

MK84100/MK84125 数控轧辊磨床

CNC ROLL GRINDER



机床用途与性能特征

MK84100/MK84125数控轧辊磨床带有CP型自动测量装置，尾架侧中心架带有U1轴(选配)工件装上机床后可以自动校正工件轴心。该机床特别适用于冶金、有色金属加工业和造纸行业的轧辊辊面的修磨。机床采用西门子840D或810D操作系统，横向进给(X)轴、纵向往复(Z)轴、中高(U)轴、测量臂(X1轴)、尾架侧中心架(U1轴)由伺服系统控制，其中X、X1和U1轴带光栅测量装置，实现闭环控制。

Main Applications and Structural Features

MK84100/MK84125 CNC roll grinder is equipped with CP type automatic measuring device.Center rest of tailstock with U1 axis can adjust axes for workpiece after mounted on machine tool.The machine is widely used,especially in the fields of metachery,nonferrous metals processing and papermaking.It adopts SIEMENS 840D or 810D operation system. Transverse feeding (x) axis.Longitudinal reciprocating(z) axis,medium-high(u) axis,measuring arm(x1 axis).Lateral center of tailstock(u1 axis) are controlled by the servo system.Among which x. x1 and u1 axis with grating measuring devices,implement closed-loop control.

技术规格参数 Specifications and Technical Parameters

	项 目 Items	MK84100	MKZ84100	MK84125	MKZ84125
加工范围 Machining scope	最大磨削直径(mm) Max grinding dia.	1000		1250	
	顶尖距(m) Center distance	4.5.6.7.8		4.5.6.7.8、10、12、15	
	工件最大重量(t) Max weight of workpiece	25		25/35	
	工件转速(无级)(r / min) Speed of Workpiece(stepless)	25		25/35	
	尾架纵向移动速度(mm / min) Vertical moving speed of tailstock	1800		1800	
	中心架支承直径(mm) Supporting dia.	Φ 100 ~ Φ 480		Φ 150 ~ Φ 780	
	拖板纵向移动速度(mm / min) Vertical moving speed of planker	50 ~ 4000		50 ~ 4000	
砂轮架 Wheel frame	砂轮床身：二导轨中心距(mm) Grinding wheel ;athe bed:center distabce between two guide-rail	1000		1000/1200	
	横向移动最大距离(mm) Max.horizontal distance	600		650	
	横向快速移动速度(mm / min) Max.horizontal distance	300		300	
	连续横进给(mm / min) Continuous horizontal feed		0.002 ~ 1.2		
	周期横进给(mm / 行程) Periodical horizontal feed		0.002 ~ 1.2		
	电子手轮进给量(mm / p) Feed volume of electric handwheel	0.001		0.001	
	砂轮规格(外×宽×内)(mm) Grinding wheel specification (outer x width x inner)	900 × 75/100 × 305		900 × 75/100 × 305	
	最大砂轮线速度(m / s) Max.grinding wheel linear speed	45		45	
	中凸(凹)量(mm) Quantity of intensive	≤2		≤2	
	测量装置测量范围(mm) Range of measuring device	150 ~ 1000		150 ~ 1250	
加工精度 machining accuracy	头架电机(kw) Headstock motor	45		55	
	砂轮电机(kw) Grinding wheel motor	55		75	
	砂轮架横进给电机(kw) Motor for horizontal feed	1.5		1.5	
	拖板纵向移动伺服电机(kw) Servo motor for planber vertical movement	3.5		3.5	
	中高伺服电机(kw) Middle and high servo motor	0.8		0.8	
	圆度 用托架支承Roudress support with bracket			0.002mm	
	圆柱度(用托架支承) Cylindricity(support with bracket)			0.002/1000mm	
	表面粗糙度(工件与砂轮适宜时)Roughness of suface(workpiece matched with grinding wheel)			Ra0.2 μ m	
辊型误差(用托架支承，中高量0.1mm) Cambering profile(support with bracket)			0.002/1000mm		