

MK1380 数控大型外圆磨床

CNC LARGE CYLINDRICAL GRINDER



机床用途与性能特征

- MK1380数控外圆磨床主要适用于重型机械、塑料机械及造纸、橡胶、印染等行业中，磨削各种金属、非金属压辊及其它工件外圆。
- 采用德国西门子数控系统，实行人机对话方式，设定磨削程序，内置PLC，CRT显示，两轴联动，分别驱动砂轮架和工作台的运动。
- 机床的砂轮架主轴采用动静压轴承，配置温度控制油箱，稳定性好，且砂轮具有恒线速功能。
- 机床具有砂轮自动切入或周期进给，工作台自动跳档，工件尺寸的自动测量，砂轮自动两轴联动修整砂轮和修整后的自动补偿。在工件一次装夹后，即可完成一个或多个轴颈的磨削加工，是一种高效、高精度的机床。
- 工作台和砂轮架驱动电机为大惯量交流伺服电机，配置全封闭防护及操纵台，提高操作安全。

Main Applications and Structural Features

- MK1380 series mainly used in the fields of nearly machinery, plastic machinery, paper making, rubber, and dye printing grind various of metallic, nonmetallic compression roller and other workpieces.
- It adopts German SIEMENS CNC system, PLC, CRT display built in, two axis linkage, drive the movement of grinding carriage and worktable separately.
- Spindle of grinding carriage adopts dynamic static pressure bearing, with temperature-control oil box, good stability, and wheel owns CLV function.
- Head stock is adjusted speed by AC motor, whose speed can be adjustable steplessly to meet different grinding of workpieces.
- The drive motor of worktable and grinding carriage is AC Servo motor, suitable for machining large spareparts.
- Full-closed protecting cover-B provided, which makes environment much better.

技术规格参数 Specifications and Technical Parameters

磨削直径Diameter to be ground	Φ100 ~ Φ800mm
顶尖距Distance between centers	3000、4000、5000mm
中心高Height of center	410mm
最大工件重量Max. weight of workpiece	5000Kg
砂轮尺寸Max. dimension of grinding wheel	Φ900 × 75 × Φ305mm
砂轮速度Speed of grinding wheel	35m/s ~ 45m/s
砂轮架速度Wheel frame rate	0.1 ~ 500mm/min
X、Y轴分辨率X, Y axis resolution	0.001 or 0.0001mm
工作台速度Hydraulic traverse speed	1 ~ 10000mm/min
主电机功率Main electrical machinery power	22KW
顶尖号Apex number	公制100

机床工作精度 Working Accuracy

(标准试件Criterion Tyr the Piece Φ200 × 800 45# Chilled steel)

圆度Roundness	≤2 μm
纵截面上直径一致性 Uniformity of dia. in longitudinal section	≤3 μm
粗糙度Roughness	0.32 μm

机床主要附件 Main Accessories

全套电器设备Complete set of electric equipment	
冷却设备Complete set of coolant equipment	1套 set
砂轮修整器Cylindrical wheel dresser	1件 piece
开式中心架Open-type steady-rest	1套 set
莫式顶尖 Mo type top	2套 set
砂轮法兰盘Wheel adaptors flange	1套 set
砂轮平衡轴Wheel balancing mandrel	1套 set
机床垫铁 Iron cushion	12/12/12/18套 set

特殊定货附件 Extra Accessories

砂轮平衡架Wheel balancing stand	1套 set
磁轭纸带过滤的冷却水箱Cooling water box	1套 set
镶块顶尖Carbide-tipped center	1件 piece
磨顶尖装置Center grinding unit	1套 set
开式中心架Open-type steady rest	1/2/3套 set
马波斯测量仪(端面) Precision cylindrical meter	1套 set
SBS或马波斯自动平衡仪 Automatic balance recording meter	1套 set