

Precision meets Motion



**Tool change in only
20 seconds**

Manual

***EWS* . Varia VX3 and VX4**

(applied for a patent)

EWS
Tool Technologies

Facts & Figures

EWS.Varia VX3

Application:
VDI 25/30 and BMT45/55 or comparable

Standard collet chuck:
RD/ER 25 430E (2-16)

Runout testbar
100mm < 20μ

Tmax:
160Nm

Tightening torque:
6Nm (torque wrench requested)

Tool change:
Ca. 20s

EWS.Varia VX4

Application:
VDI 40 and BMT65/75 or comparable

Standard collet chuck:
RD/ER 32 470E (3-20)

Runout testbar
100mm < 20μ

Tmax:
200Nm

Tightening torque:
6Nm (torque wrench requested)

Tool change:
Ca. 20s

1. Clamping the Varia insert in the tool



Make sure that the clamping ring is completely opened. Therefore turn the clamping screw anti-clockwise slightly until it stops.

Clean the interface with a cloth (do not use compressed air) and assemble the insert into the tool until it is plane. This is possible in 3 positions, respectively shifted by 120°.



Clamp the insert by turning off the Varia screw (1) clockwise and tighten it with **6Nm**.

Please note that an higher torque will lead to damage.



EWS Varia system guarantees plane tightening. Please check this through visual inspection.

The tool is now ready for operation.



To not damage the inserts only set up the collet chucks and milling arbors in the assembly jig MB-VX3 and MB-VX4 depending on the size. (see accessories)

EWS . Varia VX3/VX4

Manual

2. Removing the Varia insert out of the tool



Open the clamping ring by turning the Varia screw (1) anti-clockwise. The integrated mechanical expulsion system pushes the insert from the plane face. Turn the screw slightly against the stop.



Now you can remove the insert. Inject insert and tool after the cleaning with an oil (corrosion prevention).



The tool is now ready for the next operation.

3. Accessories

3.1. Assembly blocks

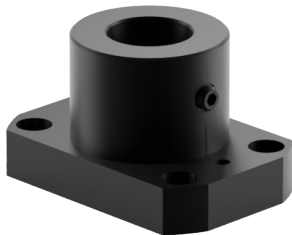


Universal assembly block: UMB100

Changeable tool adaptor

- EWS Varia VX3: MW-VX3
- EWS Varia VX4: MW-VX4

Changeable adaptors are also available in different forms.



EWS Varia assembly block

- EWS Varia VX3: MB-VX3
- EWS Varia VX4: MB-VX4



Torque wrench

- Article No. DSV SW5/05.7NM

Picture may differ from original product

EWS . Varia VX3/VX4

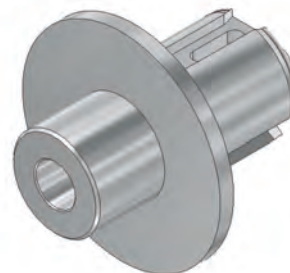
Manual

3.2. Varia inserts

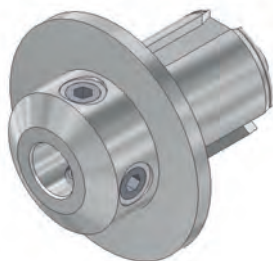
Collet chuck



Morse taper adaptor



Weldon / whistle notch insert



Floating toolholder collet chuck



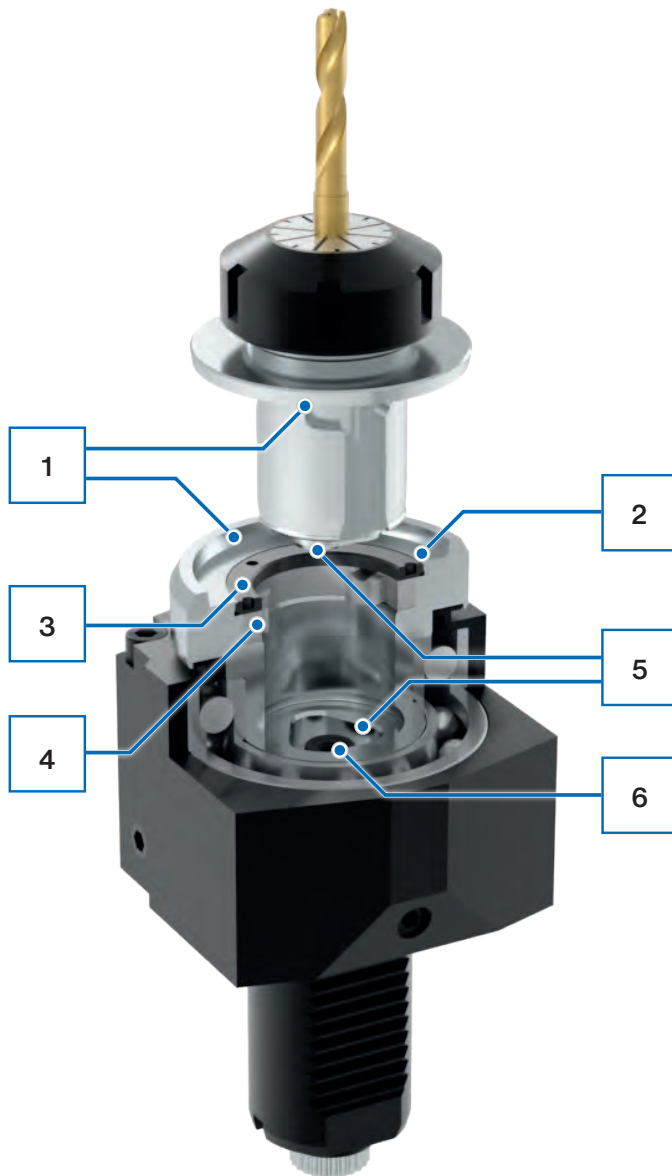
Millering insert



Hydrodehn insert



4. Details Varia VX3/VX4



1. Tapered fit for optimum runout
2. Dual contact
3. Threaded ring
4. Clamping ring with integrated „draw in“ and push out“ function
5. Polygon for torque transmission
6. Diametrical membrane seal

5. Advantages

- cutting tools are in place and ready at the machine
- quick change via just one clamping point
- no risk of injury during tool changes
- clamping of insets without any lateral forces
- safe torque transmission
- no loose parts



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