



TURLO S.r.l.
Via Monte Rosa 5
13019 VARALLO SESIA (VC) ITALY
Tel (0039) 0163 54446
Fax (0039) 0163 54226
Email: mail@turlo.it website: www.turlo.it

SPARE PARTS AND ATTACHMENT FOR MULTISPINDLE MACHINES

SCHÜTTE

catalog 2018

Attachments for
SCHÜTTE Multispindle machines

6-spindles machine:

SCHÜTTE SE16
SCHÜTTE SE25
SCHÜTTE SD32
SCHÜTTE SD51
SCHÜTTE SD63
SCHÜTTE SF13
SCHÜTTE SF20
SCHÜTTE SF26
SCHÜTTE SF32
SCHÜTTE SF42
SCHÜTTE SF51
SCHÜTTE SF67
SCHÜTTE SF81
SCHÜTTE SG18

8-spindles machine:

SCHÜTTE AD40
SCHÜTTE AF26
SCHÜTTE AF32
SCHÜTTE AF42
SCHÜTTE AF51
SCHÜTTE AF67
SCHÜTTE AF81
SCHÜTTE AG20

Edizione catalogo / Catalogue issue: 07/2018

This catalog does not show original Schütte parts and accessories,
but all the parts and accessories in this catalog are made by Turlo Srl

FULL THREADING ATTACHMENT
APPARECCHIO FILETTATORE
GEWINDESCHNEIDEINRICHTUNG
TARUDEUR
ROSCADOR
ROSQUEADOR COMPLETO



The threading attachment is used to make frontal internal or external threads.

We can supply the complete attachment.

That means all the sequence of shafts, gears, electromagnetic clutches, bearings and everything else is needed to start the threading operation.

All gears and shafts are hardened and grinded as Schutte's quality needs.

The mechanical parts are supplied already fitted together when it is possible.

The electromagnetic clutches are piloted by our Power Unit, that is also able to stop the machine in case of malfunction during the threading operation.



Our new concept threading spindles do not require any tap-holder, in fact its frontal part (collet spindle) can slide out the support and follow the tapping operation.

That is why we can check the length of the thread directly on the extraction of the collet-spindle and be sure that all the parts have the same thread length. SEE NEXT PAGE...



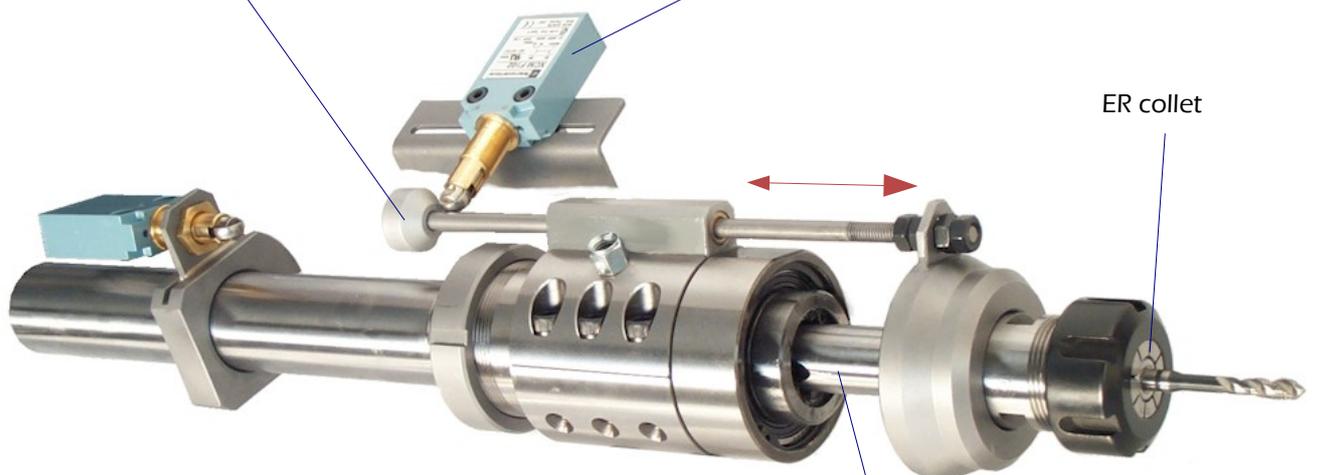
for **SCHÜTTE**
multispindle machines

FULL THREADING ATTACHMENT
APPARECCHIO FILETTATORE
GEWINDESCHNEIDEINRICHTUNG
TARUDEUR
ROSCADOR
ROSQUEADOR COMPLETO



the adjustable cam
determines the length of the thread

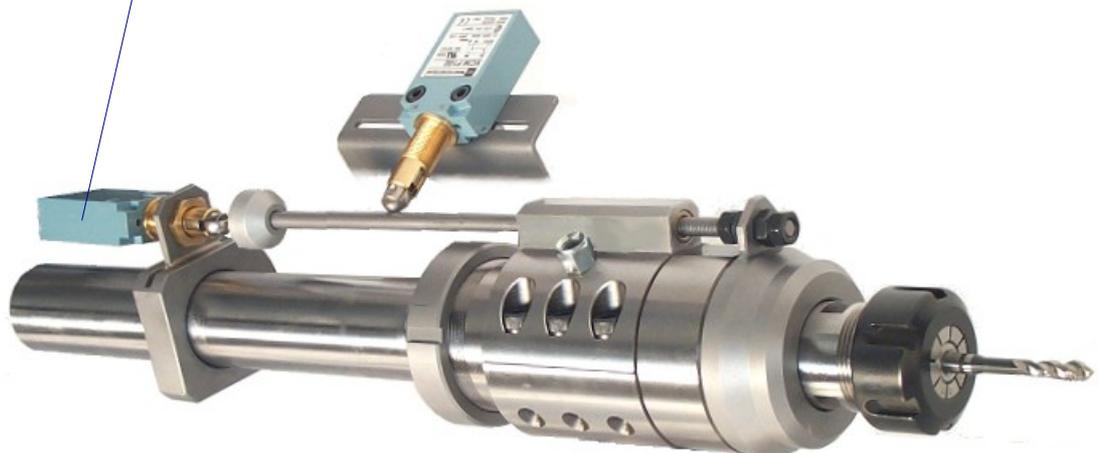
when the cam at the end of the rod touches the side-microswitch
the outway speed is engaged and the tool gets off the part.
the side microswitch is fixed to the machine structure,
so you are sure that all threads have the same length.



ER collet

the back microswitch checks if the collet-spindle is returned
to its resting position after having done the thread

the collet-spindle runs out very fluently
thanks to 3 pin-keys at 120 degrees on its stem



Threading spindle in resting position



**for SCHÜTTE
multispindle machines**

**HYDRAULIC PICK-UP ATTACHMENT
MANDRINO DA RIPRESA IDRAULICO
ABGREIFEINRICHTUNG
CONTRE BROCHE
PEGADOR E ESCAREADOR NA PARTE POSTERIOR DA PEÇA**



The pick-up attachment is used on cutting-off position frontal slide.

Its spindle rotates at the same speed than the bar, it clamps the part with the collet during the cutting-off.

Still with the part in the collet, it goes backward, allowing the positioning of the reprise tool-holder in front.

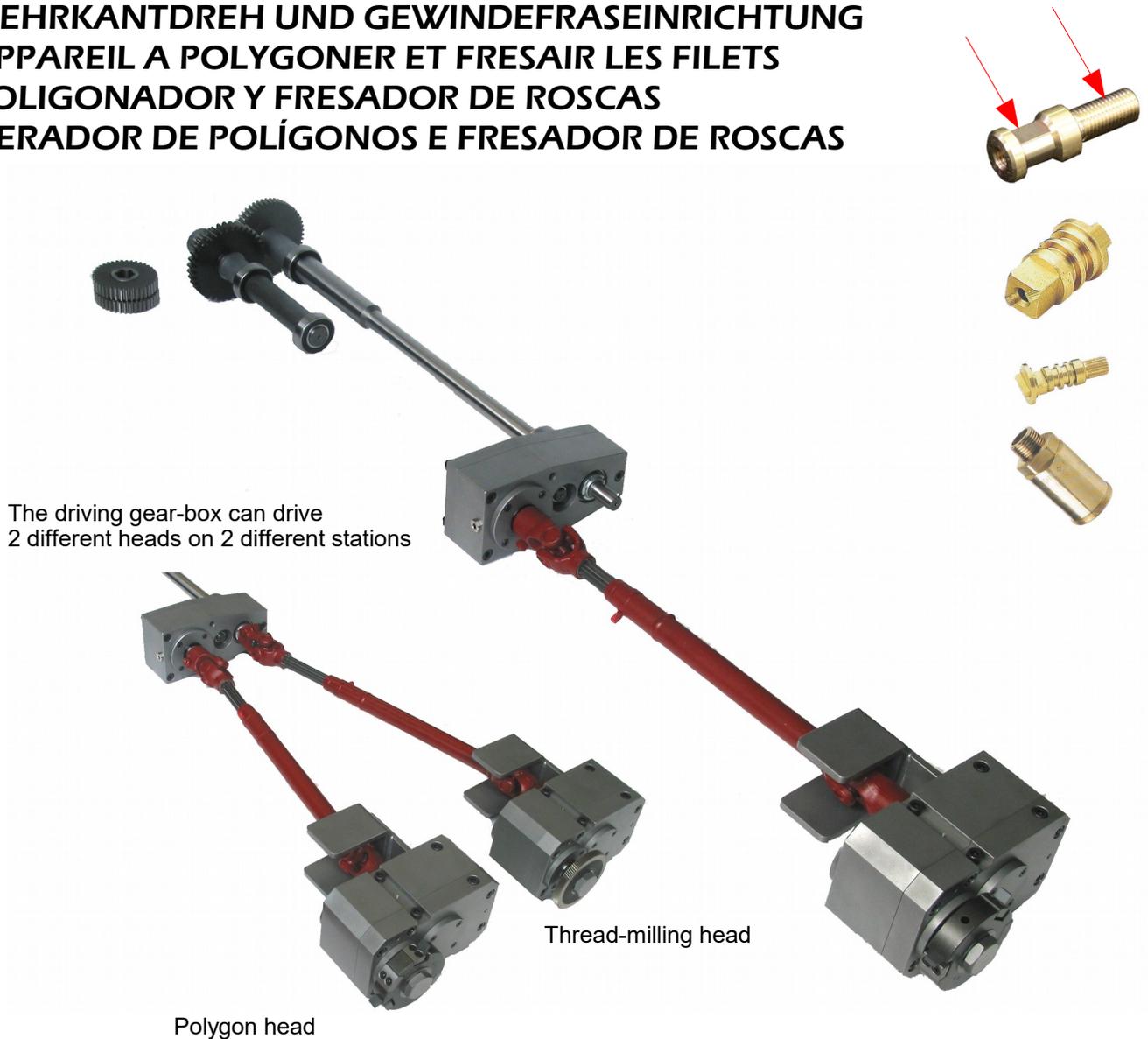
Going forward against the reprise tool it makes the finishing of the part on the back side.

The last phase is the opening of the collet and the expulsion of the part.

The opening and closing of the collet is fully hydraulic.

We can supply the hydraulic unit in case it is missing in the machine.

POLYGON-GENERATING AND THREAD-MILLING ATTACHMENT
APPARECCHIO POLIGONATORE E FRESAFIETTI
MEHRKANTDREH UND GEWINDEFRASEINRICHTUNG
APPAREIL A POLYAGONER ET FRESAIR LES FILETS
POLIGONADOR Y FRESADOR DE ROSCAS
GERADOR DE POLÍGONOS E FRESADOR DE ROSCAS



The polygon and thread milling attachment can be fitted in any station.
 The attachment is usually supplied with 2 couples of gears, the 1:1 thread milling ratio
 and the 1:2 polygon generating ratio.
 The 1:2 ratio is used to mill flats on the external diameter of the component.
 The number of milled flats is always twice the number of cutters on the tool.

- 1 cutter = 2 flats at 180° (key)
- 2 cutters at 180° = 4 flats at 90° (squares)
- 3 cutters at 120° = 6 flats at 60° (hexagons).



The cutters can have different width and they must be grinded by the user.
 The tool fitting can be chosen between original Schütte fitting or 8°32' degree conical shaped + key.

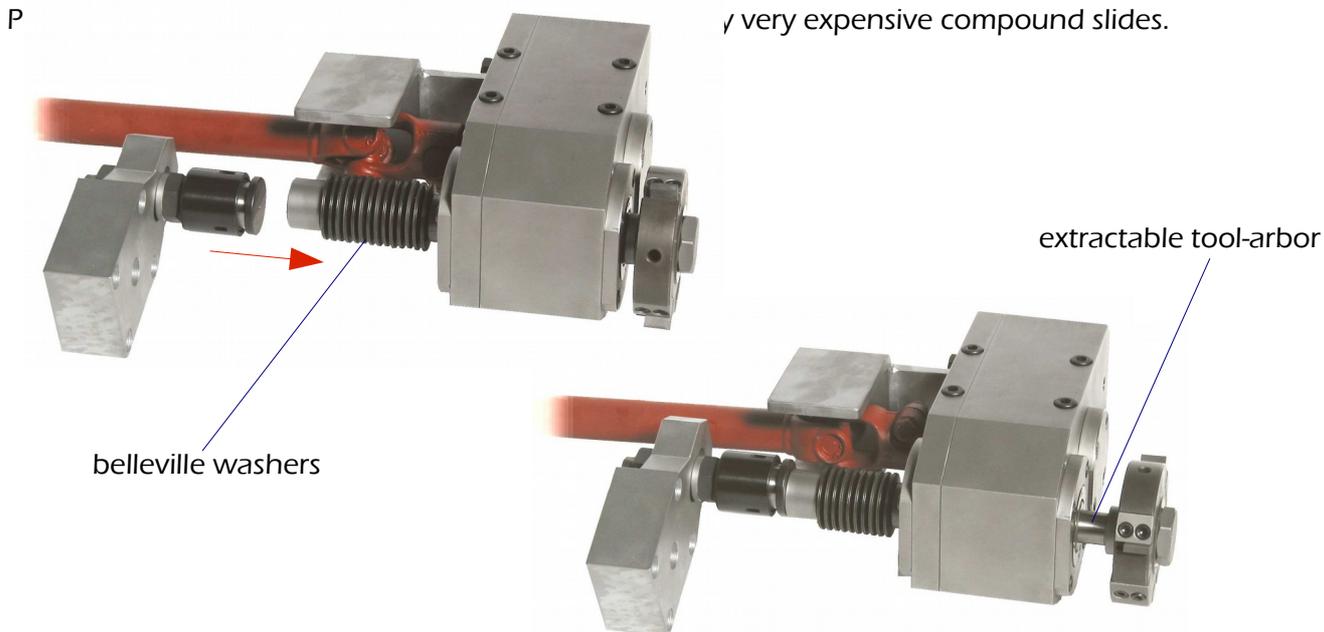


for **SCHÜTTE**
multispindle machines

POLYGON HEAD WITH AXIAL MOVEMENT OF THE TOOL FOR STEEL
TESTA POLIGONATRICE CON MOVIMENTO ASSIALE PER ACCIAIO
TÊTE A POLIGONER AVEC MOUVEMENT AXIAL POUR ACIER
POLIGONADOR CON MOVIMIENTO AXIAL PARA ACERO
POLIGONADOR COM MOVIMENTO AXIAL PARA AÇO



This polygon head has got an extractable tool-arbor.
 The tool-arbor back end is outside the head, so it can be pushed forward by a bracket fixed on the centre block in the same station. A set of belleville washers will pull the arbor into start position at the end of the cycle. This kind of attachment is very good for wide polygon jobs and even better for hard jobs on steel. In this cases we suggest to use special tools with standard inserts. Also this special polygon head is good to make frontal milled slot in the part without the radius of a millina disk





for **SCHÜTTE**
multispindle machines

HIGH SPEED DRILLING ATTACHMENT
MANDRINO FORATORE RAPIDO
SCHNELLBOHREINRICHTUNG
PERÇAGE TOURNANT
TALADRO RAPIDO
FURADOR COM ALTA VELOCIDADE



Schütte SF32 - AF32

The High Speed Drilling Attachment rotates in the opposite direction than the bar, that allows to drill at higher cutting speed.

Different pairs of ratio gears can be supplied to change the cutting speed.

The spindle is hold by the standard centre block braket.

The attachment is also available in the coolant through version:

the coolant liquid can be pushed through the drilling tool at high pressure during the drilling.

Usually supplied with spindle for ER collets.

It is good to be fit in any position.



Schütte SE16 - SE25



**for SCHÜTTE
multispindle machines**

**SYNCHRO FRONTAL MULTI-DRILLING ATTACHMENT
APPARECCHIO FORATORE MULTIPLO SINCRONIZZATO
FORADOR MÚLTIPLOS SINCRONIZADO**



This multi-driller in particular is designed to make 4 drilled holes on a specific interaxis, we can supply it for a special spindle-stopping machine, but also for standard machines.

For standard machines the multi-driller head rotates at the same speed than the bar.

The multi-driller heads are customized for the kind of component you are going to produce.

BROACHING ATTACHMENT
APPARECCHIO BROCCIATORE SINCRONO
MEHRKANTSTOBENRICHTUNG
APPAREIL Á MORTAISER (ETAMPER)
BROCIADOR
BROCHADOR



Schütte SF26 - AF26

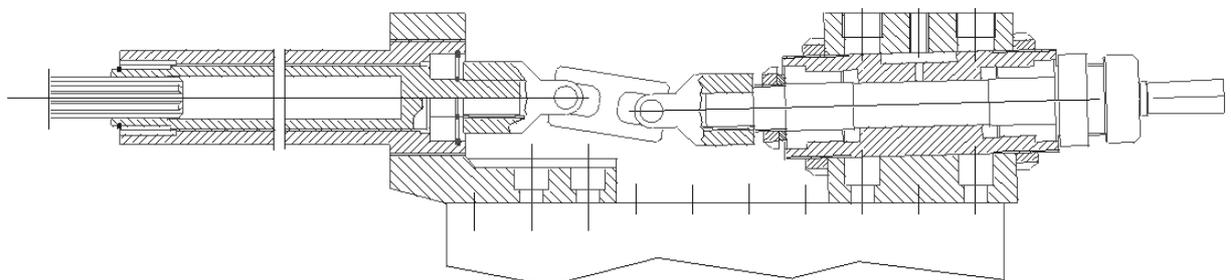
This attachment is designed to make polygons or geometrical profiles inside or outside the component, provided that they can be reached frontally.

It has to be fitted on the centre block of the machine (or upper independent longitudinal slides).

The tool rotates at the same speed than the bar.

The tool spindle axis is slightly inclined in order to reduce the axial load during the broaching.

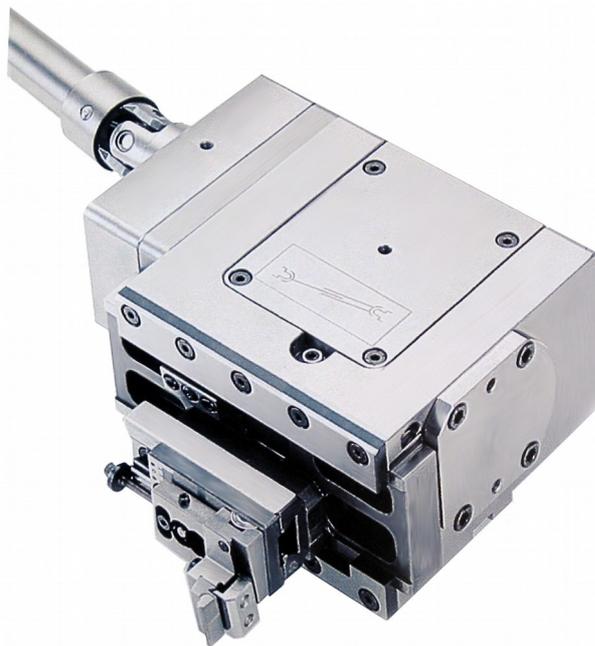
The standard tool-spindle uses ER type collets.





**for SCHÜTTE
multispindle machines**

**THREAD CHASING ATTACHMENT
FILETTATORE A PETTINE
GEWINDESTREHLER
APPAREIL À PEIGNER LES FILETS
ROSQUEADOR POR PENTES**



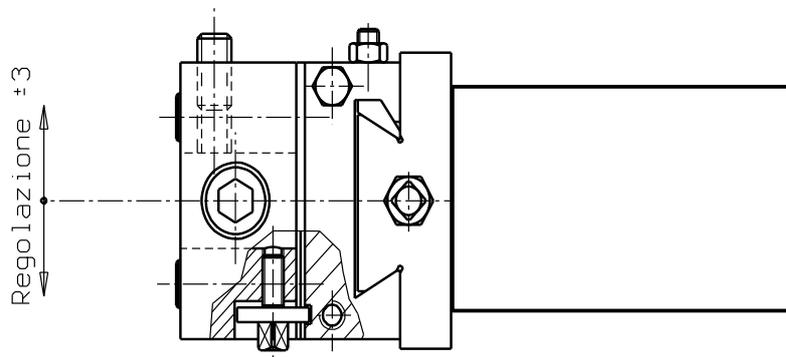
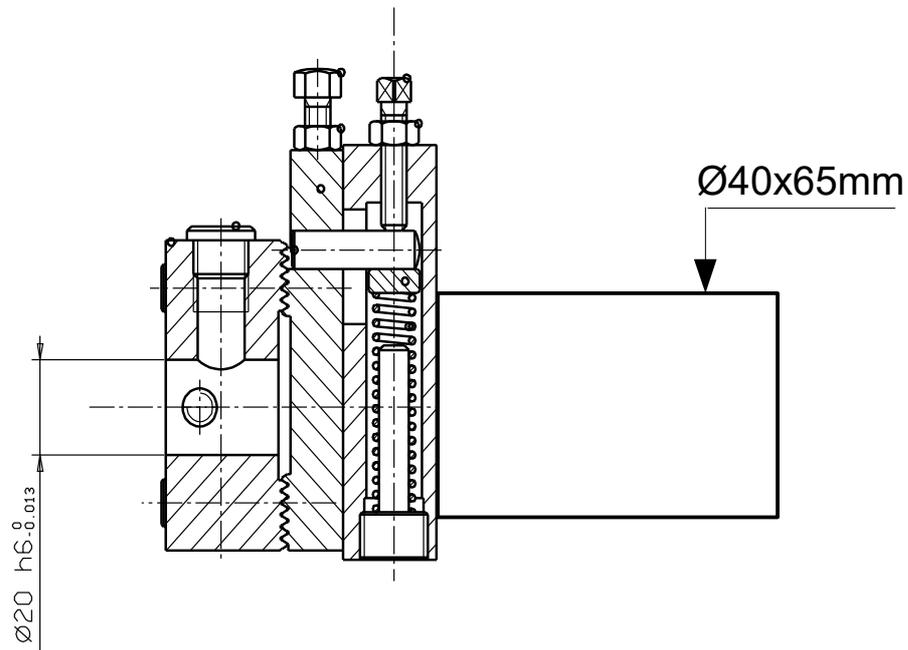
THREAD CHASING ATTACHMENT

Attachment for multispindle automatics with mechanic motion used for threading pieces on diameters which usually can't be reached by a normal die. This attachment is a valid alternative to thread rolling and to milling devices. With suitable variants, internal threads can be obtained in addition to external

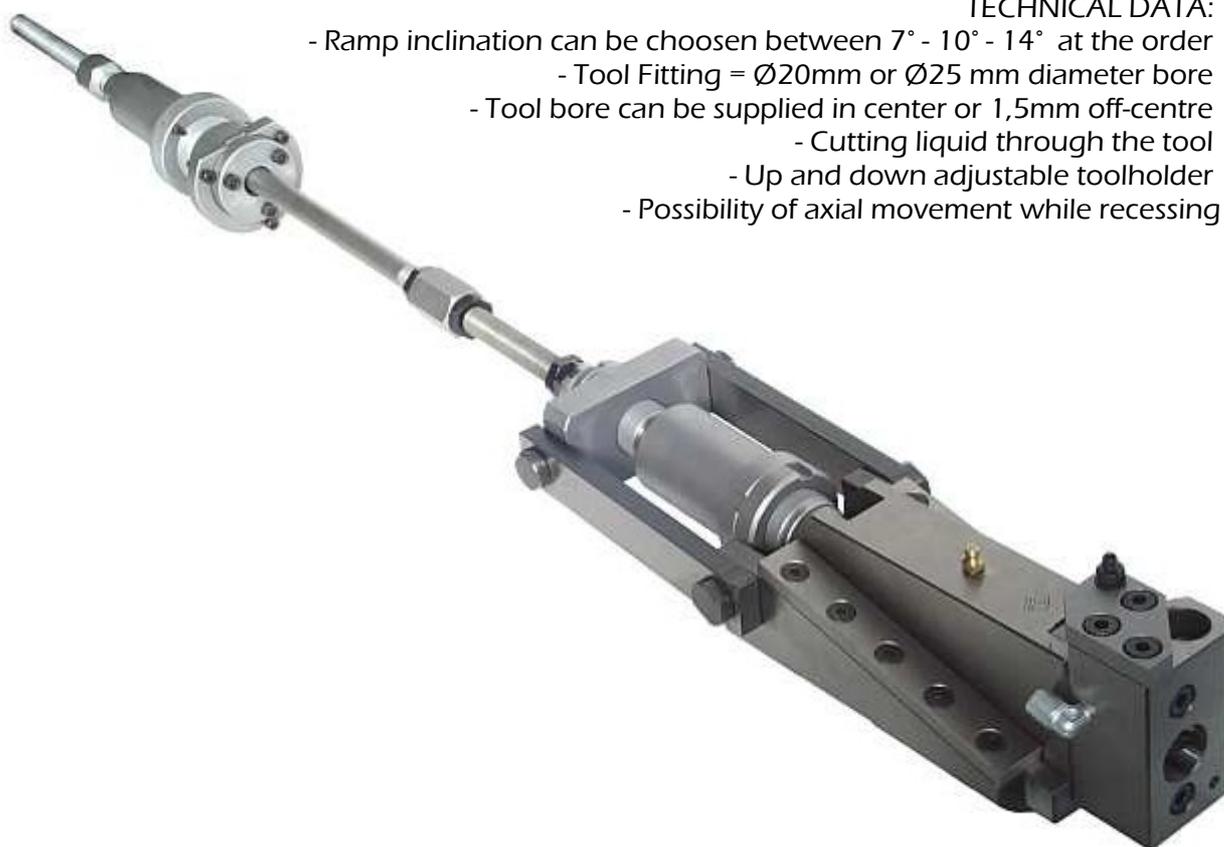


for **SCHÜTTE**
multispindle machines

RECESSING HEAD
TESTINA PER RECESSI



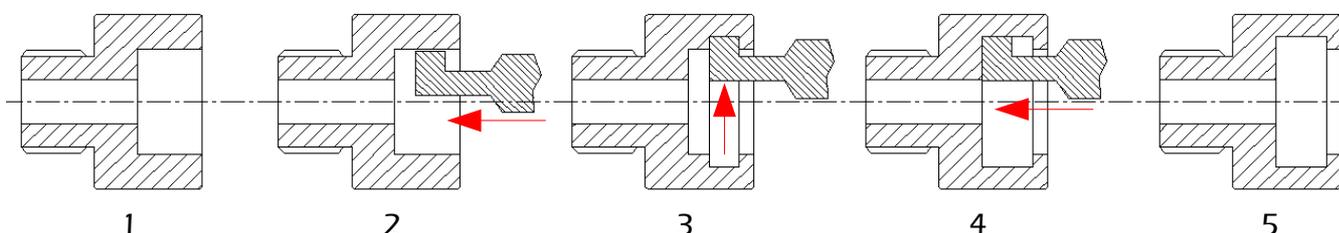
RAMP RECESSING ATTACHMENT
APPARECCHIO RECESSITORE A RAMPA
INNENAUSDREHSCHIEBER
APPAREIL A CHAMBRER
CAJEADOR
ABRIR CANAIS INTERNOS E ACIONAMENTO TIPO RAMPA



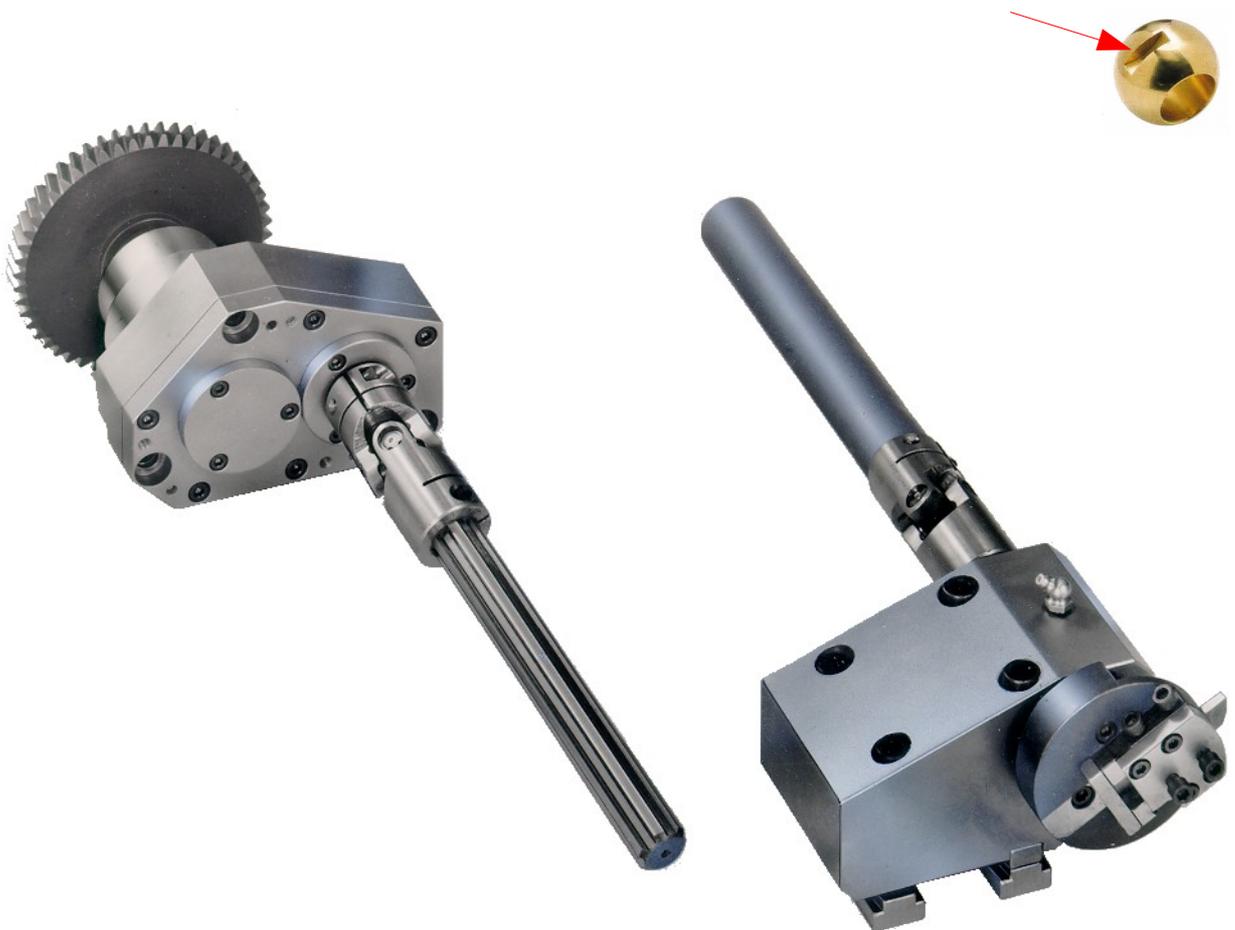
TECHNICAL DATA:

- Ramp inclination can be chosen between 7° - 10° - 14° at the order
- Tool Fitting = Ø20mm or Ø25 mm diameter bore
- Tool bore can be supplied in center or 1,5mm off-centre
- Cutting liquid through the tool
- Up and down adjustable toolholder
- Possibility of axial movement while recessing

This attachment is used to make recesses inside the component.
 It has to be fixed on the centre block of the machine (frontal station).
 After reached the right position inside the component the tool-holder moves upwards, sliding on a inclined ramp (in case of 14° ramp : 1 mm upwards every 4 mm of axial movement of the centre block).
 The length of the recess is usually the same as the length of the cutting tool.
 However, if you need to create longer recesses, our attachment can also move axially, doing long turning while recessing.



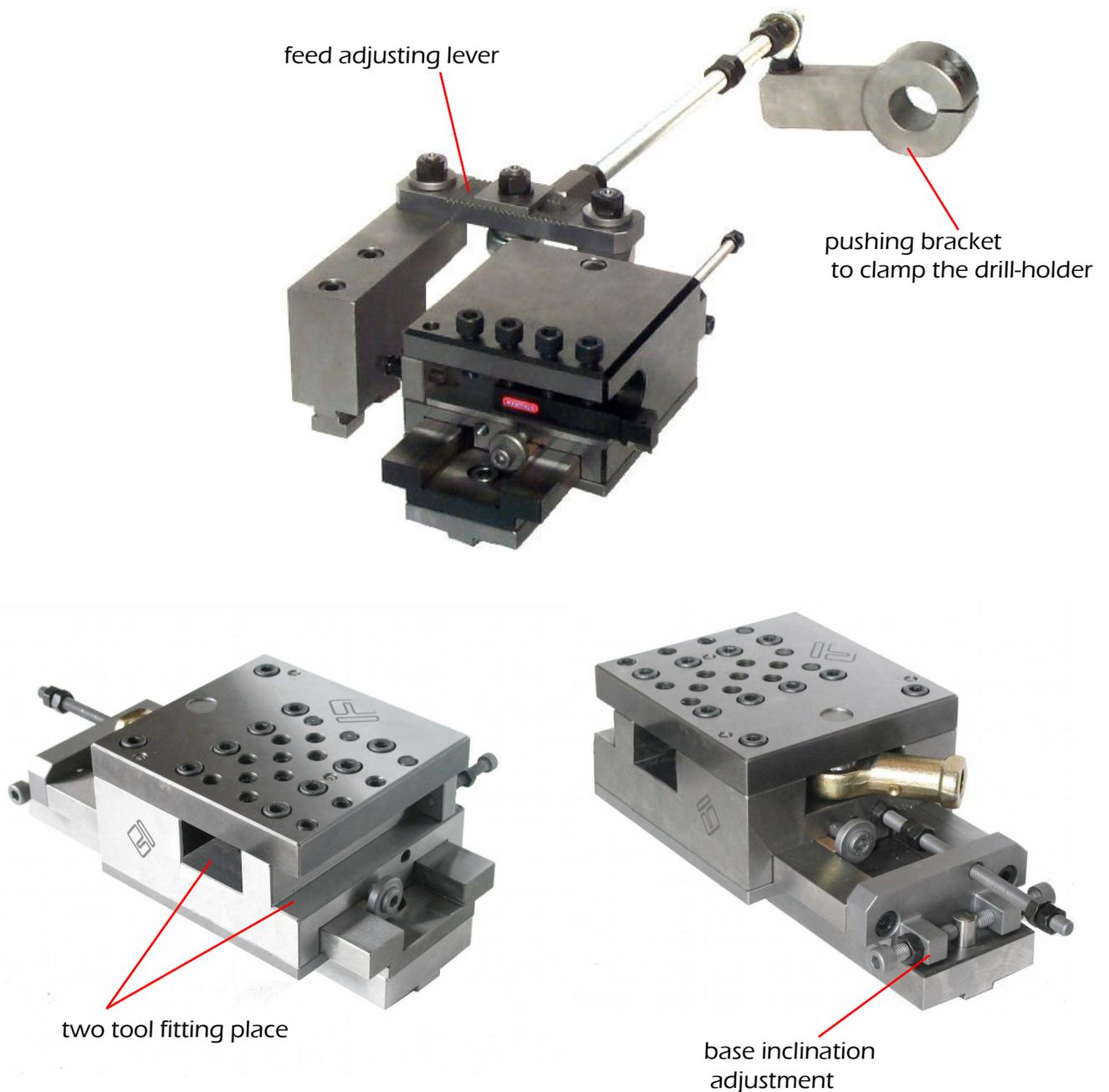
RADIAL SLOT CUTTING ATTACHMENT
APPARECCHIO CONTROPOLIGONATORE (PER SPACCO SFERE)



This attachment is designed to make radial slots on the external of the component. It must be fitted on the cross slide of the machine. The tool rotates at the same speed of the bar but in opposite direction. Each cutter on the tool makes a single slot on the component. The radius of the slot it is not the same than the radius on which rotate the cutter. The radius of the slot depends on different geometrical factors and that allows to make even small slots with a bigger tools.

LONGITUDINAL TURNING CHARIOT
CARRO TORNITORE IN PASSATA
AXIALSCHLITTEN LANGDREHSCHIEBER
CHARIOT POUR LONG TOURNAGE
CARRO PARA TORNEAMENTO LONGO

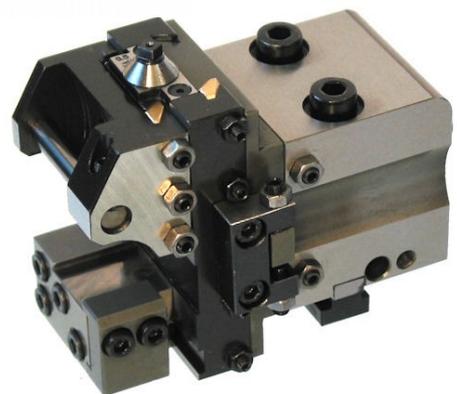
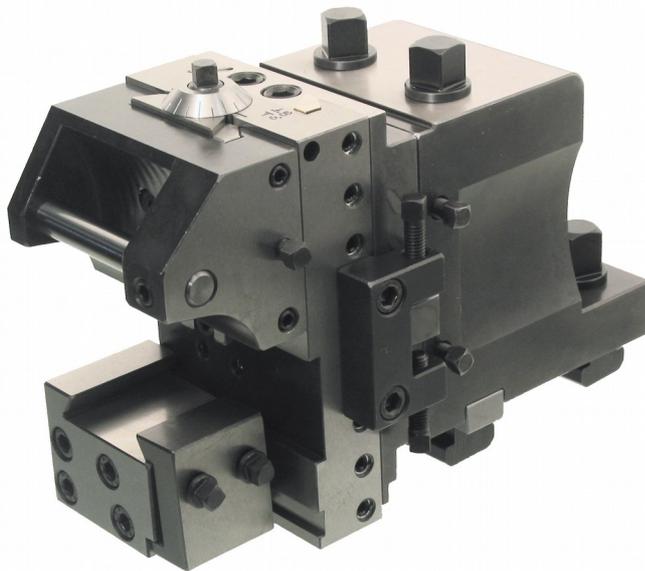
The axial chariot can be used on machine cross slides to make long turning operations. The feed is taken by fitting a pushing bracket on the centre block (same station). The bracket can be fixed directly on the centre block or it can clamp the drill holder back end. The inclination of the bottom base is adjustable. The chariot has the same feed than the centre block unless you prefer the version with adjustable feed lever.





**for SCHÜTTE
multispindle machines**

**SHAVING TOOL-HOLDER
CALIBRATORE
KALIBRIERWERKZEUGE
PORTE OUTILS À CALIBRER
CALBRADOR/AFEITADOR**



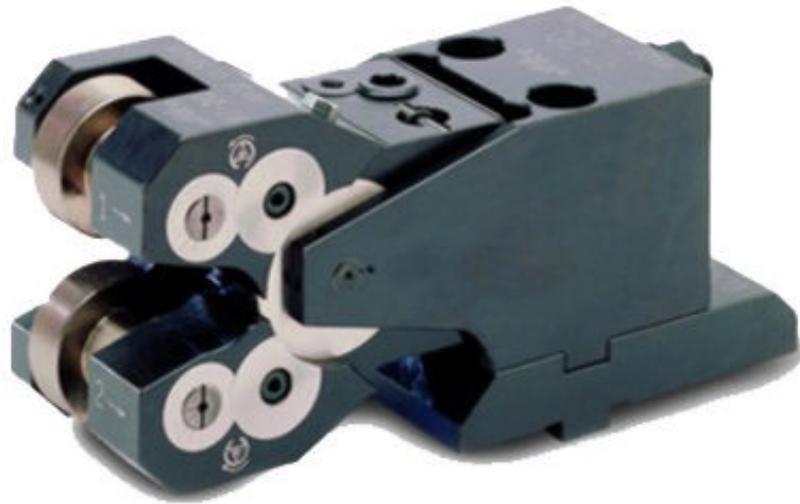
The shaving tool-holder is used to have very precise diameter.

It can be used on any cross-slides. It must be completed by the customer by a roller on
The top carbide pin and a cutting insert clamped at the bottom.



**for SCHÜTTE
multispindle machines**

**THREAD ROLLING ATTACHMENT for cross slide
RULLATORE DI FILETTI TANGENZIALE**



We can supply new or good used cross thread-rolling Fette heads,
models are the following T12, T18, T27

We can adapt them to any kind of machine model

Siamo in grado di fornire rullatori di filetti tangenziali Fette nuovi o usati.

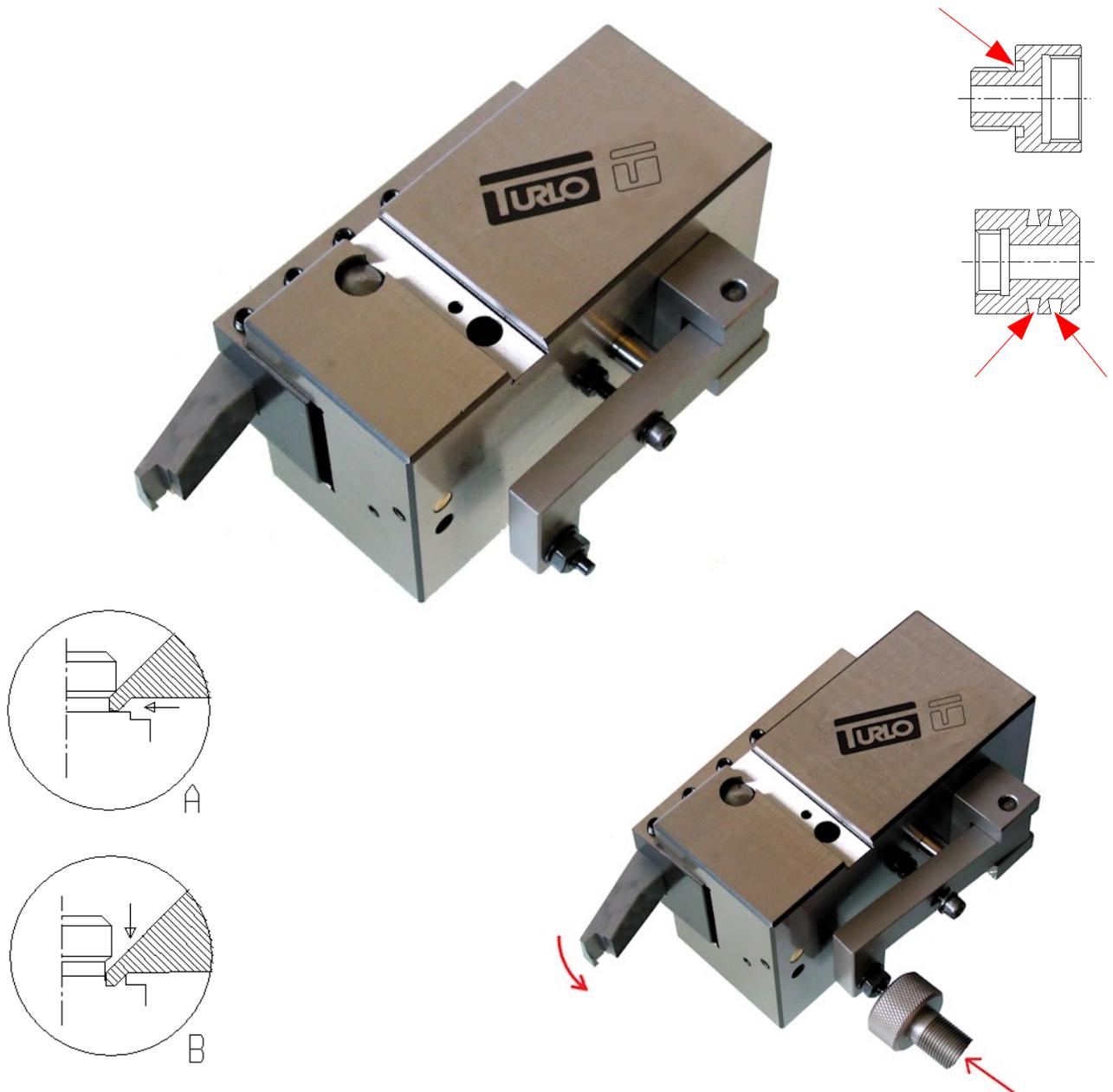
I modelli sono i seguenti: T12, T18, T27

Possiamo fornire supporti per adattarli a qualsiasi macchina



for **SCHÜTTE**
multispindle machines

BACK-SIDE TURNING TOOL-HOLDER FOR SMALL GROOVES
PORTAUTENSILE BASCULANTE PER SCARICHI POSTERIORI
PORTA FERRAMENTA PARA TORNEAR SEDE JUNTA POSTERIOR



This special cross slide tool-holder makes back (collet-side) grooving operations.

Typically used to make place for seals

The tool cutter moves along a circle but, because of the big circle radius and the small movement inside the part, the result is very like a straight movement.

The tool-holder is pushed by a bracket fixed on centre block.

The tool is not included and must be properly profiled by the customer.

We also supply similar attachment for doing frontal grooving operations.

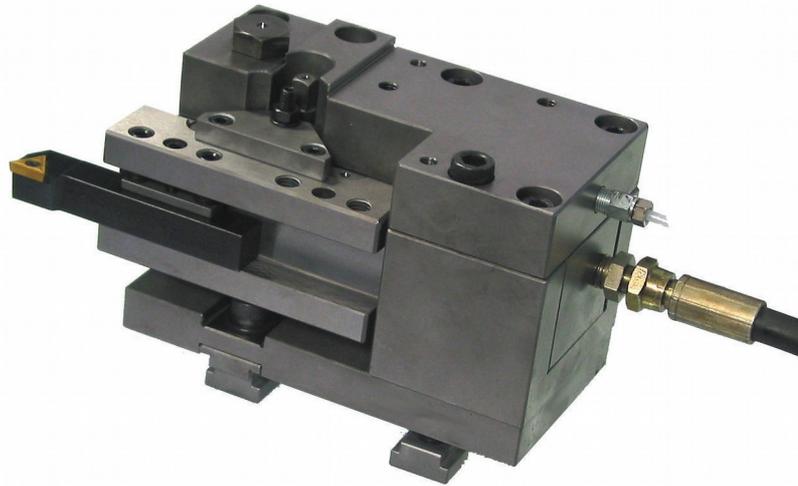


**for SCHÜTTE
multispindle machines**

FACING TOOL-HOLDER with off-movement for the tool

PORTAUTENSILE SFACCIATORE

con movimento di stacco dell'utensile



It has to be fixed on machine cross-slide. It can do part facing by X-movement of the cross slide.

At the end of the facing the hydraulic power turns a little the tool-holder in order to not touch anymore the part with the tool during the backward movement of the cross slide.

Va montato su uno dei carri trasversali della macchina. Col movimento in X del carro l'utensile sfaccia il pezzo. Alla fine della sfacciatura entra in azione il meccanismo idraulico per staccare l'utensile dal pezzo e impedirgli di toccarlo durante il movimento di ritorno del carro.

CROSS MARKING ATTACHMENT
TIMBRATORE TANGENZIALE
SIGNIEREINRICHTUNG
MARQUAGE TANGENTIEL
MARCADORES



This attachment is used to mark the components in a very simple and quick way, it is based on a completely mechanical logic.

With our attachment on, the cross slide moves forward till the engraved disk hits the component. Because of the friction between them, the disk starts to turn and mark the component. After one rotation engraving is over and a locking pin stops the disk in a special position, where it cannot touch the component again.

When cross slide returns back, a proper pin, fixed on the wall of the machine, unlocks the disk, and the spring takes it to its start position.

We can supply blank disks or engraved disk, following customer's requirements.

The same attachment can be taken apart and re-assembled the other way round in order to fit all station of the machine.

Now it is also possible to fit a disk with interchangeable letters.

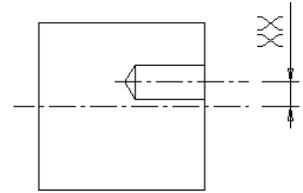


The new roller with interchangeable characters



**for SCHÜTTE
multispindle machines**

**OFF-CENTRE DRILLING SPINDLE
FORATORE ECCENTRICO
FURADOR FORA CENTRO**



This rotating spindle drills off-centre holes in a very easy way.
The interaxis is customized.



for **SCHÜTTE**
multispindle machines

ROTATING LIVE CENTER WITH COMPENSATION
CONTROPUNTA ROTANTE ELASTICA

