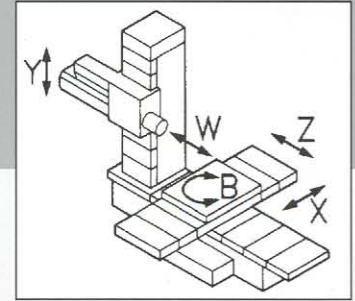


TOS VARNSDORF a. s. located in Varnsdorf, Czech Republic, was founded in 1903 and ranks among the foremost producers of horizontal boring mills. The long standing tradition and technologic maturity of the firm have been applied in its product, spread in all industrialized countries in the world.



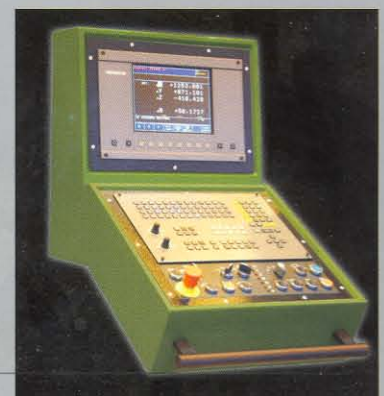
The classic model of the WH 10 CNC machine has a fixed column, a live spindle and a crosswise adjustable rotary table. It is the smallest CNC machine manufactured by TOS VARNSDORF a. s., which is the result of a gradual modernisation of the WHN 9 A/B machine. The application of modern structural elements and the properties of the most advanced control system offers the customer a cost efficient solution meeting the needs for a modern machine tool.

The feed drives for all coordinates and the spindle support are equipped with digitally controlled **Siemens AC servo-drives**. All the traversable groups are automatically hydraulically clamped upon reaching required position.

The **Heidenhain TNC 426 M** control system offers a wide range of functions for demanding technology. It controls the machine in 4 continuously controlled coordinates (X-, Y-, Z- and W-) and it ensures an automatic positioning of the rotary table. The spindle revolution sensor enables the "oriented spindle stop" function and the angle positioning of the spindle.

The control system includes:

- the LE 426 M basic module
- the TE 420 external control panel
- the BF 120 colour monitor
- the HR 410 electronic hand wheel



MAIN TECHNICAL PARAMETERS

Spindle diameter	mm	100	inch	3.94
Spindle taper		ISO 50		ISO 50
Programable spindle RPM range	RPM	10 - 1,800	RPM	10 - 1,800
Spindle RPM range extended by override pot	RPM	5 - 1,800	RPM	5 - 1,800
Main motor power (operation S2/S6 - 60%)	kW	20/19	HP	27/26
Table cross travel (X)	mm	1,250	inch	49.21
Headstock vertical travel (Y)	mm	1,100	inch	43.31
Table longitudinal travel (Z)	mm	940	inch	37
Spindle stroke (W)	mm	630	inch	24.80
Table clamping surface	mm	1,000 x 1,120	inch	39.37 x 44.09
Workpiece weight max	kg	3,000	lbs	6,600
Working feeds in X -, Y -, Z -, W axes	mm/min	4 - 4,000	inch/min	0.16-157.48
Rapid traverse in X -, Y -, Z -, W axes	mm/min	8,000	inch/min	314.96
Table (B) rotation velocity	RPM	2	RPM	2
Total power consumption	kVA	50	kVA	50
Total weight	kg	13,400	lbs	29,480

Spindle

sub-assembly is carried within a set of highly accurate angular contact bearings.

Guideways

are of friction type. The basic ways are reinforced with hardened steel plates, the counterways on transverse and longitudinal saddles are provided with a cast layer of low friction plastic material.

Machine lubrication

is automatic, of redundancy type, with oil dosers employed.

Positioning rotary table

is equipped with an optic readout to ensure high accuracy of the 4x90° position setting.

Selection of optionals - subject to special order

- CHZ 10 tool cooling kit
- FP 40 - WH 10, HF 50 A vertical milling head
- UFP 40 - WH 10, HFU 50 A universal milling head
- UU 800, 950, 1,120 angle plates

