

Variomatic T3 Rotary Transfer Machines

are the result of the experience of many decades in the field of high-performance automated machine construction.

In all applications where parts are produced in series, where short cycle times are as important as a high repetitive accuracy and minimum resetting times, Variomatic machines have proven their worth as reliable high-performance units representing the latest in technology.

Variomatic T3 rotary transfer machines have been designed for use in the electrical industry, in the building industry (locks mountings and fittings), in apparatus and instrument engineering, in the automotive and automotive component industries and in many other branches.

With their modular construction, they offer a large number of combinations so that they can easily be adapted to the required machining job. A centrally driven system of cams provides for positively controlled movements guaranteeing maximum reliability and productivity.

The Variomatic T3 is well equipped for meeting the ever growing requirements in respect of production rates and quality, offering such features as:

- | quick adjustment of machining units in three axes
- | extremely short indexing times
- | high machining and repetitive accuracy
- | long service life under severe production conditions
- | cycle times up to 100 cycles/min

Variomatic T3



Variomatic T3 – key specifications

Feed control	mechanical via cams
Controllable axes	up to 22 axes
Resetting	resettable
Swivel chuck	can be swivelled from 0 - 360°
Swivel axes	mechanical
Parts/year	3 - 100 million
Workholding fixtures	9 or 11
Productivity (see also parts/year)	high productivity, in particular in the production of large batch sizes
Workpiece size	designed above all for smaller components of up to 20 mm in diameter, up to 30 mm in width/height and up to 60 mm in length, of brass, aluminium and steel, also suitable for larger components, depending on machining parameters (power and speed)



Designed for versatility

All movements in this mechanically driven machine are controlled via cams from a central drive.

The assemblies of the machine reflect the expertise and experience gained over many years.

The result:

Variomatic T3 is a machine that sets new standards of reliability. Thanks to its modular design, it can be used for a wide range of machining operations.



The modular nature of the Variomatic T3 enables operators to perform the following operations:

- | Drilling
- | Thread cutting
- | Necking
- | Broaching
- | Reaming
- | Counterboring and -sinking
- | Tumbling
- | Cutting
- | Turning
- | Deburring
- | Face turning
- | Chamfering
- | Assembling etc.

Customised machining: No problem for T3

The back drilling head takes the problem out of machining components from two sides on a station.

Double brackets allow vertical and horizontal machining operations to be performed simultaneously.

Using variable chucking methods, the machines are capable of machining parts with complex cross-sections.

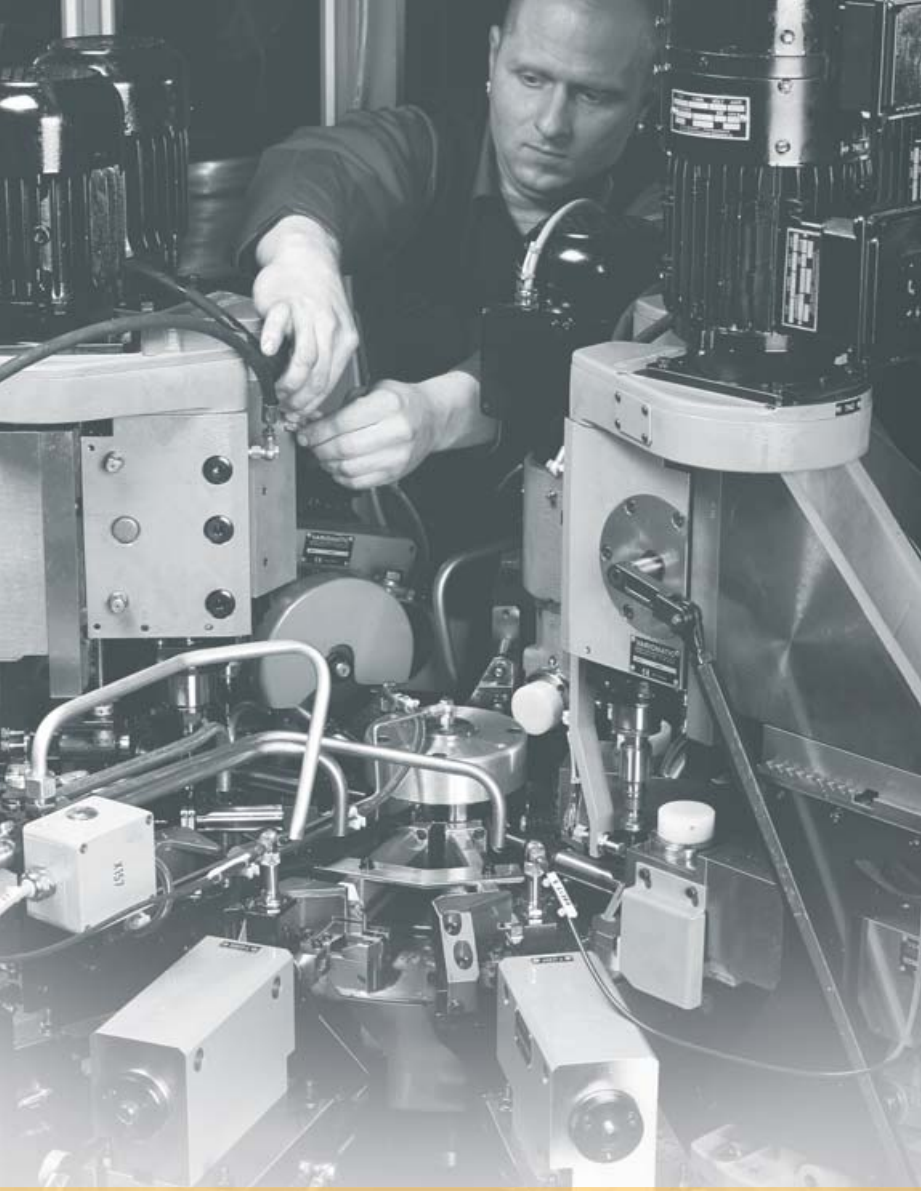
A particularly favourable feature:
Parts can be machined at any desired angle.

T3 – second to none in the world of indexing tables

- | Faster than all the rest:
Workpieces can be changed within 0.2 seconds with the Variomatic indexing table.
- | CAD-based calculation and engineering of feed cams minimises non-productive times. Even electronic controls are not able to match these results.
- | Variomatic T3 machines achieve production rates of up to 100 parts per minute. When 6 workpieces are chucked simultaneously, production rates of up to 360 parts/min become possible.

Variomatic T3





Exemplary availability: T3 – productivity on which you can rely

- | The machine has been designed to minimise the risk of failures.
- | In the very unlikely case of a defect, your own service personnel will be able to repair the machine so that you will not be forced to seek costly help from outside specialists.
- | If necessary:
Variomatic has all the spare parts you need in stock and will help without delay.
- | Ten to one:
One operator may attend up to ten Variomatic T3 machines.
- | Non-stop performance:
With their automated material feed, the machines will run year after year in three shifts.
- | Each Variomatic T3 comes with a detailed documentation.

T3
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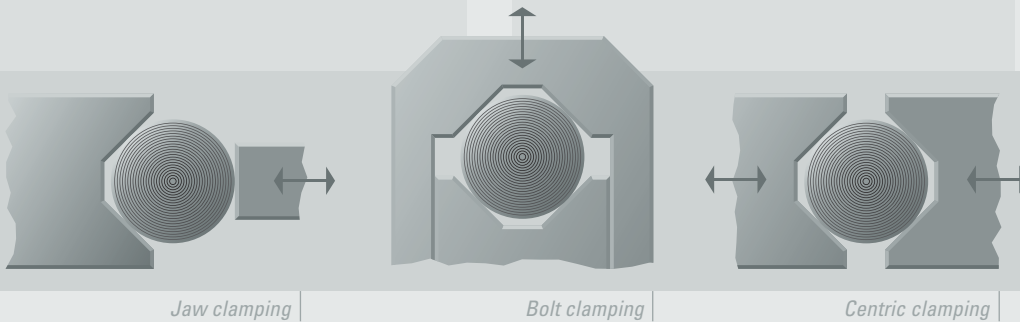


Precision to within 1/100 mm: T3 – machines of assured accuracy

- | The precise, wear-free interlocking mechanism makes for a high indexing accuracy of 0.01 mm throughout the entire service life of the machine.
- | To guarantee maximum precision, the machine's work clamping surfaces are ground in the mounted condition.
- | The mechanical driving system guarantees highest repetitive accuracy.
- | Chucking by two movable chuck jaws allows centric machining irrespective of tolerances (e. g. of an outside diameter's tolerance).

Peripheral equipment

The wide range of additional attachments are available for the Variomatic T3 and make it a machining system in the true sense of the word. The list below gives just a selection of the options available.



Variomatic is continuously designing and building new customised **attachments** to meet specific requirements. Consequently, this list will also be continuously extended and updated.

- | | |
|--------------------------------------|---|
| Supports | Stock feed devices |
| Collecting tanks and drop collectors | Sorting guides |
| Ejectors | Chip conveyors |
| Add-on machines (complete) | Bar loaders |
| Fume exhaust systems | Transfer devices |
| Gauging and testing equipment | Equipment for linking up- and downstream machines |
| Coolant units | Shifting attachments |
| Coilers | Vibrators with special feed attachments |
| Straightening devices | Feed attachments |



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