

## MMB1320B

## 精密半自动外圆磨床



## 机床用途与性能特征

- 本机床适用于大批量加工轴类零件，具有高效率，高节奏，高精度及自动检测功能，该机床结构科学合理，性能稳定可靠、外形美观大方。
- 本机床适用于汽车、拖拉机、摩托车、缝纫机、油嘴油泵等行业中大批量生产及生产线之用。
- 本机床采用程序控制磨削形式：快速趋近→粗磨→精磨→弹性磨削。达到磨削零件的高效率、高精度。

## Main Applications and Structural Features

- The machine is applied for batch production of shaft-like parts. It has high efficiency, high rate, high accuracy and automatic test functions as well as features of fine performances, reliable operation and good appearance.
- The machine is suitable for mass production and production line in the automobile, tractors, motorcycles, sewing machines, oil nozzles and pumps, etc manufacturing industries.
- The machine adopts the grinding mode under travel control: rapid approach→coarse grinding→fine grinding→elastic grinding. A high-efficient and high accuracy grinding result is thus obtained.

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## 技术规格参数 Specifications and Technical Parameters

磨削直径范围 Max. diameter to be ground	Φ8~200mm
最大磨削长度 Max. length to be ground	520/750/1000mm
顶尖中心距 Distance between centers	520/750/1000mm
中心高 Heigh of center	125mm
最大工件重量 Max. workpiece weight	50kg
工作台最大纵向移动量 Max. longitudinal travel	600/800/1080mm
工作台最大回转角度 Max. angle of swivel	-5° ~ +9° / -3° ~ +9° / -3° ~ +7°
工作台液压移动速度 Hydraulic traverse speed	0.01~4m/min
工作台手轮-转移量 Traverse per turn of handwheel	6mm/r
头架主轴转速 Spindle speed	60,85,230,120,170,460r/min
头架顶尖锥度 Taper of headstock center	No.3
头架卡盘直径 Dia. of headstock chuck	125mm
尾架顶尖锥度 Taper of tailstock center	No.3
尾架套筒移动量 Stroke of center sleeve	25mm
砂轮架快速移动量 Rapid travel of wheelhead	20mm
手轮-转砂轮架移动量 Traverse per turn of handwheel	1mm
微调手轮-格砂轮架移动量 Movement per graduation on micro adjustment knob	0.00125mm
砂轮轴转速 Speed of wheelhead spindle	2230/1820r/min
砂轮架移动量 Traverse of wheelhead	150mm
砂轮规格 Maximum diameter of grinding wheel	Φ400×(40~50)×Φ203mm
电机总容量(520mm,750mm,1000mm) Total power motor	4.24kw
机床外形尺寸(520mm,750mm,1000mm) Overall dimensions of the machine(L×W×H)	2000×1420×1600/2700×1420×1600/3100×1400×1600mm
机床重量(520mm,750mm,1000mm) Weight of the machine	2500/2900/3100kg

## 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 砂轮平衡轴 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, Flat belt	各2件pieces each
9 垫铁 Levelling wedge(fulcrum 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 Working Accuracy

圆度 Roundness	0.001mm
圆柱度 Cylindricity	0.004mm
粗糙度 Roughness	Ra≤0.04 μm

## 安装基础图 Foundation Layout

