

HUR 50

OPTIONALS

VARNSDORF
TOOLS

HAND UNIVERSAL MILLING HEAD



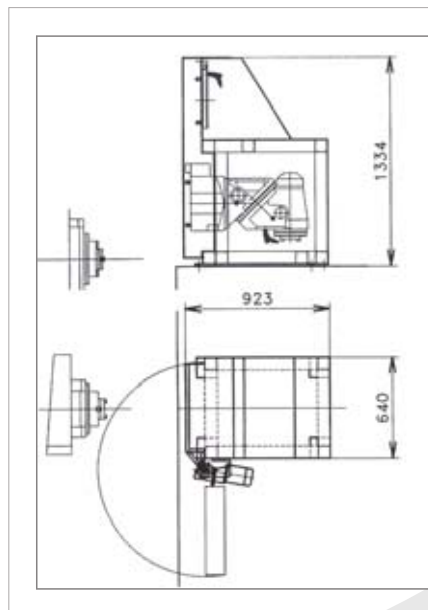
The HUR 50 hand universal milling head is intended as an option to the following horizontal milling machines: WH 10 CNC, WH(Q) 105 CNC, WHN(Q) 13 CNC, WHN 110 / 130 (Q, MC), WRD 130 / 150 (Q), PRIMA, OPTIMA, VARIA, VIVA, GRATA, MAXIMA I / II, MAGNA I / II.

The head serves to machine surfaces oriented in basic directions and in general relative to the orthogonal coordinated system of the machine.

The angles of turning in both parting planes of the head are set by means of a socket handle after unfixing the individual rotary adjustable parts of the head. The adjustable parts of the head are mutually strengthened by tightening of bolts along the circumference of the parting planes. The head can be set in 8 basic positions, using an arresting element (4 x 90° in vertical plane and 2 x 180° in angular plane). The angles of setting can be read on peripheral scales equipped with vernier of 0.1° increment. To obtain a more precise setting of position of the head spindle, it is necessary to use measuring fixtures.



Attachment of the head upon the machine headstock is carried out manually, by means of a lifting device. The positioning and fixing of its adjustable base parts is carried out manually, by means of screws.



PICK-UP (optionals stand - "SZP") is an integral part of variant modification of the WRD 130 / 150 (Q) machines, adapted for automatic mode of head's putting. Its execution (quantity of pockets, covering etc.) has to be determined in advance with the manufacturer.



To apply the head on the WRD 130 / 150 (Q) machines, a variant modification of the head attachment flange is offered, adapted for automatic mode of its putting from the PICK-UP stand when the head is fastened to ram face with use of four CYTRAC clamping units. Centring and adjustment of the head by angles is provided by means of two Hirth gear rings.

If the head is not in use upon the WRD 130 / 150 (Q) machines, the clamping parts and head connection are protected against any pollution by a cover plate that is also mounted automatically.

MAIN SPECIFICATIONS

Work spindle face diameter	mm	128.57 h5	inch	5.06 h5
Spindle taper		ISO 50		ISO 50
Spindle speed maximum	RPM	3,000	RPM	3,000
Spindle torque maximum	Nm	1,000	ft.lb	68.5
Transmitted power maximum	kW	20	HP	27
Transmission ratio		1 : 1		1 : 1
Range of turning head parts	grad	2 x ±180	grad	2 x ±180
Oil pressure feed on the headstock face	MPa	min. 8	PSI	min. 1,160
Coolant supply by nozzles	MPa	max. 0,3	PSI	max. 44
Coolant supply by spindle centreline	MPa	max. 1- 2	PSI	max. 145 - 290
Total weight of the head	kg	300	lbs	660

BASIC TECHNICAL DESCRIPTION

TOOL CLAMPING

The tool is mechanically clamped into the work spindle of the head by action of disc springs. The tool is released hydro-mechanically with supply of pressure oil from the machine.

The tool is inserted into/removed from the spindle taper manually used likewise for the machines equipped with tool automatic change. The clamping/release control of the tool inserted manually is located on the machine headstock.

TOOL COOLING

The milling head enables tool cooling by spindle centerline or

nozzles (by articulated hoses). In both cases the coolant (or pressure air, as the case may be) is supplied via hose into the rotary part of the head. From here it proceeds through valves either into the nozzles only, or through the centre of the head spindle.

LUBRICATION

Lubrication of seating of the head work spindle and individual parts of its drive is of permanent greasing type.

The individual gearings of the head spindle drive are grease lubricated with additional greasing.

In case of different head application, e. g. permanent mounting upon headstock (concerns especially the new TOStec series), please contact the manufacturer.



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