
3 1/2" app. Stroke  
2.0 secs Idle Time

2.15.

272 Y150

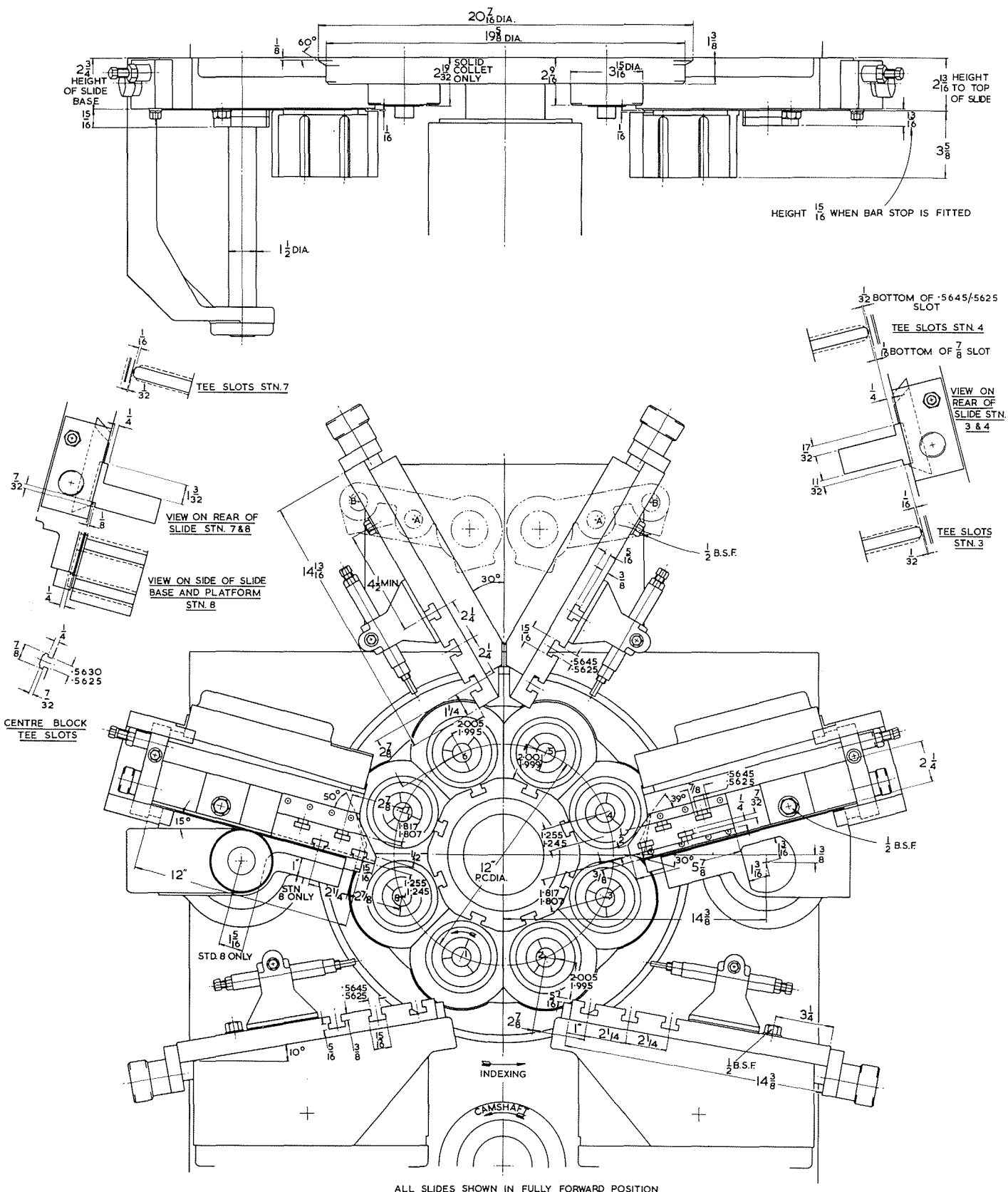
# Wickman 1-8S

A		N / MIN																n (148°)		L																								
B		N / MIN																n (148°)		L																								
N / MIN		N / MIN																n (8°)		L																								
N / MIN		N / MIN																n (8°)		L																								
71	27			3.7	3.9	4.1	4.4	4.8	5.0	5.3	5.6	6.0	6.4	6.9	7.3	7.8	8.4	9.3	10.3	11.4	12.8	14.3	15.4	16.7	18.1	19.7	22	24	26	28	30	32	34	37	42	48	55	63	73	84	97	112	130	149
69	30		3.7	3.9	4.2	4.5	4.8	5.2	5.5	5.8	6.2	6.6	7.0	7.6	8.1	8.7	9.3	10.3	11.5	12.8	14.3	15.4	16.7	18.1	19.7	22	24	26	28	30	32	34	37	42	48	55	63	73	84	97	112	130	149	
66	32	3.8	3.9	4.1	4.4	4.7	5.1	5.5	5.9	6.2	6.6	7.1	7.6	8.2	8.8	9.4	10.1	11.3	12.6	14.0	15.7	17.0	18.4	20	22	24	26	28	30	32	34	37	42	48	55	63	73	84	97	112	130	149		
64	35	4.0	4.2	4.4	4.7	5.1	5.5	6.0	6.4	6.8	7.2	7.7	8.3	9.0	9.7	10.4	11.2	12.4	13.9	15.6	17.5	18.9	20	22	24	27	29	30	33	36	40	44	48	53	58	64	71	79	88	98	109	121	134	149
61	38	4.3	4.5	4.7	5.1	5.5	6.0	6.5	7.0	7.4	8.0	8.5	9.2	10.0	10.7	11.5	12.4	13.9	15.5	17.4	19.6	21	23	25	27	30	33	36	40	44	48	53	58	64	71	79	88	98	109	121	134	149		
58	41	4.6	4.8	5.1	5.5	6.0	6.5	7.2	7.6	8.2	8.8	9.4	10.2	11.0	11.9	12.8	13.8	15.5	17.4	19.5	22	24	26	28	31	34	37	40	44	48	53	58	64	71	79	88	98	109	121	134	149			
56	43	4.8	5.0	5.3	5.8	6.3	6.9	7.6	8.1	8.7	9.3	10.1	10.9	11.8	12.7	13.8	14.8	16.7	18.7	21	24	26	28	30	33	36	40	44	48	53	58	64	71	79	88	98	109	121	134	149				
53	46	5.1	5.4	5.8	6.3	6.9	7.5	8.3	8.9	9.6	10.3	11.1	12.0	13.1	14.1	15.3	16.5	18.6	21	23	27	29	31	34	37	41	45	49	53	58	64	71	79	88	98	109	121	134	149					
49	49	5.5	5.9	6.2	6.8	7.5	8.3	9.1	9.8	10.5	11.4	12.3	13.3	14.5	15.7	17.0	18.4	21	23	26	30	32	35	38	42	46	51	55	60	65	71	77	84	92	100	109	119	129	140	151	163	176	190	
49	50	5.7	6.0	6.4	7.0	7.7	8.5	9.4	10.1	10.9	11.7	12.7	13.8	15.0	16.3	17.6	19.1	22	24	27	31	33	36	40	44	48	53	58	64	71	77	84	92	100	109	119	129	140	151	163	176	190		
46	53	6.2	6.5	7.0	7.7	8.5	9.3	10.4	11.2	12.0	13.0	14.1	15.3	16.7	18.1	19.6	21	24	27	31	35	38	41	45	49	54	59	64	71	77	84	92	100	109	119	129	140	151	163	176	190			
43	56	6.7	7.1	7.6	8.4	9.3	10.3	11.5	12.3	13.3	14.4	15.6	17.0	18.6	20	22	24	27	30	34	39	42	46	50	55	60	67	72	79	86	93	101	109	119	129	140	151	163	176	190				
41	58	7.1	7.6	8.1	9.0	9.9	11.0	12.3	13.2	14.3	15.5	16.8	18.3	20	22	24	26	29	33	37	42	46	50	54	60	65	72	77	84	92	100	109	119	129	140	151	163	176	190					
38	61	7.8	8.3	8.9	9.9	11.0	12.2	13.7	14.7	16.0	17.3	18.8	21	22	24	27	29	33	37	42	47	52	56	61	67	74	82	89	97	105	114	123	132	142	152	163	174	186	198	211	224	238		
35	64	8.6	9.2	9.9	11.0	12.2	13.6	15.3	16.5	17.9	19.4	21	23	25	28	30	33	37	42	47	54	58	64	70	76	84	93	101	109	118	127	136	146	156	166	177	188	200	212	225	238	252	266	
32	66	9.4	10.1	10.9	12.1	13.5	15.1	17.0	18.4	19.9	22	24	26	28	31	34	36	41	47	53	60	66	72	78	86	95	104	113	122	131	141	151	161	172	183	194	205	216	228	240	252	265	278	292
30	69	10.3	11.1	11.9	13.3	14.9	16.6	18.7	20	22	24	26	29	31	34	37	40	46	52	59	67	73	80	87	96	105	116	125	135	145	155	165	176	187	198	209	220	231	242	254	266	278	291	304
27	71	11.5	12.3	13.3	14.9	16.7	18.7	21	23	25	27	30	32	36	39	42	46	52	59	67	76	83	91	99	109	120	132	143	154	165	176	187	198	209	220	231	242	254	266	278	291	304	317	330
25	74	12.6	13.6	14.7	16.5	18.5	21	23	25	28	30	33	36	40	43	47	51	58	66	75	86	93	102	112	122	135	149	161	173	185	197	209	221	233	245	257	270	283	296	309	322	335	349	
23	76	13.9	15.0	16.2	18.2	20	23	26	28	31	33	37	40	44	48	52	57	65	74	84	95	104	114	124	136	150	163	176	189	202	215	228	241	254	267	280	294	308	322	336	350	364	378	
21	78	15.3	16.6	18.0	20	23	26	29	31	34	37	41	45	49	54	59	64	73	83	94	107	117	127	140	153	169	183	198	212	226	240	254	268	282	296	310	324	338	352	366	380	394	408	
18	81	18.2	19.7	21	24	27	31	35	38	41	45	49	54	59	65	71	77	88	100	113	129	141	154	169	185	204	225	247	270	294	318	342	366	390	414	438	462	486	510	534	558	582	606	

Standard Spindle Stopping 2.0 secs Idle Time

2.16.

272 Y152



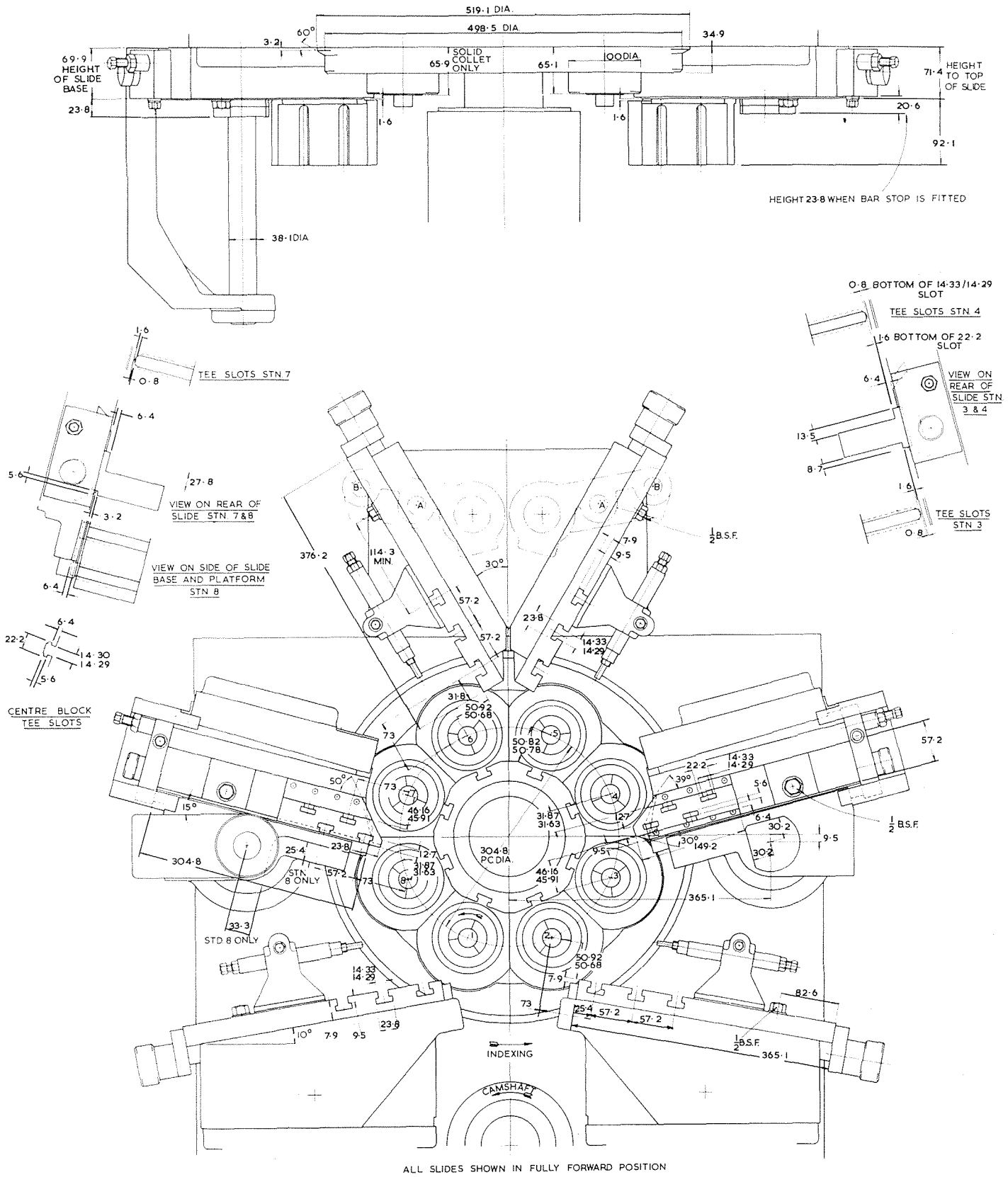
STATION	CROSS SLIDE STROKES							
	1	2	3&4	5	6		7&8	
	LEVER POSITION		LEVER POSITION		LEVER POSITION			
	A	B	A	B	A	B		
APPROACH STROKE AT MIN. FEED STROKE	1 13/32	2 25/32	1 1/8	1 3/8	2 1/32	1 3/32	1 1/32	2 29/32
APPROACH STROKE AT MAX. FEED STROKE	1 7/16	1 9/16	2 5/32	1 3/32	1 7/32	5/8	3/8	1 13/16
FEED STROKE	0-1	0-1	0-2 1/32	0-1 5/8	0-1 5/8	0-1 5/8	0-1 5/8	0-2 1/32
ADJUSTMENT BACKWARD			5/8					5/8

Capacity  
Chart for  
1 7/8 Bar  
Auto

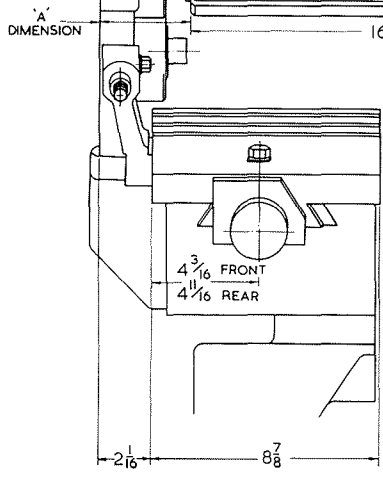
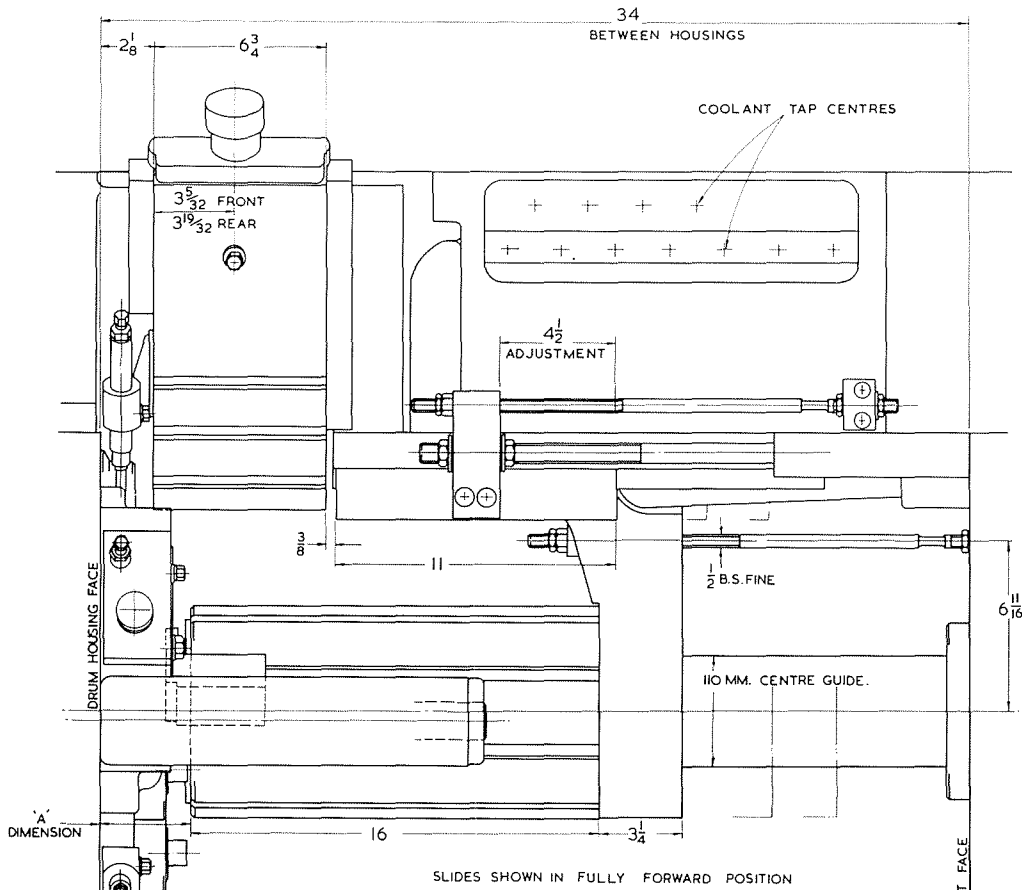


**Capacity Chart**  
for 1" - 8 Bar Automatic

**2.18.**

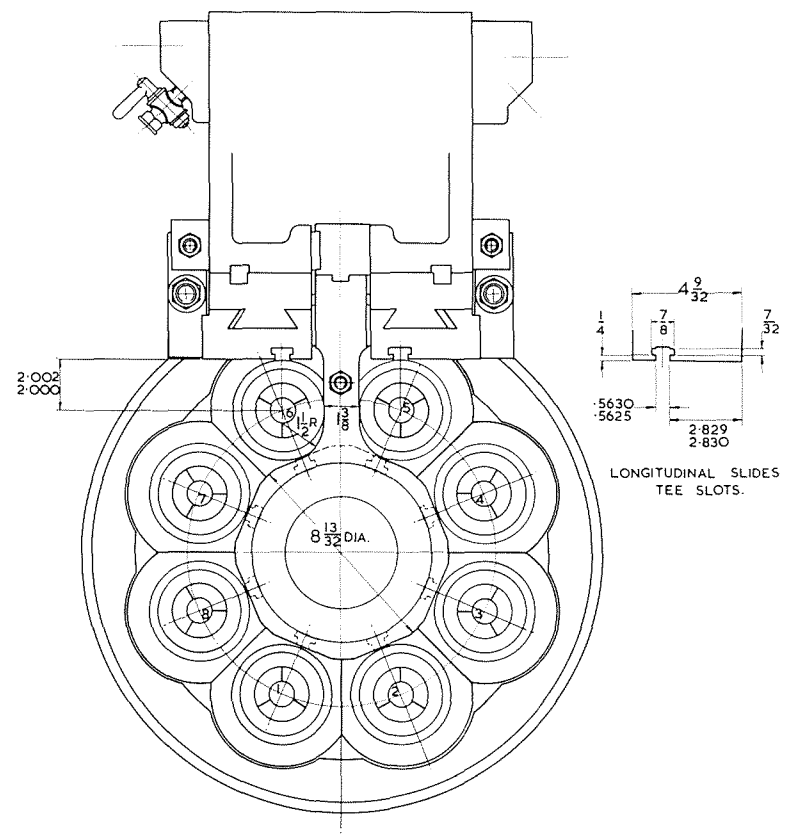


STATION	CROSS SLIDE STROKES							
	1	2	3&4	5		6		7&8
				A	B	A	B	
APPROACH STROKE AT MIN. FEED STROKE	35.7	45.2	28.6	34.9	16.7	27.8	12.7	23.0
APPROACH STROKE AT MAX. FEED STROKE	36.5	39.7	19.8	10.3	5.6	15.9	9.5	20.6
FEED STROKE	0-25.4	0-25.4	0-18.3	0-41.3	0-20.6	0-41.3	0-20.6	0-18.3
ADJUSTMENT BACKWARD	25.4	25.4	15.9	25.4	25.4	25.4	25.4	15.9



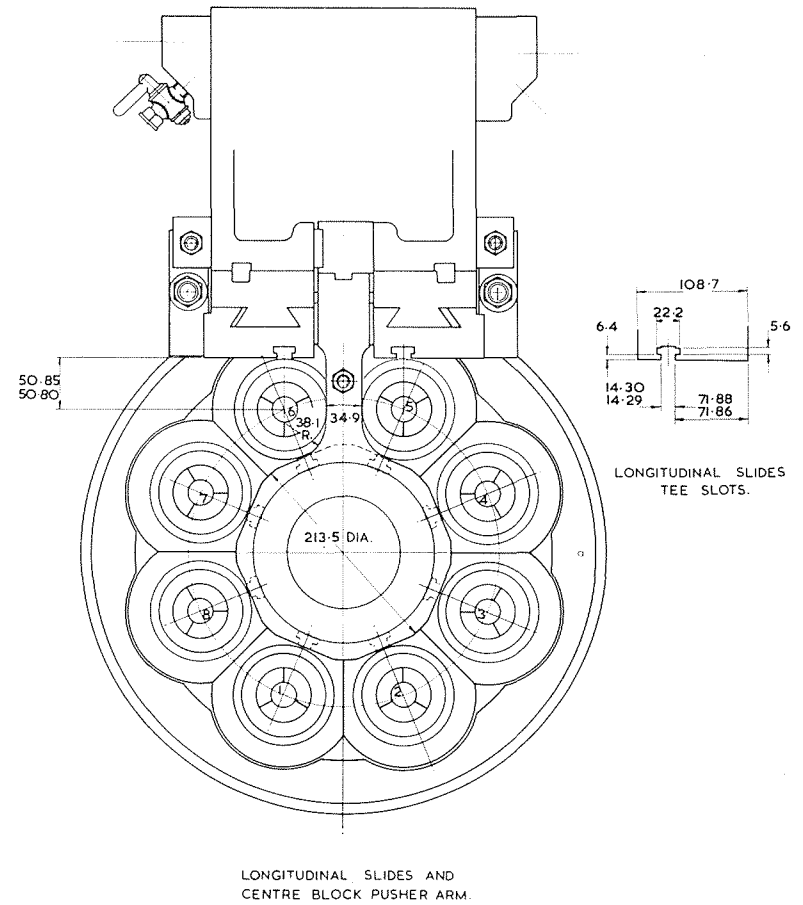
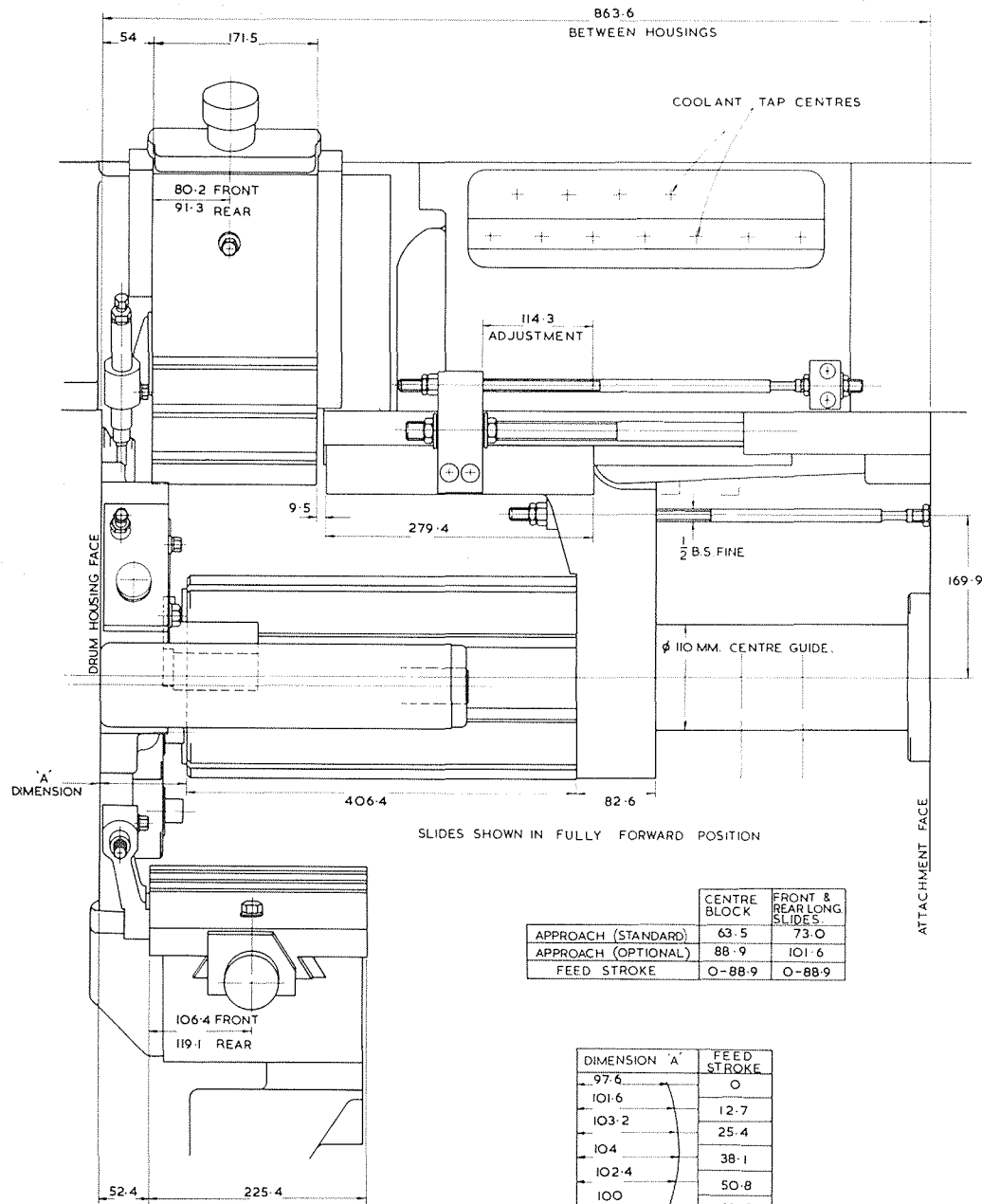
	CENTRE BLOCK	FRONT & REAR LONG SLIDES.
APPROACH (STANDARD)	2 1/2	2 7/8
APPROACH (OPTIONAL)	3 1/2	4
FEED STROKE	0 - 3 1/2	0 - 3 1/2

DIMENSION 'A'	FEED STROKE
3 27/32	0
4	1/2
4 1/16	1
4 3/32	1 1/2
4 1/2	2
4 15/16	2 1/2
3 23/32	3
3 1/2	3 1/2



LONGITUDINAL SLIDES AND CENTRE BLOCK PUSHER ARM.

Capacity Chart for 1" - 8 Bar Automatic

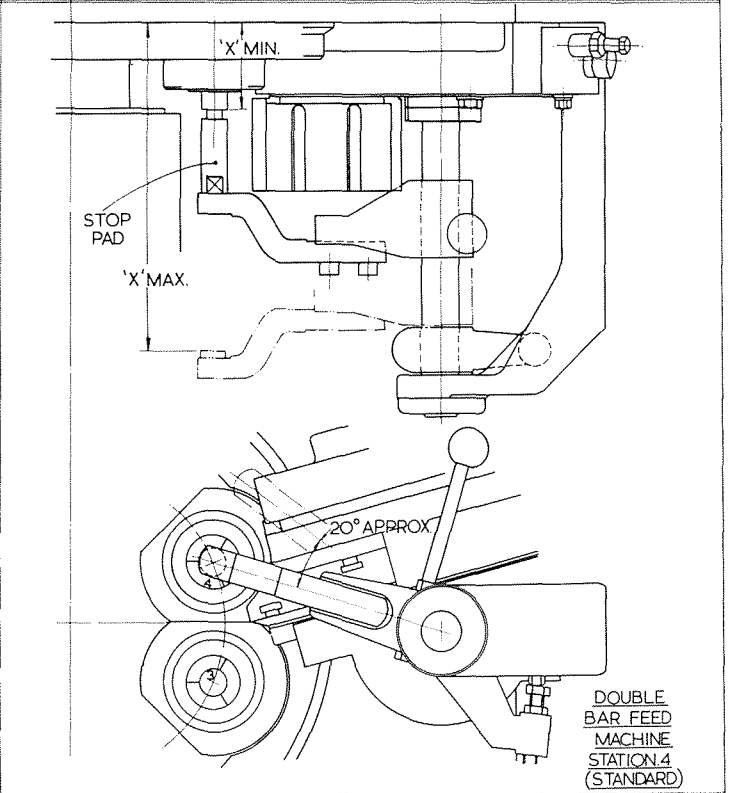
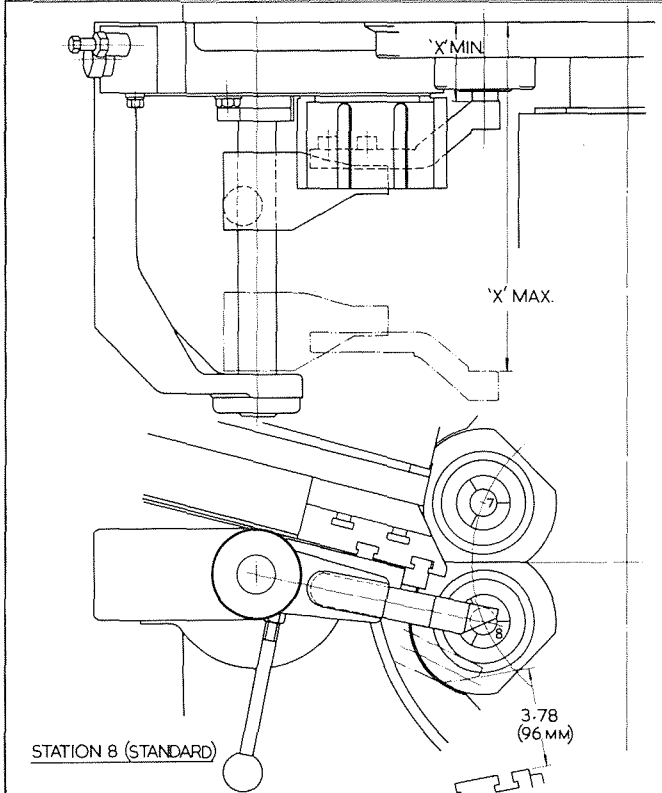
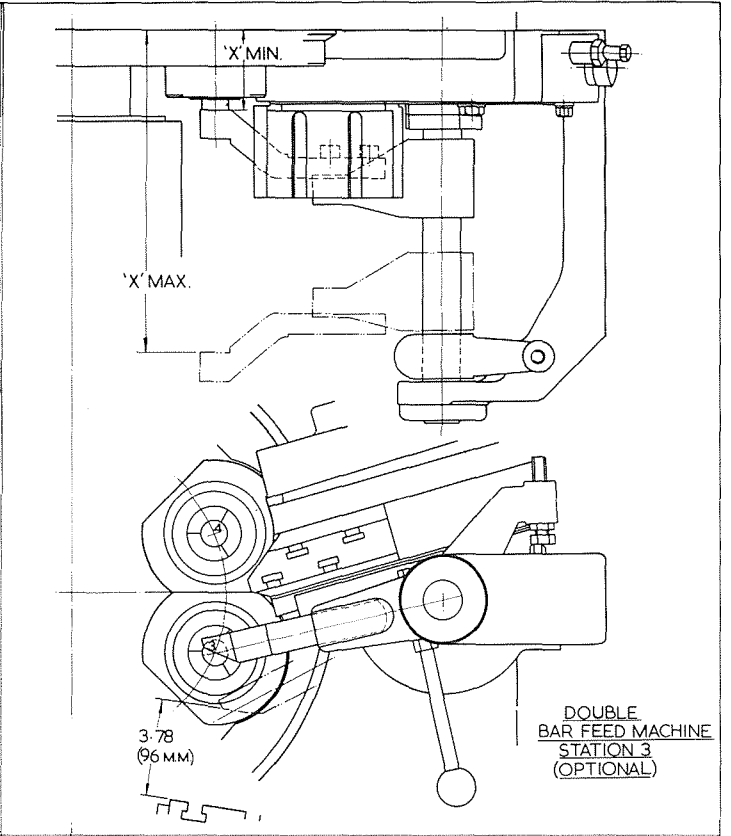
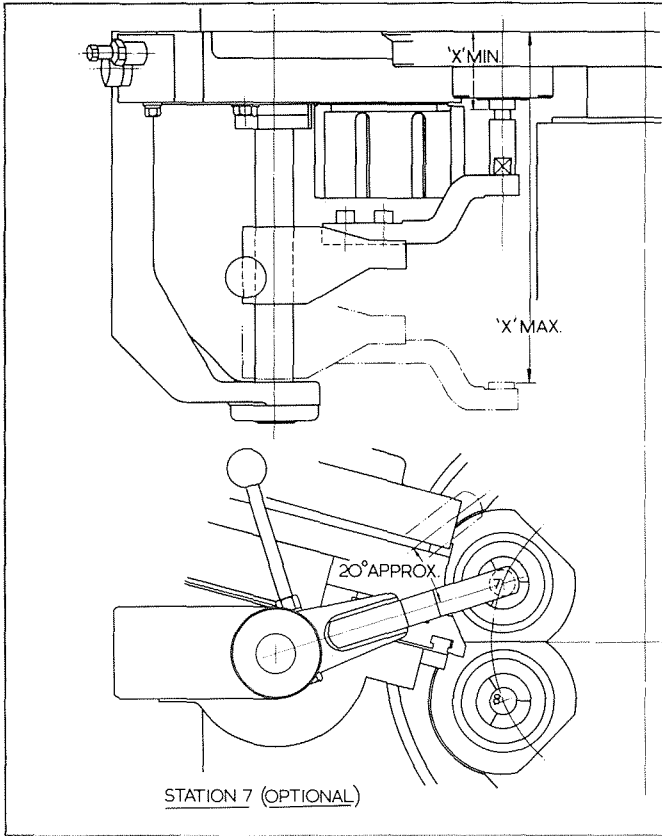


	CENTRE BLOCK	FRONT & REAR LONG SLIDES
APPROACH (STANDARD)	63.5	73.0
APPROACH (OPTIONAL)	88.9	101.6
FEED STROKE	0-88.9	0-88.9

DIMENSION 'A'	FEED STROKE
97.6	0
101.6	12.7
103.2	25.4
104	38.1
102.4	50.8
100	63.5
94.5	76.2
88.9	88.9

Capacity  
Chart  
for 1" - 8 Bar  
Automatic

2.20.



BAR 'STAND OUT' 'X'

STOP PAD No. →	255 X 162		255 X 163		255 X 164		255 X 165		255 X 166		255 X 167			
	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.		
STATION 8	3-06 78MM	13-38 340MM	—	—	—	—	—	—	—	—	—	—		
STATION 4	—	—	6-31 160MM	12-50 318MM	5-81 148MM	12-00 305MM	5-31 135MM	11-50 292MM	4-69 119MM	10-88 276MM	4-06 103MM	10-25 260MM	3-31 84MM	9-50 241MM
STATION 7	—	—	5-31 135MM	13-50 343MM	4-81 122MM	13-00 330MM	4-31 110MM	12-50 318MM	3-69 94MM	11-88 302MM	3-06 78MM	11-25 286MM	3-06 78MM	10-50 267MM
STATION 3	3-06 78MM	12-38 314MM	—	—	—	—	—	—	—	—	—	—	—	

SEE TABLE TO SELECT STOP PAD REQUIRED (PADS SUPPLIED WITH MACHINE MACHINE TOOL KIT)

BAR FEED 0.5 TO 7.0 (12.7 TO 177.8MM) IN ALL STATIONS

ON DOUBLE BAR FEED MACHINES, THE LONGER BAR FEED SHOULD BE AT THE FRONT.

MAXIMUM DIFFERENCE BETWEEN BAR LENGTHS FED 5-75 (146 MM)

# Wickman 2 $\frac{1}{4}$ "-6

A	B	68	65	62	59	56	52	49	46	43	40	38	36	68	65	62	59	56	52	49	46	43	40	38	36																											
B	A	40	43	46	49	52	56	59	62	65	68	70	72	40	43	46	49	52	56	59	62	65	68	70	72																											
N/MIN.	+	1302	1158	1032	922	825	711	636	568	507	451	416	383	377	336	299	267	239	206	184	165	147	131	120	111																											
																											L																									
																											2.5	5	7.5	10	20	30	40	50	125	MM.																
																											$\frac{1}{4}$	$\frac{1}{2}$	$\frac{3}{4}$	1	2	3	4	5		INS.																
72	27	7.0	7.6	8.2	8.9	9.6	10.8	11.7	12.8	14.1	15.5	16.6	17.8	18	20	22	24	27	31	34	38	42	47	51	55	93	5.0	2.7	5.4	8.1	10.8	22	32	43	54	135																
70	29	7.5	8.1	8.8	9.6	10.4	11.6	12.7	13.9	15.3	16.9	18.1	19.4	20	22	24	27	30	34	38	42	47	52	56	61	102	5.5	2.5	4.9	7.3	9.8	19.6	29	39	49	122																
67	32	8.3	9.0	9.8	10.6	11.6	13.0	14.3	15.7	17.3	19.1	20	22	22	25	27	30	34	39	43	48	53	60	64	70	118	6.4	2.1	4.2	6.4	8.5	17.0	25	34	42	106																
65	34	8.8	9.6	10.5	11.4	12.4	14.0	15.4	16.9	18.7	21	22	24	24	27	30	33	37	42	47	52	58	65	70	76	129	7.0	1.9	3.9	5.8	7.8	15.5	23	31	39	97																
62	37	9.7	10.6	11.6	12.6	13.8	15.6	17.2	18.9	21	23	25	27	27	30	34	37	41	48	53	59	66	74	80	88	147	8.0	1.7	3.4	5.1	6.8	13.6	20	27	34	85																
60	39	10.3	11.3	12.4	13.5	14.8	16.8	18.5	20	23	25	27	29	29	33	36	40	45	52	58	64	72	80	87	94	160	8.7	1.6	3.1	4.7	6.2	12.5	18.7	25	31	78																
57	42	11.4	12.5	13.7	15.0	16.5	18.7	21	23	25	28	30	33	33	37	41	46	51	58	65	72	81	91	98	106	182	9.8	1.4	2.8	4.1	5.5	11.0	16.5	22	28	69																
55	44	12.1	13.3	14.6	16.1	17.7	20	22	25	27	30	33	35	36	40	44	49	55	63	70	78	88	98	106	115	197	11	1.3	2.5	3.8	5.1	10.1	15.2	20	25	63																
52	47	13.4	14.7	16.2	17.8	19.6	22	25	27	30	34	36	39	40	45	50	55	62	71	79	88	99	111	120	130	223	12	1.1	2.2	3.4	4.5	9.0	13.5	17.9	22	56																
50	49	14.3	15.8	17.4	19.1	21	24	27	29	33	36	39	42	43	48	54	60	67	77	85	95	107	120	129	140	242	13	1.0	2.1	3.1	4.1	8.3	12.4	16.6	21	52																
49	50	14.8	16.3	18.0	19.8	22	25	28	31	34	38	41	44	45	50	56	62	69	80	89	99	111	124	135	146	252	14	.99	2.0	3.0	4.0	7.9	11.9	15.9	19.9	50																
47	52	15.8	17.5	19.3	21	23	27	30	33	37	41	44	48	48	54	60	67	75	86	96	107	120	135	146	158	273	15	.92	1.8	2.8	3.7	7.3	11.0	14.7	18.3	46																
44	55	17.5	19.4	21	24	26	30	33	37	41	46	49	53	54	61	68	76	84	97	108	121	135	152	164	178	308	17	.81	1.6	2.4	3.2	6.5	9.7	13.0	16.2	41																
42	57	18.8	21	23	26	28	32	36	40	44	50	53	58	59	66	73	82	91	105	117	131	147	165	178	193	335	18	.75	1.5	2.2	3.0	6.0	9.0	12.0	14.9	37																
39	60	21	23	26	29	32	36	40	45	50	56	60	65	66	74	83	92	103	119	133	148	166	186	202	219	380	21	.66	1.3	2.0	2.6	5.3	7.9	10.5	13.2	33																
37	62	23	25	28	31	34	39	44	49	54	61	65	71	72	80	90	100	112	129	144	161	181	203	220	238	413	22	.61	1.2	1.8	2.4	4.8	7.3	9.7	12.1	30																
34	65	25	28	31	35	39	44	49	55	61	69	74	80	82	91	102	114	127	147	164	184	206	231	250	271	472	25	.53	1.1	1.6	2.1	4.2	6.4	8.5	10.6	27																
32	67	28	31	34	38	42	48	54	60	67	75	81	88	89	100	112	125	139	161	180	201	225	253	274	297	516	28	.48	.97	1.5	1.9	3.9	5.8	7.7	9.7	24																
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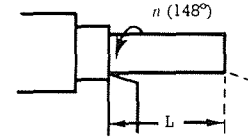
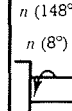
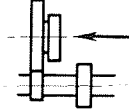
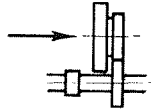
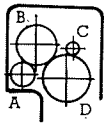
Standard Machine

# Wickman 2 $\frac{1}{4}$ -6

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N MIN.																																																		
																										L		L																						
																												MM																						
																												INS																						
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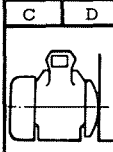
Long  
Bar Feed  
3.2.

# Wickman 6<sup>5</sup>/<sub>8</sub>-6

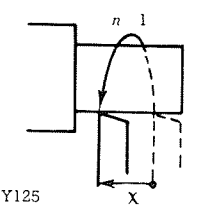
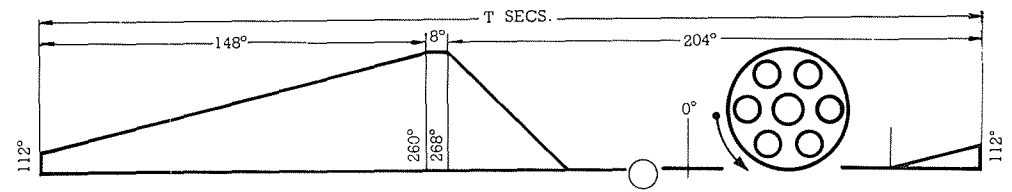


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B		40	43	46	49	52	56	59	62	65	68	70	72	74	76	78	80	A		40	43	46	49	52	56	59	62	65	68	70	72	74	76	78	80			n (148°)	n (8°)	2-5	5	7-5	10	20	30	40	50	125	MM
N/MIN.		862	767	683	611	546	471	421	376	335	298	275	254	233	214	195	177	N/MIN.		250	222	198	177	158	136	122	109	97	86	80	73	68	62	57	51	n (148°)	n (8°)			1/4	1/2	3/4	1	2	3	4	5	INS	
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X (0-001 INS.)



960 N/MIN.

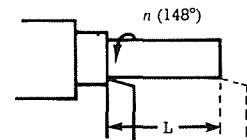
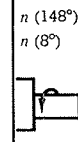
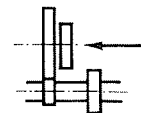
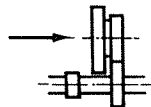
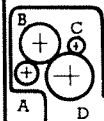


372Y125

960 R.P.M.  
Motor

3.3

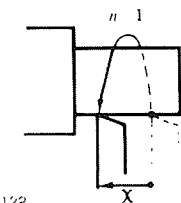
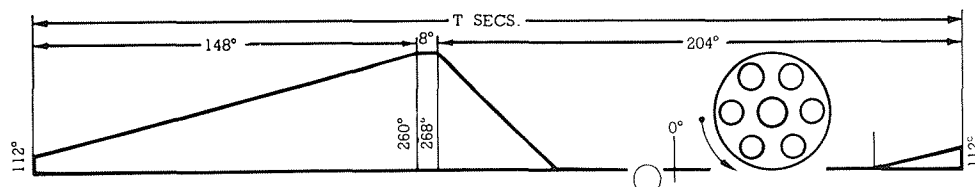
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47	52	15-8	17-5	19-3	21	23	27	30	33	37	41	44	48	52	56	61	67	48	54	60	67	75	86	96	107	120	135	146	158	172	187	205	225	273	15	9-2	1-8	2-8	3-7	7-3	11-0	14-7	18-3	46
44	55	17-5	19-4	21	24	26	30	33	37	41	46	49	53	58	63	69	75	54	61	68	76	84	97	108	121	135	152	164	178	194	211	231	254	308	17	8-1	1-6	2-4	3-2	6-5	9-7	13-0	16-2	41
42	57	18-8	21	23	26	28	32	36	40	44	50	53	58	63	68	74	82	59	66	73	82	91	105	117	131	147	165	178	193	210	229	251	275	335	18	7-5	1-5	2-2	3-0	6-0	9-0	12-0	14-9	37
39	60	21	23	26	29	32	36	40	45	50	56	60	65	71	77	84	92	66	74	83	92	103	119	133	148	166	186	202	219	238	259	284	311	380	21	6-6	1-3	2-0	2-6	5-3	7-9	10-5	13-2	33
37	62	23	25	28	31	34	39	44	49	54	61	65	71	77	84	91	100	72	80	90	100	112	129	144	161	181	203	220	238	259	282	309	339	413	22	6-1	1-2	1-8	2-4	4-8	7-3	9-7	12-1	30
34	65	25	28	31	35	39	44	49	55	61	69	74	80	87	95	104	114	82	91	102	114	127	147	164	184	206	231	250	271	295	322	352	386	472	25	5-3	1-1	1-6	2-1	4-2	6-4	8-5	10-6	27
32	67	28	31	34	38	42	48	54	60	67	75	81	88	95	104	113	124	89	100	112	125	139	161	180	201	225	253	274	297	323	352	385	423	516	28	4-8	9-7	1-5	1-9	3-9	5-8	7-7	9-7	24
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24	75	40	45	50	55	62	71	79	88*	99	111	120	130	141	154	168	184	132	148	166	185	207	239	267	299	335	376	407	442	481	524	574	630	771	42	3-2	6-5	9-7	1-3	2-6	3-9	5-2	6-5	16-2
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19	81	54	60	67	75	83	96	107	120	134	150	162	176	192	209	228	251	179	201	225	251	281	325	363	406	455	512	555	602	655	714	782	859	1052	57	2-4	4-8	7-1	9-5	1-9	2-9	3-8	4-8	11-9



1450 N/MIN.

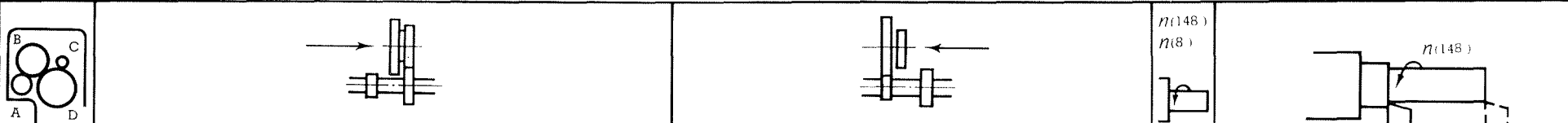


372Y122

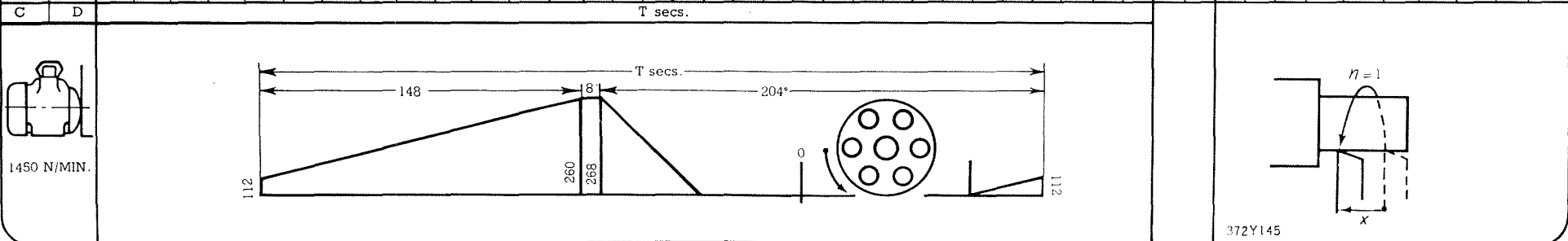
1450 R.P.M.  
Motor  
3.4.



# Wickman 6<sup>5</sup>/<sub>8</sub>"-6

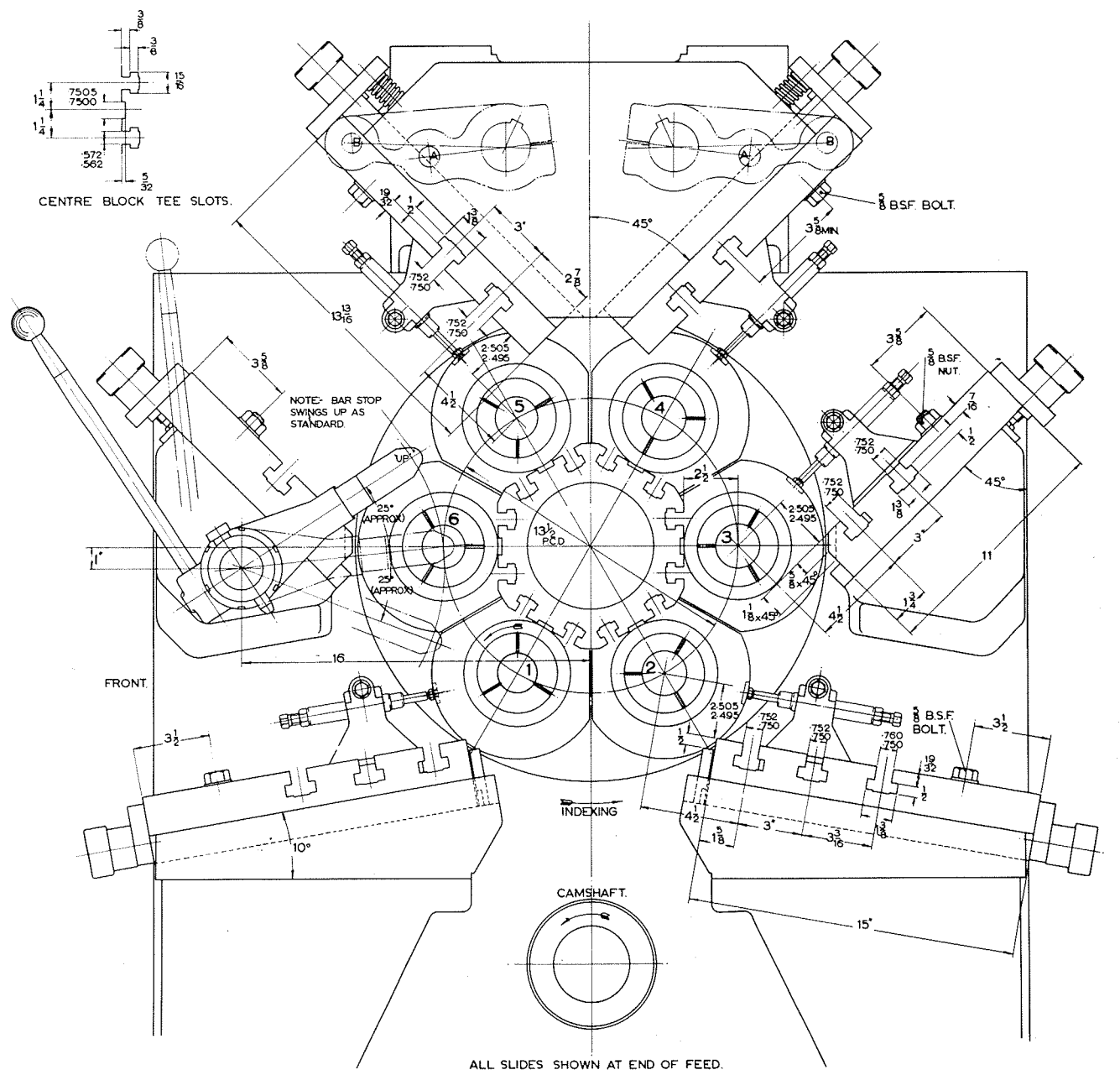
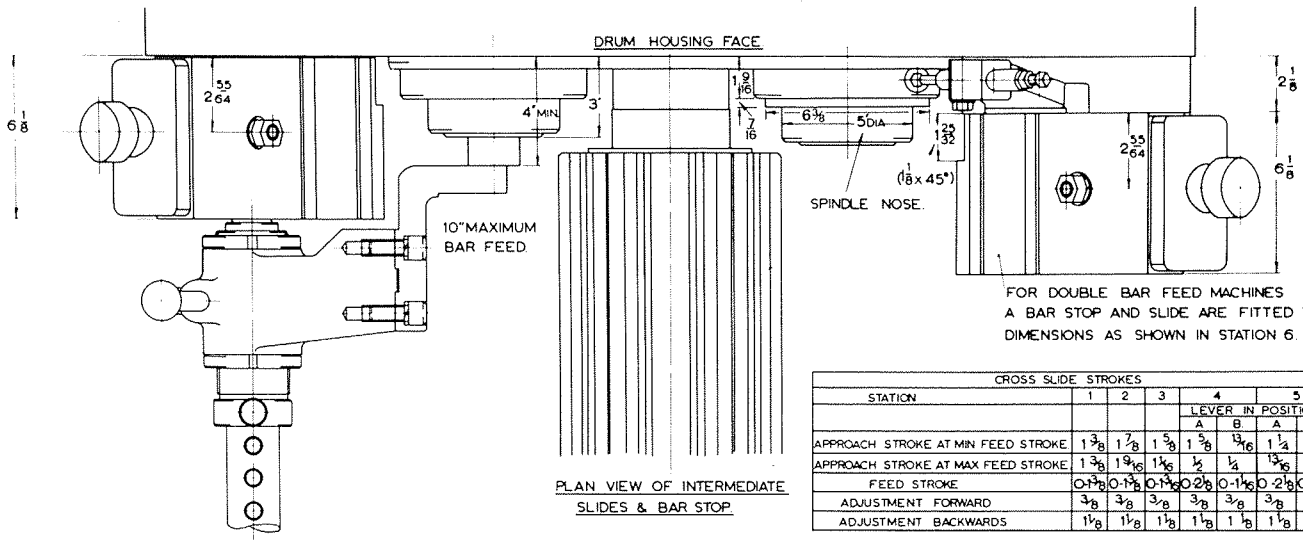


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B		40	43	46	49	52	56	59	62	65	68	70	72	74	76	78	80	40		43	46	49	52	56	59	62	65	68	70	72	74	76	78	80											
N/MIN.		1302	1158	1032	922	825	711	636	568	507	451	416	383	352	323	295	268	377		336	299	267	239	206	184	165	147	131	120	111	102	93	85	78	n(148)	n(8)	L	M/M INS							
		2.5	5	7.5	10	20	30	40	50	125			2.5	5	7.5	10	20	30	40	50	125																								
72	27	8-8	9-1	9-7	10-3	11	12-1	13	14	15	16-6	17-6	18-7	20	22	23	25	19	21	23	25	28	31	34	38	42	47	50	54	58	63	69	75	87	4-7	4-7	2-9	5-8	8-6	11-5	23	35	46	58	144
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47	52	16-8	18-4	20	22	24	27	30	33	37	41	44	47	51	55	60	65	47	53	59	65	72	83	92	103	115	129	139	150	163	178	194	213	256	14	1-0	2	2-9	3-9	7-8	11-7	15-6	19-6	49	
44	55	18-4	20	22	24	27	30	33	37	41	45	49	52	57	61	67	73	53	59	66	73	81	93	104	116	129	145	156	169	184	200	219	240	289	16	9	1-7	2-6	3-5	6-9	10-4	13-8	17-3	43	
42	57	19-7	22	24	26	29	32	36	40	44	49	52	56	61	66	72	79	57	64	71	79	88	101	112	125	140	157	169	184	199	217	237	260	314	17	8	1-6	2-4	3-2	6-4	9-6	12-7	15-9	40	
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37	62	23	26	28	31	34	39	43	48	53	59	64	69	74	81	88	96	70	78	87	96	107	124	138	153	172	192	208	225	245	267	292	320	388	21	6	1-3	1-9	2-5	5-2	7-7	10-3	12-9	32	
34	65	26	29	32	35	38	44	49	54	60	67	72	78	84	91	100	109	79	88	98	109	122	140	156	174	194	219	237	257	279	304	332	365	442	24	6	1-1	1-7	2-3	4-5	6-8	9-1	11-3	28	
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29	70	32	35	39	43	47	54	60	67	74	83	90	97	105	114	124	136	98	110	123	137	152	176	196	219	245	275	298	323	351	382	418	459	558	30	4	9	1-3	1-8	3-6	5-4	7-2	9	22	
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24	75	40	44	49	54	60	69	76	85	95	106	115	124	134	146	160	175	126	141	157	176	196	226	254	282	316	355	384	417	453	494	540	593	723	39	3	7	1-0	1-4	2-8	4-1	5-5	6-9	17	
21	78	46	52	57	63	70	81	90	100	112	125	135	146	159	173	189	207	149	167	186	208	232	268	299	335	375	421	456	494	537	586	641	704	859	46	3	6	9	1-2	2-3	3-5	4-7	5-8	15	
19	81	53	59	65	72	80	92	103	114	128	143	155	167	182	198	216	237	170	191	213	238	266	307	343	383	429	482	522	567	616	672	735	807	986	53	3	5	8	1-0	2-0	3-0	4-1	5-1	13	



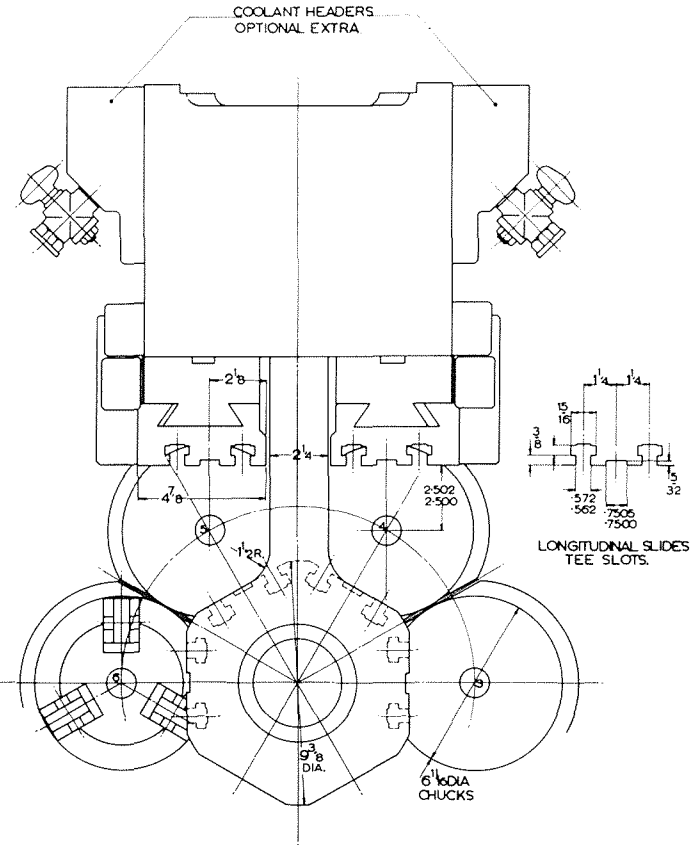
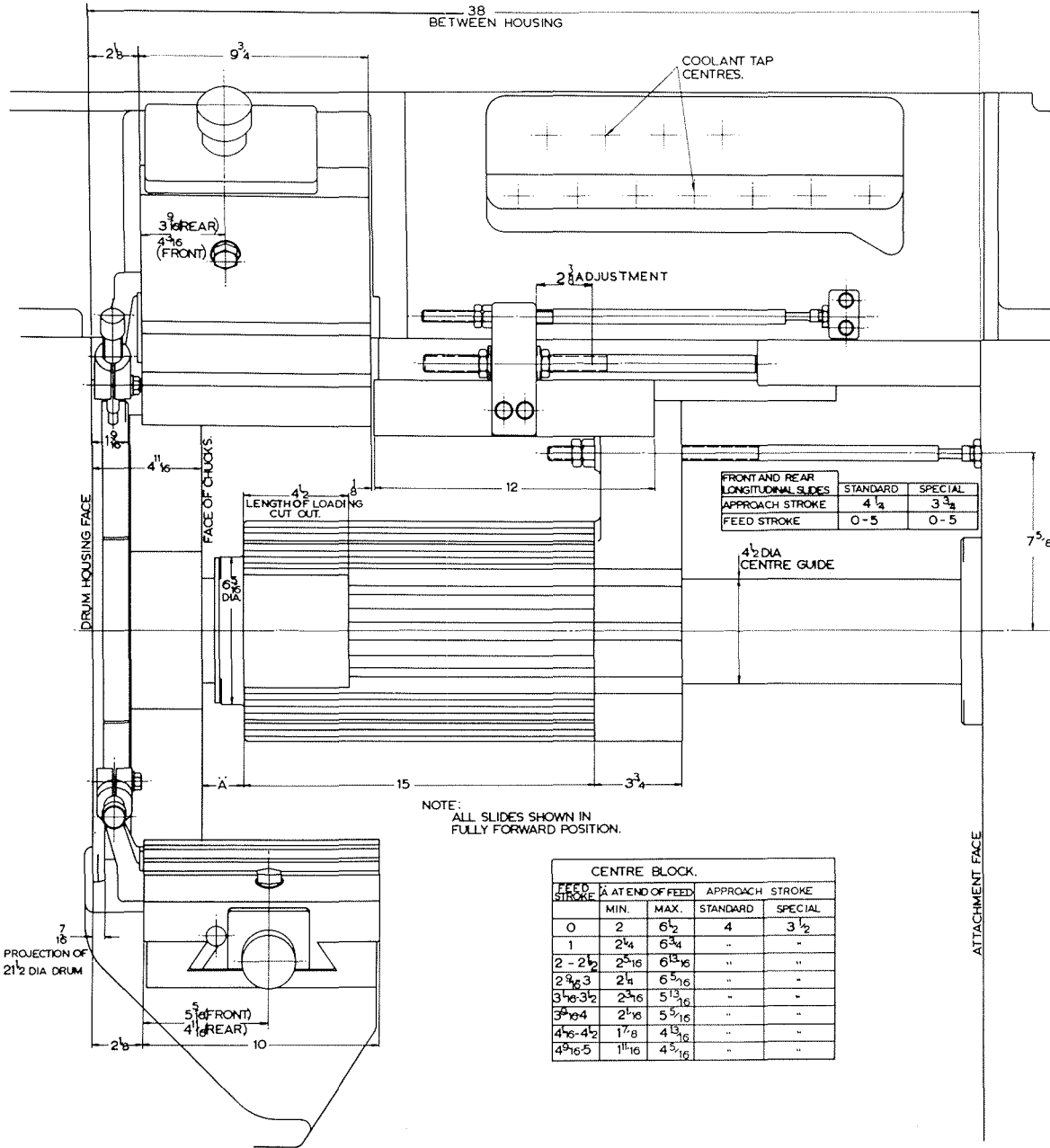
6<sup>5</sup>/<sub>8</sub>"-6  
Double Index  
3.5.

Capacity  
Chart for  
2 1/4" - 6 Bar  
300 Z20  
**3.10.**

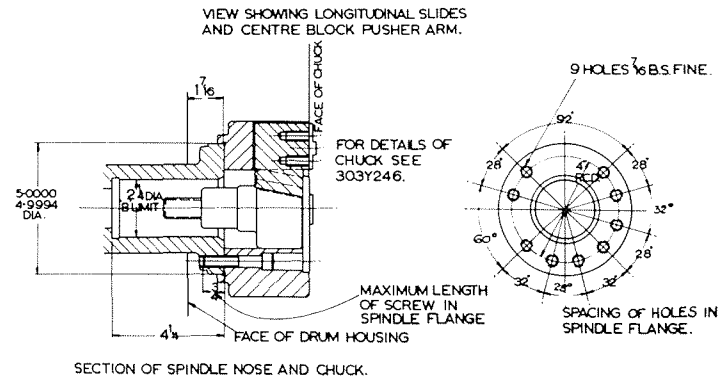






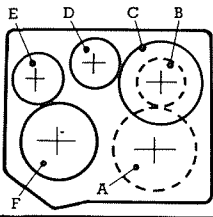


CENTRE BLOCK.				
FEED STROKE	A AT END OF FEED		APPROACH STROKE	
	MIN.	MAX.	STANDARD	SPECIAL
0	2	6 1/2	4	3 1/2
1	2 1/4	6 3/4	-	-
2 - 2 1/2	2 5/16	6 15/16	-	-
2 3/8 - 3	2 1/4	6 5/16	-	-
3 1/8 - 3 1/2	2 3/16	5 1/16	-	-
3 7/8 - 4	2 1/8	5 3/16	-	-
4 1/8 - 4 1/2	1 7/8	4 3/16	-	-
4 3/8 - 5	1 11/16	4 3/16	-	-

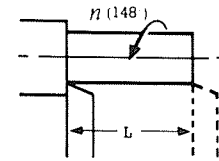
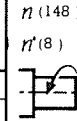


Capacity Chart for 6 5/8" - 6 Spindle Chucker

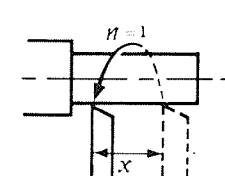
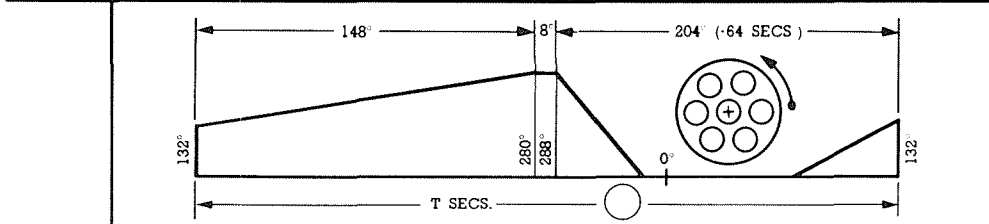
# Wickman 5-6



A	47	47	47	45	47	45	43	47	45	47	47	47	45	43	39	39	33	33	29	29	27	25
B	25	25	25	27	25	27	29	25	27	25	25	25	27	29	33	33	39	39	43	43	45	47
C	47	45	43	43	39	39	39	33	33	29	27	25	25	25	27	25	29	27	25	25	25	25
D	25	27	29	29	33	33	33	39	39	43	45	47	47	47	45	47	43	45	47	45	47	47



N/MIN.	L																				n(148)	n'(8)	X (.01 MM.)	X (.001)								
	2.5	5	7.5	10	20	50	MM.	INS.																								
59	19		1.2	1.2	1.3	1.4	1.5	1.5	1.7	1.8	1.9	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.7	5.2	5.7	32	1.7	7.8	15.5	23	31	62	155	
57	20		1.1	1.2	1.3	1.3	1.4	1.5	1.6	1.8	1.9	2.0	2.2	2.4	2.6	2.9	3.1	3.4	3.7	4.1	4.5	5.0	5.6	6.2	35	1.9	7.1	14.2	21	28	57	142
56	22	1.1	1.2	1.3	1.4	1.4	1.5	1.6	1.7	1.9	2.0	2.2	2.4	2.6	2.9	3.1	3.4	3.7	4.1	4.5	5.0	5.5	6.2	6.9	39	2.1	6.4	12.7	19.1	25	51	127
54	24	1.2	1.3	1.4	1.4	1.5	1.6	1.8	1.9	2.1	2.2	2.4	2.6	2.9	3.2	3.4	3.8	4.1	4.6	5.1	5.6	6.2	6.9	7.7	45	2.4	5.6	11.2	16.9	22	45	112
52	26	1.3	1.4	1.4	1.5	1.6	1.8	1.9	2.0	2.2	2.4	2.6	2.9	3.2	3.5	3.8	4.2	4.6	5.0	5.6	6.2	6.9	7.7	8.6	50	2.7	5.0	10.0	15.0	20	40	100
50	28	1.3	1.4	1.5	1.7	1.8	1.9	2.1	2.2	2.4	2.6	2.9	3.1	3.5	3.8	4.2	4.6	5.0	5.6	6.2	6.8	7.6	8.5	9.5	56	3.0	4.5	8.9	13.4	17.8	36	89
48	30	1.4	1.5	1.6	1.8	1.9	2.1	2.2	2.4	2.6	2.8	3.1	3.4	3.8	4.2	4.6	5.1	5.5	6.2	6.9	7.6	8.4	9.4	10.5	63	3.4	4.0	8.0	12.0	16.0	32	80
46	32	1.5	1.6	1.8	1.9	2.0	2.2	2.4	2.6	2.8	3.1	3.4	3.8	4.2	4.6	5.0	5.6	6.1	6.8	7.6	8.3	9.3	10.4	11.6	70	3.8	3.6	7.2	10.8	14.4	29	72
43	34	1.6	1.8	1.9	2.1	2.2	2.4	2.7	2.9	3.1	3.4	3.8	4.2	4.6	5.1	5.6	6.3	6.8	7.6	8.5	9.4	10.5	11.7	13.2	79	4.3	3.2	6.3	9.5	12.6	25	63
41	37	1.8	1.9	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.7	5.2	5.8	6.3	7.1	7.7	8.6	9.6	10.6	11.9	13.3	14.9	90	4.9	2.8	5.5	8.3	11.1	22	55
39	39	1.9	2.1	2.2	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.6	5.1	5.7	6.3	7.0	7.8	8.5	9.5	10.6	11.7	13.1	14.7	16.5	100	5.4	2.5	5.0	7.5	10.0	20	50
37	41	2.0	2.2	2.4	2.6	2.9	3.2	3.5	3.8	4.2	4.6	5.0	5.6	6.2	6.9	7.6	8.5	9.3	10.4	11.7	12.9	14.5	16.2	18.2	111	6.0	2.3	4.5	6.8	9.0	18.0	45
34	43	2.2	2.4	2.7	2.9	3.2	3.5	3.9	4.2	4.7	5.1	5.7	6.3	7.0	7.8	8.6	9.6	10.6	11.8	13.2	14.6	16.4	18.4	21	127	6.8	2.0	3.9	5.9	7.9	15.8	39
32	46	2.5	2.7	2.9	3.2	3.5	3.9	4.3	4.7	5.2	5.7	6.3	7.1	7.9	8.8	9.7	10.9	11.9	13.3	14.9	16.5	18.6	21	23	144	7.8	1.7	3.5	5.2	6.9	13.9	35
30	48	2.7	2.9	3.2	3.5	3.9	4.3	4.7	5.1	5.7	6.3	7.0	7.8	8.7	9.7	10.7	12.0	13.2	14.8	16.6	18.3	21	23	26	160	8.7	1.6	3.1	4.7	6.2	12.5	31
28	50	2.9	3.2	3.5	3.9	4.2	4.7	5.2	5.7	6.3	6.9	7.7	8.6	9.7	10.8	11.9	13.4	14.7	16.4	18.4	20	23	26	29	179	9.7	1.4	2.8	4.2	5.6	11.2	28
26	52	3.2	3.5	3.9	4.3	4.7	5.2	5.7	6.3	7.0	7.7	8.6	9.6	10.7	12.0	13.3	14.9	16.3	18.3	21	23	26	29	32	200	11	1.2	2.5	3.7	5.0	10.0	25
24	54	3.5	3.9	4.3	4.7	5.2	5.8	6.4	7.0	7.8	8.6	9.6	10.7	12.0	13.4	14.8	16.7	18.3	20	23	26	29	32	36	225	12	1.1	2.2	3.3	4.4	8.9	22
22	56	3.9	4.3	4.7	5.3	5.8	6.4	7.1	7.8	8.7	9.6	10.7	12.0	13.5	15.1	16.7	18.8	21	23	26	29	32	36	41	255	14	1.0	2.0	2.9	3.9	7.8	20
20	57	4.2	4.7	5.2	5.8	6.4	7.1	7.9	8.7	9.7	10.7	12.0	13.4	15.0	16.8	18.6	21	23	26	29	32	36	41	46	285	15	.9	1.8	2.6	3.5	7.0	17.5
19	59	4.6	5.1	5.6	6.3	6.9	7.7	8.6	9.4	10.5	11.6	13.0	14.5	16.3	18.3	20	23	25	28	32	35	39	44	50	311	17	.8	1.6	2.4	3.2	6.4	16.1

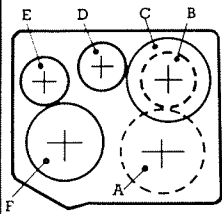


472Y104

Standard Machine

4.1.

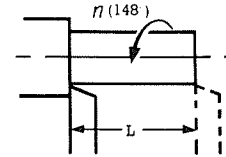
# Wickman 8<sup>1/2</sup>"-65



A		47	45	47	45	43	47	45	47	47	47	45	43	39	39	33	33	33	29	29	27	25
B		25	27	25	27	29	25	27	25	25	25	27	29	33	33	39	39	43	43	45	47	
C		43	43	39	39	33	33	29	27	25	25	25	27	25	29	27	25	27	25	25	25	
D		29	29	33	33	33	39	39	43	45	47	47	47	47	45	47	45	47	45	47	47	47

n (148)

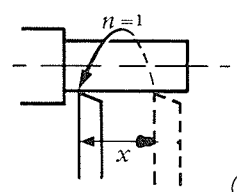
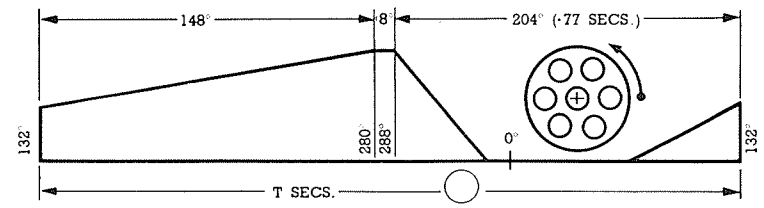
n (8°)



		L																				n (148°)		n (8°)						
		3550	3150	2800	2500	2240	2000	1800	1600	1400	1250	1120	1000	900	800	710	630	560	500	450	400	355	2.5	5	7.5	10	20	50	MM.	
																						25	50	75	1	2			INS.	
59	19	1.4	1.5	1.6	1.7	1.8	1.9	2.0	2.2	2.3	2.5	2.8	3.0	3.2	3.6	3.8	4.2	4.7	5.1	5.6	6.3	7.0	35	1.9	7.2	14.4	22	29	58	144
57	20	1.5	1.6	1.6	1.7	1.9	2.0	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.1	4.5	5.0	5.5	6.1	6.7	7.5	38	2.0	6.6	13.2	19.8	26	53	132
56	22	1.5	1.6	1.7	1.9	2.0	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.5	5.0	5.5	6.0	6.7	7.5	8.3	42	2.3	5.9	11.8	17.7	24	47	118
54	24	1.6	1.8	1.9	2.0	2.2	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.6	5.0	5.5	6.1	6.7	7.5	8.3	9.3	48	2.6	5.2	10.4	15.7	21	42	104
52	26	1.8	1.9	2.0	2.2	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.6	5.1	5.5	6.1	6.8	7.5	8.3	9.3	10.4	54	2.9	4.6	9.3	13.9	18.6	37	93
50	28	1.9	2.0	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.6	5.1	5.6	6.1	6.8	7.5	8.3	9.2	10.3	11.5	60	3.3	4.1	8.3	12.4	16.6	33	83
48	30	2.0	2.2	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.2	4.6	5.1	5.6	6.2	6.7	7.5	8.3	9.2	10.2	11.4	12.8	67	3.6	3.7	7.4	11.1	14.8	30	74
46	32	2.1	2.3	2.5	2.7	2.9	3.2	3.5	3.8	4.1	4.6	5.0	5.6	6.1	6.8	7.4	8.2	9.2	10.1	11.3	12.6	14.1	75	4.1	3.3	6.7	10.0	13.3	27	67
43	34	2.3	2.5	2.7	3.0	3.2	3.5	3.8	4.2	4.6	5.1	5.6	6.2	6.8	7.6	8.3	9.2	10.3	11.4	12.7	14.2	15.9	85	4.6	2.9	5.9	8.8	11.7	23	59
41	37	2.5	2.8	3.0	3.3	3.6	3.9	4.3	4.6	5.1	5.7	6.3	7.0	7.7	8.6	9.4	10.4	11.7	12.9	14.4	16.1	18.1	97	5.3	2.6	5.1	7.7	10.3	21	51
39	39	2.7	3.0	3.2	3.5	3.9	4.2	4.6	5.1	5.6	6.2	6.9	7.7	8.4	9.4	10.3	11.5	12.8	14.2	15.9	17.8	19.9	108	5.8	2.3	4.6	7.0	9.3	18.6	46
37	41	2.9	3.2	3.5	3.8	4.2	4.6	5.0	5.5	6.1	6.8	7.6	8.4	9.3	10.3	11.3	12.6	14.1	15.6	17.5	19.6	22	119	6.5	2.1	4.2	6.3	8.4	16.8	42
34	43	3.2	3.6	3.9	4.3	4.7	5.1	5.6	6.2	6.9	7.6	8.5	9.5	10.5	11.7	12.8	14.3	16.0	17.7	19.9	22	25	136	7.4	1.8	3.7	5.5	7.3	14.7	37
32	46	3.6	3.9	4.3	4.7	5.2	5.7	6.3	6.9	7.7	8.6	9.6	10.7	11.8	13.2	14.4	16.1	18.1	20	23	25	28	155	8.4	1.6	3.2	4.8	6.5	12.9	32
30	48	3.9	4.3	4.7	5.2	5.7	6.2	6.9	7.6	8.5	9.5	10.6	11.8	13.0	14.6	16.0	17.9	20	22	25	28	32	172	9.3	1.5	2.9	4.4	5.8	11.6	29
28	50	4.3	4.7	5.1	5.7	6.3	6.9	7.6	8.4	9.4	10.5	11.7	13.1	14.4	16.2	17.7	19.9	22	25	28	31	35	192	10.4	1.3	2.6	3.9	5.2	10.4	26
26	52	4.7	5.2	5.7	6.3	7.0	7.6	8.5	9.3	10.4	11.6	13.0	14.5	16.1	18.0	19.8	22	25	28	31	35	39	216	11.6	1.2	2.3	3.5	4.6	9.3	23
24	54	5.2	5.7	6.3	7.0	7.7	8.5	9.4	10.4	11.6	13.0	14.5	16.2	18.0	20	22	25	28	31	35	39	44	242	13.1	1.0	2.1	3.1	4.1	8.2	21
22	56	5.7	6.4	7.0	7.8	8.7	9.5	10.6	11.7	13.0	14.6	16.3	18.3	20	23	25	28	32	35	39	44	50	274	14.8	.9	1.8	2.7	3.6	7.3	18.2
20	57	6.3	7.0	7.7	8.6	9.6	10.5	11.7	13.0	14.5	16.2	18.2	20	23	25	28	31	35	39	44	49	55	307	16.6	.8	1.6	2.4	3.3	6.5	16.3
19	59	6.8	7.6	8.4	9.3	10.4	11.4	12.7	14.1	15.7	17.6	19.8	22	25	28	30	34	38	42	48	54	60	335	18.1	.7	1.5	2.2	3.0	6.0	14.9

X (.01 MM.)  
X (.001)

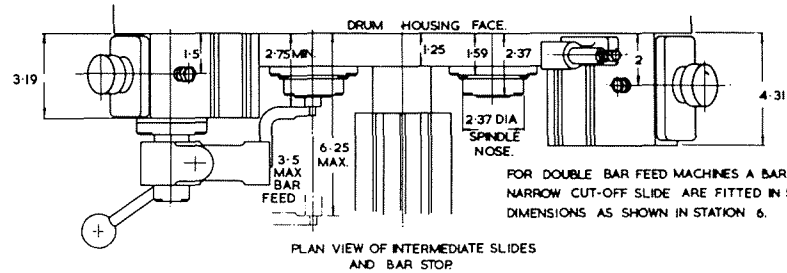
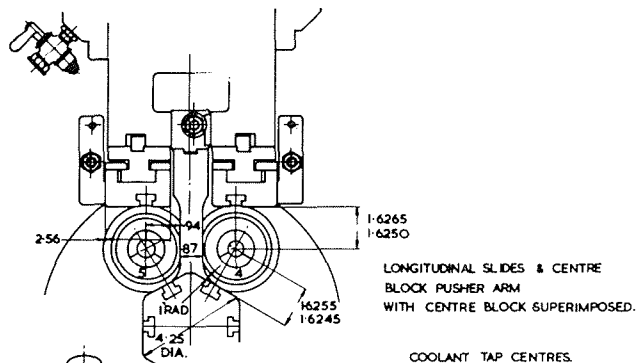
T. SECS.



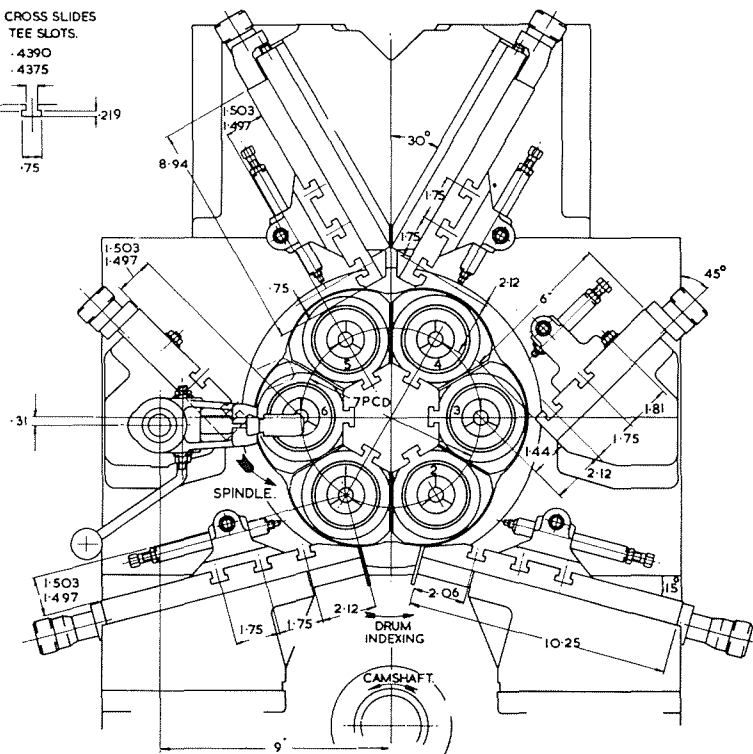
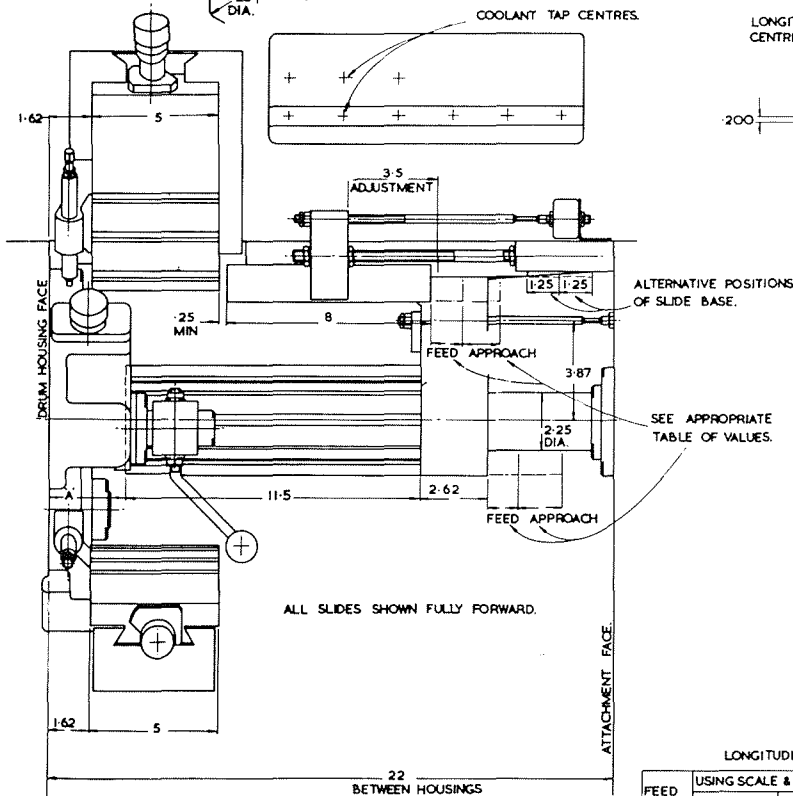
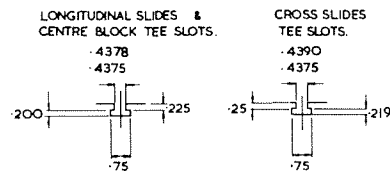
Spindle Stopper

4.2.

472Y103A



FOR DOUBLE BAR FEED MACHINES A BAR STOP AND A NARROW CUT-OFF SLIDE ARE FITTED IN STATION 3. DIMENSIONS AS SHOWN IN STATION 6.



ALL SLIDES SHOWN IN FULLY FORWARD POSITION  
 .625 BACKWARD ADJUSTMENT AVAILABLE ON ALL CROSS SLIDES FROM POSITION SHOWN.

CENTRE BLOCK STROKES.

FEED STROKE	APPROACH, DRUM LOCKED	TOTAL APPROACH	DIMENSION A
0	1.45	2.25	3.2
0.5	1.25	2.0	3.3
1.0	1.15	1.75	3.3
1.5	1.0	1.50	3.2
2.0	.75	1.25	2.95

LONGITUDINAL SLIDE STROKES.

FEED STROKE	USING SCALE & HOLE A.		USING SCALE & HOLE B.	
	APPROACH, DRUM LOCKED	TOTAL APPROACH	APPROACH, DRUM LOCKED	TOTAL APPROACH
0	1.45	2.2	—	—
0.5	1.3	2.0	—	—
1.0	1.15	1.8	1.6	2.45
1.5	1.0	1.55	1.4	2.20
2.0	.8	1.25	1.2	1.90
2.5	—	—	1.0	1.6
3.0	—	—	.90	1.35
3.5	—	—	.75	1.15

CROSS SLIDE STROKES.

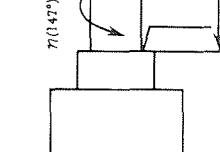
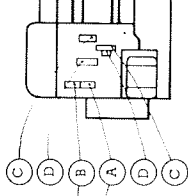
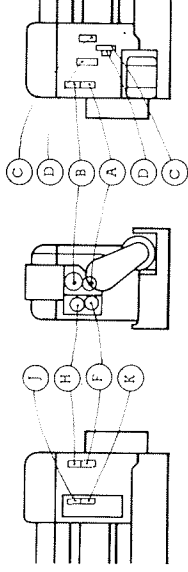
STATION	1	2	3	4	5	6
FEED STROKE	0 TO .5	0 TO .5	0 TO .35	0 TO .5	0 TO .5	0 TO .35
APPROACH STROKE AT MIN (ZERO) FEED STROKE	.75	.91	.93	.93	.76	.75
APPROACH STROKE AT MAX FEED STROKE.	.76	.78	.78	.72	.72	.73

Capacity Chart for 5/8" - 6 Spindle Bar Automatic



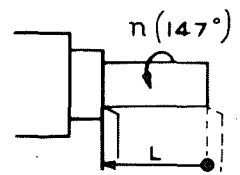
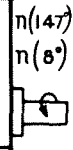
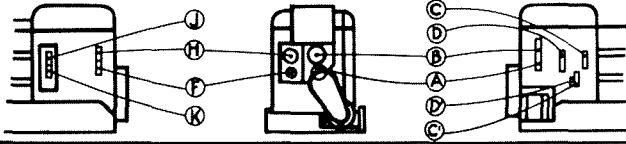
# Wickman

# 1 3/4"-8



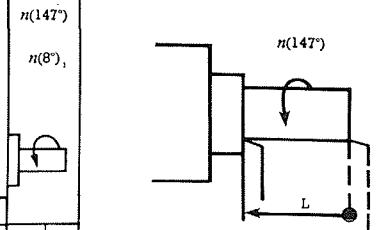
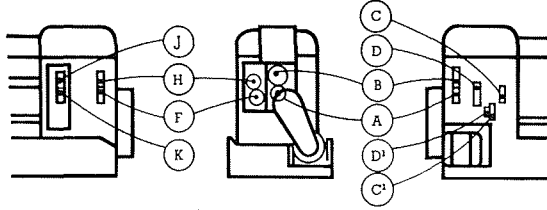
A	CC										DD										L					INS												
	30	47	45	42	40	37	35	32	30	27	55	52	50	47	45	42	40	37	35	32	30	27	24	22	2.5		5	7.5	10	20	30	40	50	125	250			
44	27	47	24	7.1	7.6	8.2	9	9.6	10.6	11.3	12.6	13.7	15.5	13.5	16.2	16.4	18.4	19.9	22	24	26	30	34	37	43	51	57	81	44	31	61	93	12	24	37	49	61	153
42	29	47	24	7.6	8.4	8.9	9.6	10.4	11.3	12.4	13.9	15	16.9	14.7	16.7	18.1	20	22	23	27	31	33	38	42	48	57	63	92	5	2.7	5.4	8.2	11	22	33	43	54	135
39	32	47	24	8.5	9.4	10	11	11.8	13.1	14.1	15.9	17.2	19.6	17	19.3	21	23	26	29	31	36	39	45	49	57	67	75	109	6	2.3	4.8	6.8	9.1	18	27	36	45	113
42	29	44	27	6.6	9.5	10.1	11.1	11.9	13.3	14.3	16.1	17.4	19.9	17.2	19.5	21	23	26	29	32	36	39	45	49	57	66	76	110	6	2.3	4.8	6.8	9.1	18	27	36	45	113
37	34	47	24	9.2	10.1	10.6	12	12.9	14.4	15.5	17.4	19	22	19.7	21	23	26	28	32	35	40	43	50	54	63	75	83	122	16	2	4.1	6.1	8.1	16	24	32	41	103
39	32	44	27	9.7	10.7	11.4	12.7	13.6	15.2	16.4	18.5	20	23	19.8	23	25	28	30	34	37	42	46	53	58	67	81	89	133	7	1.9	3.8	5.7	7.6	15	23	31	38	96
37	34	47	24	10.3	11.3	12.3	13.7	14.7	16.4	17.8	20	21	25	22	25	27	31	33	36	41	46	51	58	64	74	89	96	144	6	1.7	3.4	5.1	6.8	14	21	27	34	85
39	32	42	29	10.6	11.6	12.5	13.9	14.9	16.7	18.1	20	22	25	22	25	29	31	34	38	42	47	52	59	65	76	90	100	147	8	1.7	3.4	5.1	6.8	14	21	27	34	85
32	39	47	24	11.2	12.5	13.4	15	16.1	18.1	19.6	22	24	28	24	27	30	34	37	42	45	52	57	65	71	83	99	110	162	13	3.1	4.6	6.2	12	18	25	31	78	
37	34	42	29	11.4	12.7	13.6	15.2	16.3	18.4	19.9	23	25	28	24	26	30	34	37	42	46	53	58	67	74	84	101	112	165	13	3.1	4.6	6.2	12	18	25	31	78	
34	37	44	27	11.8	13.2	14.2	15.8	17	19.1	21	23	26	29	25	29	32	36	39	44	48	55	60	69	75	86	104	116	171	15	3.1	4.6	6.2	12	18	25	31	78	
29	42	47	24	12.8	14.3	15.4	17.2	18.6	21	23	26	28	32	32	35	39	43	49	53	58	65	70	78	88	106	121	134	194	14	2.9	4.3	5.8	12	17	23	29	73	
32	39	44	27	12.9	14.4	15.5	17.4	18.8	21	23	26	28	33	32	35	40	43	49	54	61	67	72	80	90	108	124	139	194	10	1.3	2.6	3.8	9.2	10	16	21	26	65
34	37	42	29	13	14.5	15.6	17.4	18.8	21	23	26	29	33	32	35	40	44	50	54	62	68	78	85	99	119	132	145	195	10	1.3	2.6	3.8	9.2	10	16	21	26	65
37	34	39	32	13	14.5	15.6	17.5	18.9	21	23	26	29	33	32	35	40	44	50	54	62	68	78	85	99	119	132	145	195	10	1.3	2.6	3.8	9.2	10	16	21	26	65
27	44	47	24	14	15.7	16.9	19	21	23	25	29	31	36	31	35	39	44	48	55	59	68	75	86	94	109	123	135	186	15	1.5	2.2	3.4	4.6	9.2	14	18	23	58
32	39	42	29	14.1	15.4	16.7	19.2	21	23	25	29	32	36	31	35	39	44	48	55	60	69	75	86	95	111	123	147	219	12	1.1	2.3	3.4	4.6	9.2	14	18	23	58
29	42	47	24	14.6	16	17.4	20	22	25	27	30	33	38	33	38	41	47	51	58	63	72	79	92	100	117	140	185	231	13	1.1	2.1	3.2	4.3	8.6	13	17	21	54
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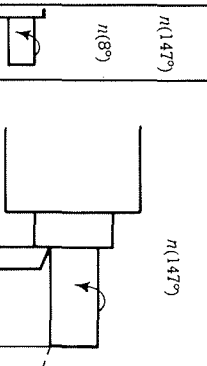
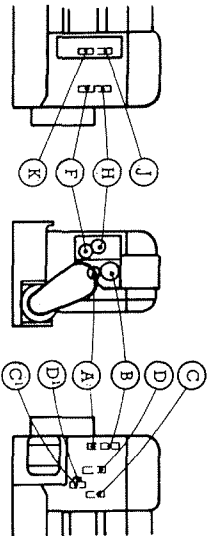
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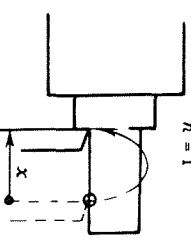
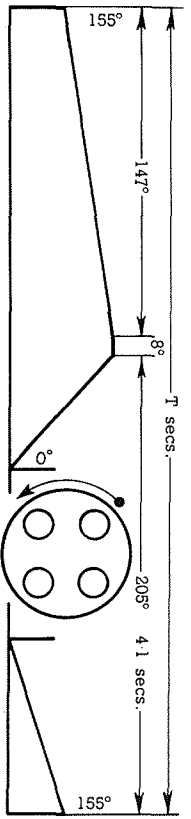
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# Wickman 3 1/2" 4



A	CCI																						DDI																						L				
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B	CCI																						DDI																						L				
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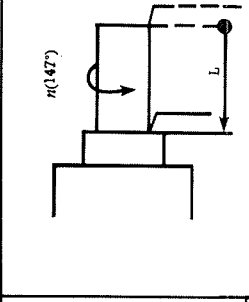
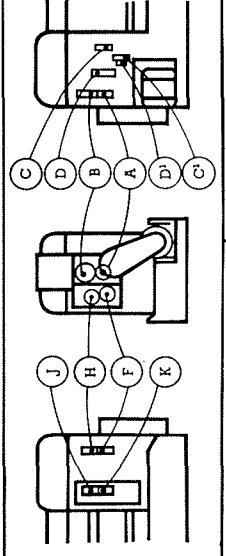


572Y102B

(0-001 INS.)

(0-01 MM.)

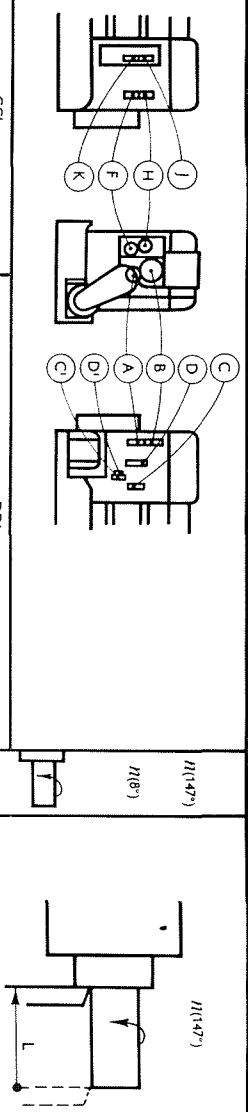
# Wickman 4 1/8-4



A	CC'										DD'										EE'										FF'										GG'										HH'										II'										JJ'										KK'																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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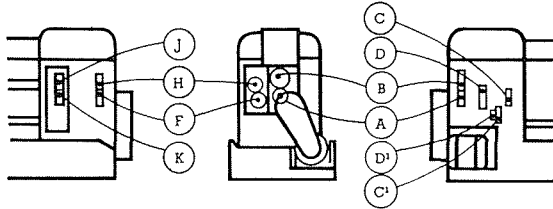


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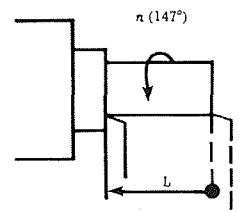
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n (147°)

n (8°)

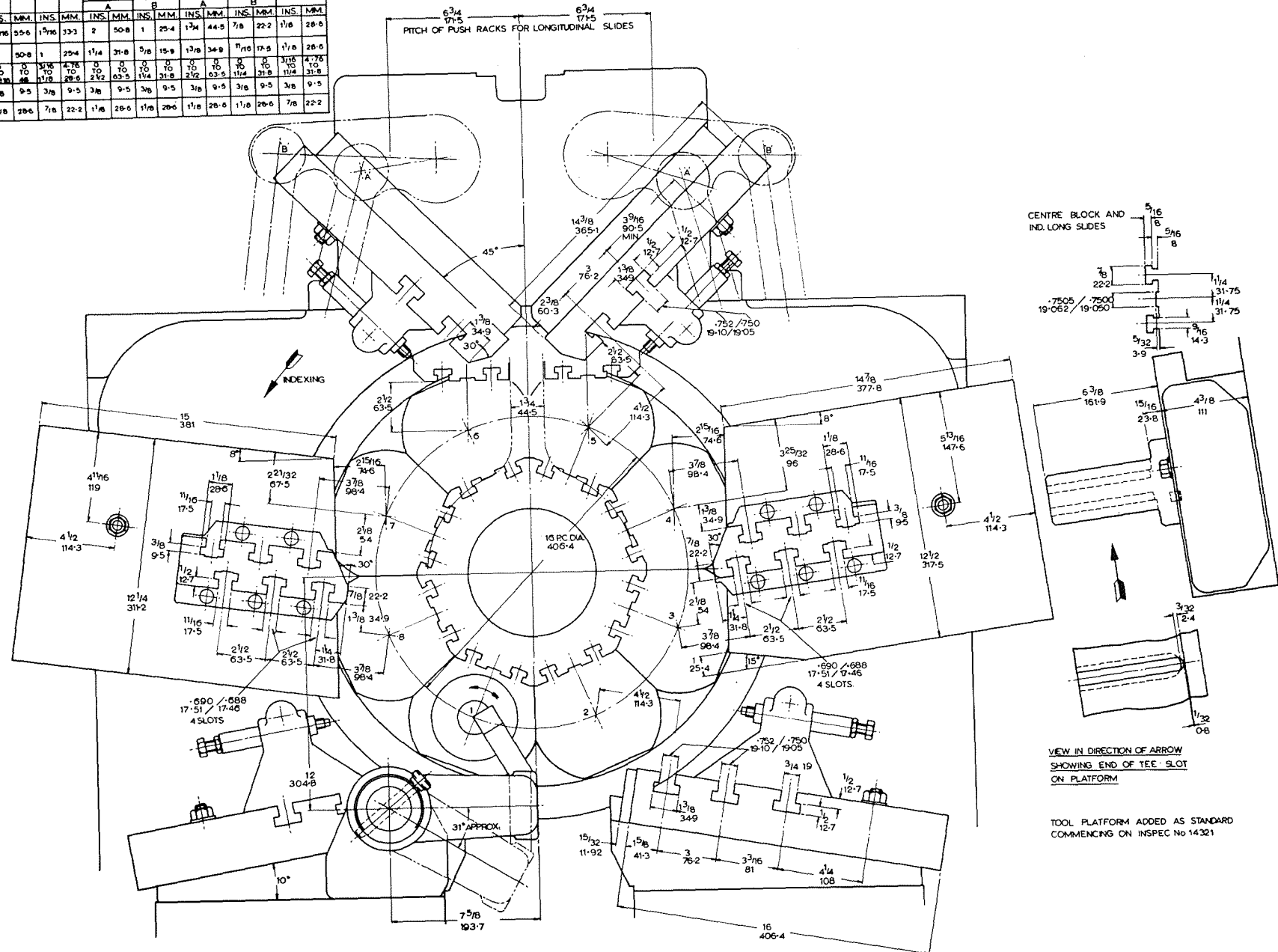


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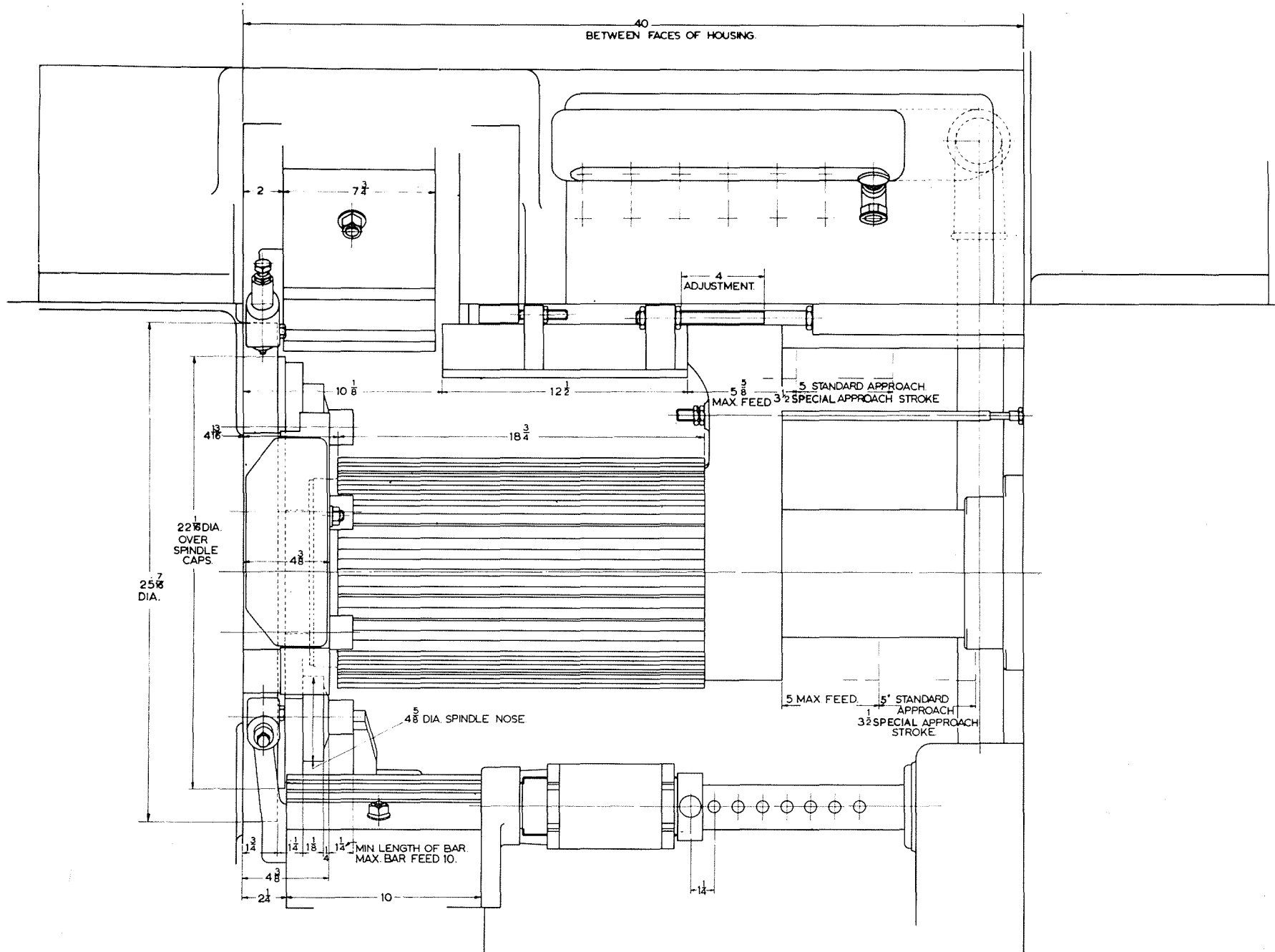


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	LEVER		POSITION		A		B		A		B					
	INS.	MM.	INS.	MM.	INS.	MM.	INS.	MM.	INS.	MM.	INS.	MM.	INS.	MM.		
APPROACH STROKE AT MIN. FEED	1 5/8	41.3	2 7/8	55.6	1 9/16	33.3	2	50.8	1	25.4	1 3/4	44.5	7/8	22.2	1 1/8	28.0
APPROACH STROKE AT MAX. FEED	2	50.8	2	50.8	1	25.4	1 1/4	31.8	5/8	15.9	1 3/8	34.9	1 1/8	28.0	1 1/8	28.0
FEED STROKE	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
ADJUSTMENT FORWARD	3/8	9.5	3/8	9.5	3/8	9.5	3/8	9.5	3/8	9.5	3/8	9.5	3/8	9.5	3/8	9.5
ADJUSTMENT BACKWARDS	1/8	28.0	1/8	28.0	7/8	22.2	1 1/8	28.0	1 1/8	28.0	1 1/8	28.0	7/8	22.2	1 1/8	28.0



Capacity Chart for 1 3/4" - 8 Bar Spindle Automatic

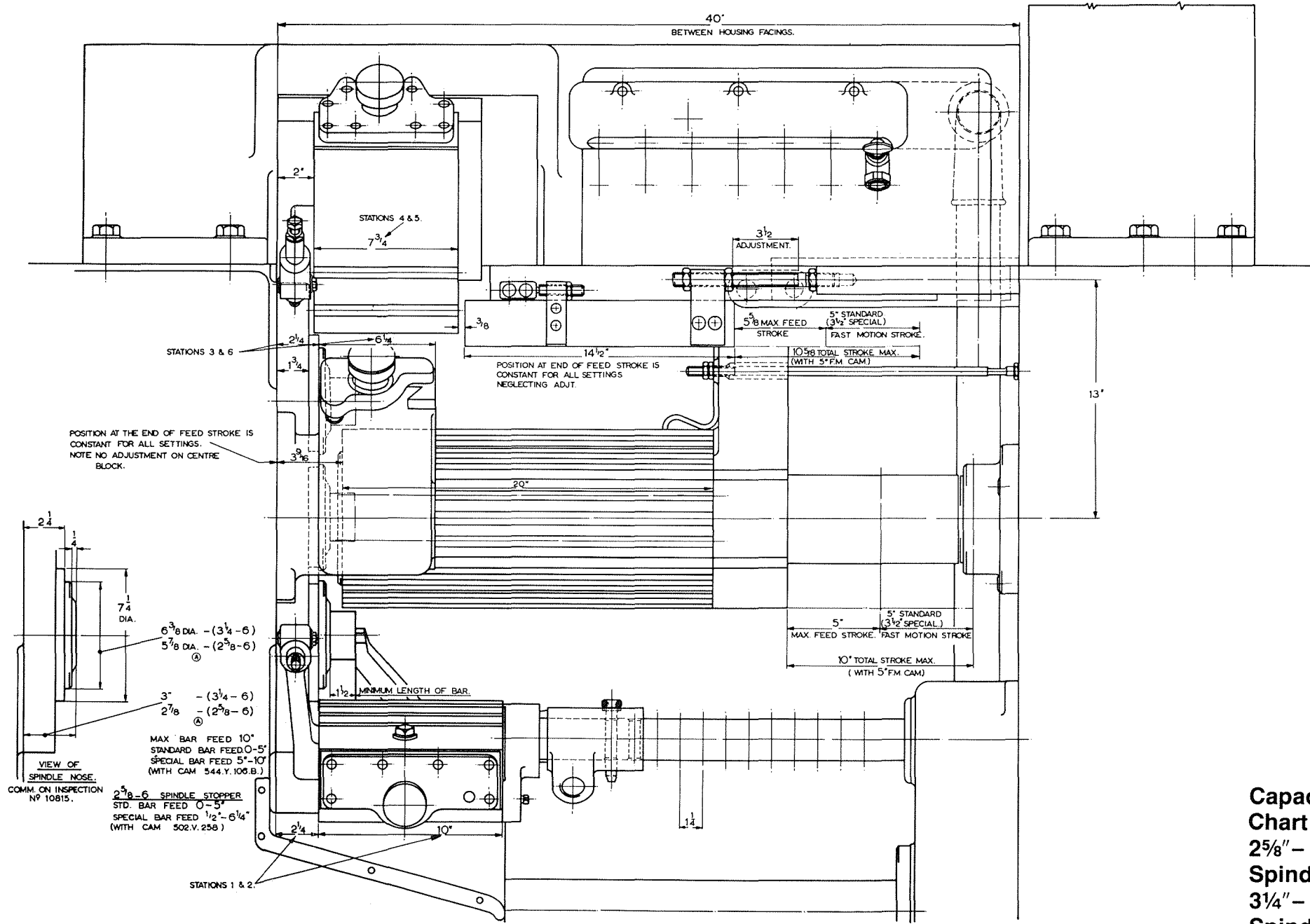
5.10.



Capacity  
Chart for  
1 3/4" - 8 Spindle  
Automatic

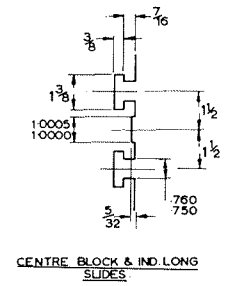
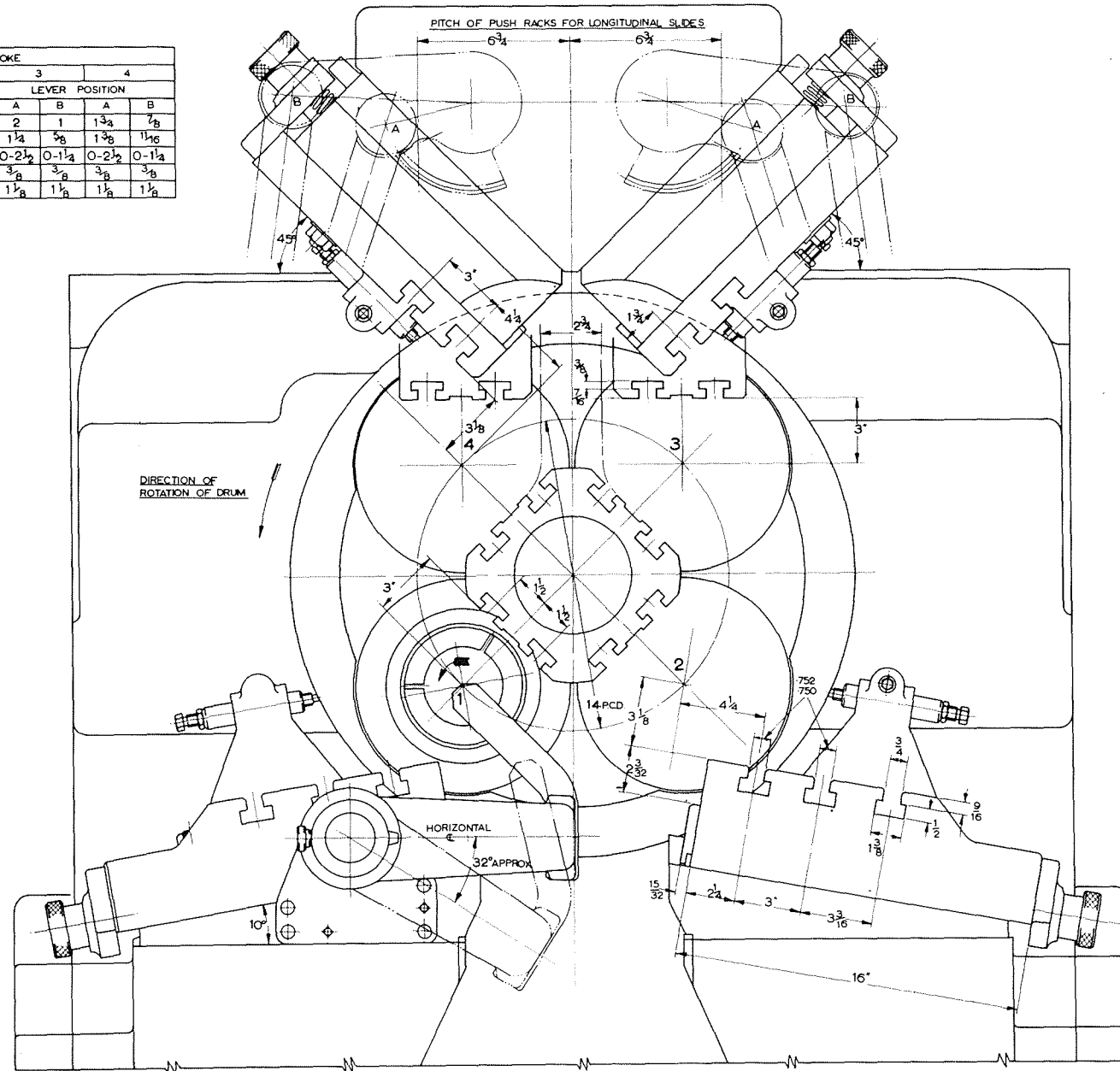
5.11.1.





**Capacity Chart for 2 5/8" - 6 Bar Spindle and 3 1/4" - 6 Bar Spindle Automatic**

STATION →	CROSS SLIDE STROKE					
	1	2	3		4	
			LEVER POSITION			
			A	B	A	B
APPROACH STROKE AT MIN FEED	$1\frac{5}{8}$	$2\frac{3}{16}$	2	1	$1\frac{3}{4}$	$\frac{7}{8}$
APPROACH STROKE AT MAX FEED	2	2	$1\frac{1}{4}$	$\frac{5}{8}$	$1\frac{3}{8}$	$1\frac{1}{16}$
FEED STROKE	$0-1\frac{1}{4}$	$0-1\frac{1}{16}$	$0-2\frac{1}{2}$	$0-1\frac{1}{4}$	$0-2\frac{1}{2}$	$0-1\frac{1}{4}$
ADJUSTMENT FORWARD	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$
ADJUSTMENT BACKWARD	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$

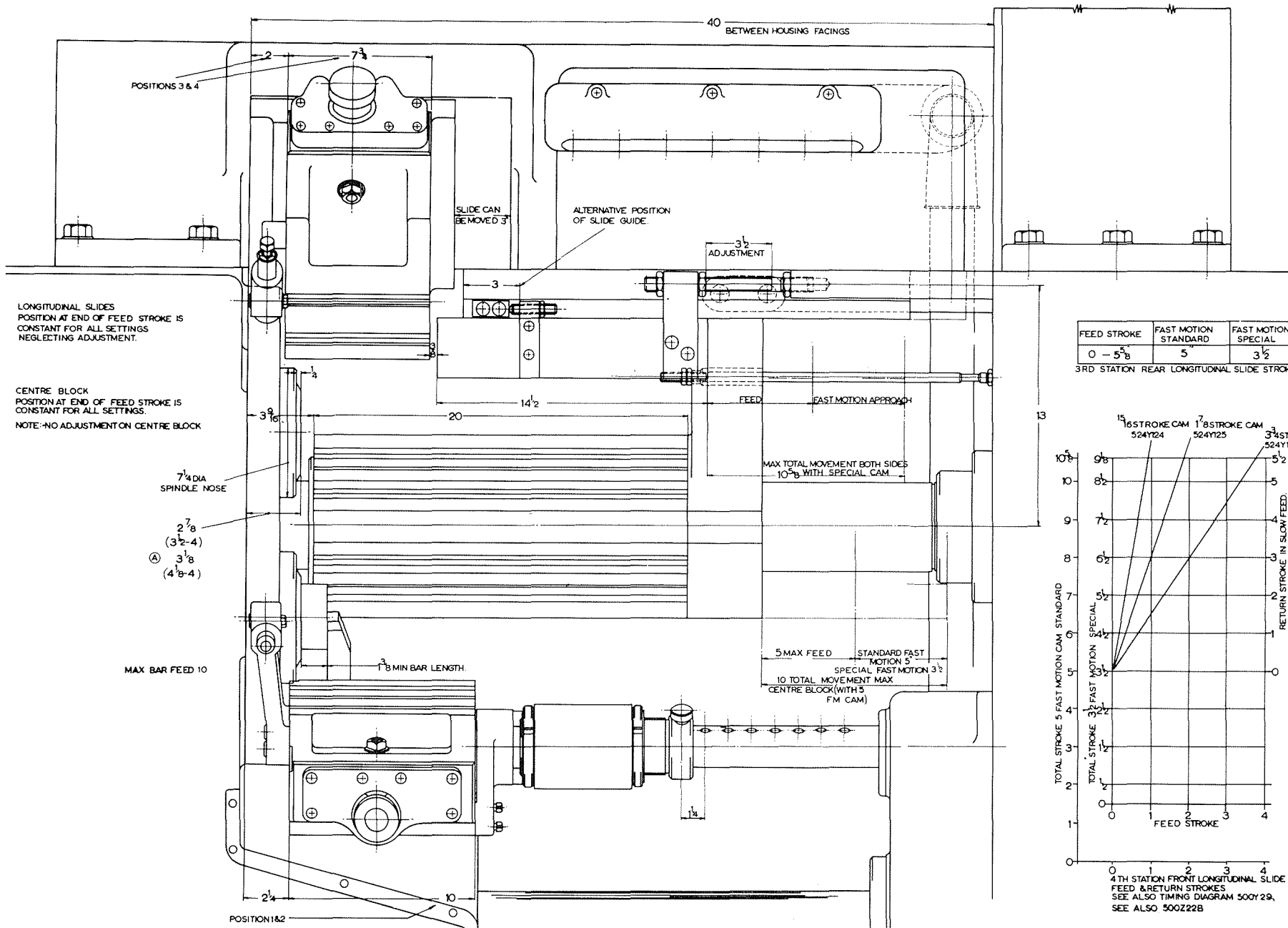


CENTRE BLOCK & IND LONG SLIDES

SEE ALSO 500Z23B

Capacity Chart for 3 1/2" - 4 Bar Spindle and 4 1/8" - 4 Bar Spindle Automatic

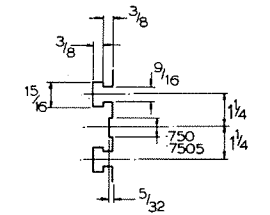
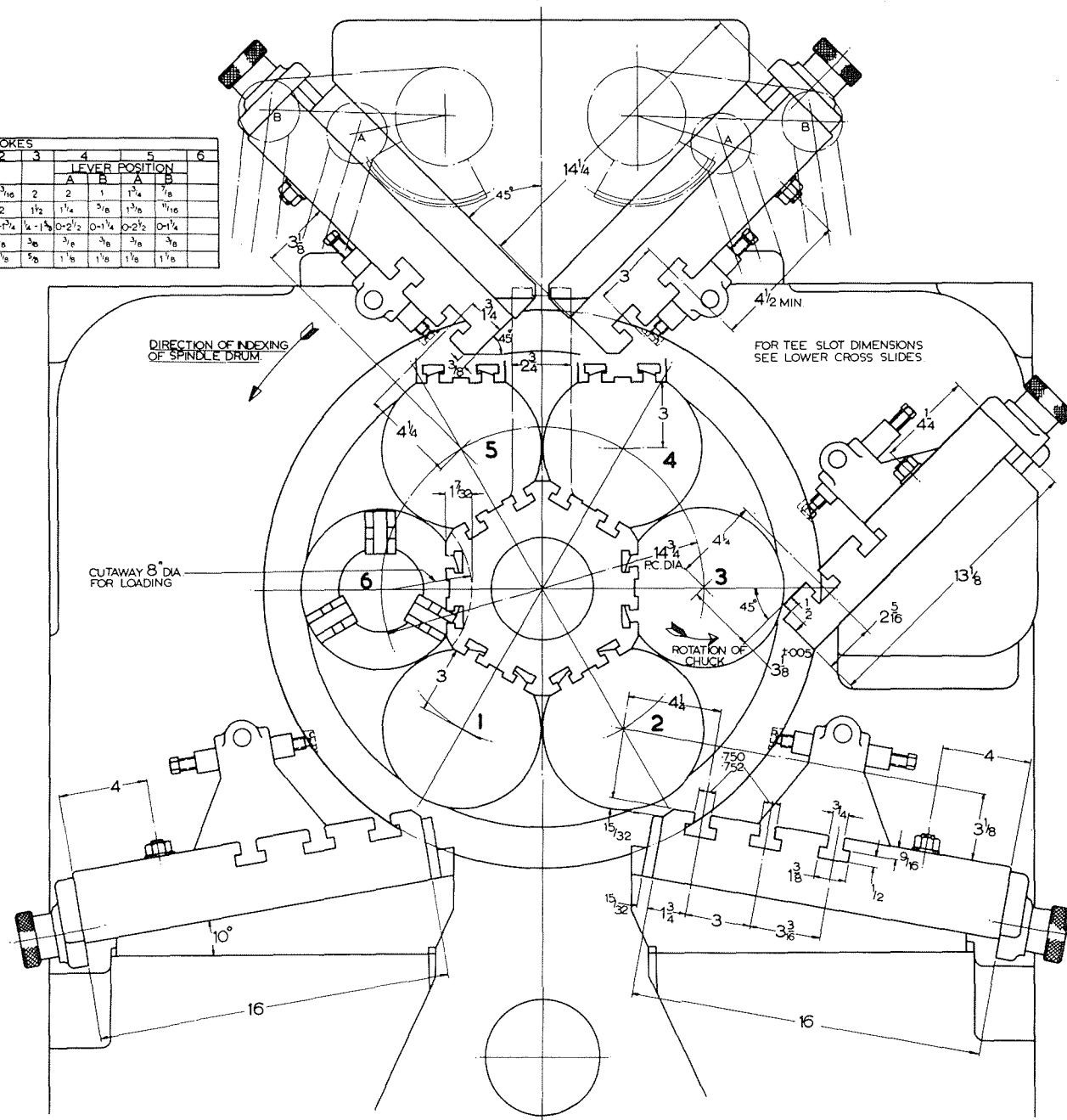
5.14.



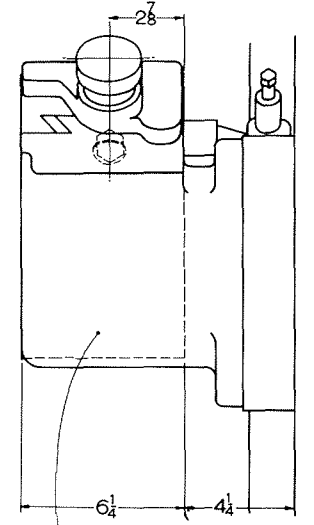
Capacity Chart for 3 1/2" - 4 Bar Spindle and 4 1/8" - 4 Bar Spindle Automatic

5.15.1.

CROSS SLIDE STROKES						
STATION	LEVER POSITION					
	1	2	3	4	5	6
APPROACH STROKE AT MIN FEED	1 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>16</sub>	2	2	1	1 <sup>1</sup> / <sub>4</sub>
APPROACH STROKE AT MAX FEED	2	2	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>16</sub>
FEED STROKE	0-1 <sup>1</sup> / <sub>4</sub>	0-1 <sup>1</sup> / <sub>4</sub>	1/4-1 <sup>1</sup> / <sub>2</sub>	0-1 <sup>1</sup> / <sub>4</sub>	0-2 <sup>1</sup> / <sub>2</sub>	0-1 <sup>1</sup> / <sub>4</sub>
ADJUSTMENT FORWARDS	2 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>16</sub>
ADJUSTMENT BACKWARDS	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>



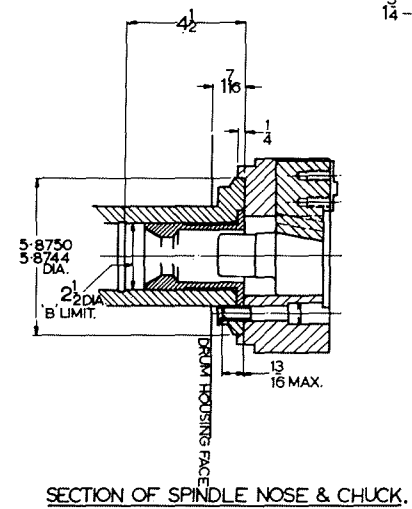
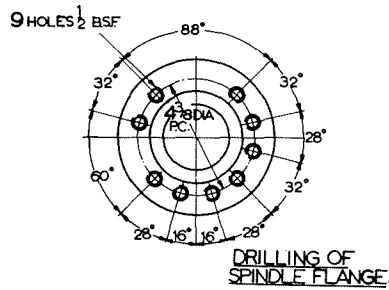
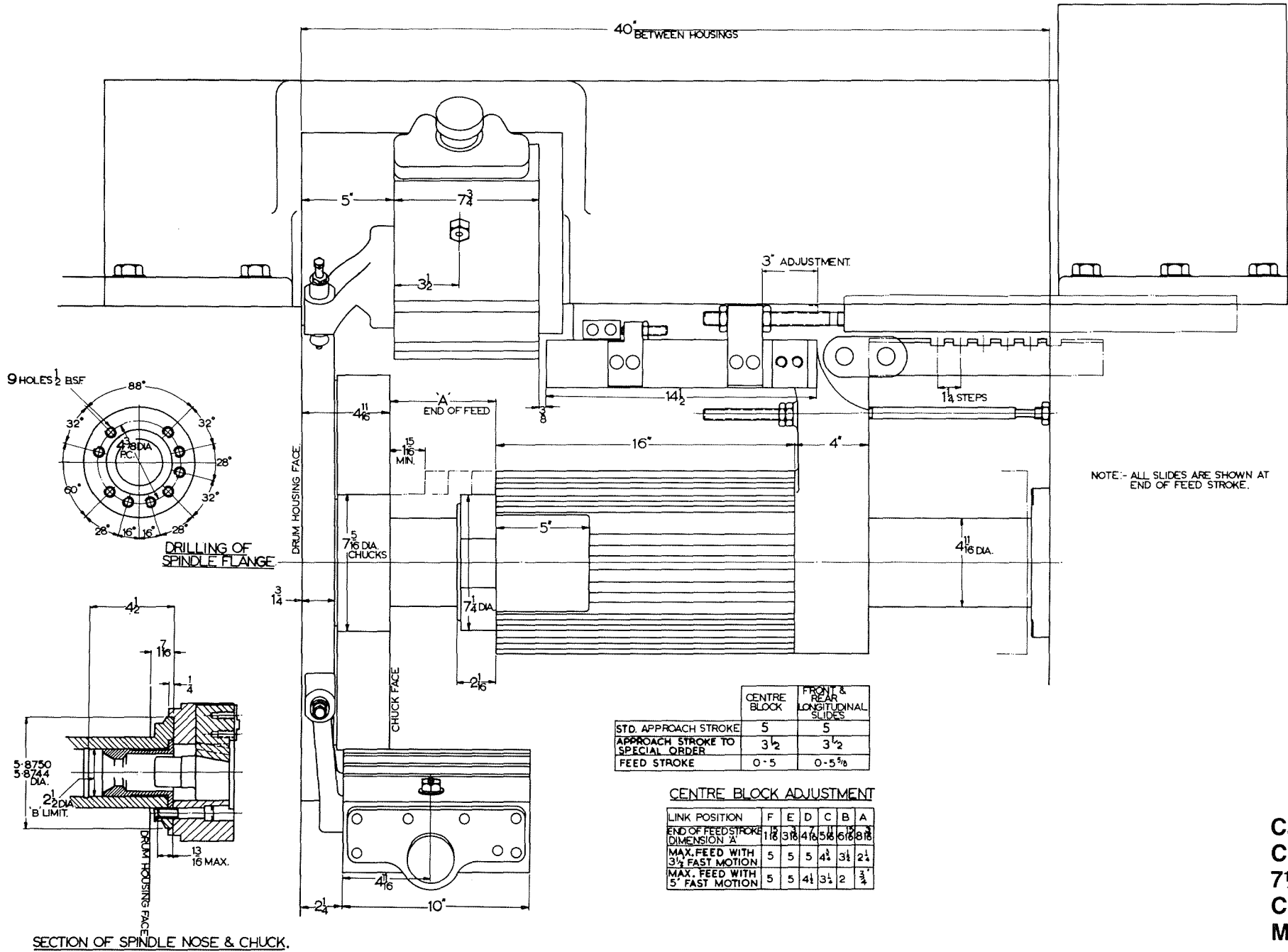
CENTRE BLOCK & IND. LONG SLIDES



3RD STATION CROSS SLIDE, SEC 539B. OPTIONAL EXTRA. ①

Capacity  
Diagram  
7<sup>1</sup>/<sub>4</sub>" - 6  
Chucker  
**5.16.**





	CENTRE BLOCK	FRONT & REAR LONGITUDINAL SLIDES
STD. APPROACH STROKE	5	5
APPROACH STROKE TO SPECIAL ORDER	3 1/2	3 1/2
FEED STROKE	0.5	0.5 5/8

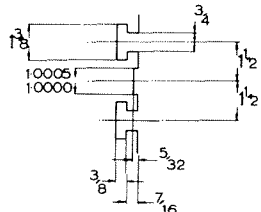
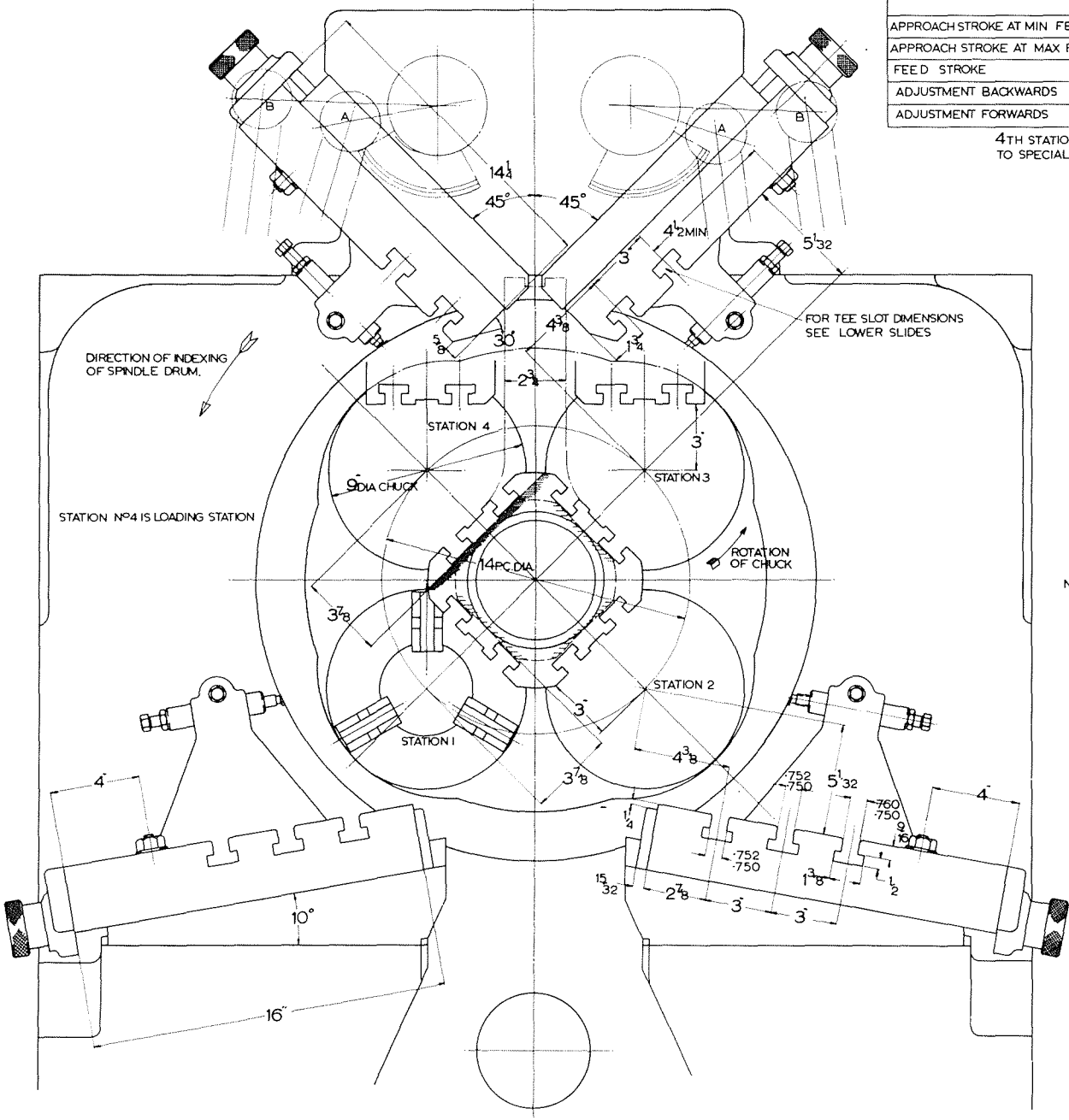
CENTRE BLOCK ADJUSTMENT						
LINK POSITION	F	E	D	C	B	A
END OF FEED STROKE DIMENSION 'A'	1 1/8	3 1/8	4 1/8	5 1/8	6 1/8	8 1/8
MAX. FEED WITH 3 1/2\"/>						

NOTE:- ALL SLIDES ARE SHOWN AT END OF FEED STROKE.

**Capacity Chart**  
**7 1/4" - 6 Chucker**  
**Commencing**  
**M/C No. 95013**

CROSS SLIDE STROKES.				
STATION	1	2	3	
			A	B
APPROACH STROKE AT MIN. FEED.	$1\frac{5}{8}$	$2\frac{3}{16}$	2	1
APPROACH STROKE AT MAX FEED.	2	2	$1\frac{1}{4}$	$\frac{5}{8}$
FEED STROKE	$0 - 1\frac{3}{4}$	$0 - 1\frac{3}{4}$	$0 - 2\frac{1}{2}$	$0 - 1\frac{1}{4}$
ADJUSTMENT BACKWARDS	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$	$1\frac{1}{8}$
ADJUSTMENT FORWARDS	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$	$\frac{3}{8}$

4TH STATION CROSS SLIDE  
TO SPECIAL ORDER ONLY.

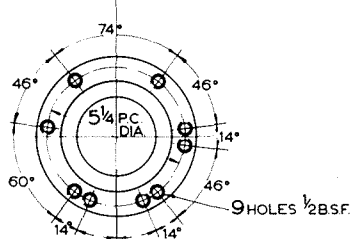
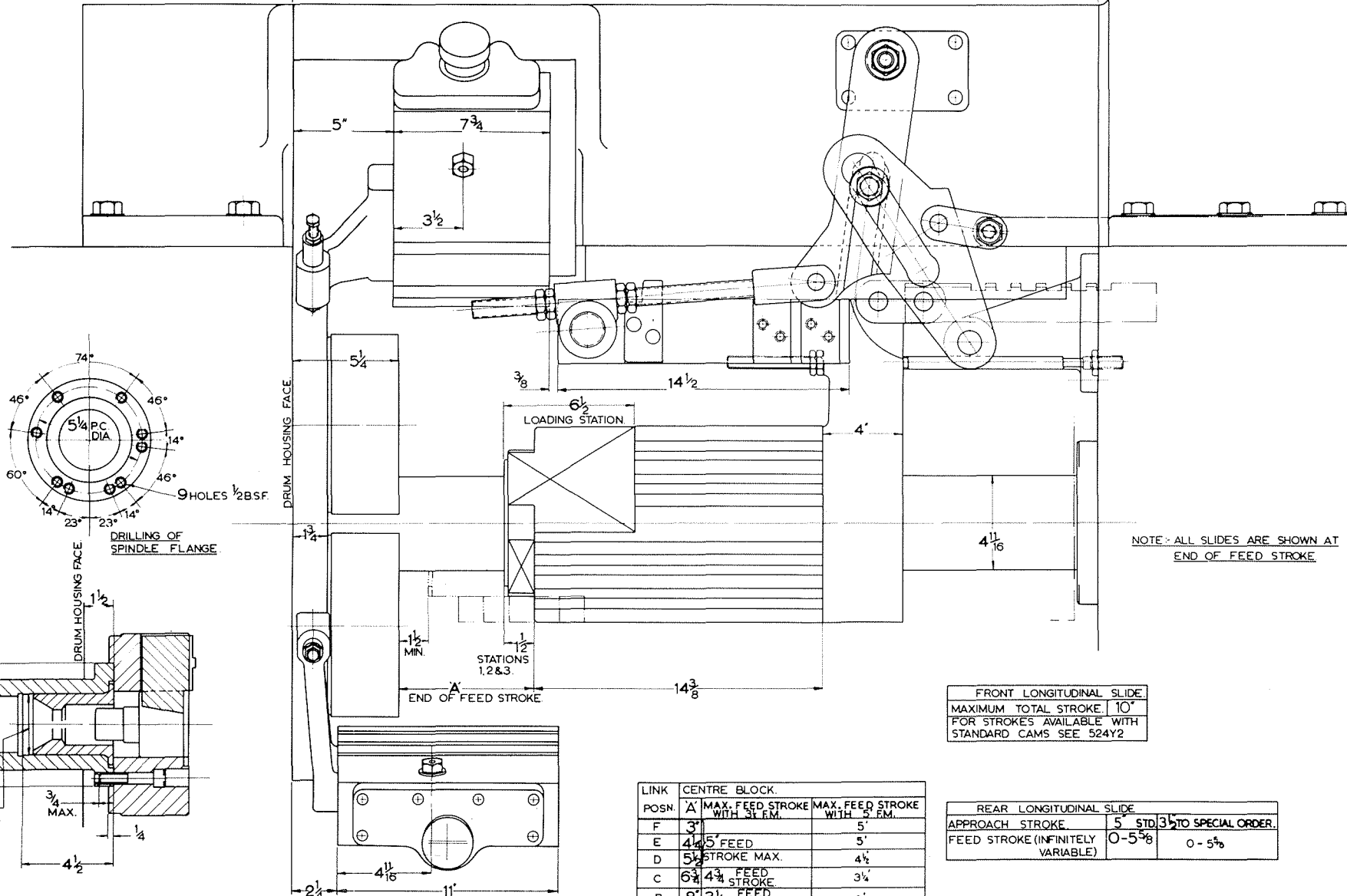


CENTRE BLOCK & IND. LONG SLIDES

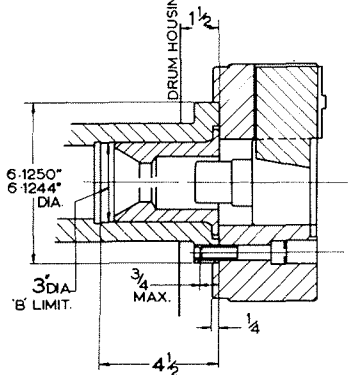
NOTE: ALL SLIDES ARE SHOWN AT  
END OF FEED STROKE.

Capacity  
Chart for  
9" - 4 Spindle  
Chucker  
  
**5.18.**

40" BETWEEN HOUSING FACES



DRILLING OF SPINDLE FLANGE



SECTION OF SPINDLE NOSE AND CHUCK

NOTE: ALL SLIDES ARE SHOWN AT END OF FEED STROKE

FRONT LONGITUDINAL SLIDE  
 MAXIMUM TOTAL STROKE 10"  
 FOR STROKES AVAILABLE WITH  
 STANDARD CAMS SEE 524Y2

LINK	CENTRE BLOCK	
POSN.	A' MAX. FEED STROKE WITH 5L.F.M.	MAX. FEED STROKE WITH 5.F.M.
F	3"	5"
E	4 1/2" 5" FEED	5"
D	5 1/2" STROKE MAX.	4 1/2"
C	6 3/4" 4 1/2" FEED STROKE	3 1/4"
B	8" 3 1/2" FEED	2"
A	9 1/4" 2 1/4" FEED STROKE	3/4"

REAR LONGITUDINAL SLIDE		
APPROACH STROKE	5 STD.	3 1/2 TO SPECIAL ORDER.
FEED STROKE (INFINITELY VARIABLE)	0 - 5 5/8	0 - 5 5/8

Capacity Chart for 9" - 4 Spindle Chucker

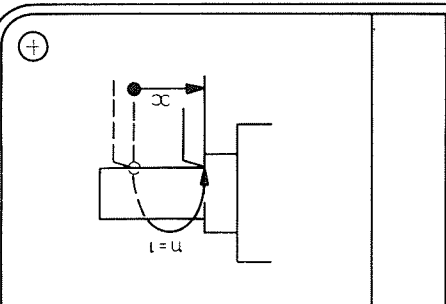
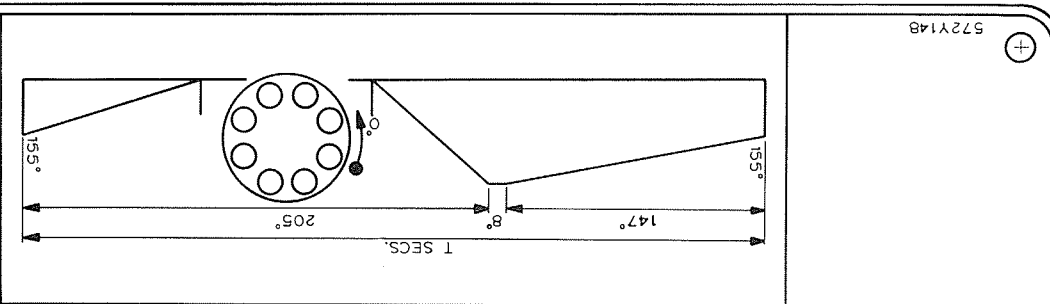
5.19.1.

# Wickman 6-8

Standard  
Speed  
& Feed  
Chart  
1450  
r.p.m.  
Motor

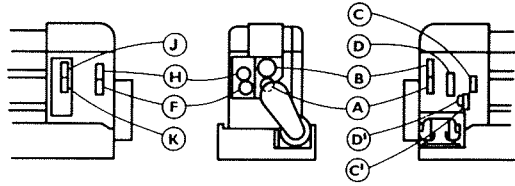
5.20.

572Y148



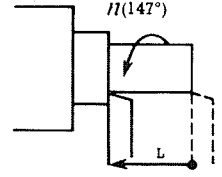
F	H	J	K	T SECS.																																			
24	47	27	44	56	64	70	80	88	101	112	129	110	127	140	159	175	201	220	250	277	321	352	411	488	550	1011	55	1011	55	0.3	0.5	0.7	1.0	2.0	3.0	4.0	5.0	12	
19	52	34	37	53	60	66	72	75	82	95	104	121	103	119	142	165	201	222	256	285	312	365	434	490	515	944	51	944	51	0.3	0.6	0.8	1.1	2.1	3.2	4.4	5.5	14	
24	47	29	42	57	63	72	79	90	100	115	124	142	113	124	142	165	179	199	222	246	285	312	365	434	490	515	944	51	944	51	0.3	0.6	0.8	1.1	2.1	3.2	4.4	5.5	14
19	52	37	34	45	51	56	64	70	80	88	102	87	100	110	126	138	158	173	197	218	254	277	325	385	434	797	43	797	43	0.3	0.6	0.9	1.3	2.5	3.5	4.5	6.3	16	
24	47	32	39	42	48	53	61	66	77	84	97	83	96	105	120	131	151	165	187	208	240	263	309	366	413	756	41	756	41	0.3	0.7	1.0	1.3	2.6	4.0	5.5	6.7	17	
27	44	29	42	48	50	56	66	76	83	95	104	118	130	150	163	183	205	238	263	285	320	357	429	478	748	41	748	41	0.3	0.7	1.0	1.3	2.6	4.0	5.5	6.7	17		
19	52	39	32	40	46	50	57	63	72	79	92	78	90	99	113	124	142	155	176	195	226	248	290	349	388	712	39	712	39	0.4	0.7	1.1	1.4	2.8	4.2	5.6	7.0	18	
24	47	34	37	39	44	48	54	60	69	75	87	74	86	94	107	117	135	147	167	185	215	235	276	331	369	675	37	675	37	0.4	0.7	1.1	1.5	3.0	4.5	6.0	7.4	19	
19	52	42	29	36	41	45	51	56	64	70	81	69	80	88	100	110	126	137	156	173	200	220	257	309	344	629	31	629	31	0.4	0.8	1.1	1.4	2.8	4.2	5.6	7.0	20	
24	47	37	34	33	38	41	47	51	58	64	74	63	73	80	91	100	114	125	142	157	179	197	230	276	300	570	31	570	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	42	29	35	39	43	49	53	61	67	78	66	76	84	95	104	120	131	148	165	190	209	245	294	327	599	33	599	33	0.4	0.8	1.1	1.4	2.8	4.2	5.6	7.0	22	
24	47	37	34	33	38	41	47	51	58	64	74	63	73	80	91	100	114	125	142	157	179	197	230	276	300	570	31	570	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	44	27	31	35	38	44	48	55	60	69	59	68	75	85	93	103	112	128	141	163	179	205	250	291	532	29	532	29	0.5	0.9	1.4	1.9	3.8	5.5	7.2	8.9	25	
29	42	32	39	33	37	40	46	50	57	63	73	62	72	79	89	98	113	123	139	154	179	196	229	275	306	559	30	559	30	0.4	0.9	1.3	1.8	3.6	5.2	6.9	8.4	24	
19	52	44	27	31	35	38	44	48	55	60	69	59	68	75	85	93	103	112	128	141	163	179	205	250	291	532	29	532	29	0.5	0.9	1.4	1.9	3.8	5.5	7.2	8.9	25	
29	42	34	37	29	33	36	41	45	52	57	65	55	64	70	80	88	100	110	124	138	160	175	205	245	273	499	27	499	27	0.5	1.0	1.5	2.0	4.0	6.0	8.0	10		
24	47	34	37	34	38	41	47	51	58	64	74	63	73	80	91	100	114	125	142	157	179	197	230	276	300	570	31	570	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53	61	67	76	83	96	104	118	131	152	166	194	224	260	474	26	474	26	0.5	1.1	1.6	2.2	4.2	6.2	8.4	11		
27	44	27	44	46	50	58	60	69	75	83	96	80	88	100	110	124	138	152	166	180	204	224	260	310	344	629	31	629	31	0.4	0.9	1.3	1.8	3.5	5.0	6.5	7.8	22	
19	52	47	24	28	32	34	39	43	50	54	62	53																											

# Wickman 6"-8"



$n(147^\circ)$

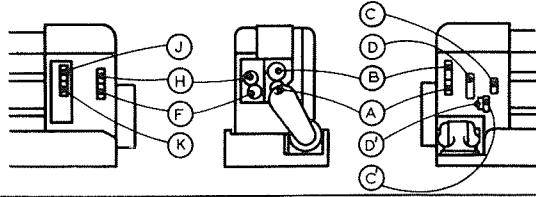
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CC' DD'

A	55	52	50	47	45	42	40	37	35	32	30	27	55	52	50	47	45	42	40	37	35	32	30	27	24	22														
B	32	35	37	40	42	45	47	50	52	55	57	60	32	35	37	40	42	45	47	50	52	55	57	60	63	65														
N/MIN.	1260	1090	1000	870	793	691	630	548	498	432	390	333	394	341	310	271	246	214	195	170	155	134	120	104	87	77														
44	27	47	24	9-5	10-4	10-9	11-9	12-6	13-8	14-7	16-2	17-3	19-4	21	24	21	23	25	28	30	34	37	42	46	52	57	66	77	87	99	5-4	2-5	5-0	7-6	10	20	30	40	50	126
42	29	47	24	10-1	11-1	11-7	12-8	13-6	14-9	15-9	17-7	18-9	21	23	26	23	26	28	31	34	38	41	47	51	59	64	74	87	97	112	6-1	2-2	4-5	6-7	9-0	18	27	36	45	112
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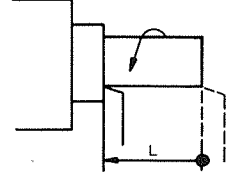
# Wickman 6-8 D



$n(147^\circ)$

$n(8^\circ)$

$n(147^\circ)$



CC' DD'

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N/MIN.

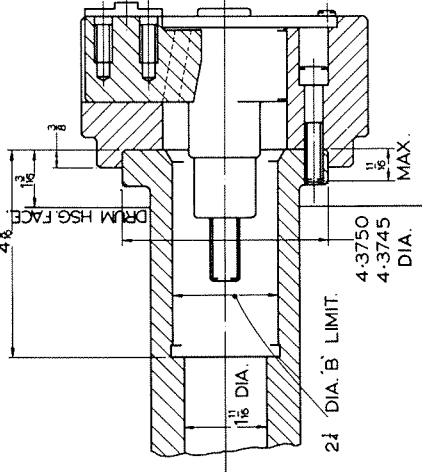
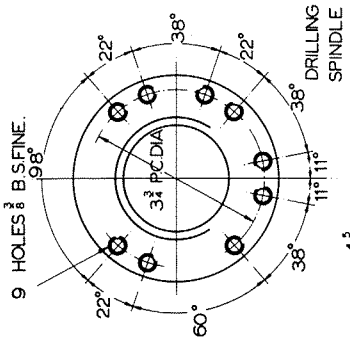
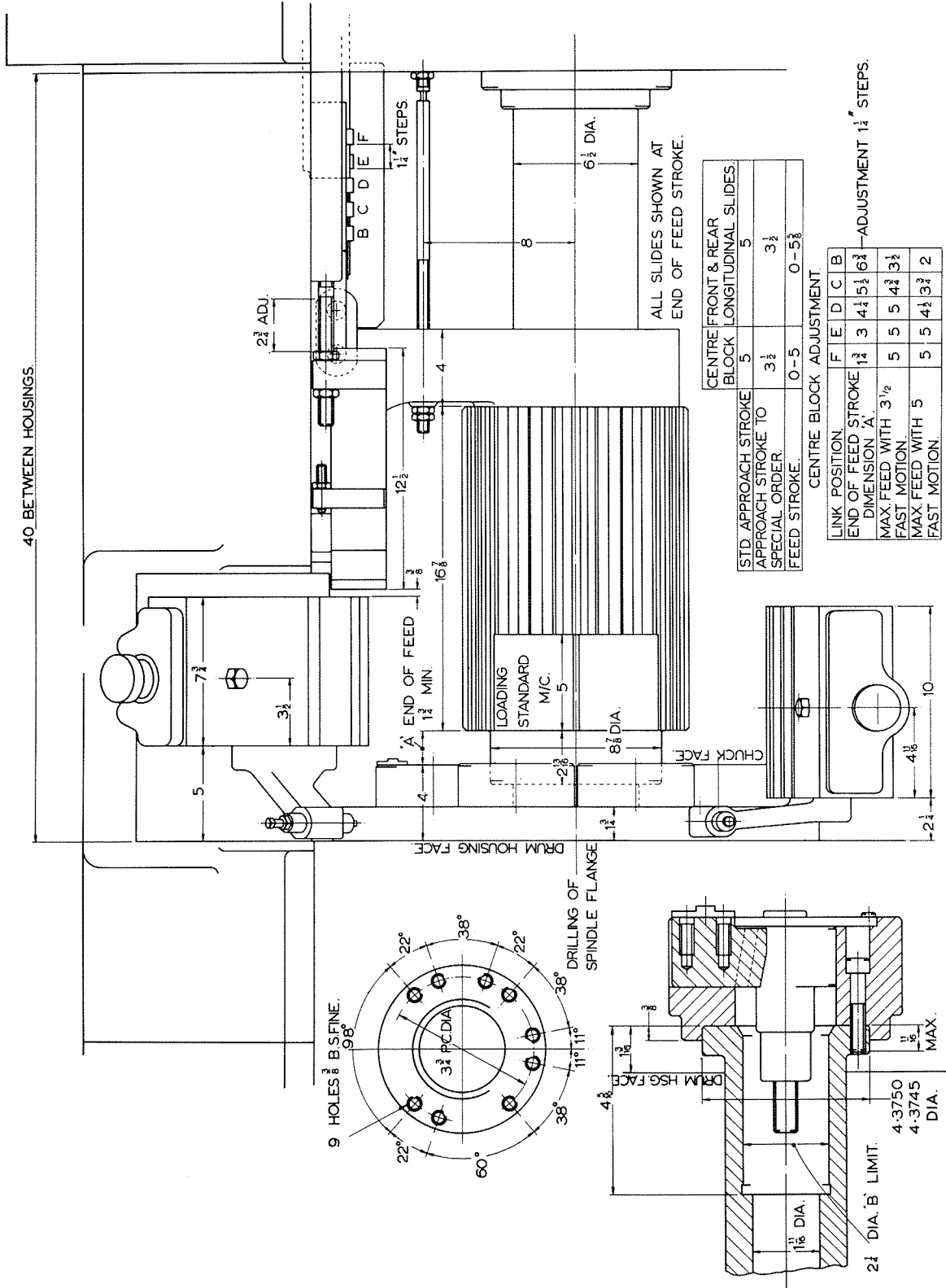
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$n(147^\circ)$

$n(8^\circ)$

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25	50	75	100	200	300	400	500	1250	INS.

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19	52	47	24	27	31	34	38	41	47	51	59	50	58	63	72	80	90	98	112	123	142	158	182	218	243	443	24	0.6	1.1	1.7	2.3	4.5	6.8	9.1	11	28
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19	52	44	27	32	36	39	45	49	55	60	71	61	68	75	85	95	107	117	135	147	170	189	218	260	291	532	29	0.5	0.9	1.4	1.9	3.8	5.7	7.5	9.4	24
29	42	32	39	34	38	41	47	50	57	63	73	62	72	79	90	98	113	123	142	155	179	199	229	272	306	559	30	0.4	0.9	1.3	1.8	3.6	5.4	7.2	9.0	22
27	44	34	37	34	39	42	47	50	58	63	74	63	72																							



STD APPROACH STROKE	5
APPROACH STROKE TO SPECIAL ORDER	3 1/2
FEED STROKE	0-5

CENTRE BLOCK ADJUSTMENT	
LINK POSITION	F E D C B
END OF FEED STROKE DIMENSION 'A'	1 1/2 3 4 1/2 5 1/2 6 1/2
MAX FEED WITH 3 1/2 FAST MOTION	5 5 5 4 1/2 3 1/2
MAX FEED WITH 5 FAST MOTION	5 5 4 1/2 3 1/2 2

**Capacity Chart**  
6" - 8" **5.23.**

SECTION OF SPINDLE NOSE AND CHUCK. SEE 500Y246 FOR CHUCK DRG.

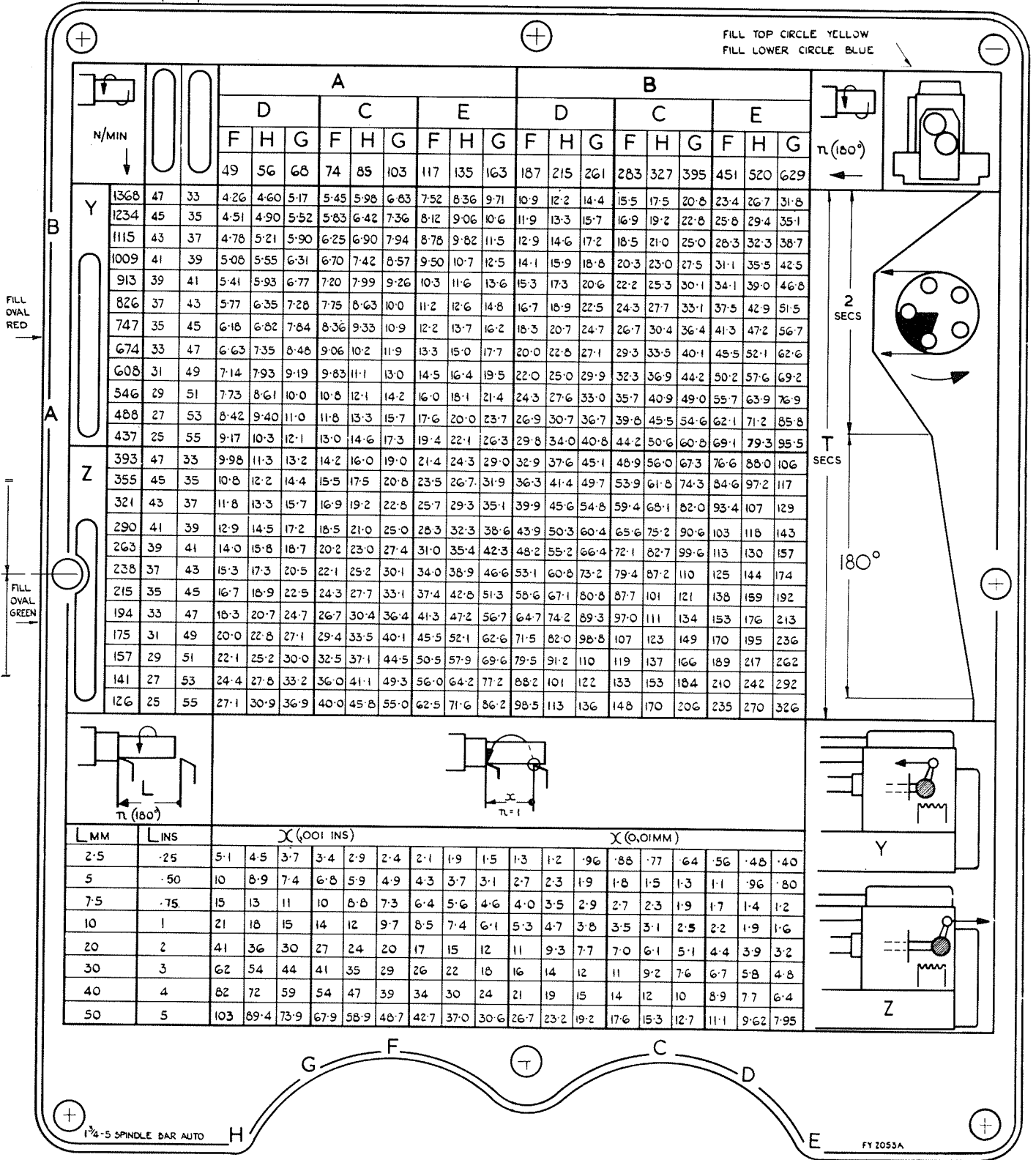
SEE ALSO 500Z19.



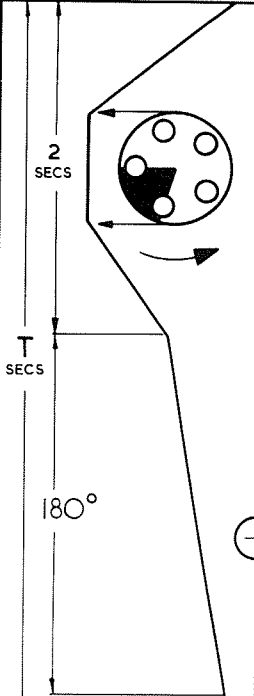


FILL OVAL BLUE FILL OVAL YELLOW

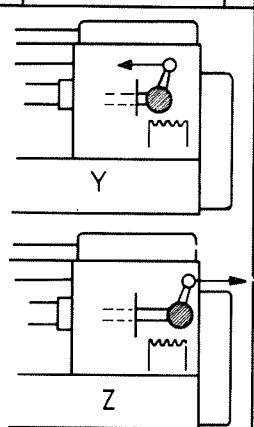
FILL TOP CIRCLE YELLOW  
FILL LOWER CIRCLE BLUE



	A												B																				
	D				C				E				D				C				E												
	F	H	G		F	H	G		F	H	G		F	H	G		F	H	G		F	H	G										
N/MIN	49	56	68	74	85	103	117	135	163	187	215	261	283	327	395	451	520	629															
Y	1368	47	33	4.26	4.60	5.17	5.45	5.98	6.83	7.52	8.36	9.71	10.9	12.2	14.4	15.5	17.5	20.8	23.4	26.7	31.8												
	1234	45	35	4.51	4.90	5.52	5.83	6.42	7.36	8.12	9.06	10.6	11.9	13.3	15.7	16.9	19.2	22.8	25.8	29.4	35.1												
	1115	43	37	4.78	5.21	5.90	6.25	6.90	7.94	8.78	9.82	11.5	12.9	14.6	17.2	18.5	21.0	25.0	28.3	32.3	38.7												
	1009	41	39	5.08	5.55	6.31	6.70	7.42	8.57	9.50	10.7	12.5	14.1	15.9	18.8	20.3	23.0	27.5	31.1	35.5	42.5												
	913	39	41	5.41	5.93	6.77	7.20	7.99	9.26	10.3	11.6	13.6	15.3	17.3	20.6	22.2	25.3	30.1	34.1	39.0	46.8												
	826	37	43	5.77	6.35	7.28	7.75	8.63	10.0	11.2	12.6	14.8	16.7	18.9	22.5	24.3	27.7	33.1	37.5	42.9	51.5												
	747	35	45	6.18	6.82	7.84	8.36	9.33	10.9	12.2	13.7	16.2	18.3	20.7	24.7	26.7	30.4	36.4	41.3	47.2	56.7												
	674	33	47	6.63	7.35	8.48	9.06	10.2	11.9	13.3	15.0	17.7	20.0	22.8	27.1	29.3	33.5	40.1	45.5	52.1	62.6												
	608	31	49	7.14	7.93	9.19	9.83	11.1	13.0	14.5	16.4	19.5	22.0	25.0	29.9	32.3	36.9	44.2	50.2	57.6	69.2												
	546	29	51	7.73	8.61	10.0	10.8	12.1	14.2	16.0	18.1	21.4	24.3	27.6	33.0	35.7	40.9	49.0	55.7	63.9	76.9												
	488	27	53	8.42	9.40	11.0	11.8	13.3	15.7	17.6	20.0	23.7	26.9	30.7	36.7	39.8	45.5	54.6	62.1	71.2	85.8												
	437	25	55	9.17	10.3	12.1	13.0	14.6	17.3	19.4	22.1	26.3	29.8	34.0	40.8	44.2	50.6	60.8	69.1	79.3	95.5												
Z	393	47	33	9.98	11.3	13.2	14.2	16.0	19.0	21.4	24.3	29.0	32.9	37.6	45.1	48.9	56.0	67.3	76.6	88.0	106												
	355	45	35	10.8	12.2	14.4	15.5	17.5	20.8	23.5	26.7	31.9	36.3	41.4	49.7	53.9	61.8	74.3	84.6	97.2	117												
	321	43	37	11.8	13.3	15.7	16.9	19.2	22.8	25.7	29.3	35.1	39.9	45.6	54.8	59.4	68.1	82.0	93.4	107	129												
	290	41	39	12.9	14.5	17.2	18.5	21.0	25.0	28.3	32.3	38.6	43.9	50.3	60.4	65.6	75.2	90.6	103	118	143												
	263	39	41	14.0	15.8	18.7	20.2	23.0	27.4	31.0	35.4	42.3	48.2	55.2	66.4	72.1	82.7	99.6	113	130	157												
	238	37	43	15.3	17.3	20.5	22.1	25.2	30.1	34.0	38.9	46.6	53.1	60.8	73.2	79.4	92.1	110	125	144	174												
	215	35	45	16.7	18.9	22.5	24.3	27.7	33.1	37.4	42.8	51.3	58.6	67.1	80.8	87.7	101	121	138	159	192												
	194	33	47	18.3	20.7	24.7	26.7	30.4	36.4	41.3	47.2	56.7	64.7	74.2	89.3	97.0	111	134	153	176	213												
	175	31	49	20.0	22.8	27.1	29.4	33.5	40.1	45.5	52.1	62.6	71.5	82.0	98.8	107	123	149	170	195	236												
	157	29	51	22.1	25.2	30.0	32.5	37.1	44.5	50.5	57.9	69.6	79.5	91.2	110	119	137	166	189	217	262												
	141	27	53	24.4	27.8	33.2	36.0	41.1	49.3	56.0	64.2	77.2	88.2	101	122	133	153	184	210	242	292												
	126	25	55	27.1	30.9	36.9	40.0	45.8	55.0	62.5	71.6	86.2	98.5	113	136	148	170	206	235	270	326												



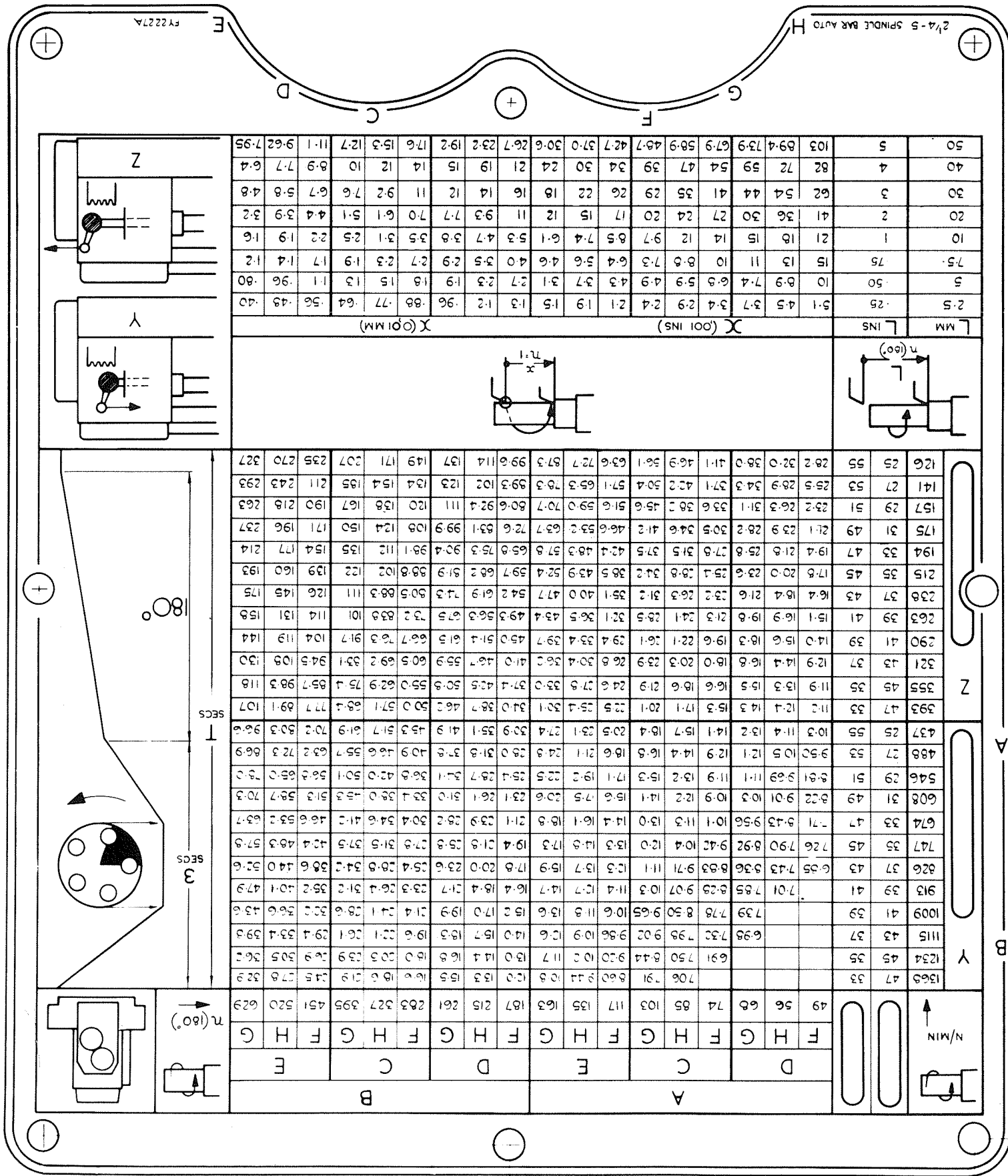
L MM	L INS	X (0.001 INS)																X (0.01MM)															
		5.1	4.5	3.7	3.4	2.9	2.4	2.1	1.9	1.5	1.3	1.2	.96	.88	.77	.64	.56	.48	.40	1.8	1.5	1.3	1.1	.96	.80								
2.5	.25	10	8.9	7.4	6.8	5.9	4.9	4.3	3.7	3.1	2.7	2.3	1.9	1.8	1.5	1.3	1.1	.96	.80	1.9	1.8	1.5	1.3	1.1	.96	.80							
5	.50	15	13	11	10	8.8	7.3	6.4	5.6	4.6	4.0	3.5	2.9	2.7	2.3	1.9	1.7	1.4	1.2	2.7	2.3	1.9	1.7	1.4	1.2								
7.5	.75	21	18	15	14	12	9.7	8.5	7.4	6.1	5.3	4.7	3.8	3.5	3.1	2.5	2.2	1.9	1.6	3.5	3.1	2.5	2.2	1.9	1.6								
10	1	27	24	20	19	17	15	12	11	9.3	8.1	7.0	6.1	5.1	4.4	3.9	3.2	4.3	3.9	3.2	4.4	3.9	3.2										
20	2	41	36	30	27	24	20	17	15	12	11	9.3	8.1	7.0	6.1	5.1	4.4	3.9	3.2	7.0	6.1	5.1	4.4	3.9	3.2								
30	3	62	54	44	41	35	29	26	22	18	16	14	12	11	9.2	7.6	6.7	5.8	4.8	10.5	9.2	7.6	6.7	5.8	4.8								
40	4	82	72	59	54	47	39	34	30	24	21	19	15	14	12	10	8.9	7.7	6.4	14.0	12	10	8.9	7.7	6.4								
50	5	103	89.4	73.9	67.9	58.9	48.7	42.7	37.0	30.6	26.7	23.2	19.2	17.6	15.3	12.7	11.1	9.62	7.95	17.5	15.3	12.7	11.1	9.62	7.95								



FILL CIRCLE IN DIAGRAM Y - RED  
FILL CIRCLE IN DIAGRAM Z - GREEN

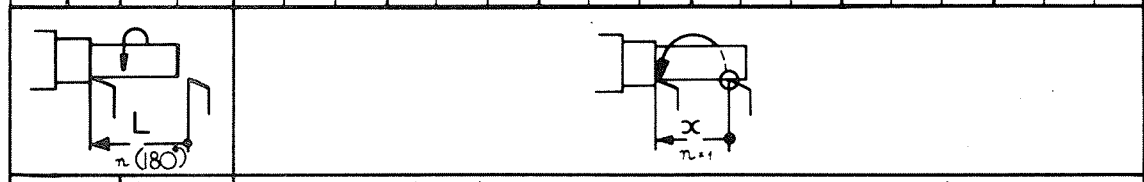
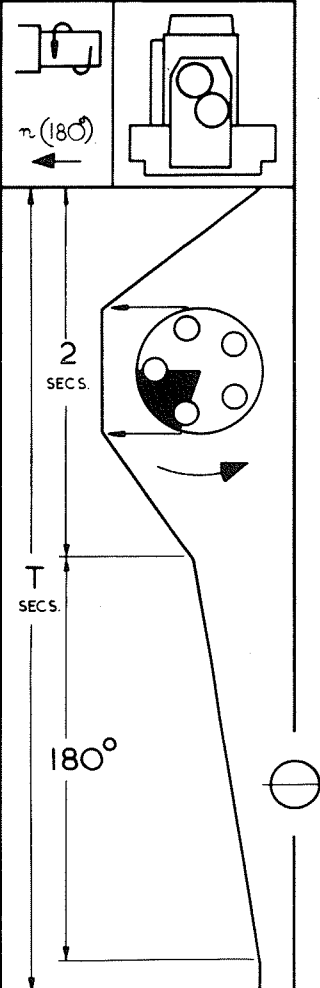
Standard Machine  
1 3/4" 5  
6.1

**Standard Machine**  
**2 1/4" - 5 Spindle**  
**6.2.**

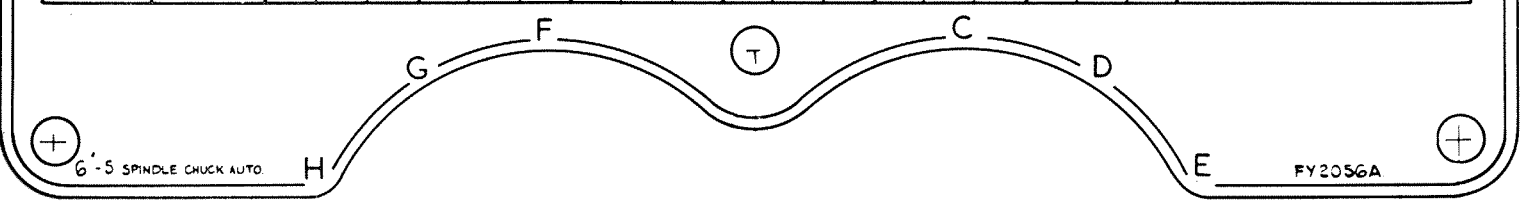
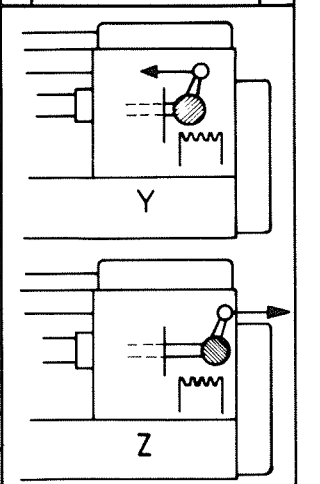




N/MIN. ↓	A												B											
	D			C			E			D			C			E								
	F	H	G	F	H	G	F	H	G	F	H	G	F	H	G	F	H	G						
	40	46	55	61	70	85	97	112	135	155	175	215	234	270	326	373	429	519						
Y	1129	47	33	426	460	517	545	598	683	752	836	971	109	122	144	155	175	208	234	267	318			
	1020	45	35	451	490	552	583	642	736	812	906	106	119	133	157	169	192	228	258	294	354			
	921	43	37	478	521	590	625	690	794	878	982	115	129	146	172	185	210	250	283	323	387			
	833	41	39	508	555	631	670	742	857	950	107	125	141	159	188	203	230	275	311	355	428			
	754	39	41	541	593	677	720	799	926	103	116	136	153	173	206	222	253	301	341	390	468			
	682	37	43	577	635	728	775	863	100	112	126	148	167	189	225	243	277	331	375	429	515			
	617	35	45	618	682	784	836	933	109	122	137	162	183	207	247	267	304	364	413	472	567			
	557	33	47	663	735	848	906	102	119	133	150	177	200	228	271	293	335	401	455	521	626			
	502	31	49	714	793	919	983	111	130	145	164	195	220	250	299	323	369	442	502	578	692			
	451	29	51	773	861	1000	1082	124	142	160	181	214	243	276	330	357	409	490	557	633	769			
	404	27	53	842	940	1100	1188	133	152	176	200	237	269	307	367	398	455	546	621	712	858			
	360	25	55	917	1033	1210	1300	146	173	194	221	263	298	340	408	442	506	608	691	793	955			
Z	325	47	33	998	1103	132	142	160	190	214	243	290	329	376	451	489	560	673	766	880	106			
	294	45	35	108	122	144	155	175	208	235	267	319	363	414	487	539	618	743	846	972	117			
	265	43	37	118	133	158	169	192	228	257	293	351	399	456	548	594	681	820	934	107	129			
	234	41	39	129	145	172	185	210	250	283	323	386	439	503	604	656	752	906	103	118	143			
	217	39	41	140	158	187	202	230	274	310	354	423	482	552	664	721	827	996	113	130	157			
	196	37	43	153	173	205	221	252	301	340	389	466	531	608	732	794	872	110	125	144	174			
	178	35	45	167	189	225	243	277	331	374	428	513	586	671	808	877	101	121	138	159	192			
	160	33	47	183	207	247	267	304	364	413	472	567	647	742	883	970	111	134	153	176	213			
	144	31	49	200	228	271	294	335	401	455	521	626	715	820	988	107	123	148	170	195	236			
	130	29	51	221	252	300	325	371	445	505	579	696	795	912	110	119	137	166	189	217	262			
	116	27	53	244	278	332	360	411	493	560	642	772	882	101	122	133	153	184	210	242	292			
	104	25	55	271	309	369	400	458	550	625	716	862	985	113	136	148	170	206	235	270	326			



LMM	LINS	X (0.01 INS)										X (0.01 MM)									
2.5	.25	6.3	5.4	4.5	4.1	3.6	2.9	2.6	2.2	1.9	1.6	1.4	1.2	1.1	.93	.77	.67	.56	.48		
5	.50	13	11	8.9	8.2	7.1	5.9	5.2	4.5	3.7	3.2	2.8	2.3	2.1	1.9	1.5	1.3	1.2	.96		
7.5	.75	19	16	13	12	11	8.8	7.8	6.7	5.6	4.8	4.2	3.5	3.2	2.8	2.3	2.0	1.7	1.4		
10	1	25	22	18	16	14	12	10	9.0	7.4	6.5	5.6	4.6	4.3	3.7	3.1	2.7	2.3	1.9		
20	2	50	43	36	33	28	24	21	17	15	13	11	9.3	8.5	7.4	6.1	5.4	4.6	3.8		
30	3	75	65	53	48	43	35	31	27	22	19	17	14	13	11	9.2	8.0	7.0	5.8		
40	4	100	86	72	66	57	47	41	36	30	25	22	18	17	15	12	11	9.3	7.7		
50	5	125	108	89.4	82.1	71.3	58.8	51.7	44.8	37.1	32.4	28.1	23.2	21.3	18.5	15.3	13.4	11.6	9.63		



6" - 5 SPINDLE CHUCK AUTO. H

FY2056A E

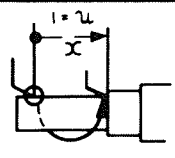
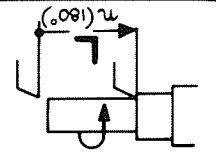
Standard machine 6" - 5 Spindle Chucker 6.5.

6 - 5 SP CHUCKER  
SLOW SPEED

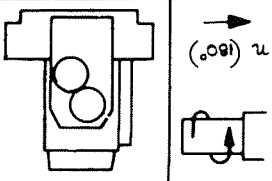
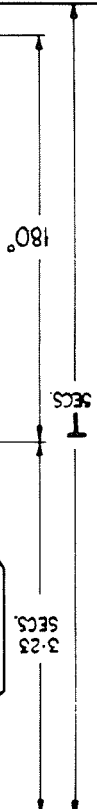
SPY1479A

M.M. INS  
X (100 INS)  
X (0.01 M.M.)

50	5	125	108	108	89.4	82.1	71.5	58.8	51.7	44.8	37.1	32.4	28.1	23.2	21.5	18.5	15.5	13.4	11.6	9.65
40	4	100	86	72	66	66	57	47	41	36	30	25	22	18	17	15	12	11	9.3	7.7
30	3	75	65	53	49	43	35	31	27	22	19	17	14	13	11	9.2	8.0	7.0	5.8	
20	2	50	43	36	33	28	24	21	17	15	13	11	9.3	8.5	7.4	6.1	5.4	4.6	3.8	
10	1	25	22	18	16	14	12	10	9.0	7.4	6.5	5.6	4.8	4.2	3.5	3.2	2.8	2.3	1.9	
7.5	3/4	19	16	13	12	11	8.8	7.8	6.7	5.6	4.8	4.2	3.5	3.2	2.8	2.3	2.0	1.7	1.4	
5	1/2	15	11	8.9	8.2	7.1	5.9	5.2	4.5	3.7	3.2	2.8	2.3	2.1	1.9	1.5	1.3	1.2	0.96	
2.5	1/4	8.3	5.4	4.5	4.1	3.6	2.9	2.6	2.2	1.9	1.6	1.4	1.2	1.1	0.93	0.77	0.7	0.58	0.48	



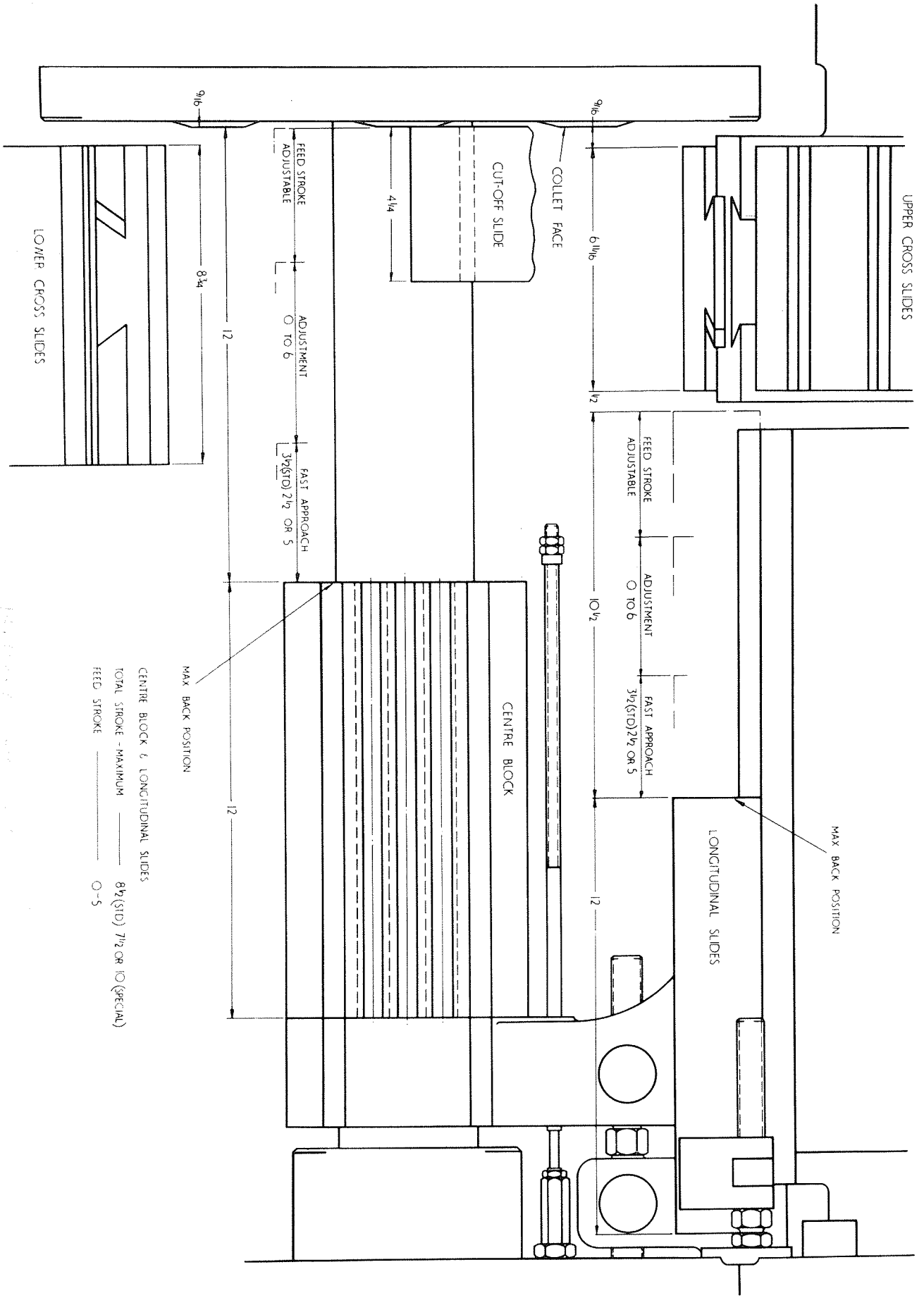
63	25	55	44.6	50.9	60.9	66.0	75.6	90.7	103	118	142	163	187	225	245	282	340	388	446	539
70	27	53	40.5	46.2	55.2	59.8	68.5	82.0	93.1	107	128	147	168	203	221	254	306	349	402	486
76	29	51	36.7	41.8	49.8	54.0	61.7	73.9	83.9	96.1	116	132	152	183	198	228	275	314	361	436
87	31	49	33.2	37.8	45.0	48.7	55.6	66.6	75.5	86.5	104	119	136	164	178	205	247	282	324	391
97	33	47	30.1	34.2	40.7	44.0	50.2	60.1	68.1	77.9	93.6	107	122	147	160	184	222	253	291	351
107	35	45	27.6	31.3	37.2	40.2	45.8	54.5	61.9	71.0	85.2	97.1	111	134	147	167	202	230	264	319
119	37	43	25.2	28.5	33.8	36.5	41.5	49.6	56.0	64.1	76.9	87.6	100	121	131	151	182	207	238	287
131	39	41	23.1	26.2	31.0	33.4	38.1	45.1	51.3	58.5	70.1	79.9	91.5	110	119	137	165	188	216	261
145	41	39	21.2	24.0	28.3	30.5	34.7	41.2	46.6	53.2	63.7	72.5	83.0	99.7	108	124	150	170	196	236
160	43	37	19.5	22.0	26.0	28.0	31.7	37.7	43.6	49.5	58.0	66.0	75.5	90.7	98.4	113	136	155	178	214
177	45	35	18.0	20.2	23.8	25.6	29.0	34.4	39.5	44.2	52.8	60.0	68.6	82.3	88.2	103	123	140	161	194
197	47	33	16.5	18.5	21.7	23.3	26.4	31.2	34.2	40.0	47.7	54.2	62.0	74.3	80.5	92.3	111	126	145	175
218	25	55	15.2	17.0	20.0	21.5	24.2	28.6	32.1	36.6	43.5	49.3	56.2	67.5	73.1	83.7	101	114	131	158
244	27	53	13.9	15.6	18.2	19.5	21.2	26.0	29.1	33.1	38.2	44.5	50.8	60.7	65.8	75.3	90.3	103	118	142
273	29	51	12.8	14.2	16.5	17.9	20.0	23.5	26.5	29.9	35.4	40.2	45.7	54.6	59.1	67.7	81.1	92.1	106	127
303	31	49	11.8	13.1	15.2	16.3	18.4	21.5	24.0	27.1	32.3	36.4	41.4	49.3	53.4	61.0	73.1	83.0	95.3	114
337	33	47	11.0	12.2	14.0	15.0	16.9	19.7	22.0	24.8	29.3	33.1	37.7	44.8	48.5	55.4	66.3	73.3	86.2	104
373	35	45	10.2	11.3	13.0	13.8	15.4	18.0	20.2	22.7	26.8	30.3	34.2	40.9	44.2	50.3	60.2	68.3	78.1	93.8
413	37	43	9.54	10.5	12.0	12.8	14.3	16.5	18.5	20.8	24.5	27.6	31.3	37.2	40.2	45.8	54.8	62.0	71.0	85.2
456	39	41	8.95	9.81	11.2	11.9	13.2	15.3	17.0	19.2	22.5	25.3	28.6	34.1	36.7	41.9	49.8	56.4	64.5	77.4
504	41	39	8.40	9.18	10.4	11.1	12.3	14.2	15.7	17.7	20.7	23.3	26.3	31.1	33.6	38.0	45.3	51.4	58.7	70.3
557	43	37	7.91	8.62	9.76	10.3	11.4	13.1	14.5	16.2	19.0	21.3	24.2	28.5	30.6	34.7	41.4	46.8	53.4	64.0
617	45	35	7.50	8.10	9.13	9.64	10.6	12.2	13.4	15.0	17.5	19.7	22.0	26.0	28.0	31.8	37.7	42.7	48.6	58.1
683	47	33	7.05	7.61	8.53	9.01	9.88	11.3	12.4	13.8	16.1	18.0	20.2	23.8	25.6	29.0	34.4	38.7	44.2	52.6



N/MIN

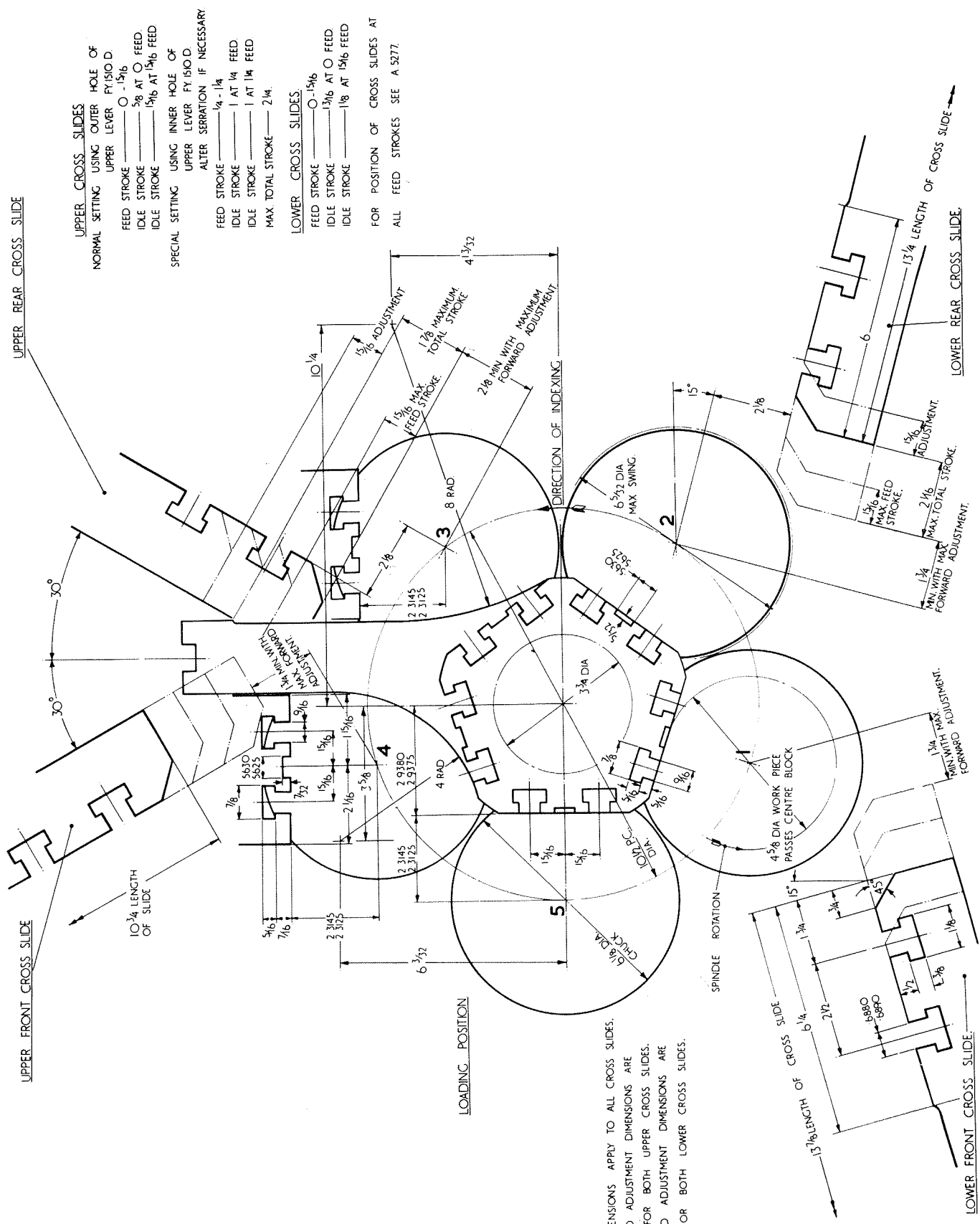
40	46	55	61	70	85	97	112	135	155	178	215	234	270	326	373	429	519
F	H	G	F	H	G	F	H	G	F	H	G	F	H	G	F	H	G
D			C			E			A			B			E		

9" - 5 Spindle  
Chucker  
Slow Speed  
6.6.



CENTRE BLOCK & LONGITUDINAL SLIDES  
 TOTAL STROKE - MAXIMUM 8 3/4 (STD) 7 1/2 OR 10 (SPECIAL)  
 FEED STROKE 0-5

**Capacity**  
**Chart**  
**1 3/4" and 2 1/4" - 5**  
**Spindle**  
**Automatic**



UPPER CROSS SLIDES

NORMAL SETTING USING OUTER HOLE OF UPPER LEVER PY1510 D

- FEED STROKE — 0 — 15/16
- IDLE STROKE — 5/8 AT 0 FEED
- IDLE STROKE — 15/16 AT 15/16 FEED

SPECIAL SETTING USING INNER HOLE OF UPPER LEVER PY1510 D

- FEED STROKE — 1/4 — 1/4
- IDLE STROKE — 1 AT 1/4 FEED
- IDLE STROKE — 1 AT 1/4 FEED
- MAX TOTAL STROKE — 2 1/4

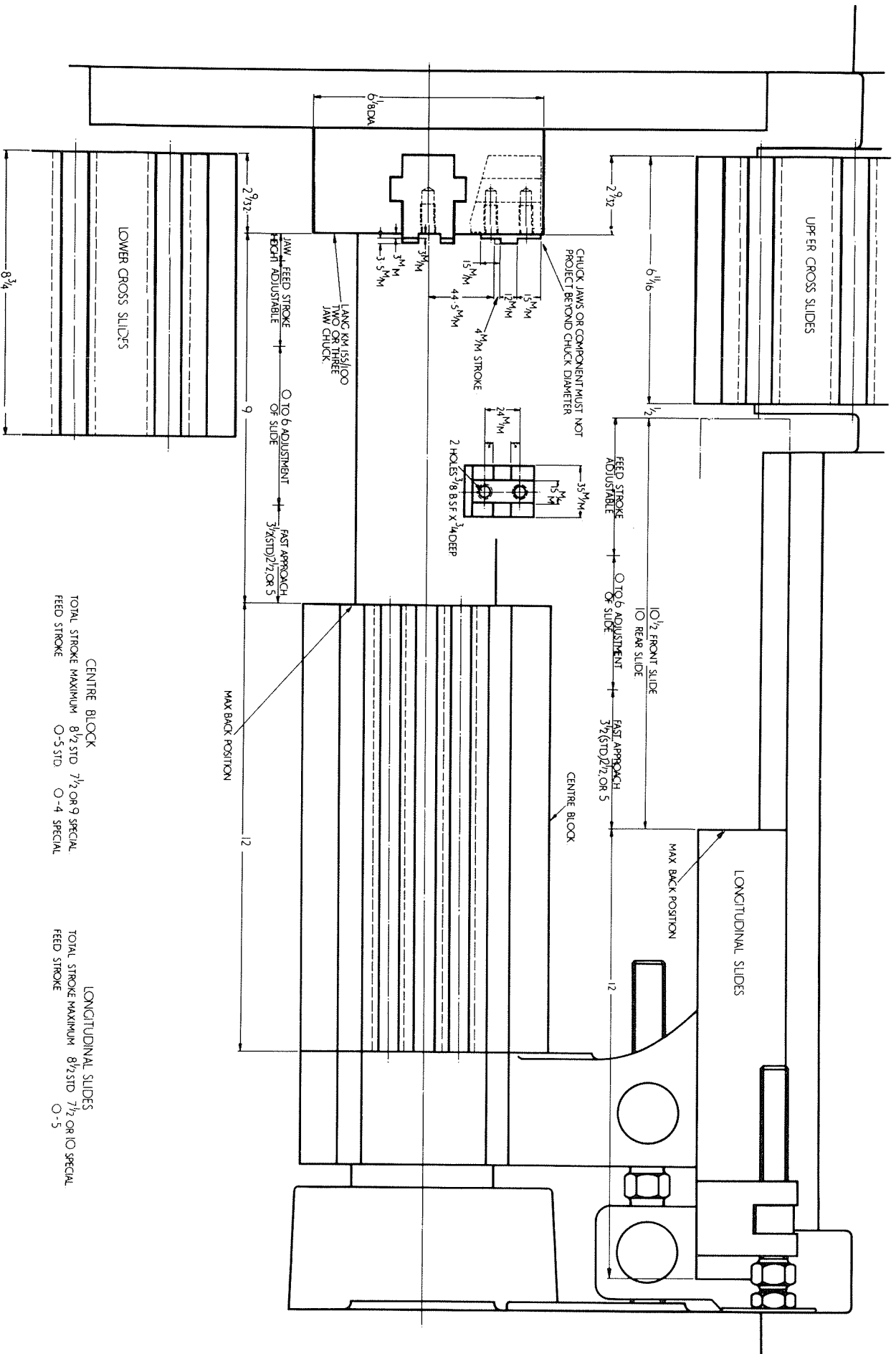
LOWER CROSS SLIDES

- FEED STROKE — 0 — 15/16
- IDLE STROKE — 1 3/16 AT 0 FEED
- IDLE STROKE — 1 1/8 AT 15/16 FEED

FOR POSITION OF CROSS SLIDES AT ALL FEED STROKES SEE A 5277.

T SLOT DIMENSIONS APPLY TO ALL CROSS SLIDES. STROKE AND ADJUSTMENT DIMENSIONS ARE IDENTICAL FOR BOTH UPPER CROSS SLIDES. STROKE AND ADJUSTMENT DIMENSIONS ARE IDENTICAL FOR BOTH LOWER CROSS SLIDES.

**Capacity Chart**  
**6" - 5 Spindle**  
**Chucking**  
**Automatic**



CENTRE BLOCK  
 TOTAL STROKE MAXIMUM 8 1/2 STD 7 1/2 OR 9 SPECIAL  
 FEED STROKE O-5 STD O-4 SPECIAL

LONGITUDINAL SLIDES  
 TOTAL STROKE MAXIMUM 8 1/2 STD 7 1/2 OR IO SPECIAL  
 FEED STROKE O-5

**Tool Capacity Chart - Front Elevation**  
**6" - 5 Spindle Chucking Automatic**