

**Precision leading and feed spindle lathes – unique in terms of precision and control. With DPA 21 digital position display and quick change tool holder. TH 4615V featuring Siemens inverter Vario drive**

**Facts that impress in terms of quality, performance and price**

- ▶ Tempered and polished z-axis guideway
- ▶ Coolant system featuring separate coolant tank, fill level display and oil trap; easy and complete draining and cleaning as per DIN
- ▶ Guaranteed concentricity of spindle nose better than 0.015 mm
- ▶ Clockwise/anti-clockwise rotation switchable on bed slide, switchable via switching spindle
- ▶ Mechanical longitudinal feed switch-off of bed slide with four configurable eccentrics
- ▶ Leading spindle cover
- ▶ Emergency stop device with foot pedal
- ▶ Electrical system with Siemens components
- ▶ Safety hand wheels with release function in the X and Z axis
- ▶ Scale on thread gauge adjustable
- ▶ Central lubrication in bed slide
- ▶ Quick change tool holder SWH 5-B
- ▶ Tool holder 25 x 120 type D for square chisels

**Main spindle**

- Tempered and ground
- Running in oil bath
- Borne on 2 adjustable precision taper roller bearings
- Gearwheels easy action, tempered and ground

**Quick shift feed gear**

- Closed design
- Gearwheels and shafts tempered and ground
- Running in oil bath on precision bearings

**Switch**

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

- ▶ Digital position display DPA 21
  - > Rev counter
  - > Clear reduction of manufacturing times
  - > Greater operation accuracy
  - > Reduction of error quota
  - > Glass scales

**TH 4615V:**

- Siemens Sinamics frequency inverter / Safety Integrated
- ▶ Speed monitoring in line with Machinery Directive

**Control cabinet**

- 24 Volt DC adapter
- All contactors und relays by Siemens or Schneider - TH 4210V by Eaton



**TH 4615V: Inverter SINAMICS G120D**



More information: „Siemens frequency inverter SINAMICS G 120D“ auf Seite 144

**Slide**

- Precise workmanship
- Hand wheels with adjustable fine scaling 0.04 / 0.02 mm
- All guides adjustable using wedge rails
- Gears and shafts running in oil bath
- Adjustment range top slide ± 90°

**Cable guidance**

- Via energy chain (as of TH 4615)

**Hand wheels**

- Decoupled
- tested in accordance with EN 23125

**Chip guard**

- Generously dimensioned
- Integrated LED machine lamp

**Tailstock**

- Adjustable ± 15 mm for turning balls
- Tailstock spindle sleeve and hand-wheel with adjustable fine scaling 0.025 mm

**Clockwise/anticlockwise switch**

- Two channel
- tested in accordance with EN 23125

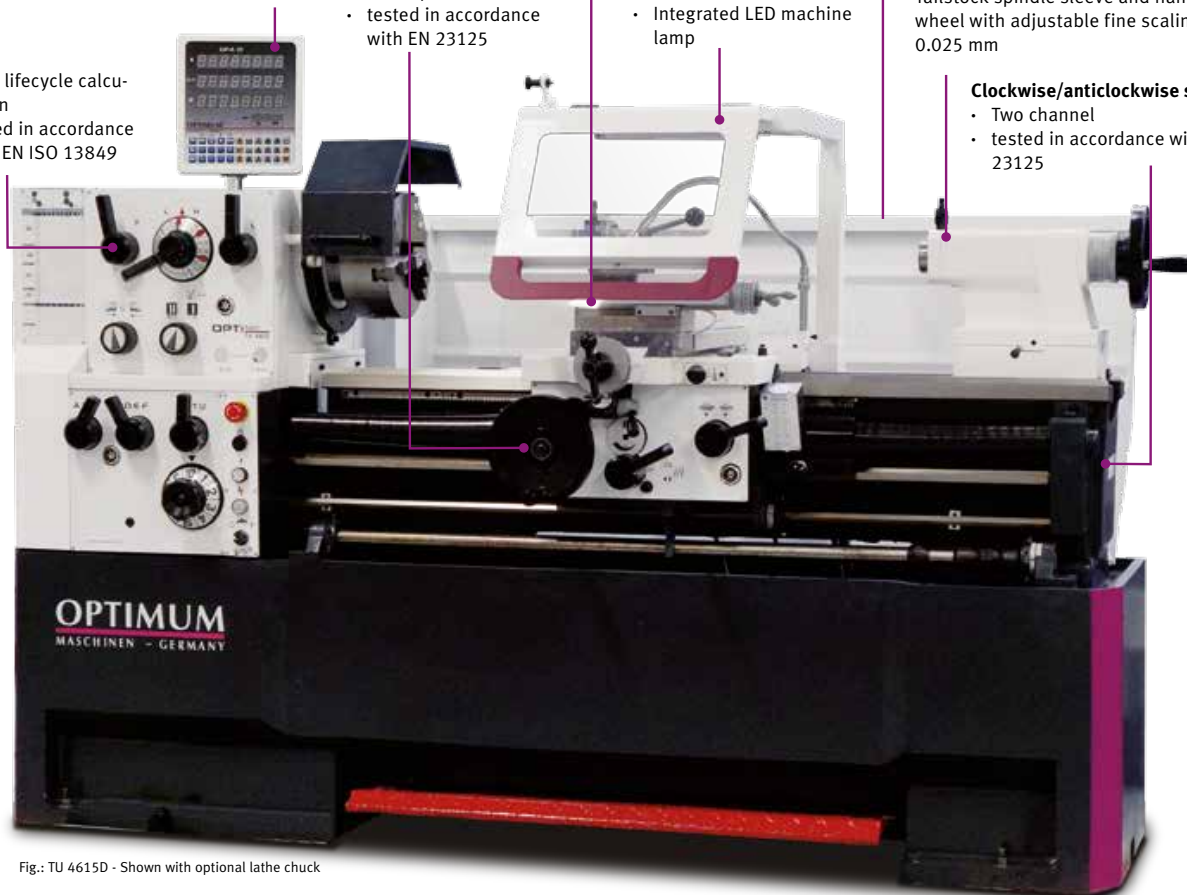
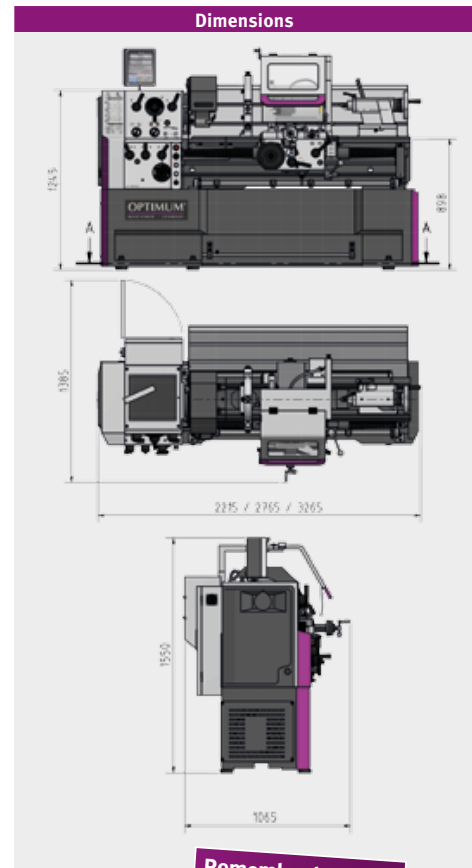


Fig.: TU 4615D - Shown with optional lathe chuck

## Technical specifications, accessories and dimensions

<b>Model</b>	<b>TH 4610D</b>	
Article no.	3462110	
<b>Model</b>	<b>TH 4615D</b>	<b>TH 4615V</b>
Article no.	3462120	3462125
<b>Model</b>	<b>TH 4620D</b>	
Article no.	3462130	

Technical specifications		
Electrical connection	400 V / 3 Ph ~50 Hz	
Total connected load	5.8 kW	8.5 kW
Spindle		
Drive motor	5.5 kW	7.5 kW
Spindle taper	MT 6	MT 7
Spindle holder	Camlock DIN ISO 702-2 No. 6	Camlock DIN ISO 702-2 No. 8
Spindle bore, bar passage diameter	Ø 58 mm	Ø 80 mm
Work area		
Max. height	230 mm	
Max. width TH 4610D	1,060 mm	
Max. width TH 4615D / TH 4615V	1,560 mm	
Max. width TH 4620D	2,060 mm	
Orbit Ø above machine bed	460 mm <sup>(1)</sup>	
Orbit Ø above cross slide	270 mm	
Orbit Ø in the bed bridge	690 mm	
Turning length in bed bridge	240 mm	
Bed width	300 mm	
Speed range		
Spindle speed	25 - 2,000 rpm	30 - 2,000 rpm
Number of gears	12 gears	elec. control
Strokes		
Top slide stroke	125 mm	
Cross slide stroke	285 mm	
Feeds and pitches		
Longitudinal feed within the range	0.031 - 1.7 mm/rev (42 feeds)	
Cross feed within	0.014 - 0.784 mm/rev (42 feeds)	
Pitch - metric in range	0.1 - 14 mm/rev (41 pitches)	
Pitch - inch in range	112 - 2 turns/inch (41 pitches)	
Diametral pitch in range	4 - 112 (50 threads)	
Modular thread in range	0.1 - 7 mm/rev (34 thread)	
Tailstock		
Tailstock chuck	MT 4	
Spindle sleeve diameter / stroke	Ø 60 mm / 130 mm	
Dimensions		
Length	2,215 / 2,765 / 3,265 mm	
width x height	1,065 x 1,550 mm	
Net weight	1,720 / 1,977 / 2,400 kg	2,020 kg
Transport packaging flat rate**	TPFR 4 / TPFR 5	



### Scope of Delivery

- Fixed steady passageway max. Ø 160 mm
- Travelling steady passageway max. Ø 100 mm
- LED machine lamp
- Reduction sleeve MT 6/MT 4 (TH 4210D-TH 4620D)
- Reduction sleeve MT 7 / MT 4 (TH 4615V)
- Fixed centre MT 4
- Quick change tool holder 5-B
- Tool holder 25 x 120 type D for square chisels
- Thread gauge
- Position stop with granular adjustment
- Set of interchangeable gears
- Machine initially filled with premium grade oil
- Operating tool

Lathe chuck	Art no.
<b>▶ OPTIMUM lathe chucks</b>	
<b>Three-jaw lathe chuck</b> Ø 250 mm no. 6, centric	3442765
<b>Four-jaw lathe chuck</b> Ø 250 mm no. 6, centric	3442852
<b>Four-jaw lathe chuck</b> Ø 250 mm no. 6, individual	3442884
<b>Four-jaw lathe chuck</b> Ø 315 mm no. 8, centric	3442856
<b>Four-jaw lathe chuck</b> Ø 315 mm no. 8, individual	3442888
<b>▶ BISON lathe chucks</b>	
<b>Three-jaw lathe chuck</b> Ø 250 mm no. 6, centric	3450330
<b>Four-jaw lathe chuck</b> Ø 250 mm no. 6, centric	3450380
<b>Three-jaw lathe chuck</b> Ø 250 mm no. 8, centric	3450331
<b>Four-jaw lathe chuck</b> Ø 250 mm no. 8, centric	3450381
<b>Four-jaw lathe chuck</b> Ø 315 mm no. 8, centric	3450385

Tool holders and lathe tools	Art no.
<b>Spare tool holder</b> 25 x 120 Type D for square chisels	3384306
<b>Spare tool holder</b> 32 x 130 type H for round chisels	3384324
<b>Lathe tool set</b> HM 20 mm, 5-part	3441670
<b>Lathe tool set</b> HM 20 mm, 5-part	3441617
<b>▶ Clamping disc</b>	
<b>Clamping disc</b> Ø 350 mm no. 6	3442980
<b>Clamping disc</b> Ø 450 mm no. 8	3442982
<b>▶ Accessories</b>	
<b>Universal collet chuck device</b> 5C (not Vario)	3441507
<b>Spring collet set</b> 3 - 25 mm, 5C, 17-part	3441509
<b>Vibration damping base</b> SE 3 (6 pcs. needed)	3381018
<b>Collet chuck</b> 5C - Camlock no. 6	3441556

\*\* 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