

# Φ630mm大型外圆磨床系列

## MW1363B外圆磨床



### 机床用途与性能特征

- M1363型外圆磨床适用于磨削圆柱形或圆锥形回转体工件的外圆表面，用于单件小批生产的场合。
- 机床工作台的纵向移动可由液压无级变速传动，亦可用手轮传动。
- 砂轮架横向进给可由液压作微量自动周期进给和快速进退，亦可用手轮实现粗细两种进给。
- 砂轮架和工作台导轨采用静压润滑。
- 工件、砂轮、液压泵、冷却泵，分别由独立电机驱动。
- 机床各运动部件具有电器、液压和机械连锁结构，操作安全可靠。

### Main Applications and Structural Features

- M1363 Cylindrical Grinder is designed for grinding cylindrical or tapered surface of rotational parts. It is highly adaptable for single and small batch production.
- The table longitudinal traverse is actuated by hydraulic means at infinitely variable speed or operated by handwheel.
- Auto intermittent micro-infeed and rapid approach and withdrawal of the wheelhead can be effected hydraulically; while rough- & fine-feed realized by handwheel.
- The worktable and wheelhead guideways are hydrostatically lubricated.
- Workpiece, wheel, hydraulic pump, coolant pump, are driven separately by their individual motors.
- Each motion part of the grinder is controlled by electric, hydraulic, mechanical interlocking mechanisms, and thus the grinder can be operated with ease and safety.

# MW1363B

## 外圆磨床

### 技术规格参数 Specifications and Technical Parameters

可磨直径范围Grinding dia.	Φ30 ~ Φ630 mm
中心高Center height	350 mm
最大工件重量Max. workpiece weight	3000 kg
可磨最大工件长度Max. grinding length	2000/3000/4000/5000 mm
砂轮尺寸(外径×宽×内径)Wheel size (O.D.×W×I.D.)	Φ750×75×Φ305 mm
砂轮主轴转速Wheel-spindle speed	870 r/min
工作台最大移动量Max. worktable traverse	2150/3200/4200/5200 mm
工作台最大移动速度Max. worktable travel speed	3 m/min
砂轮线速度Wheel peripheral velocity	35 m/sec
砂轮架快速进退量Wheelhead rapid approach and withdrawal traverse	100 mm
自动周期进给量(粗/细)Automatic intermittent infeed (fine/coarse)	0.02/0.0025 mm
手动微量进给量(粗/细)Manual microfeed (fine/coarse)	0.02/0.0025 mm
油泵排量Hydraulic pump displacement	25 mL/r
油泵压力Hydraulic pump pressure	1.6 Mpa
冷却液流量Coolant flow	50 L/min
外型尺寸(长×宽×高)Overall dimensions (L×W×H)	(5320、6090、10240、12000)×2140×1550

### 机床主要附件 Main Accessories

开式中心架Open-type steady rest	1套set
砂轮压紧法兰盘Wheel flange	1套set
机床垫铁Levelling wedge	12/12/18/22套sets
测量桥板Measuring bridge-board	1件pc.
电箱Electric cabinet	1套set
润滑油箱Lubricant tank	1套set
顶尖Center	2件pc.
螺母Nut	2件pc.
砂轮外圆修整器Wheel periphery dresser	1套set
砂轮平衡轴Wheel balancing mandrel	1套set

### 特殊定货附件 Extra Accessories

磁辊纸带过滤机Paper-tape filter	1套set
磨顶尖装置Center grinding unit	1套set
砂轮平衡架Wheel balancing stand	1套set
磨削指示仪Grinding indicating instrument	1套set
单轴数显表及磁尺Single-axis digital display and magnetic bar	1套set
磁性分离器Magnetic separator	1套set
镶块顶尖Carbide-tipped center	1套set

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

圆度Roundness	3 ~ 5 μm
纵截面内尺寸一致性Uniformity of dia. in longitudinal section	8 μm
表面粗糙度Surface roughness	Ra0.32 μm

