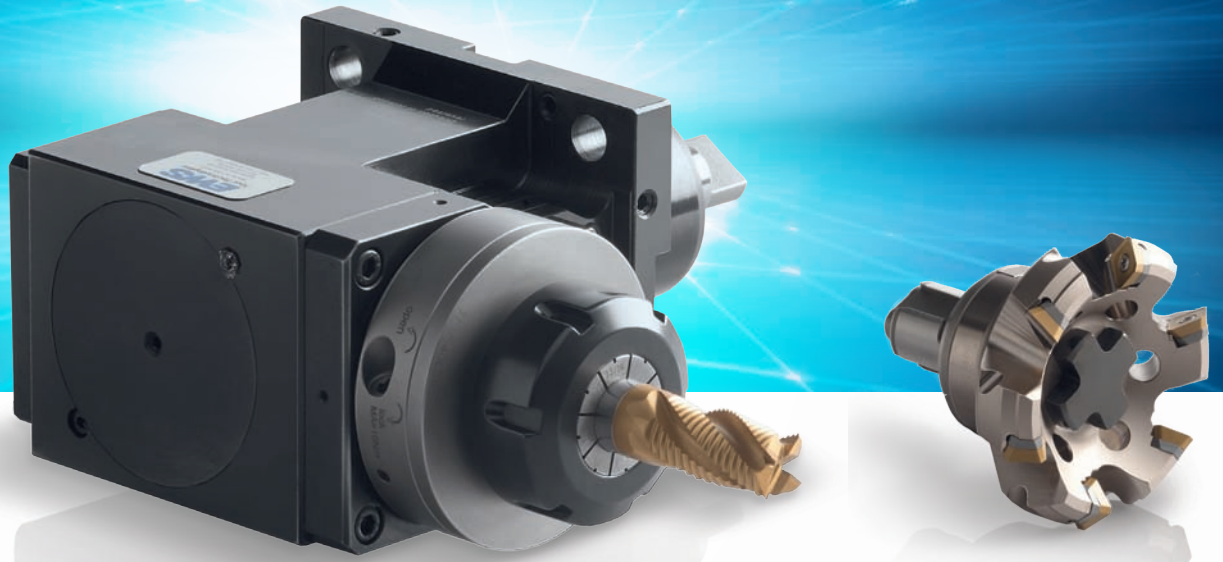


**Precision meets Motion**



**Tool change in only  
20 seconds**

## **Manual**

***EWS . Varia V5***

(applied for a patent)

**EWS**  
Tool Technologies

#### 1. Clamping the Varia insert in the tool



Make sure that the clamping ring is completely opened. Therefore turn the clamping screw anti-clockwise slightly until it stops.

Clean the interface with a cloth (do not use compressed air) and assemble the insert into the tool until it is plane. This is possible in 3 positions, respectively shifted by 120°.



Clamp the insert by turning off the Varia screw (1) clockwise and tighten it with 10Nm.

We recommend the torque key DSV SW5 of our accessories program.

Please note that an higher torque will lead to damage.



EWS Varia system guarantees plane tightening. Please check this through visual inspection.

The tool is now ready for operation.



To not damage the inserts only set up the collet chucks and milling arbors in the assembly jig MB-V5. (see accessories)

## EWS . Varia V5

### Manual

#### 2. Removing the Varia insert out of the tool



Open the clamping ring by turning the Varia screw (1) anti-clockwise. The integrated mechanical expulsion system pushes the insert from the plane face. Turn the screw slightly against the stop.



Now you can remove the insert. Inject insert and tool after the cleaning with an oil (corrosion prevention).



The tool is now ready for the next operation.

### 3. Accessories

#### 3.1. Assembly blocks



Universal assembly block: UMB100

Changeable tool adaptor

- EWS Varia V5: MW-V5

Changeable adaptors are also available in different forms.



**EWS Varia assembly block**

- EWS Varia V5: MB-V5

*Picture MB-V4*



**Torque wrench**

- Article No. DSV SW5 / 10NM

*Picture may differ from original product*

**EWS . Varia V5**

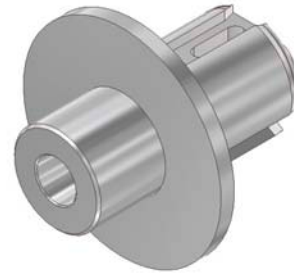
**Manual**

**3.2. Varia inserts**

**Collet chuck**



**Morse taper adaptor**



**Weldon / whistle notch insert**



**Floating toolholder collet chuck**



**Millering insert**



**Hydrodehn insert**







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