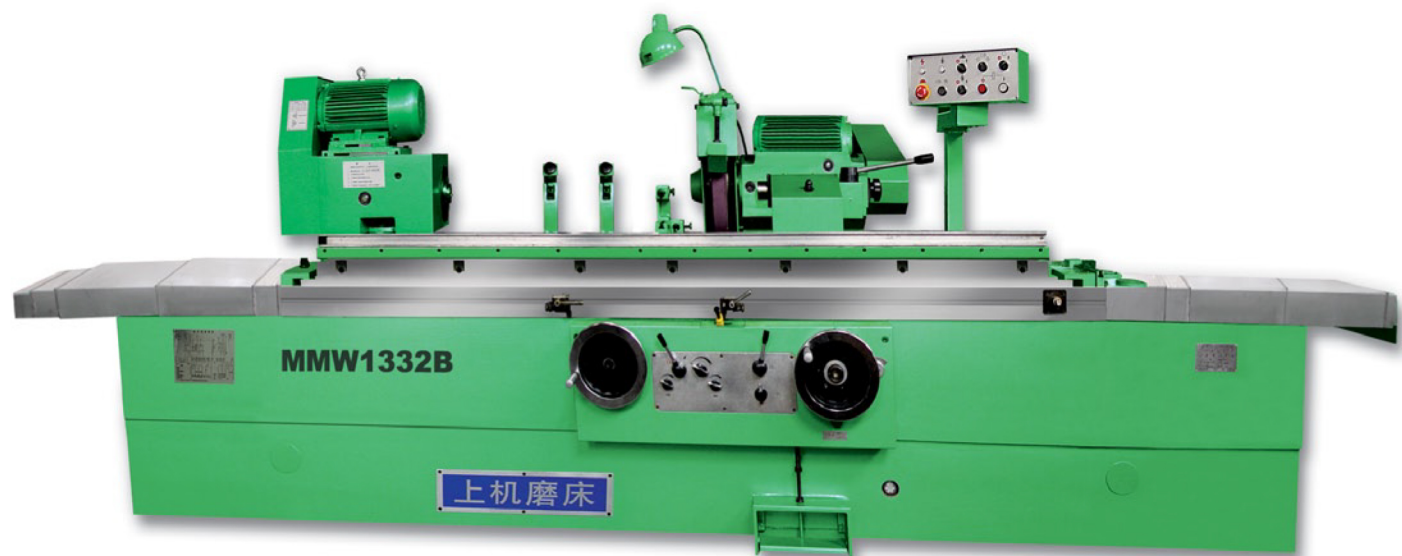


## MMW1332B

## 精密外圆磨床



## 机床主要用途与性能特征

- MMW1332B型精密外圆磨床用以加工对精度及粗糙度有较高要求的圆柱形或圆锥体的回转体工件。机床纵向移动由液压无级传动，也可用手轮传动，横向具有液压快速进退，横向进给由手轮进给。
- 机床砂轮架轴承采用动静压轴承，其精度高、刚性好。
- 头架采用交流变频调速，在转速范围内可作无级调速。尾架采用密集滚珠形式，其刚性好。
- 机床配有磨削指示仪，便于对工件进行高精度磨削。

## Main Applications and Structural Features

- Model MMW1332B precise cylindrical grinder is used for grinding the rotary workpieces such as cylindrical or conical parts which have higher requirements of accuracy and roughness. Longitudinal travel is realized by hydraulic drive at stepless speed, or by handwheel. Rapid hydraulic advance and with drawal is effected in transverse, and the transversal feed is controlled by handwheel.
- Wheelhead is supported by hydro-static-dynamic hybrid bearings, which have high accuracy and excellent rigidity.
- Workhead has A.C. freq-conversion speed with in the range of speed. Taistock is supported by dense-ball type bearing, which has excellent rigidity.
- The machine is equipped with grinding indicating instrument, benefiting high-accuracy grinding.

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## 精密外圆磨床

## 技术规格参数 Specifications and Technical Parameters

磨削直径范围 Range of grinding O.D 用中心架 with steady-rest	Φ10 ~ 60 mm
不用中心架 without steady-rest	Φ8 ~ 320 mm
最大磨削长度 Maximum grinding length	1000/1500/2000/3000 mm
中心高 Center height	180 mm
最大工件重量Max. workpiece weight	150 kg
工作台转动范围 Swivel range of worktable	-3° ~ +5° / -3° ~ +4° / -2° ~ +3° / -1.5° ~ +1.5°
砂轮最大线速度 Maximum peripheral speed of grinding wheel	35 m/s
砂轮规格 Maximum diameter of grinding wheel	Φ600 × 75 × Φ305 mm
头架主轴转速 Spindle speed	20-200 r/min
砂轮主轴转速 Wheel spindle speed	1110/555 r/min
砂轮架快速进退量 Rapid advance & withdrawal amount	25 mm
砂轮架电机功率Wheel head motor power	11 kw
机床总功率Total motor power	13 kw
机床外形尺寸 Overall dimensions of the machine	4900 × 1680 × 1665/5800 × 1680 × 1665/8000 × 1724 × 1665/11000 × 1724 × 1720 mm
机床重量Weight	3900/4700/6200/7700 kg

## 机床主要附件 Main Accessories

电箱Electric cabine	1套set
润滑油箱Lub tank	1套set
纸带过滤机Paper-tape filter	1套set
砂轮外圆修整器Wheel periphery dresser	1套set
开式中心架Open-type steady rest	1/1/2/2套sets
机床垫铁Levelling wedge	11/13/15/18块pcs
磨削指示仪Grinding indicating instrament	1套set
砂轮压紧法兰Wheel flange	1套set

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

圆度Roundness	≤ 1 ~ 2 μ m
纵截面内尺寸一致性Uniformity of diameters in longitudinal section	≤ 3 ~ 5 μ m
表面粗糙度Surface roughness	≤ Ra0.04 μ m
表面波纹度Surface waviness	≤ 0.4 μ m

## 特殊定货附件 Extra Accessories

端面修整器End-face wheel dresser
砂轮平衡架Wheel balancing apparatus

## 安装基础图 Foundation Layout

