



MW1463B外圆磨床



机床用途与性能特征

- MW1463B大型万能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和内孔表面，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。
- 内圆磨具可以磨削深长内孔达800mm。
- 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。

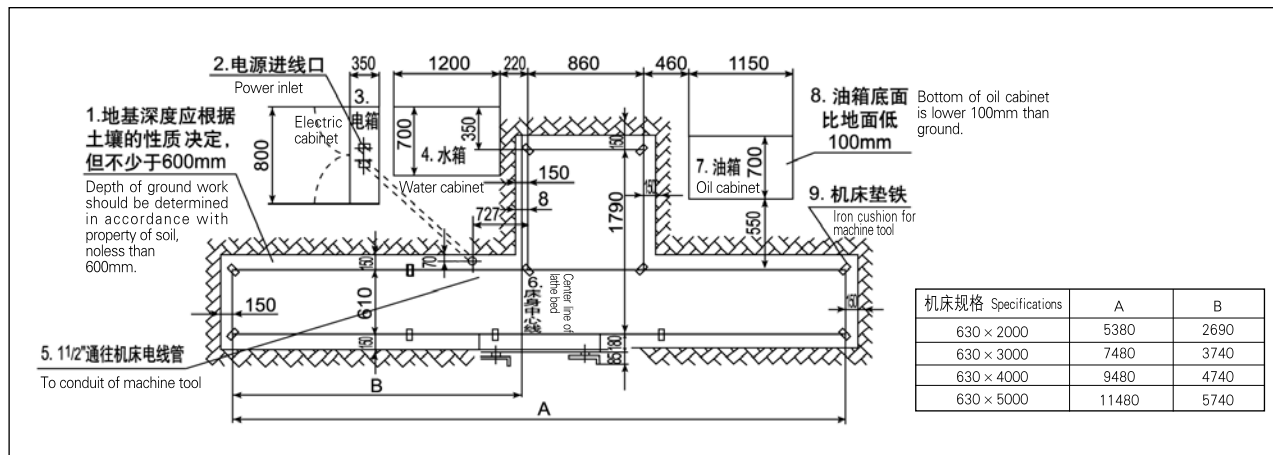
Main Applications and Structural Features

- MW1463B Large Universal Cylindrical Grinder is designed for grinding cylindrical or tapered surface of rotational parts and internal grinding. 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.
- Internal grinding length arrive at least 800 mm.
- 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.

技术规格参数 Specifications and Technical Parameters

可磨直径范围Grinding dia.	Φ30 ~ Φ630 mm
可磨内孔直径Grinding I.D.dia.	Φ30-250mm
可磨最大工件长度(外圆/内圆)Max. grinding length	2000、3000、4000、5000 mm/800mm
最大工件重量Max. workpiece weight	3000 kg
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
内圆磨具转速 Speed of interial grinding	10000, 6000, 4200, 3000r/min
中心高Center height	335 mm
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
机床重量weight	16000/18000/22000/28000 kg

安装基础图 Foundation Layout



机床主要附件 Main Accessories

开放式中心架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
内圆磨具Internal grinding	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
内圆磨杆Internal stick	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(外圆/内圆)	Ra0.32 μm/0.63 μm