

CYLINDRICAL GRINDING MACHINE

MW1320B

外圆磨床



机床用途与性能特征

● 机床结构灵巧、精度稳定，磨削效率高。工件、砂轮、油泵和冷却泵均分别以单独电机带动。配备了液压驱动和电气控制，操作方便。具有精巧简廉特点，适宜于成批及大量生产车间，磨削圆柱形或圆锥形外圆工件。

● 本机床是在M1320的基础上对其主要液压部件油压筒，快速进退油缸、操纵箱、压力阀板、油泵等作了重新设计。工作台面回转角度从顺时针 3° ，逆时针 6° 增大为顺时针 5° ，逆时针 9° 。机床的外形方面也作了较大的改进。

Main Applications and Structural Features

● The structure of the machine is delicate, its accuracy is stable and its grinding efficiency is high. Workpiece, wheel, oil-pump, and coolant pump are respectively driven by their individual motors. It has hydraulic drive, electric control, so it is convenient to operate it. It is suitable for batch and mass production for grinding cylindrical or conical workpieces.

● It is designed on the base of M1320, especially improved for its hydraulic cylinders, rapid advance & withdrawal cylinder, control box, pressure-valve board and oil pump. The worktable swing angle from C.W. 3° and C.C.W. 6° is increased to C.W. 5° and C.C.W. 9° . The overall appearance of the machine is also changed.

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技术规格参数 Specifications and Technical Parameters

磨削直径范围 Diameter to be ground	$\Phi 8 \sim 200$ mm
最大磨削长度 Max. length to be ground	520/750/1000 mm
中心高 Height of center	125 mm
顶尖中心距 Distance between centers	520/750/1000 mm
最大工件重量 Max. workpiece weight	50 kg
工作台最大纵向移动量 Max. longitudinal travel	600/800/1080 mm
工作台最大回转角度 Max. angle of swivel	$-5^\circ \sim +9^\circ$ / $-3^\circ \sim +9^\circ$ / $-3^\circ \sim +7^\circ$
工作台液压移动速度 Hydraulic traverse speed	0.1-4 m/min
工作台手轮-转移动量 Traverse per turn of hand wheel	6 mm/r
头架主轴转速 Spindle speed	60,85,230,120,170,460 r/min
头尾架顶尖锥度 Taper of headstock center	No.3
头架卡盘直径 Dia. of headstock chuck	125 mm
尾架套筒移动量 Stroke of center sleeve	25 mm
砂轮架快速移动量 Rapid travel of wheel head	20 mm
手轮-转砂轮架移动量 Traverse per turn of hand wheel	1 mm
微调手轮-格砂轮架移动量 Movement per graduation on micro adjustment knob	0.00125 mm
砂轮轴转速 Speed of wheel head spindle	2230/1820 r/min
砂轮架移动量 Traverse of wheel head	150 mm
砂轮规格 Max. diameter of grinding wheel	$\Phi 400 \times (40 \sim 50) \times \Phi 203$ 或 $\Phi 300 \times (25 \sim 40) \times \Phi 127$ mm
电机总容量 Total power motor	4.24 kw
机床外形尺寸 Overall dimensions of the machine (L×W×H)	2000×1420×1600/2700×1420×1600/3100×1400×1600
机床重量 Weight of the machine	2500/2900/3000 kg

机床主要附件 Main Accessories

1 冷却液箱 Coolant tank	1套 set
2 砂轮修整器 Grinding wheel dresser	1套 set
3 开式中心架 Center rest open type	1套 set
4 砂轮平衡架 Wheel balancing stand	1套 set
5 顶尖 Center	2件 piece
6 半顶尖 Half center	2件 piece
7 桃子夹头 Driving dog	1套 set
8 三角皮带、多楔带、平皮带 V belt/Poly-V belt/Fat belt	各2件 pieces each
9 垫铁 Leveling wedge (skid base)	3件 pieces
10 松卸螺帽 Unlocked nut	1件 piece
11 砂轮夹板 Wheel fixers	2套 set
12 内六角套筒扳手 Hex socket wrench	1件 piece

特殊定货附件 Extra Accessories

1 圆弧修整器 Circular wheel dresser	1套 set
2 砂轮平衡架 Wheel balancing stand	1套 set

机床工作精度(标准试件) Working Accuracy(Criterion for the Piece)

圆度 Roundness	0.0015 mm
圆柱度 Cylindricity	0.005 mm
粗糙度 Roughness	$R_a \leq 0.32 \mu m$

安装基础图 Foundation Layout

