

of the latest E.E.C. electrical and mechanical safety regulations for the prevention of accidents.

Performance / Efficiency:

- The proven machine concept ensures the constantly high quality of the final products.
- Maximum flexibility with respect to range and shape of products.
- Optimum tap life and "ghost shift operation" via torquemeter.
- Easy tapping of English, metric and BSW threads as well as right and left

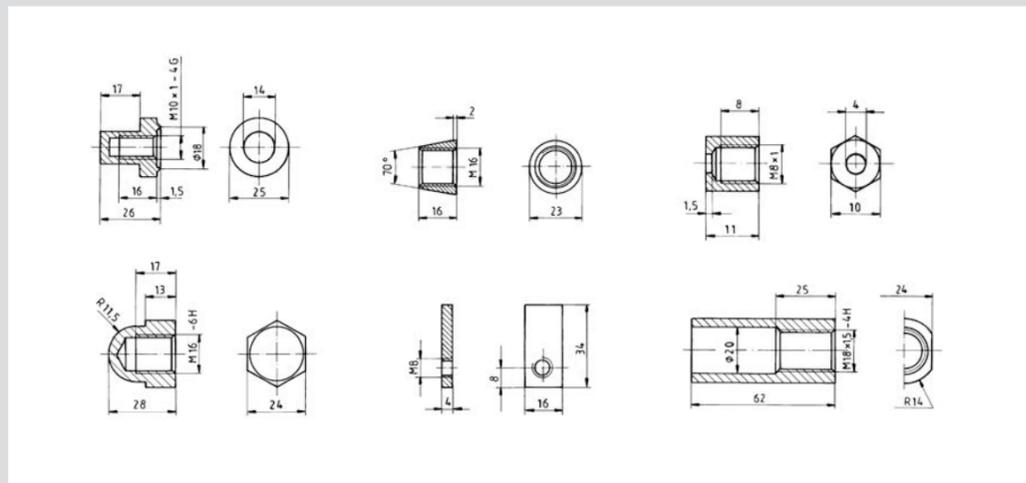
- hand threads.
- Improved productivity due to fast motions and increased availability.
- Increased tap life and minimum machine wear due to efficient coolant treatment.
- Mechanical and electrical safety devices ensure the maximum protection for all staff and the machine.

VARIMAC

Technical Data:

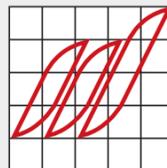
	VARIMAC 10	VARIMAC 20	VARIMAC 30
Thread dimension	M4 - M12 1/8" - 1/2"	M6 - M20 1/4" - 3/4"	M16 - M33 5/8" - 1.3/4"
Spindelanzahl	1	1	1
Max. outside diameter of parts	25 mm	50 mm	80 mm
Max. length of parts	70 mm	70 mm	100 mm
Power of spindle motor	5,9 kW	6,9 kW	13,2 kW
Speed range	0 - 4000 rpm	0 - 2300 rpm	0 - 1400 rpm
Steuerung der Maschine	SPS	SPS	SPS
Max. output	3000 pcs/h	2700 pcs/h	pcs/h
Coolant volume	150 l	150 l	180 l
Net/gross weight	1900/2280 kg	1900/2280 kg	3200/4000 kg
Dimensions (LxWxH) mm	2100x980x1900	2100x980x1900	2700x1165x2050

Subject to technical modification



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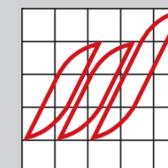
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Streicher
GEWINDETECHNIK

AUTOMATIC REVERSING SINGLE-SPINDLE TAPPING MACHINE

VARIMAC



Streicher
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VARIMAC

The result of decades of experience combined with the latest techniques concerning thread production and the application of advanced technologies is our **Automatic Reversing Single-Spindle Tapping Machine "VARIMAC"**

The advanced, perfected performance and shape of this machine sets new standards in terms of versatility, precision of manufactured parts, performance and optimum efficiency.

Field of Application:

The machine is suitable for the efficient boring, counterboring and tapping of blind, shouldered and tubular parts, all types of

nuts and similar parts such as punched, turned, forged or cast parts.

The Varimac models 10, 20 and 30 cover thread sizes of M3 to M36 and handle component maximum outside diameters of up to 80 mm, with maximum lengths up to 100 mm.

Handling:

The handling of the machine is extremely simple and can be learnt easily by unskilled operators. The clear machine construction requires only the minimum maintenance and service. The ergonomic, internally lit, well arranged working area ensures easy access and control of all tools and machine parts. The electrically locked protection doors offer increased operating convenience in line with maximum safety. The changing of tools can be realized easily and within the shortest possible time.

Operation / Working Mode:

The automatic feed of the work pieces is realized by a barrel hopper feed or an electromagnetic vibrator conveyor. An indexing ring which is driven discontinuously by a step-by-step motion linkage, ensures the part transport from the feed channel to the clamping or working position and, from there, to the output position. The radial and axial clamping of the work pieces without run-out is realized by a pneumatic cylinder controlled by limit switches. Depending on the requirements, the order of the clamping cylinders can be changed by a selector switch.

The Varimac is provided with a coolant container that has a large capacity which always ensures a continuously low coolant temperature even when multi-shift operations are in use.

For the thread feeding, the standard model includes a lead screw with accurate thread pitch, so ensuring a completely neutral tapping operation without detrimental pressure or tension on the thread flanks. English, metric and BSW threads, as well as right and left hand threads can be tapped. For special applications, a pneumatic feed



Working area

system is available. A hydropneumatic feed is used for boring in the solid. The spindle being equipped for the fixing of different quick change chucks.

Drive:

The work spindle is driven by a powerful reversing rotary current motor, via a belt and exchangeable pulleys. For increased dynamic requirements a frequency-controlled servomotor is available. Advance and return speeds are continuously variable and can be set separately.

Control:

The robust, electronically programmed control ensures the coordination and control of all motions, this considerably increases the easy handling of the machine. Electronic control, essential for all modern, advanced machines, ensures that any incorrect handling operation is ignored.

Upon request, a precisely adjustable torque meter for switching off the machine in case of a blunt tool is available. With this attachment fitted optimum tap life is ensured, increased productivity also becomes available via unmanned operation. Furthermore an interface for external connection to a data retrieval system can be provided if requested.



electric compartment



back view

Chip disposal / Coolant:

The standard version uses a chip box for collecting the chips that are produced. However, it is recommended that a magnetic drum or conveying belt be incorporated in the machine body, for transporting the nearly dry chips out of the machine. The almost oil-free finished parts are then transported, free from chips, either to the internal collecting box or to an external container. The new filtration system ensures the efficient and reliable elimination of the finest chips and rubbed-off parts. This gives a maximum tap life and a considerable reduction to the wear taking place to

all moving parts. This ensures that the optimum working conditions are maintained for an increased period of time.

Machine Design / Construction:

The pleasant and modern appearance of the machine is due to the appealing design and the use of two-colour painting. The retracted tool table bearer increases its stability and ensures ergonomically correct conditions for the operators. The design and construction of the machine corresponds to the latest state of the art technology, and meets the requirements

