

EWS .Varia VXT

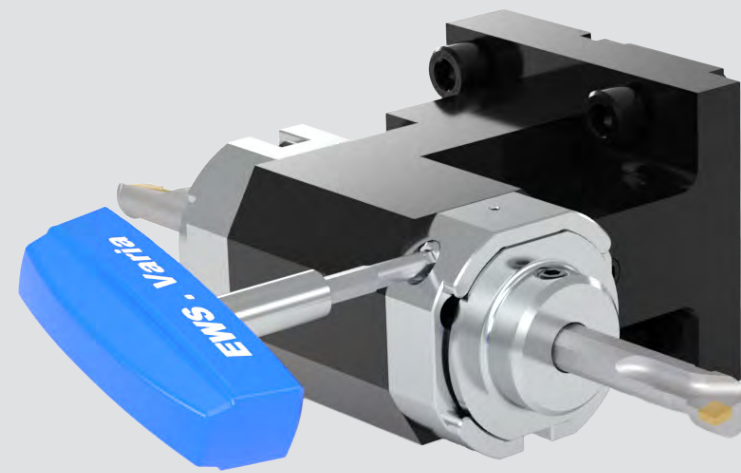
The innovative quick-change system for static turning applications



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EWS
Tool Technologies



EWS. *Varia VXT*

All the benefits at a glance

- **Optimized stability and damping**

- Two-sided-cone flex system for improved service life and surface quality
- Widely spaced support points for maximum stability and rigidity
- Dual surface fit for reliable torque absorption

- **Tool change, flexibility and modularity**

- One-handed operation for fast and safe tool change
- Can be used as standard and overhead tool
- Backwards compatible with EWS.Varia VX inserts for conversion to the VXT system Cost-effective due to compatibility with VX basic holders
- Compact tool clamping

■ **Highest precision and repeatability**

- Repeatability
+/- 0.002 mm
- Transmittable torque
VXT3 = 160 Nm
VXT4 = 200 Nm
- Coolant pressure
Max. coolant pressure 80 bar

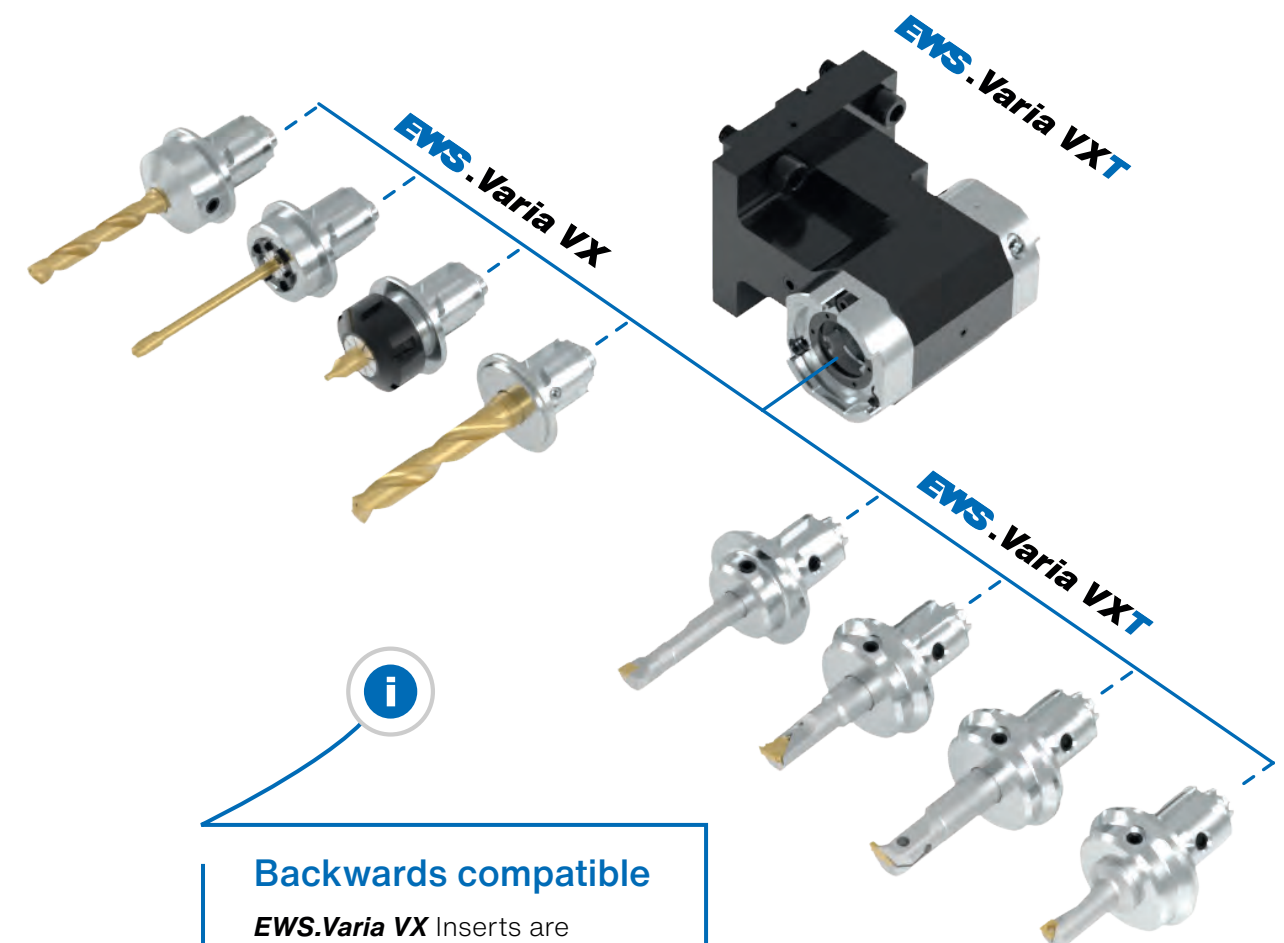


EWS.*Varia VXT*

**The innovative quick-change system
for static turning applications.**

***EWS.Varia VXT* - Your key to mastering internal turning**

EWS.Varia VXT is the latest addition to our successful EWS Varia range. Developed specifically for static turning applications, this system combines maximum precision, stability and flexibility. Based on the proven EWS.Varia VX system, the new VXT line enables extremely compact tool clamping. Especially when machining towards the turret box, every millimetre of clamping length counts.



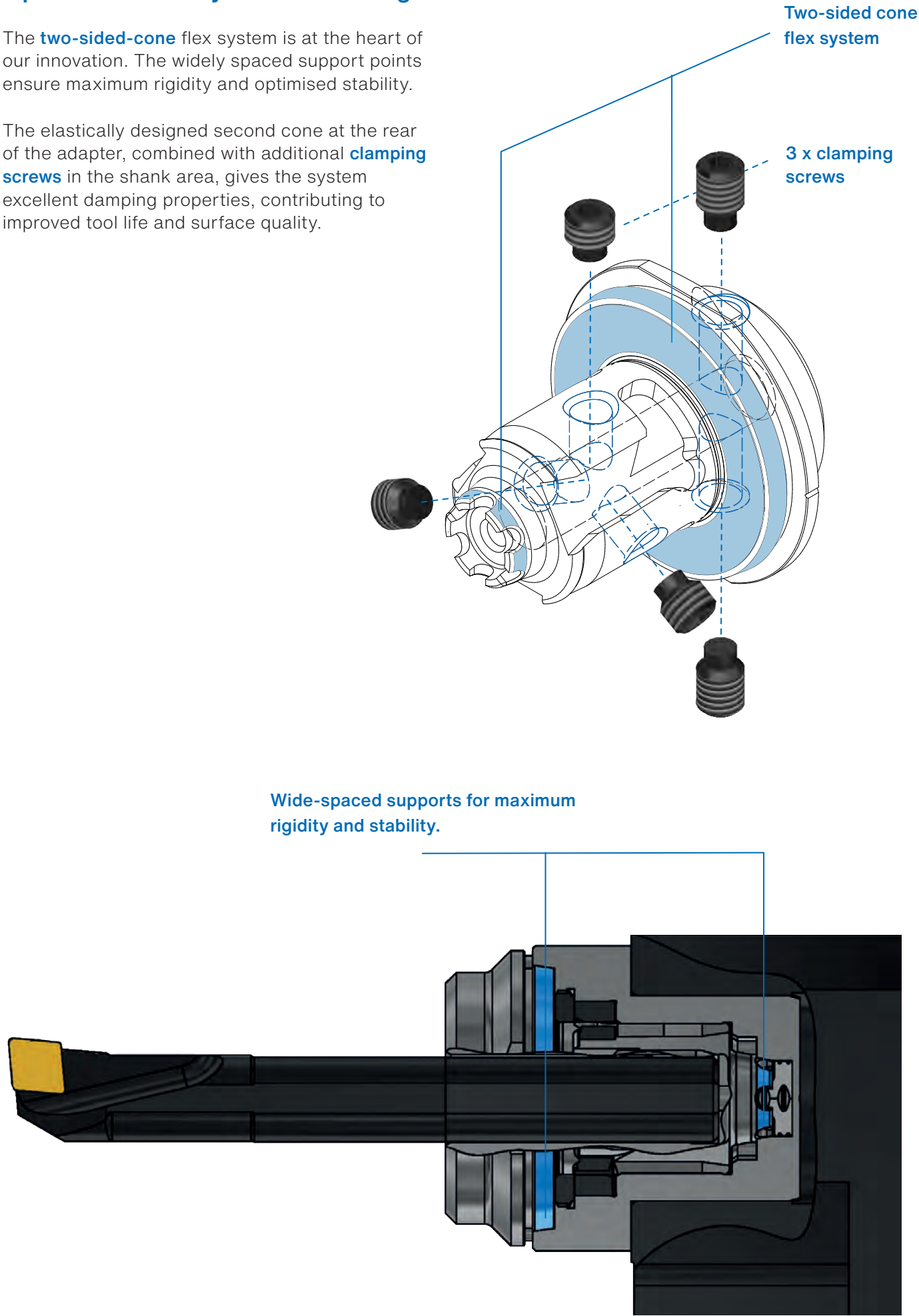
Backwards compatible

EWS.Varia VX Inserts are usable with the new **EWS.Varia VXT** interface.

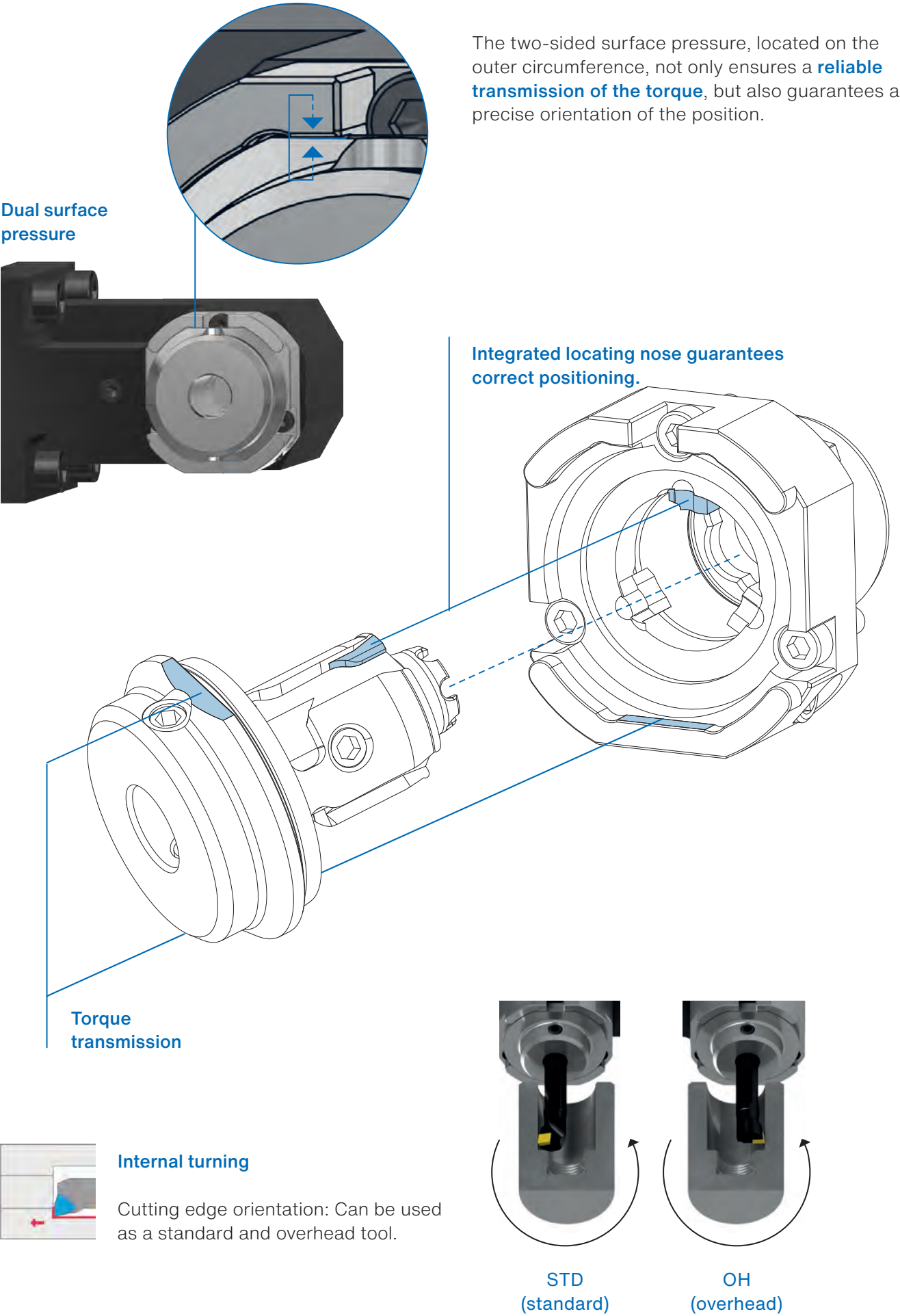
Optimised stability and cushioning

The **two-sided-cone** flex system is at the heart of our innovation. The widely spaced support points ensure maximum rigidity and optimised stability.

The elastically designed second cone at the rear of the adapter, combined with additional **clamping screws** in the shank area, gives the system excellent damping properties, contributing to improved tool life and surface quality.



Tool change, flexibility and modularity

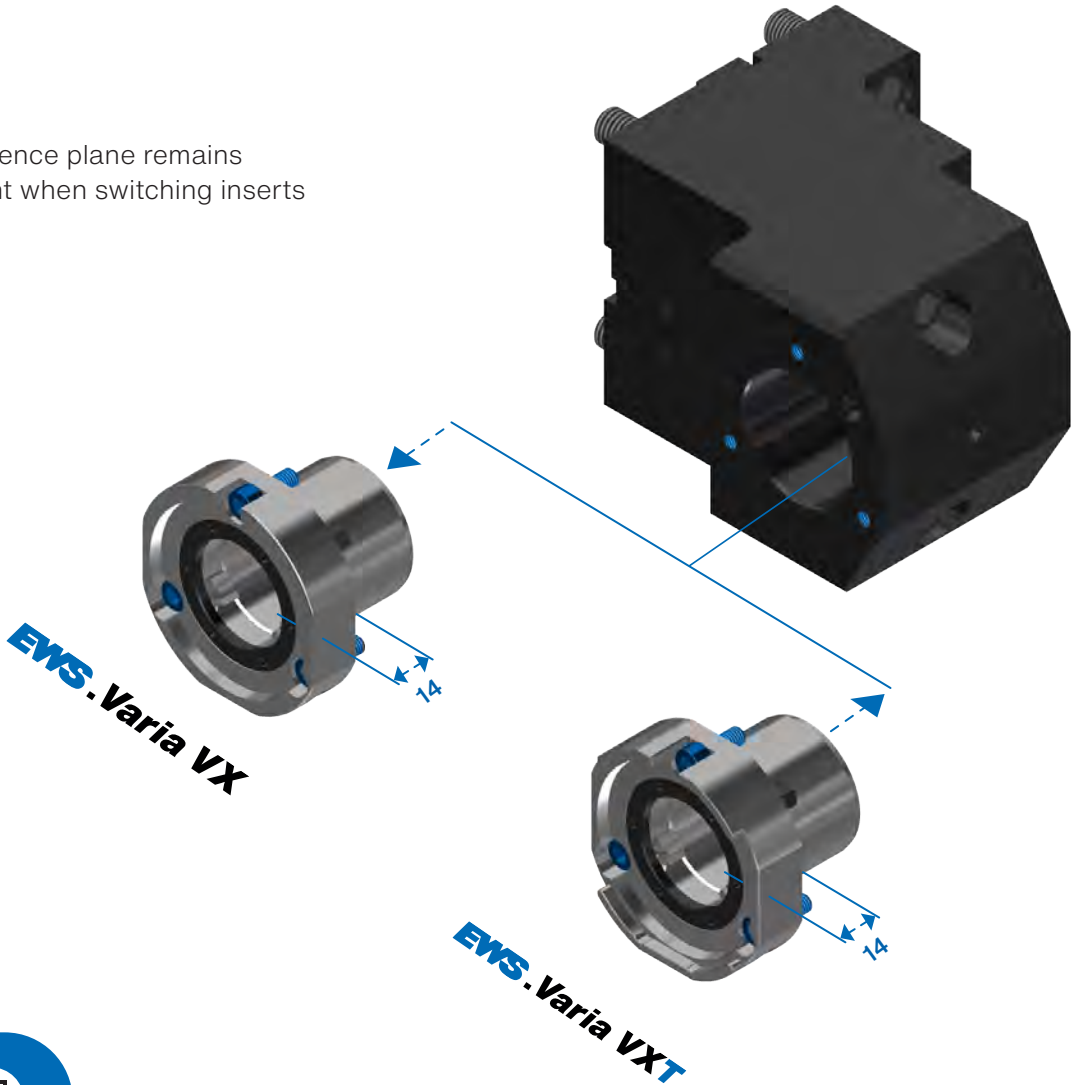


One-sided and cost-effective entry

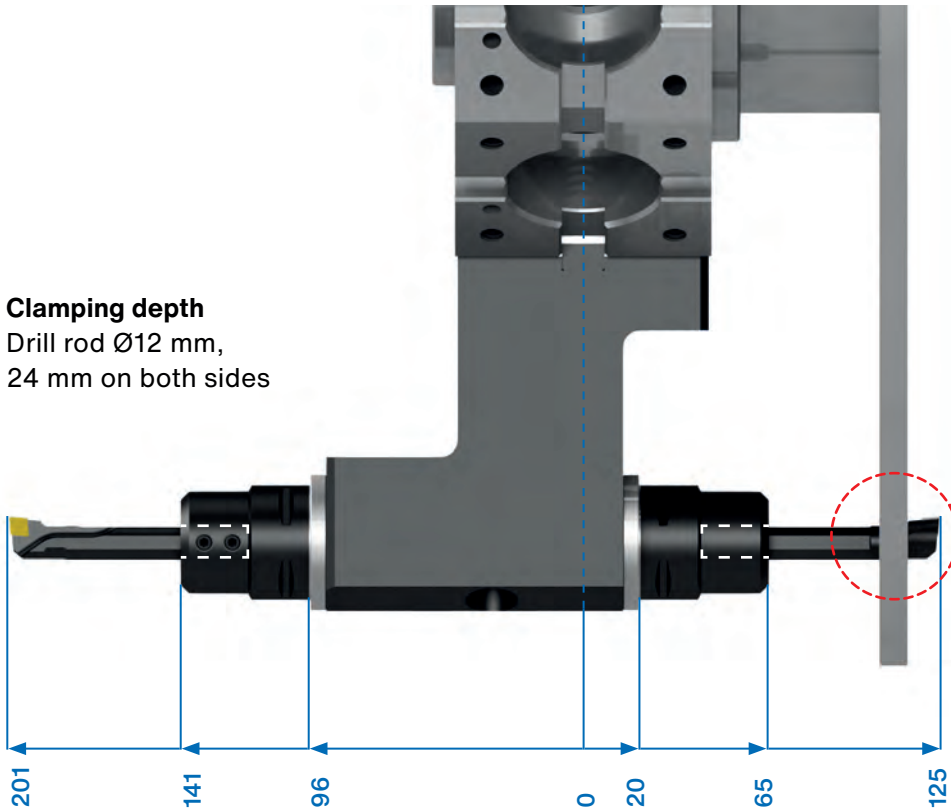
For users of the **EWS.Varia VX** system, we offer a specially developed **EWS.Varia VXT** insert. This allows existing tool holders to be cost-effectively converted to the **EWS.Varia VXT** system, ensuring a seamless transition to the latest technology. For maximum cost efficiency and a smooth transition, simply convert your existing **VX** toolholders to the **VXT** system. For more information, please refer to the user manual.

VXT3		VXT4	
MNR	No.	MNR	No.
230946	WE-VXT3-02	232646	WE-VXT4-02

 The reference plane remains consistent when switching inserts



USER
MANUAL

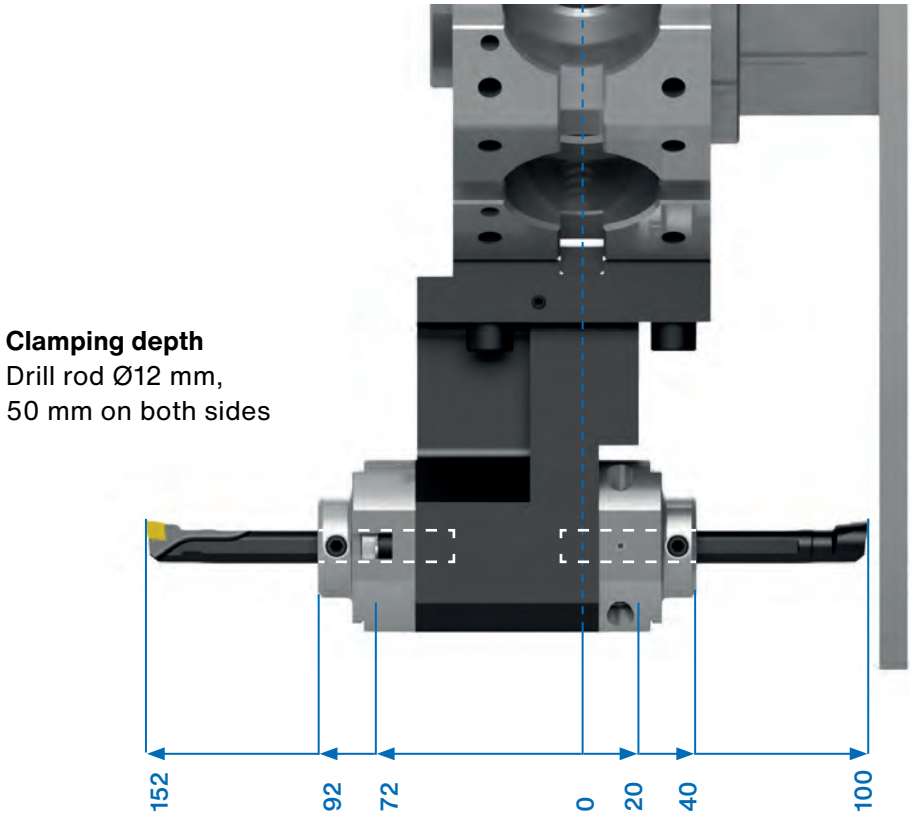


PSC 40

Common PSC solution:

- Unstable due to small clamping depth of the boring bar.
- Space intensive design

 Risk of collision



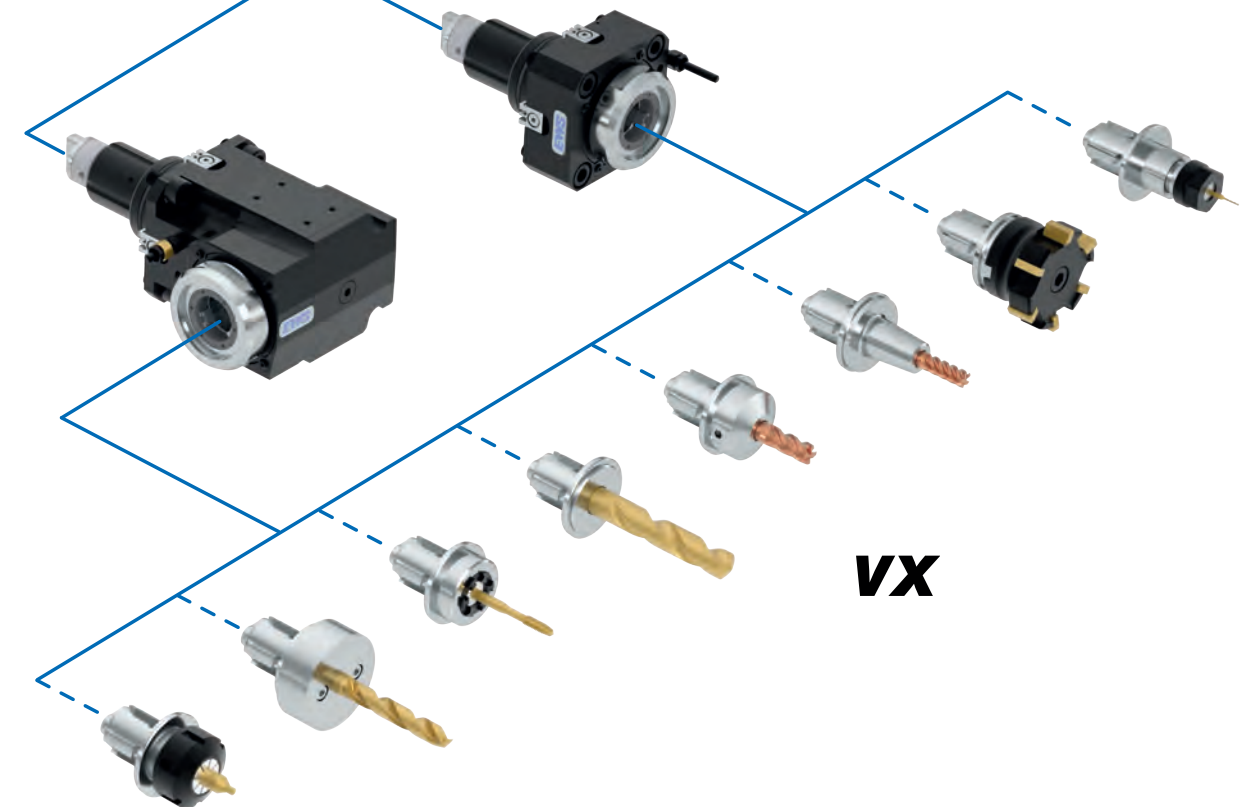
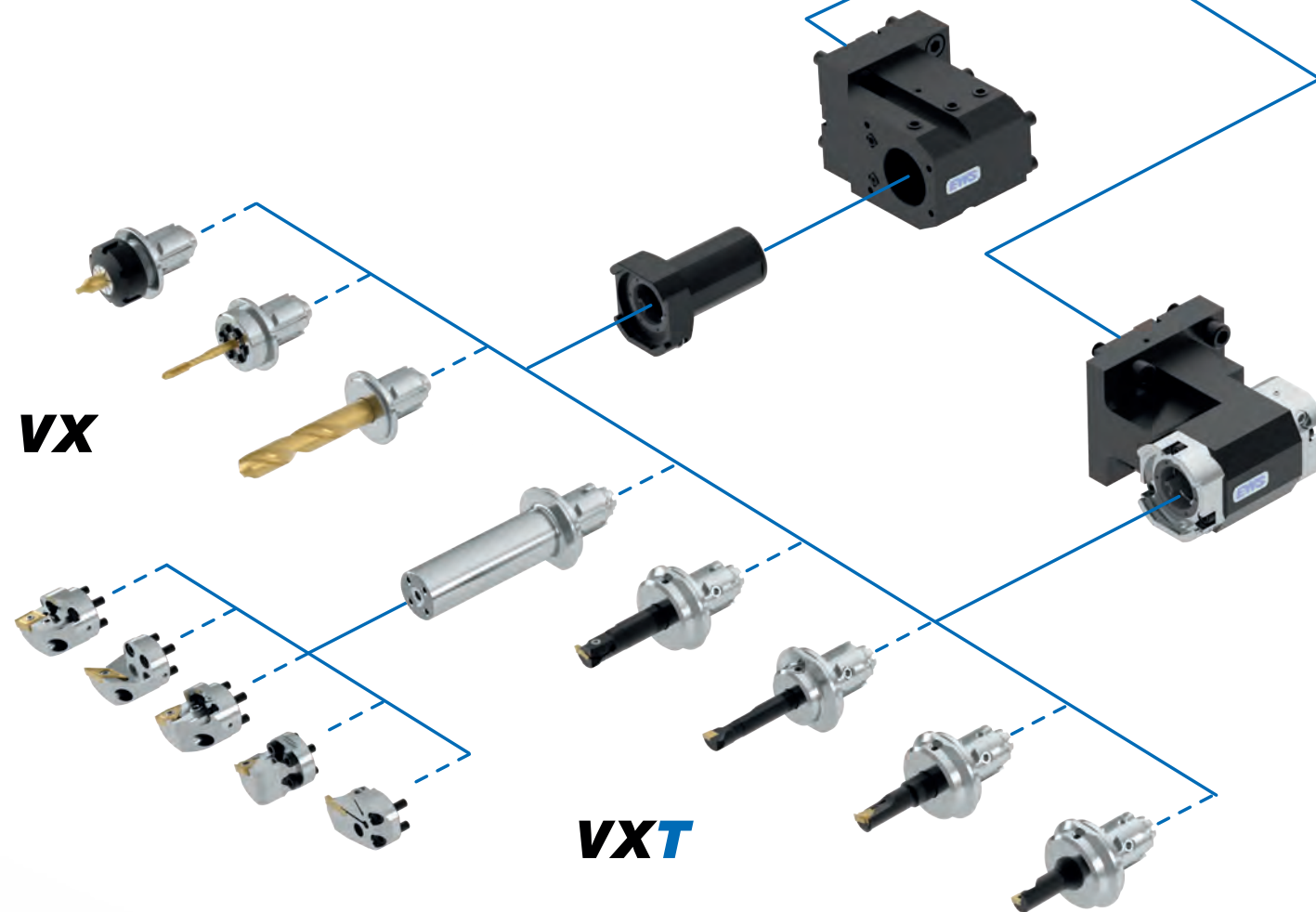
VXT3

Innovative VXT3 solution:

- Stable due to high clamping depth of the boring bar.
- Compact design

EWS.Varia

Quick-change system



In combination, **EWS.Varia VXT** and **EWS.Varia VX** cover the most frequent machining operations.

EWS.Varia VX

Centric drilling

- Tapping/moulding/milling
- Core hole drilling
- Centre drilling
- Countersinking

EWS.Varia VXT

Internal turning operations

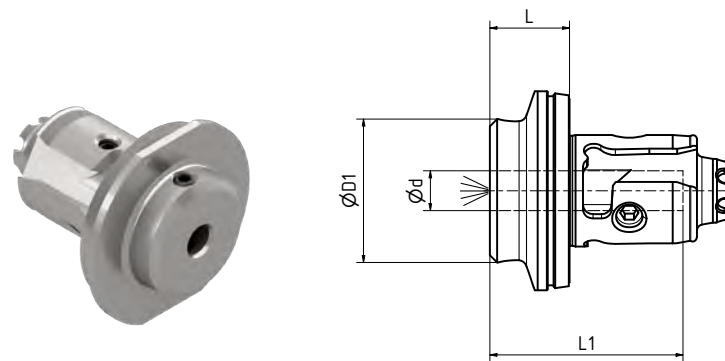
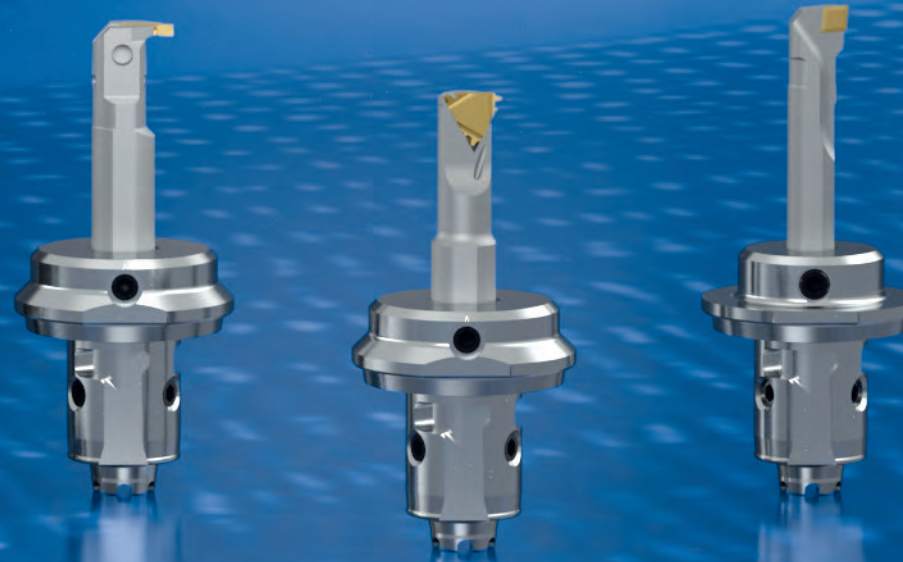
- Roughing
- Finishing
- Grooving
- Thread turning

Axial radial: Drilling/milling operations

- Tapping/moulding/milling
- Core hole drilling
- Rough milling
- spot drilling
- Roughing/finishing milling
- Deburring milling

EWS.Varia VXT

Boring bar inserts



Metric

VXT3

	MNR	No.	d	D1	L	L1	IC
	232709	19.VXT306L18	6	32	18	47	✓
	232708	19.VXT308L18	8	32	18	47	✓
	232707	19.VXT310L20	10	36	20	50	✓
	232706	19.VXT312L20	12	36	20	50	✓
	232698	19.VXT316L20	16	46	20	50	✓

VXT4

	MNR	No.	d	D1	L	L1	IC
	232715	19.VXT406L18	6	36	18	47	✓
	232714	19.VXT408L18	8	36	18	47	✓
	232713	19.VXT410L20	10	42	20	50	✓
	232712	19.VXT412L20	12	42	20	50	✓
	232711	19.VXT416L20	16	46	20	52	✓
	232710	19.VXT420L23	20	55	23	58	✓

Inch

VXT3

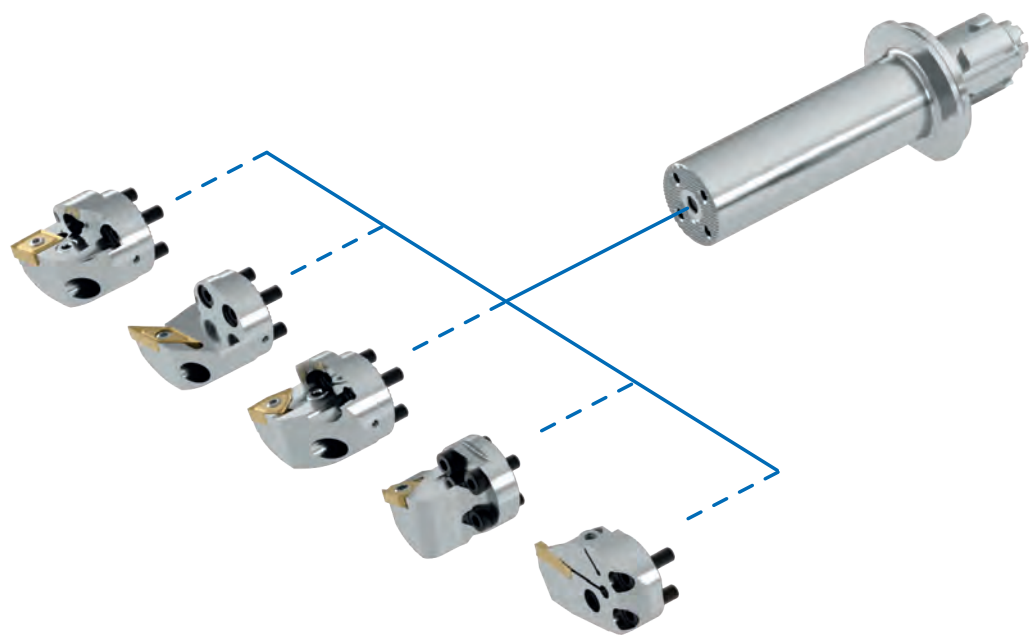
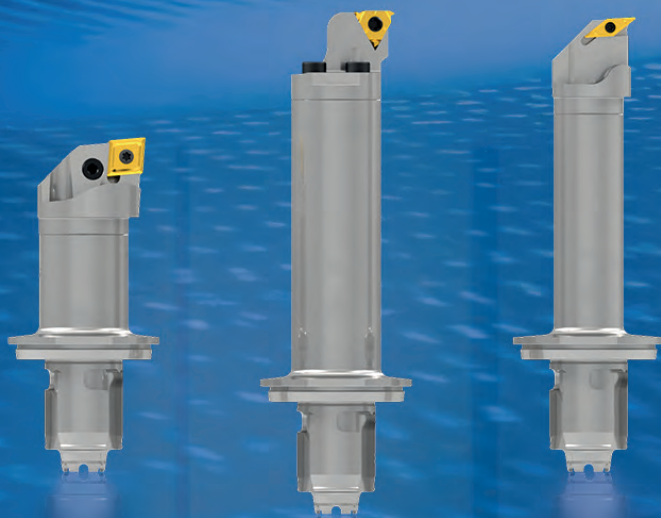
	MNR	No.	d	D1	L	L1	IC
	232954	19.VXT306.35L18	1/4"	32	18	47	✓
	232955	19.VXT309.53L20	3/8"	36	20	50	✓
	232956	19.VXT312.7L20	1/2"	36	20	50	✓
	232957	19.VXT315.88L20	5/8"	46	20	50	✓

VXT4

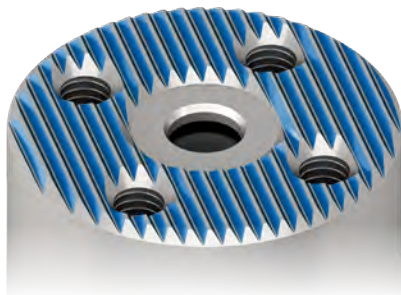
	MNR	No.	d	D1	L	L1	IC
	232958	19.VXT406.35L18	1/4"	36	18	47	✓
	232959	19.VXT409.53L20	3/8"	42	20	50	✓
	232961	19.VXT412.7L20	1/2"	42	20	50	✓
	232962	19.VXT415.88L20	5/8"	46	20	52	✓
	232963	19.VXT419.05L23	3/4"	55	23	58	✓

EWS.Varia VXT

Cutting Head (CH) adapter for modular exchangeable cutting heads



CH adapters open up new possibilities in internal turning.



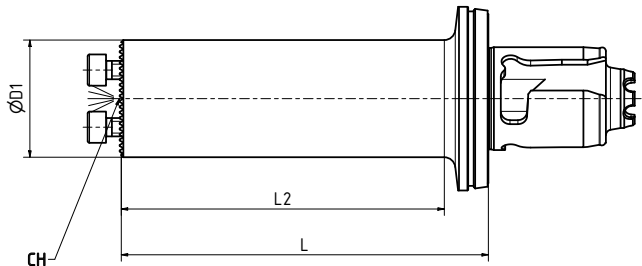
The **precision-ground serration** ensures a backlash-free, positive-fit connection and maximum repeatability.

Cutting heads can be changed within seconds, significantly reducing setup times and increasing operational flexibility.

By combining the compatibility of the EWS CH adapters with common modular cutting head systems and the strengths of the **VXT** system, the result is an ideal solution for a flexible internal turning. At the same time, our adapters enable significantly greater cutting depths compared to conventional quick-change systems.

Application range:

- Boring bar diameters: 20 to 40 mm
- Machining depths: up to 4.5xD
- Coolant pressure: up to 80 bar



VXT3

	MNR	No.	Ø-shank	L	L2	D1	IC
	236090	36.VXT3CH20L60X20	CH20	60	48	20	✓
	236025	36.VXT3CH20L82X20	CH20	82	70	20	✓
	236091	36.VXT3CH25L45X25	CH25	45	33	25	✓
	236026	36.VXT3CH25L88X25	CH25	88	76	25	✓
	236092	36.VXT3CH32L45X32	CH32	45	33	32	✓
	236028	36.VXT3CH32L108X32	CH32	108	96	32	✓
	236093	36.VXT3CH40L40X40	CH40	40	28	40	✓
	236029	36.VXT3CH40L112X40	CH40	112	100	40	✓

VXT4

	MNR	No.	Ø-shank	L	L2	D1	IC
	236094	36.VXT4CH25L45X25	CH25	45	31	25	✓
	236030	36.VXT4CH25L102X25	CH25	102	88	25	✓
	236095	36.VXT4CH32L45X32	CH32	45	31	32	✓
	236031	36.VXT4CH32L126X32	CH32	126	112	32	✓
	236096	36.VXT4CH40L40X40	CH40	40	26	40	✓
	236033	36.VXT4CH40L132X40	CH40	132	118	40	✓



Variety of options for internal turning

The CH system offers a wide range of cutting heads for roughing, finishing, threading, and parting. This ensures that the optimal solution is available for every internal turning task.

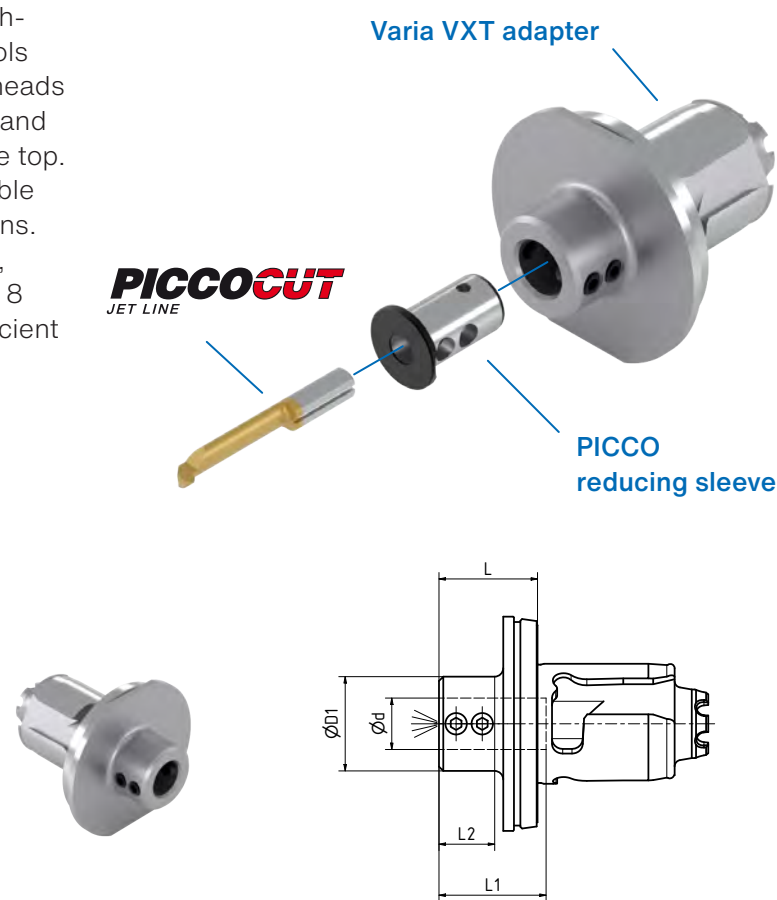
All variants can be found in the EWS e-shop under “Component Search” or in the boring bar catalog starting on page 14.



**BORING BAR
CATALOG**

EWS adapter for mini internal turning applications

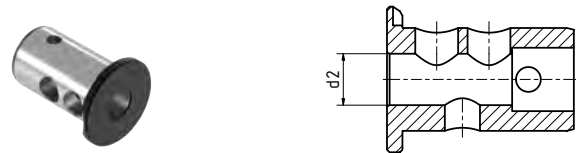
This adapter enables the integration of the high-performance **ISCAR PICCOCUT JET LINE** tools into the **EWS.Varia VXT** system. The cutting heads feature internal cooling, an optimized coating, and are securely clamped with two screws from the top. The double-sided mounting option allows flexible use in both left-hand and right-hand orientations. In combination with suitable reduction sleeves, the adapter covers a diameter range from 4 to 8 mm, providing a precise, flexible, and cost-efficient solution for mini internal turning operations in confined spaces.



VXT3

	MNR	No.	d	L	D1	L1	L2	IC
	236279	19.VXT312L23-PICCO	12	23	22	13	25	✓

PICCO Reduzierhülse



	MNR	No.	d2
	236404	28.1204-PICCO	4
	236405	28.1205-PICCO	5
	236406	28.1206-PICCO	6
	236407	28.1207-PICCO	7
	236408	28.1208-PICCO	8

Alignment Inserts

With the **VXT** setting inserts, the center height and axis alignment of the turret can be checked reliably. Especially in small-scale internal turning operations, maximum accuracy is essential, as it increases tool life and ensures consistently high machining quality.

In addition, the setting inserts are ideal for calibrating presetting devices to our **VXT** adapters, making them an important component of the EWS Ready. Safe. Go. setup concept.

VXT3

	MNR	No.	d1	L	d2	l1
	236013	EVXT3.40.110	40	110	10	8

VXT4

	MNR	No.	d1	L	d2	l1
	236014	EVXT4.40.120	40	120	10	8



VXT blanks for individual solutions

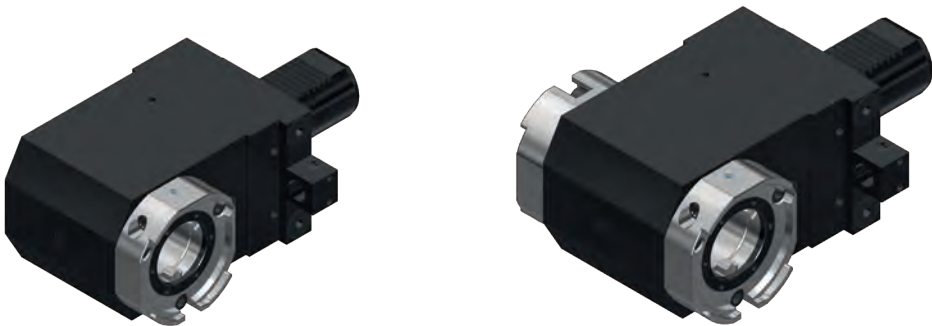
In addition to the standard program, we also offer **VXT** blanks in various lengths and diameters on request.

For example, if you are a cutting material or tool manufacturer, you can use these blanks to integrate specific insert seats and directly combine your system with the advantages of EWS. Varia **VXT**.

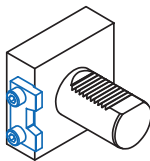
Get in touch with us – we will be happy to advise you.



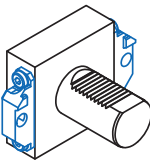
Clamping units for VDI star turrets



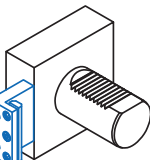
■ one-sided ■ Two-sided



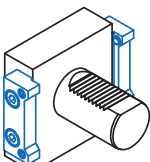
V-Strip



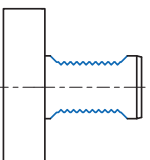
Trifix



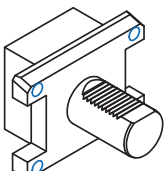
Stop strip,
adjustable



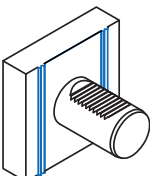
Traub strip



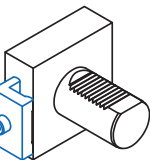
RL



PL



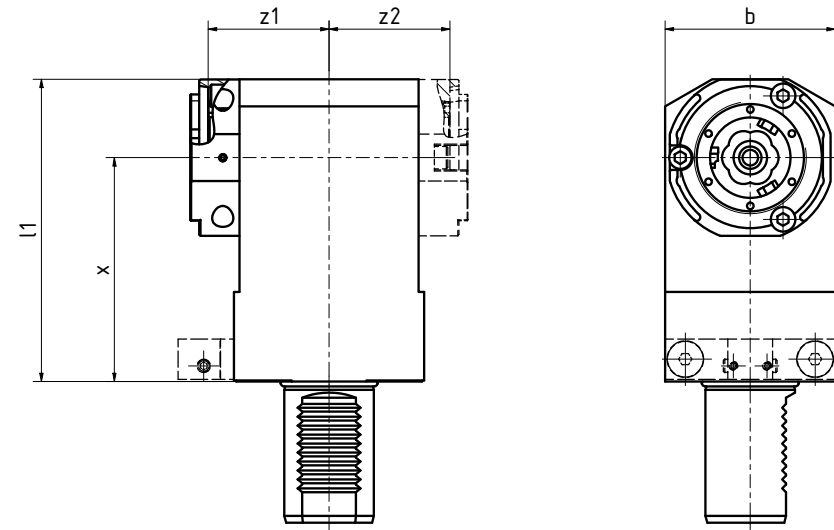
W-toothing



Terminal strip

VXT3

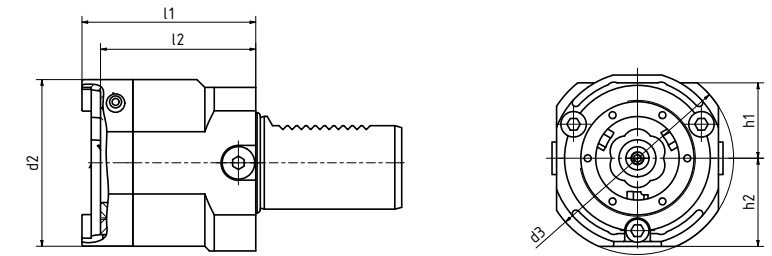
MNR	No.	Ø-shank	Tool-holder	Alignment system	x	z1	z2	l1	b	EC/IC
232612	19.25VXT3G200RLWZ0	VDI25-RL	one-sided	W-Interlocking	70	0	-	100	60	✓
232617	17.25VXT3DG200RLW	VDI25-RL	two-sided	W-Interlocking	70	47	47	100	60	✓
232597	19.25VXT3G200RLVZ0	VDI25-RL	one-sided	V-strip	70	0	-	100	60	✓
232593	17.25VXT3MFT	VDI25	one-sided	Pin (block)	75	47	-	105	60	✓
232595	19.25VXT3MFTRLZ0	VDI25-RL	one-sided	Pin (block)	75	0	-	105	60	✓
235194	19.25VXT3MFTRLTFLZ0	VDI25-RL	one-sided	Trifix	75	0	-	105	60	✓
232596	17.25VXT3DMFT	VDI25	two-sided	Pin (block)	75	47	47	105	60	✓
235135	17.25VXT3DMFTTF	VDI25	two-sided	Trifix	75	47	47	105	60	✓
232598	19.25VXT3E332RLZ0	VDI25-RL	one-sided	Terminal strip	75	0	-	105	60	✓
232599	17.25VXT3DE332	VDI25	two-sided	Terminal strip	75	47	47	105	60	✓
235709	17.30VXT3DTNC65	VDI30	two-sided	Traub strip	70	47	47	98	70	✓
232600	19.30VXT3CTXRLZ0	VDI30-RL	one-sided	Pin (block)	85	0	-	115	64	✓
232651	17.30VXT3DCTXTF	VDI30	two-sided	Trifix	85	47	47	115	64	✓
234724	17.30VXT3G300RLW	VDI30-RL	one-sided	W-Interlocking	90	47	-	120	78	✓
232613	19.30VXT3G300RLWZ0	VDI30-RL	one-sided	W-Interlocking	90	0	-	120	78	✓
232618	17.30VXT3DG300RLW	VDI30-RL	two-sided	W-Interlocking	90	47	47	120	78	✓
235290	17.30VXT3G300RLV	VDI30-RL	one-sided	V-strip	90	47	-	120	64	✓
235292	17.30VXT3DG300RLV	VDI30-RL	two-sided	V-strip	90	47	47	120	64	✓
232605	19.30VXT3TNX65RLZ0	VDI30-RL	one-sided	Traub strip	90	0	-	120	70	✓
233177	17.30VXT3DTNX65	VDI30	two-sided	Traub strip	90	47	47	120	64	✓
232601	19.30VXT3LCTXRLZ0	VDI30-RL	one-sided	Pin (block)	100	0	-	130	64	✓
232873	19.30VXT3LCTXRLTFLZ0	VDI30-RL	one-sided	Trifix	100	0	-	130	64	✓
235139	19.30VXT3LCTXRLTFRZ0	VDI30-RL	one-sided	Trifix	100	0	-	130	64	✓
235138	17.30VXT3LDTOEMX100A35	VDI30	two-sided	Stop bar, adjustable	100	47	47	130	64	✓
232603	17.30VXT3LDCTX	VDI30	two-sided	Pin (block)	100	47	47	130	64	✓
232604	17.30VXT3LDCTXTF	VDI30	two-sided	Trifix	100	47	47	130	64	✓
232606	17.30VXT3LDE365A35	VDI30	two-sided	Stop bar, adjustable	120	47	47	150	64	✓



VXT4

MNR	No.	Ø-shank	Tool-holder	Alignment system	x	z1	z2	l1	b	EC/IC
234980	19.40VXT4TOEMRLZ0	VDI40-RL	one-sided	Stop bar, adjustable	100	0	-	135	76	✓
232648	19.40VXT4CTXRLZ0	VDI40-RL	one-sided	Pin (block)	100	0	-	135	76	✓
232607	17.40VXT4DCTX	VDI40	two-sided	Pin (block)	100	54	54	135	76	✓
232608	17.40VXT4DCTXTF	VDI40	two-sided	Trifix	100	54	54	135	76	✓
235134	17.40VXT4DTOEMX100	VDI40	two-sided	Stop bar, adjustable	100	54	54	135	76	✓
234474	19.40VXT4SQT10X100	VDI40 Mazak - 30°/Ø16	one-sided	Pin	100	61	-	135	76	✓
232616	19.40VXT4G400RLWZ12	VDI40-RL	one-sided	W-Interlocking	110	12	-	145	80	✓
232619	17.40VXT4DG400RLW	VDI40-RL	two-sided	W-Interlocking	110	54	54	145	80	✓
232876	19.40VXT4LCTXRLTFLZ0	VDI40-RL	one-sided	Trifix	120	0	-	155	76	✓
232609	17.40VXT4LDCTX	VDI40	two-sided	Pin (block)	120	54	54	155	76	✓
232610	17.40VXT4LDCTXTF	VDI40	two-sided	Trifix	120	54	54	155	76	✓
232611	17.40VXT4LDCTXTF-PL	VDI40-Pro-Line	two-sided	Trifix	120	54	54	155	90	✓
235136	19.40VXT4MP620RZ-5X130	VDI40 Mazak - Ø20	one-sided	Pin	130	-5	-	165	76	✓
232620	19.40VXT4SQT15X135	VDI40 Mazak - 30°/Ø20	one-sided	Pin eccentric, adjustable	135	55	-	170	76	✓
232623	17.40VXT4DSQT15X135	VDI40 Mazak - 30°/Ø20	two-sided	Pin eccentric, adjustable	135	74	34	170	76	✓

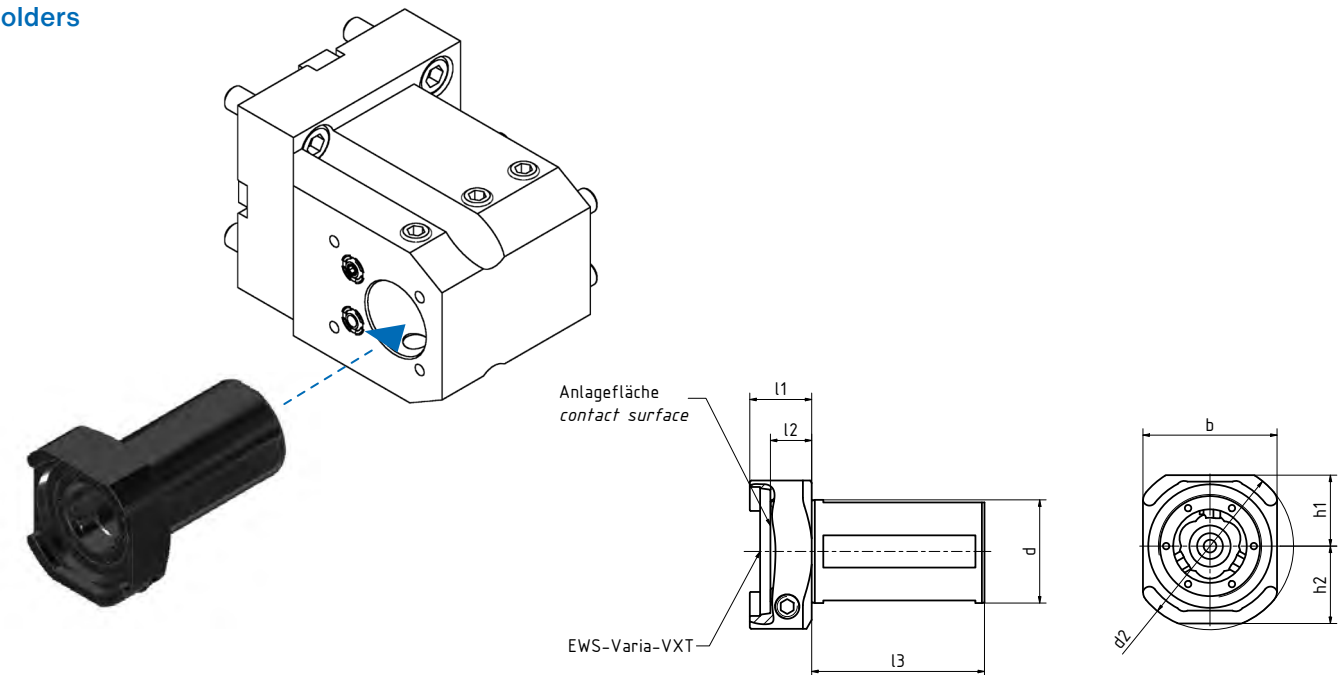
Clamping units for VDI disk turrets



MNR	No.	Ø-shank	Interface size	d2	d3	h1	h2	l1	l2	EC/IC
232590	19.25VXT3	VDI25	VXT3	64,8	58	25	25	68	60	✓
232591	19.30VXT3	VDI30	VXT3	64,8	68	28	30	68	60	✓
232592	19.40VXT4	VDI40	VXT4	74,8	83	32,5	-	75	67	✓

ZYL-Adaptor *EWS Varia VXT*

for use in boring bar holders



MNR	Nr.	d	d2	b	h1	h2	l1	l2	l3	EC/IC
232583	19.32VXT3-ZYL	32	64,8	52	27,5	30	44	36	53	✓
234266	19.40VXT3-ZYL	40	64,8	52	27,5	30	24	16	67	✓
235658	19.32VXT4-ZYL	32	74,8	67	35	35	50	42	53	✓
232584	19.40VXT4-ZYL	40	74,8	67	35	35	50	42	67	✓
237415	19.50VXT4-ZYL	50	74,8	67	35	35	24	16	67	✓

Clamping units for BMT turrets



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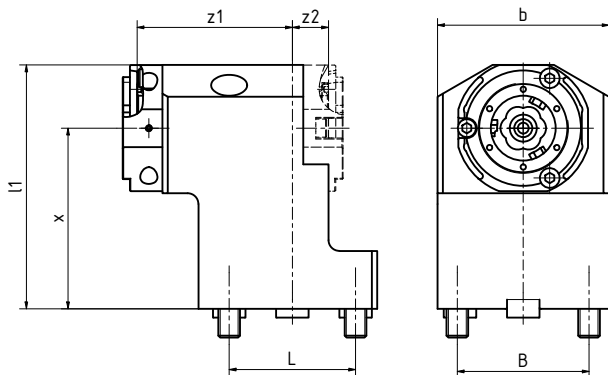
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One-sided



Two-sided



VXT3

MNR	No.	BMT-size	Drilling pattern	Tool-holder	x	z1	z2	I1	b	EC/IC
235568	17.BMTVXT3DSL200X40	BMT32E	35 x 76	two-sided	40	9	85	69	99	✓
232636	19.BMTVXT3NZZ0X95	BMT40 DMG Mori	70 x 62	one-sided	95	0	-	125	76,8	✓
232637	17.BMTVXT3DNZX95	BMT40 DMG Mori	70 x 62	two-sided	95	65	65	125	76,8	✓
232664	19.BMTVXT3BMT45X65	BMT45	58 x 58	one-sided	65	52	-	95	75	✓
232633	19.BMTVXT3BMT45X85	BMT45	58 x 58	one-sided	85	52	-	115	75	✓
232635	17.BMTVXT3DBMT45X85	BMT45	58 x 58	two-sided	85	72	20	115	75	✓
235141	17.BMTVXT3DBND	BMT45A	68 x 56	two-sided	75	46	46	105	74	✓
232644	17.BMTVXT3TW10	BMT55C	50 x 60	one-sided	65	54	-	95	80	✓
232645	17.BMTVXT3DTW10X70	BMT55C	50 x 60	two-sided	70	54	54	100	80	✓
235236	19.BMTVXT3LT2000V16	BMT55 Okuma	80 x 65	one-sided	85	70	-	115	86	✓
232629	17.BMTVXT3BMT55X70	BMT55	64 x 64	one-sided	70	36	-	100	85	✓
235027	17.BMTVXT3DBMT55X70	BMT55	64 x 64	two-sided	70	72	20	100	85	✓
232630	17.BMTVXT3BMT55X85	BMT55	64 x 64	one-sided	85	36	-	115	85	✓
232667	17.BMTVXT3BMT55X100	BMT55	64 x 64	one-sided	100	36	-	100	85	✓
232632	17.BMTVXT3DBMT55X100	BMT55	64 x 64	two-sided	100	72	20	130	85	✓

VXT4

MNR	No.	BMT-size	Drilling pattern	Tool-holder	x	z1	z2	I1	b	EC/IC
235680	19.BMTVXT4LB4000	BMT60A Okuma	80 x 78	one-sided	90	74	-	125	96,8	✓
232639	19.BMTVXT4LB2000	BMT60B Okuma	65 x 73	one-sided	90	71,5	-	125	90	✓
232642	17.BMTVXT4DLB2000	BMT60B Okuma	65 x 73	two-sided	90	80,5	27,5	125	90	✓
232671	19.BMTVXT4NLX90	BMT60 DMG Mori	94 x 84	one-sided	90	65	-	125	108	✓
232625	19.BMTVXT4BMT65X72	BMT65	70 x 73	one-sided	72	65	-	107	94	✓
236326	17.BMTVXT4DBMT65X72	BMT65	70 x 73	two-sided	72	88	16	107	95	✓
232627	19.BMTVXT4BMT65X100	BMT65	70 x 73	one-sided	100	65	-	135	94	✓
232628	17.BMTVXT4DBMT65X100	BMT65	70 x 73	two-sided	100	86	20	135	94	✓
235121	19.BMTVXT4VT4Z5X132.5	BMT65	70 x 73	one-sided	132,5	5	-	167,5	94	✓
232638	19.BMTVXT4QSM200X85	BMT68 Mazak	110 x 68	one-sided	85	64	-	120	84	✓



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VXT3STARTKIT-Promo (MNR: 236488)

EWS.Varia VXT3



- 1x T-Carrier TC-100
(No.: TC-100 VX3-20)
- 3x Collet insert VX ER25
(No.: 31.VX325L30)
- 1x Collet wrench ER25
(No.: 225)
- 2x Boring bar insert 19.VXT3...
(select two Ø)

☐ Ø6	☐ Ø1/4"
☐ Ø8	☐ Ø3/8"
☐ Ø10	☐ Ø1/2"
☐ Ø12	☐ Ø5/8"
☐ Ø16	
- 1x VXT-adapter for combination holder Ø32
(No.: 19.32VXT3-ZYL)
- 5x Tool-Tag
(No.: PT.VX3)
- 1x Torque wrench
(No.: DSV SW5/05.7NM)
- 1x Mounting block
(No.: MB-VX3)

VXT4STARTKIT-Promo (MNR: 236492)

EWS.Varia VXT4



- 1x T-Carrier TC-100
(No.: TC-100 VX4-20)
- 3x Collet insert VX ER32
(No.: 31.VX432L30)
- 1x Collet wrench ER32
(No.: 232)
- 2x Boring bar insert 19.VXT4...
(select two Ø)

☐ Ø6	☐ Ø1/4"
☐ Ø8	☐ Ø3/8"
☐ Ø10	☐ Ø1/2"
☐ Ø12	☐ Ø5/8"
☐ Ø16	☐ Ø3/4"
☐ Ø20	
- 1x VXT-adapter for combination holder Ø40
(No.: 19.40VXT4-ZYL)
- 5x Tool-Tag
(No.: PT.VX4)
- 1x Torque wrench
(No.: DSV SW5/05.7NM)
- 1x Mounting block
(No.: MB-VX4)

EWS Group

Tooling Systems and Turrets

EWS USA

EWS USA

13931 Sunfish Lake Blvd NW
Ramsey · MN 55303 USA
Telefon +1-763-576-6910
E-Mail support@ews-tools.com
www.ews-tools.com

EWS Tool Technologies

EWS Weigle GmbH & Co. KG

Maybachstraße 1 · D-73066 Uhingen
Telefon +49(0)7161-93040-100
E-Mail info@ews-tools.de
www.ews-tools.de

EWS Türkiye

EWS Tutucu Sistemleri ve Taretleri Anonim Şirket

Aydınlı mah. Melodi No.2/19 Sk. Bİlmo
San.Sit. 18-19 · 34956 Tuzla / İstanbul
Turkey
Telefon +90-216-593-22-44
E-Mail mehmet@ewstools.com
www.ews-tools.de

EWS China

EWS Tool Holder Technologies (Taicang Co. Ltd)

Beijing East Road No. 88
215400 Taicang · Jiangsu
P. R. China
Telefon +86-512-3306-2600
E-Mail sales.cn@ews-tools.de
www.ews-tools.cn

EWS Korea

EWS Korea Co. Ltd.

80-101 · Golden root-ro
Juchon-myeon · Gimhae-si
Gyeongsangnam-do · Korea
Telefon +82-55-267-8085
E-Mail info@ewskorea.co.kr
www.ewskorea.co.kr



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