

Tandem Underfloor Wheel Lathe

Type 106 D CNC

Tandem Underfloor Wheel Lathe

The tandem arrangement allows the machining of two vehicle mounted wheel sets at the same time by arranging two underfloor wheel lathes at one track.

This arrangement is recommendable if:

- the desired number of machining operations can not be effected with one machine,
- the number of wheel sets to be machined per vehicle can not be done within a certain time (i.e. between the peak hours),
- two wheel sets have to be machined to a very similar diameter (i.e. electrically coupled motor wheel sets of high speed trains).



Machining possibilities / Fields of application of the Tandem Underfloor Wheel Lathe Type 106 D CNC



- Machining of two wheel sets at the same time
- Turning of wheel tyre profiles on wheel sets in situ
- Machining of brake discs on wheel sets in situ
- Machining of single wheel sets
- Machining of coupled wheel sets
- Machining of wheel sets of different gauges

on all Mainline Railway, Metro and Tram vehicles

Main Dimensions and Operating Data

Subject to technical changes

Wheel Base Tandem	min	2.200 mm
Displacement.....		700 mm
or according to requirements		
Track gauge as requested.....	e.g.	1.435 mm
Tread diameter.....		500 – 1.400 mm
Max. axle load.....		300 kN
Weight	appr.	30.000 kg
Length.....	appr.	7.000 mm
Width.....	appr.	8.000 mm
Depth.....	appr.	2.600 mm

Machining accuracies

Max. diameter difference of the wheels of an axle.....		0,15 mm *
of all wheels of a bogie		0,3 mm *
Radial run-out, measuring circle plane		0,1 mm *
Deviation from lateral run-out.....		0,3 mm
Shape error of profile.....		0,2 mm *
Surface quality profile	Ra	11 - 12 µm

*)In the case of rubber-sprung wheel sets, the value may increase by up to 0.3 mm.

Machine data

Drive rating.....		2 x 30 kW
Operating Voltage.....		400 V / 50 Hz
Control Voltage		230 V / 50 Hz
Cutting speed, profile machining.....		4 – 128 mm
Feed range.....		0,1 – 2,5 mm/U
Chip cross section tool post.....	ca.	6 – 7 / - 10 mm ²

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