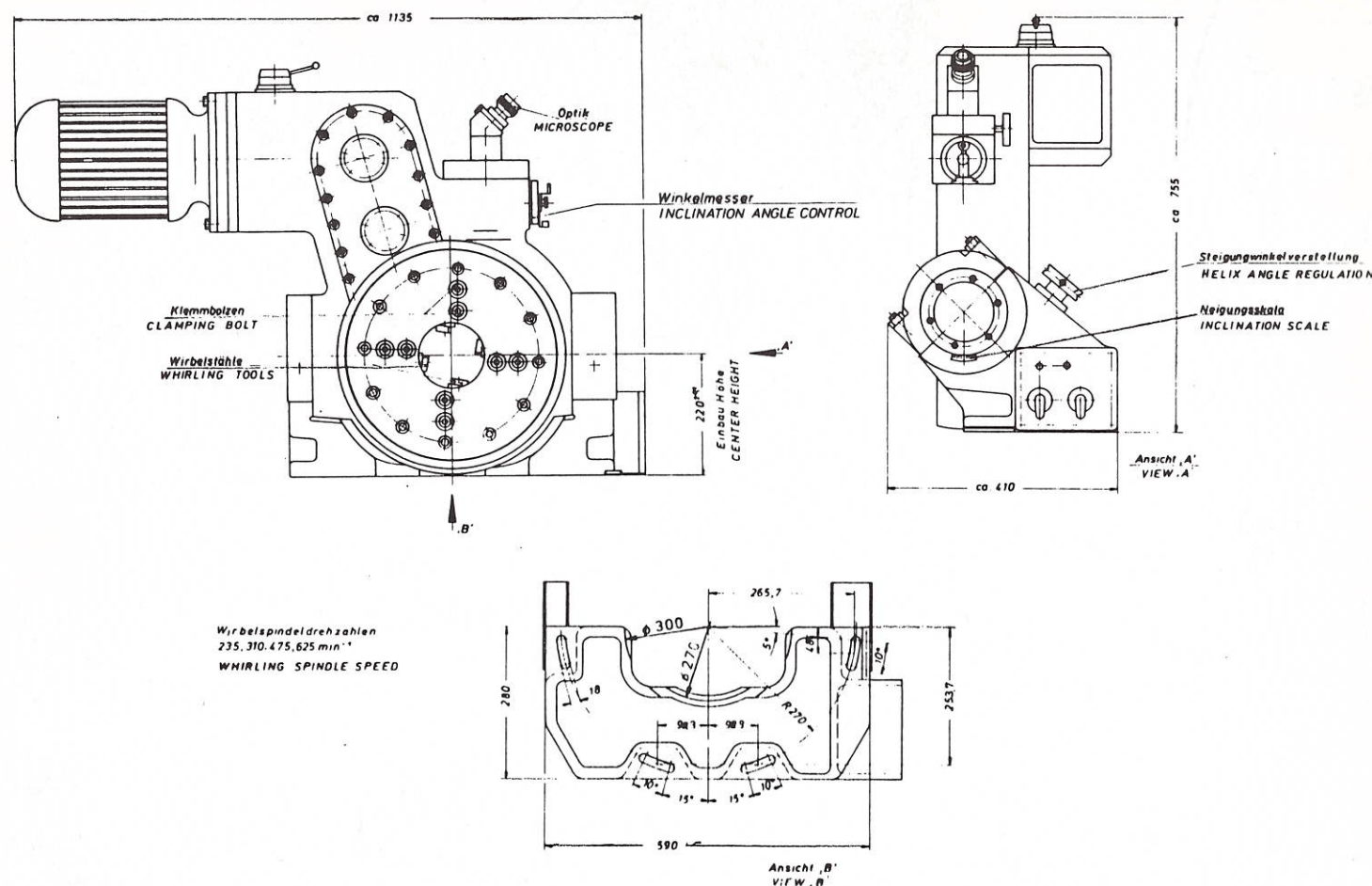


Installation Dimensions Whirling Unit Type L 4



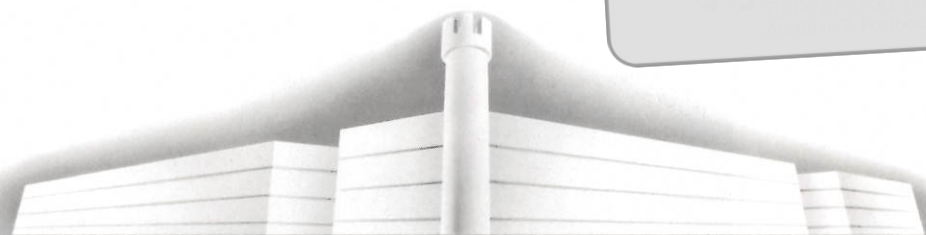
Technical Data

Center height:	220 mm above machined surface of cross slide
Bore of the tool holder ring location:	250 mm
Helix angle setting right:	29°
Helix angle setting left:	25°
Max. adjustable tool point circle:	216 mm
Min. adjustable tool point circle:	68 mm
Motor rating:	4.9/5.9 kW
Motor speed:	1 : 4.48
Speed change gears:	1 : 4.48
	1 : 6.15
Tool holder ring output speed:	235 - 310 - 475 - 625 rpm
Max. workpiece dimensions:	210 mm
Min. workpiece dimensions:	50 mm

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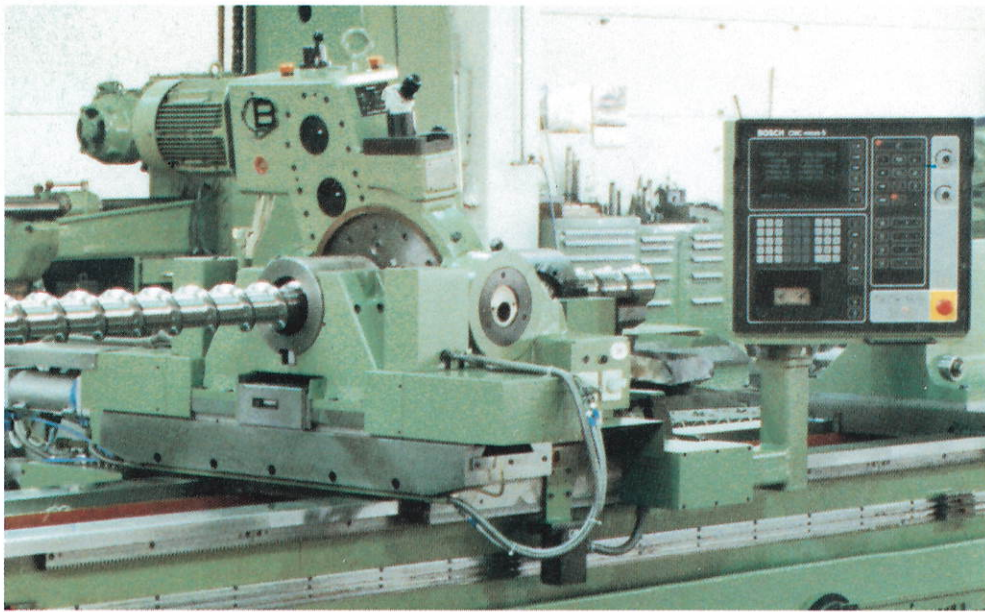
Telefon 05563/6006 • Telex 965603 bgmkr • Telefax 05563/6423

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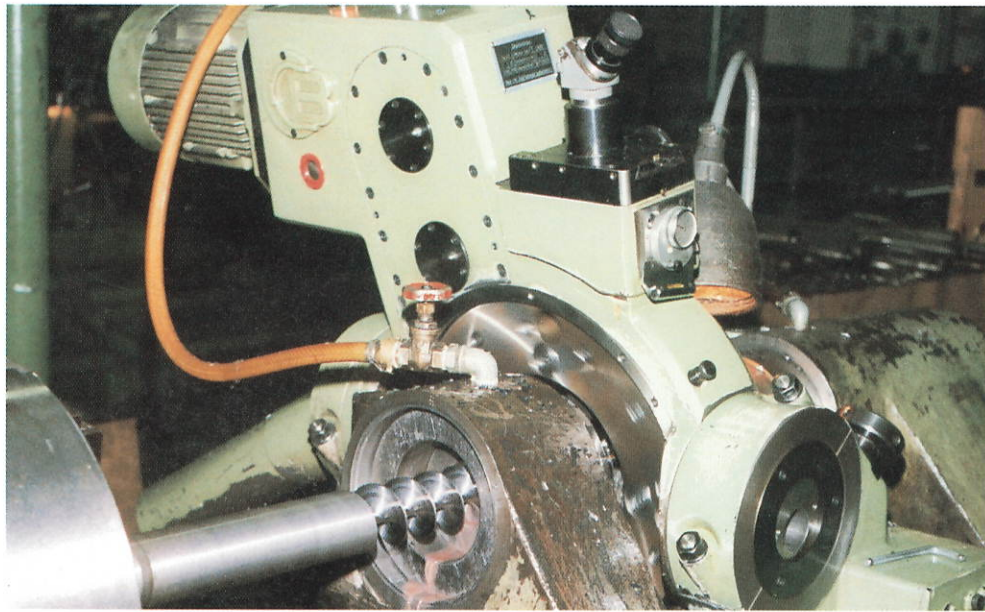
Burgsmüller

wirbel Information

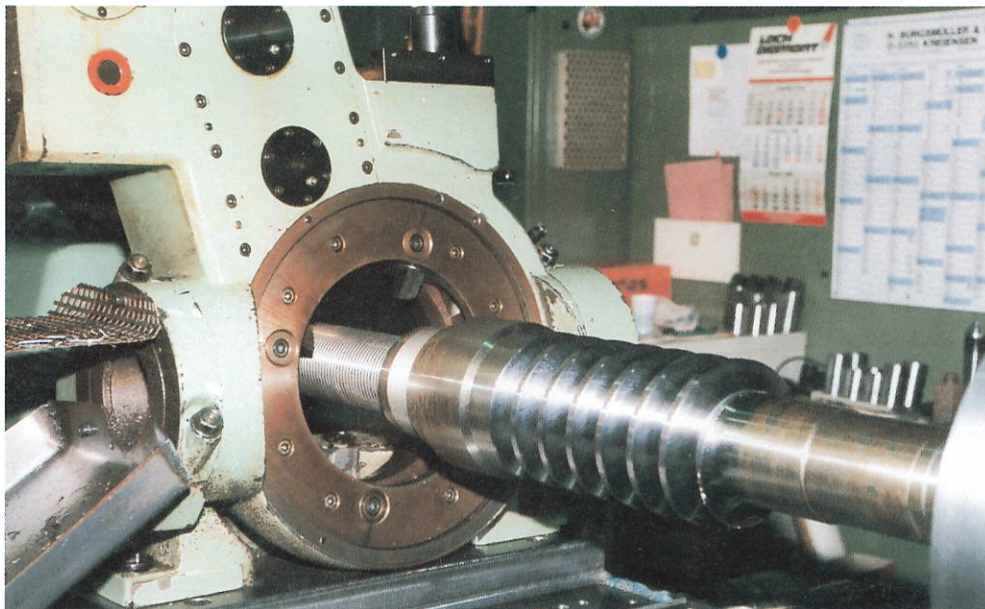
Whirling Unit L 4



Whirling of an extruder worm with tapered core, diameter 115 mm



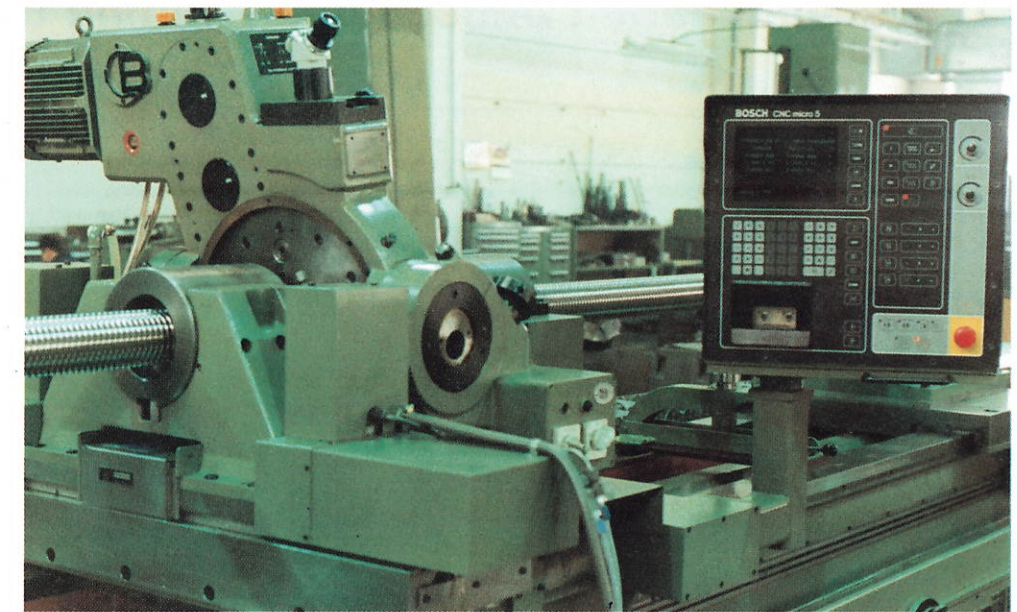
Whirling of a proporing worm, external diameter 82 mm, minor diameter 13.5 mm, land width 2.5 mm



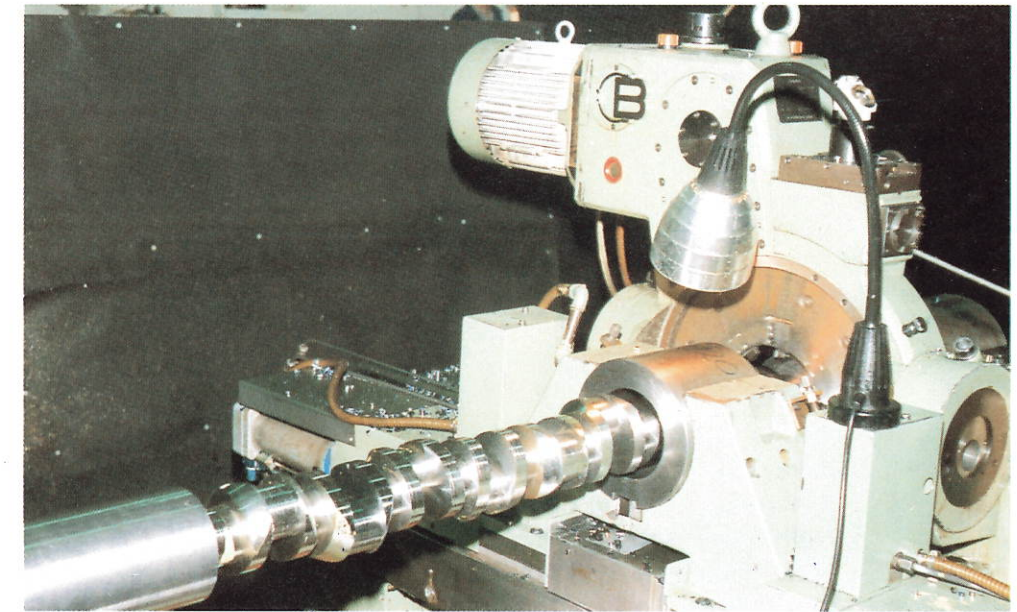
Whirling of a gear worm, external diameter 150 mm, module $m = 12$ mm

Realized versatility demonstrated with the Burgsmüller Thread Whirling Attachment Type L 4

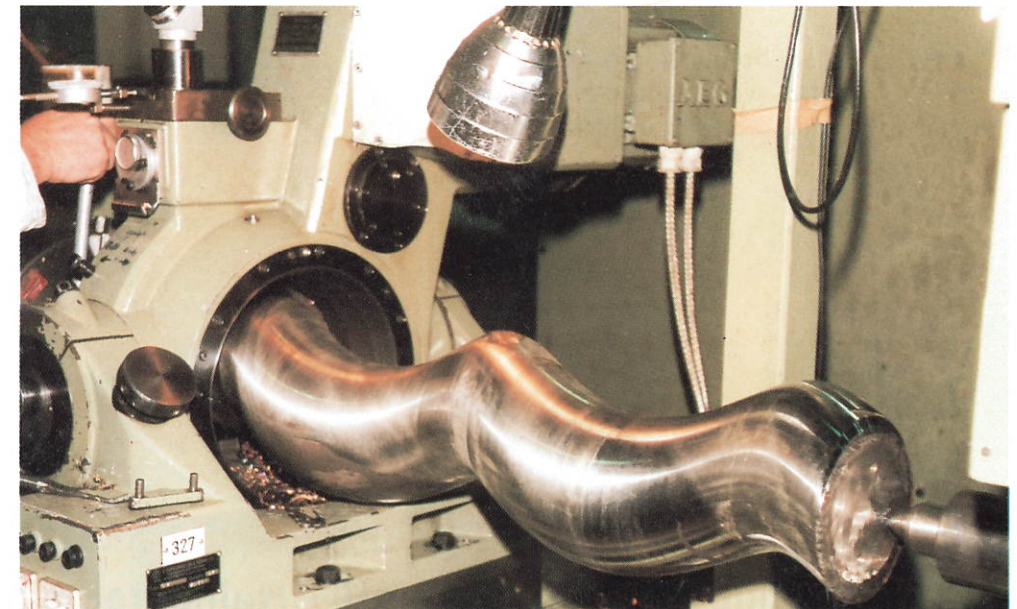
- One conception module
- One attachment
- Multiple application possibilities
- The application - oriented flexible tooling system grants machining of different workpiece profiles.
- The workpiece determines expenses and therefore the necessary production machine tool.
The workpiece in question determines only the employment of standard throw-away tips or profile-ground cutting tips, whether 4 - 6 or 8 tools are used and which toolholder ring has to be used.
- Seperate tool pre-setting grants production time utilization.
Optical micro-tool setting grants high precision.
Easy handling grants acceptance.
Combined with NC-techniques the attachment represents an extremely economical machining procedure.



Whirling of a ballscrew, diameter 80 mm, pitch 10 mm



Whirling of a crankshaft, total stroke 72 mm



Whirling of an eccentric worm, workpiece diameter 210 mm, eccentricity 30 mm