Screw Slotting Attachments

For 00, 2 and 3 Ultramatic Screw Machines

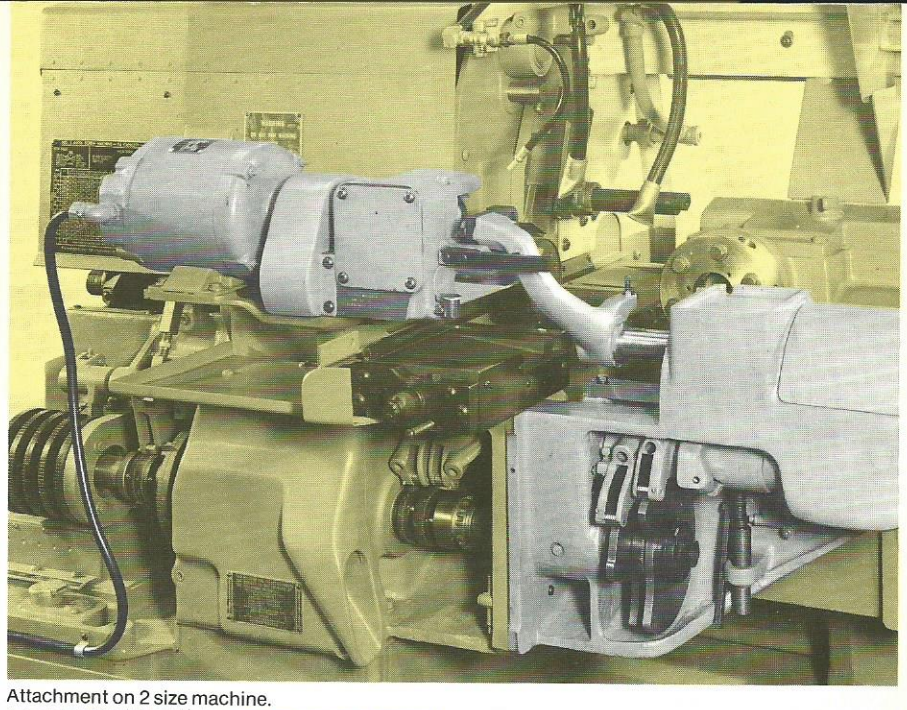
The Screw Slotting Attachment will take screws or similar pieces as they are cut off by the machine and slot their heads or ends automatically, thus doing away with an extra machine for slotting, and in most cases wholly completing the piece in the time required to make the piece without slotting. While the machine is producing one part at the spindle, the attachment is slotting the preceding one.

The attachment consists of two parts: (1) a saw, keyed to an arbor and driven continuously by a 1/3 H.P. (.25kw) A.C. motor through positive drive belt, changeable sheaves, and worm and wheel; and (2) a transfer arm, which picks up and transfers the piece from the machine spindle and feeds it against the saw. The movements of the arm are controlled by cams furnished with the attachment and located on the camshafts of the machine. These cams are designed to slot almost any screw within the capacity of the machine. Adjustable cam holders are furnished as standard equipment.

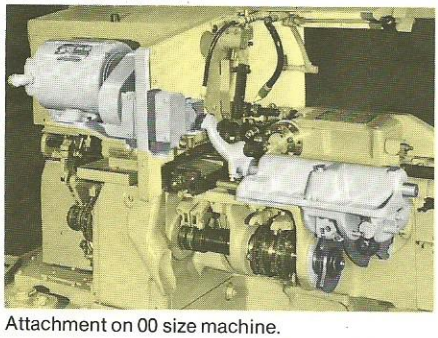
The work is held in a bushing, which is carried in an adjustable floating holder mounted in the arm. As the arm moves away from the saw after the slotting operation, the finished product is forced out automatically by a stationary ejector piece.

The saw arbor is mounted on a slide which has adjustment parallel to the machine spindle and vertical adjustment. Depth of cut is regulated by adjusting the position of this slide. A safety guard almost entirely encloses the saw.

Two saws are sometimes mounted on the arbor for cutting parallel flats. In this case it is necessary to use the Slabbing Holder in conjunction with the Screw Slotting Attachment.



Attachment on 2 size machine.



Attachment on 00 size machine.

The transferring mechanism is fastened to finished surfaces provided on the bed of the machine. Movements of the arm are controlled by standard cams mounted on the machine camshafts. Several sets of standard cams for various cycle times are available. The 00 attachment is furnished with cams for cycle times of 5 seconds and slower; the 2 with cams for cycles of 12 seconds and slower. (For intricate jobs special cams may be required.) A cam, adjustable on the camshaft, gives a maximum longitudinal movement of 1 1/16" (27mm) (1 5/16" (33mm) with special cam) on the 00 size, and 2 5/8" (66mm) on the 2 and 3 size. The design of the standard cam gives the arm a steady advance for cutting, with rapid withdrawal on completion of the cut. This cam provides for slotting all screws, within the capacity of the machine, to standard depth. Longitudinal adjustment of the arm is provided.

Changeable sheaves furnished with the 00 attachment give saw speeds of 262 R.P.M., 575 R.P.M. and 1290 R.P.M. Another set of available sheaves gives a speed of 862 R.P.M.

Changeable sheaves furnished with the 2 and 3 attachments give saw speeds of 166 R.P.M., 363 R.P.M. and 817 R.P.M. Another set of available sheaves gives a speed of 545 R.P.M.

A motor that runs at ½ regular speed is available for use with material that requires lower speeds than normally avialable.

Capacities and Shipping Weights

Machine Where Used	SIZE OF WORK*				SIZE OF SAW‡				Diameter of Arbor Collar	
	Maximum Thread Diameter		Maximum Length**		Diameter of Saw		Diameter of Hole			
	Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm
00	5/16	8	1½	38	1¾	45	5/8	16	1 3/8	35
2 or 3	¾	19.1	4	102	2¾	70	¾	19.1	1 3/4	45

*These limits may be exceeded slightly under certain conditions.
‡Saw furnished is carbon steel unless otherwise specified. High speed steel saw available at extra cost.
**From face of machine collet.

Shipping Weight (approximate) 00-103 Lbs. 47 KG
Shipping Weight (approximate) 2 or 3 -310 Lbs. 141 KG