

# TECHNOLOGICAL SHEET No. 4

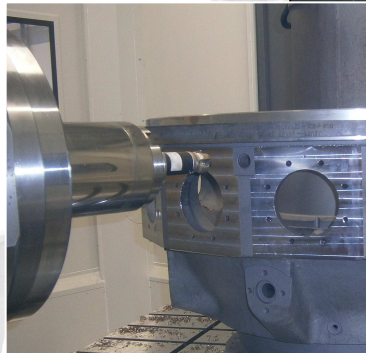
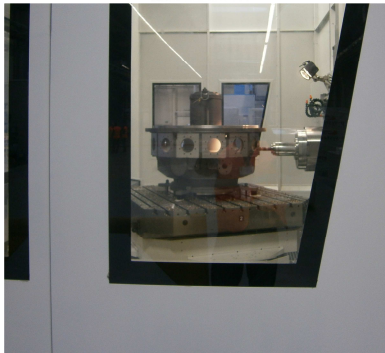
www.tosvarnsdorf.eu

Complete overhaul of compressor diffuser

## SOLUTION OF CUSTOMER TECHNOLOGY

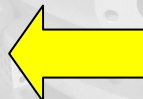
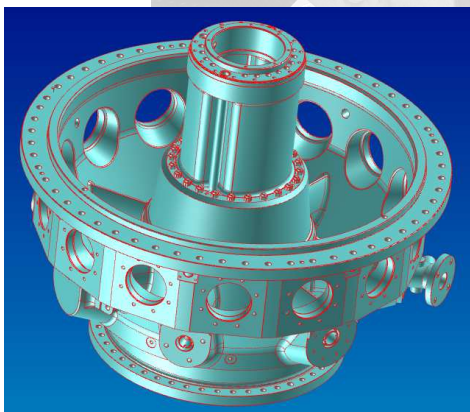
**New goals need new solutions**

Presentation of **WHN 130 MC** milling machine technological usage by the complete overhaul of compressor diffuser.



### The machining parameters

Workpiece material	cast iron
Hardness	156-217 BHN
The surface roughness	Ra 1,6
Table positioning	0,001°
The faces flatness	0,005 mm



On the machine were realized following technological operations:

- face milling of the surfaces around the workpiece perimeter on the table rotation
- drilling of holes in max. diameter of 160 mm
- HUI 50 milling head application

**TOS VARNSDORF a.s.**

# Horizontal milling and boring machine WHN 130 (Q, MC)



Up-to-date machine tool for an effective machining of non-rotary workpieces of medium size and weight from cast iron, cast steel and steel, employing the partprograms of the most progressive technological features. Machine design and working place arrangement can be modified according to the customer's needs.

## Technical specifications

Working space – max. travels		
Table transverse travel X	mm	up to 4,000
Headstock vertical travel Y	mm	up to 2,500
Column longitudinal travel Z	mm	up to 2,000
Headstock „R“ with traveling spindle		
Spindle diameter	mm	140
Spindle speed range	RPM	10 – 3,000
Main motor power (S1/S6)	kW	37 / 46
Spindle stroke W	mm	560
Headstock „R“ with traveling spindle		
Spindle diameter	mm	130
Spindle speed range	RPM	10 – 2,500
Main motor power (S1/S6)	kW	37 / 46
Spindle stroke W	mm	800
Table		
Workpiece weight max	kg	12,000
Clamping surface	mm	1,600 x 1,800
		1,800 x 2,240
Automatic pallet change		
Number of pallets in system		2
Workpiece weight max	kg	8,000
Pallet clamping surface	mm	1,600 x 1,800
Time of pallet change	sec	85
Feeds		
Feed range – X, Y, Z, W	mm.min <sup>-1</sup>	1 – 6,000
Feed range – B	min <sup>-1</sup>	0,003 – 1,5
Rapid traverse – X, Y, Z, W	mm.min <sup>-1</sup>	10,000
Rapid traverse – B	min <sup>-1</sup>	2



**FURTHER INFORMATION**  
**YOU CAN FIND ON OUR**  
**WEBSITE**

**[www.tosvarnsdorf.eu](http://www.tosvarnsdorf.eu)**



**[www.tosvarnsdorf.eu](http://www.tosvarnsdorf.eu)**