

Fully equipped leading and feed spindle lathes.

TH 3309D with digital position display DPA 21, TH 3309V with brushless motor for continuous speed control and digital position display DPA 21

Facts that impress in terms of quality, performance and price

- ▶ Tempered and polished z-axis guideway
- ▶ Spindle collet Camlock DIN ISO 702-2 no. 4
- ▶ Guaranteed concentricity of spindle nose better than 0.015 mm
- ▶ Motor circuit breaker (TH 3309 / TH 3309D)
- ▶ DC 24-Volt electric system with two-channel safety circuit as per EN 23125
- ▶ Lockable main switch
- ▶ Clockwise/anti-clockwise rotation switchable on bed slide
- ▶ Leading spindle cover
- ▶ Machine chassis and tool compartment on right-hand side
- ▶ Safety hand wheels with release function in the X and Z axis
- ▶ Emergency stop device with foot pedal

Control cabinet

- 24 Volt DC adapter
- All contactors and relays by Siemens or Schneider - TH 3309V by Eaton



Slide

- Precise workmanship
- Hand wheels with adjustable fine scaling 0.04 / 0.02 mm
- Four x tool holder
- All guides adjustable using wedge rails
- Adjustment range top slide ± 90°

TH 3309D / TH 3309V

Digital position display DPA 21

- › User-friendly membrane keyboard, splash water protected, sealed and dazzle free
- › Clear reduction of manufacturing times
- › Greater operation accuracy
- › Reduction of error quota
- › X, Z, Z axis each with 8-digit display
- › Clear-cut keyboard layout
- › Glass scales

TH 3309V

- ▶ Smooth action and powerful brushless drive
- ▶ Speed change easily adjustable via potentiometer

TH 3309V:

Powerful brushless drive

- Particularly smooth action
- Virtually constant torque over the entire speed range
- High usable performance



Prism bed

- With pronounced ribbing
- Induction tempered
- Precision ground

TH 3309D / TH 3309V

- Digital position display DPA 21

Main spindle

- Running in oil bath
- Gearwheels easy action, tempered and ground

Hand wheels

- Decoupled
- tested in accordance with EN 23125

Switch

- With lifecycle calculation
- tested in accordance with EN ISO 13849

Chip tray

- Pulls out
- Guide rails

Machine chassis

- With 3 covers (no compartments)

Chuck protection

- tested in accordance with EN 23125

LED machine lamp

- Integrated into chip guard

Tailstock

- Adjustable ±10 mm for turning balls
- Tailstock spindle sleeve and hand-wheel with adjustable fine scaling 0.025 mm

Clockwise/anti-clockwise switch

- Two channel
- tested in accordance with EN 23125

Tool compartment



Fig.: TH 3309D - Shown with optional lathe chuck

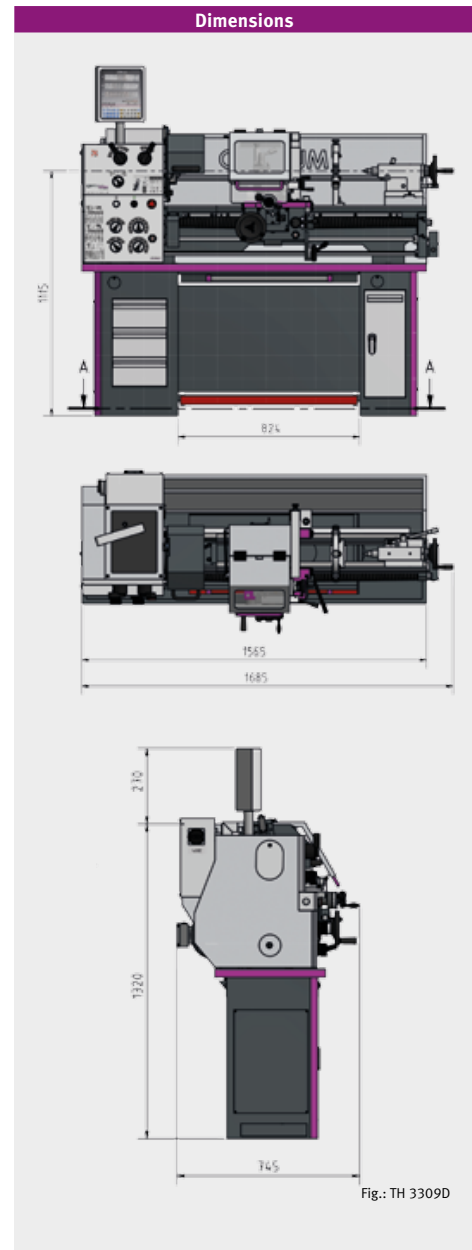
The Vario lathe complies with the DIN EN 55011 standard: class C1

Technical specifications, accessories and dimensions

Model	TH 3309	TH 3309 D	TH 3309 V
Article no.	3402030	3402040	3402045
Technical specifications			
Electrical connection	400 V/3 Ph	230 V/1 Ph	
Spindle			
Drive motor	1.5 kW	2.2 kW	
Spindle taper	MT 5		
Spindle holder	Camlock DIN ISO 702-2 No. 4		
Spindle bore, bar passage diameter	Ø 38 mm		
Four x tool holder mounting height	16 mm		
Technical specifications			
Max. height	165 mm		
Max. width	830 mm		
Orbit Ø above machine bed	330 mm ⁽¹⁾		
Orbit Ø without bed bridge	448 mm		
Turning length in bed bridge	196 mm		
Speed range			
Spindle speed	70 - 2,000 rpm	15 - 2,250 rpm	
Number of gears	16 speeds	8 speed, elec. controlled	
Strokes			
Top/cross slide stroke	98 mm / 164 mm		
Feeds and pitches			
Longitudinal feed within the range	0.052 - 1.392 mm/rev (32 feeds)		
Cross feed within	0.014 - 0.38 mm/rev (32 feeds)		
Pitch - metric in range	0.4 - 7 mm/rev (26 pitches)		
Pitch - inch in range	56 - 4 turns/inch (34 pitches)		
Tailstock			
Tailstock chuck	MT 3		
Tailstock spindle sleeve diameter/ stroke	Ø 32 mm/110 mm		
Dimensions			
Length x width x height	1,685 x 745 x 1,320 / 1,590 mm		
Net weight	430 kg		
Transport packaging flat rate**	TPFR 2		

Accessories	Art no.
► lathe chuck	
OPTIMUM three-jaw lathe chuck Ø 160 mm no. 4, centric	3442761
OPTIMUM three-jaw lathe chuck Ø 200 mm no. 4, centric	3442762
OPTIMUM Four-jaw lathe chuck Ø 160 mm no. 4, centric	3442840
OPTIMUM Four-jaw lathe chuck Ø 200 mm no. 4, centric	3442843
OPTIMUM Four-jaw lathe chuck Ø 200 mm no. 4, individual	3442879
BISON three-jaw lathe chuck Ø 160 mm no. 4, centric	3450305
BISON three-jaw lathe chuck Ø 200 mm no. 4, centric	3450310
BISON Four-jaw lathe chuck Ø 160 mm no. 4, centric	3450355
BISON Four-jaw lathe chuck Ø 200 mm no. 4, centric	3450360
► Tool holders and lathe tools	
Quick change tool holder SWH 3-E	3384303
Factory assembly SWH 3-E	9000400
Spare tool holder 20 x 100 type D for square chisels	3384304
Spare tool holder 30 x 100 type H for round chisels	3384322
Lathe tool set 16 mm, 5-part "Made in Germany"	3441216
Lathe tool set 16 mm, 5-part	3441610
► Accessories	
Collet chuck 5C	3441554
Spring collet set 3 - 25 mm 5C, 17 kg	3441509
Position stop with granular adjustment	3441522
Vibration-damping machine base SE2 (6 pcs. required)	3381016
► More „Accessories Turning“ on page 148	

** PTO for an explanation of the packaging surcharges; details of TPFR plus VAT.
(1) Explanation see „General notes on operating our machines“ on page 211



**Remember to order
a lathe chuck**

Scope of Delivery
• Fixed steady passageway Ø 19 - 70 mm
• Travelling steady passageway Ø 16 - 50 mm
• LED machine lamp
• Reduction sleeve MT 5 - MT 3
• Two fixed centres MT 3
• Quadruplicate tool holder 16 mm
• Set of interchangeable gears
• Machine chassis
• Machine initially filled with premium grade oil
• Operating tool