

# MK1350 数控大型外圆磨床

CNC LARGE CYLINDRICAL GRINDER



## 机床用途与性能特征

- MK1350数控外圆磨床主要用于磨削大型的轴类零件。特别适用冶金行业，机车车辆行业车轴加工及柴油机、内燃机等大批量生产的场合。
- 采用德国西门子数控系统，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，工件轴向自动定位等功能，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。
- 工作台和砂轮架的驱动电机为大惯量交流伺服电机，适合加工大型零件。
- 机床配置密封性良好的全封闭防护罩壳，使工作环境卫生良好。

## Main Applications and Structural Features

- MK1350 CNC cylindrical grinder is mainly used to grind large axes parts, especially suitable for metallurgy field, mass production of locomotive, diesel engine, internal-combustion engine.
- 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	Φ30 ~ Φ500mm
顶尖距 Distance between centers	1500、2000、3000、4000mm
中心高 Height of center	270mm
最大工件重量 Max. weight of workpiece	2000Kg
砂轮尺寸 Max. dimension of grinding wheel	Φ750 × 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、Z轴分辨率 X, Z axis resolution	0.0005, 0.001mm
工作台速度 Speed of worktable	1 ~ 10000mm/min
主电机功率 Main electrical machinery power	15KW
顶尖号 Apex number	莫氏6号

## 机床工作精度 Working Accuracy

(标准试件 Criterion for the Piece Φ100 × 800 45# Chilled steel )

圆度 Roundness	≤ 2.5 μm
纵截面上直径一致性 Uniformity of dia. in longitudinal section	≤ 8 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
硬质合金顶尖 Full hard alloy center	2件 piece
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
磁辊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
东京精密或马波斯测外圆端面测量仪 Tokyo precision cylindrical meter	各1套 set
美国SBS自动平衡仪 SBS automatic balance recording meter	1套 set
电箱除湿制冷装置 Dehumidifying & refrigerating device	1套 set