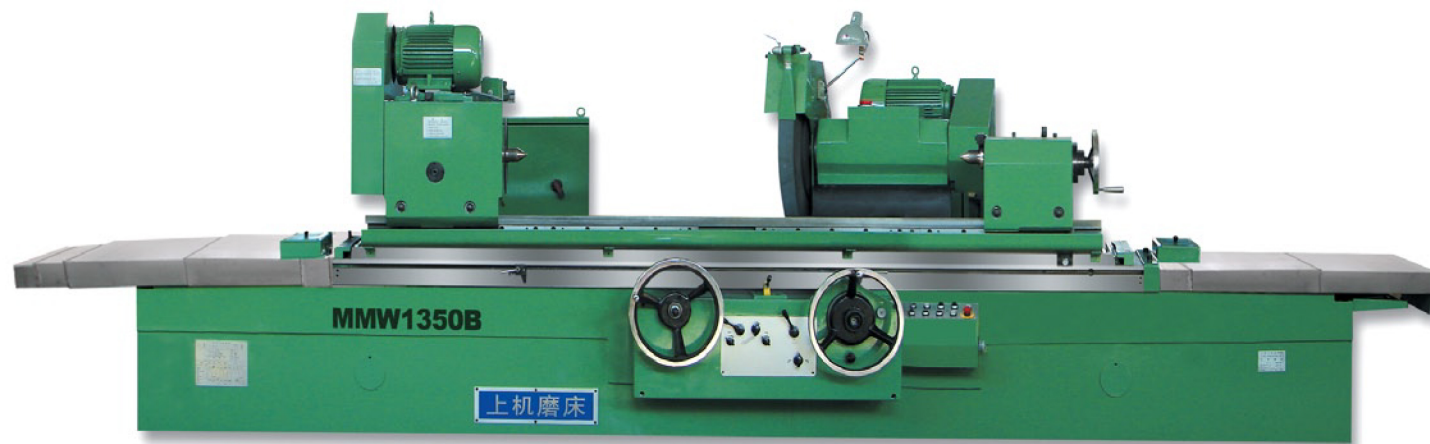


Φ500mm大型外圆磨床系列

MMW1350B精密外圆磨床



机床主要用途与性能特征

- MMW1350B型精密外圆磨床适用于磨削IT6~IT7级精度的圆柱形或圆锥形回转体工件的外圆表面，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，也可用手轮传动。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，也可用手轮实现粗细两种进给。
- 工件、砂轮、油泵和冷却泵分别用单独的电机驱动。

Main Applications and Structural Features

- MMW1350B Precise Cylindrical Ginder is designed for grinding cylindrical or tapered surface of rotational parts for accuracy class IT6~IT7. It is suitable for single and small batch production.
- Worktable longitudinal traverse is actuated by hydraulic means at infinitely variable speed or operated by handwheel. Auto intermittent micro-infeed and rapid approach & withdrawal of wheelhead is effected hydraulically; while rough- and fine-infeed can also realized by handwheel.
- Workpiece, wheel, hydraulic pump and coolant pump are driven separately by their individual motors.

MMW1350B

精密外圆磨床

技术规格参数 Specifications and Technical Parameters

可磨直径范围Range of grinding dia.	Φ25 ~ 500 mm
最大磨削长度Max. grinding length	2000/3000 mm
顶尖距Distance between centers	2000/3000 mm
中心高Center height	270 mm
最大工件重量Max. workpiece weight	2000 kg
中心架支撑直径Steady-rest supporting dia.	Φ25 ~ 200 mm
用尾架上修整器修整砂轮时最大磨削长度When the dresser mounted on the tailstock is used for dressing wheel, Max. grinding length	1750/2750 mm
砂轮规格Wheel dia.	Φ750 × 75 × Φ305 mm
砂轮主轴转速Wheel-spindle speed	448,890 r/min
砂轮线速度Wheel peripheral velocity	35 m/sec
机床尺寸(长×宽×高)Machine dimensions (L×W×H)	(8600, 10240) × 2620 × 1600 mm
砂轮架快速进退量 Rapid advance & withdrawal amount	100 mm
砂轮架电机功率Wheel head motor power	15 kw
机床电机总功率Total motor power	20 kw
机床重量Weight	12000/13500 kg

机床主要附件 Main Accessories

全套电器设备	Complete set of electric equipment	1套1set
冷却设备	Complete set of coolant equipment	1套1set
砂轮修整器	Wheel peripheral dresser	1件1pc
开式中心架	Steady rest	1套set
砂轮法兰盘	Wheel adaptors	1件1pc
砂轮平衡轴	Wheel balancing mandrel	1套1set
机床垫铁	Levelling wedge	12/18套sets

特殊定货附件 Extra Accessories

砂轮平衡架Wheel balancing stand	1套set
磁辊纸带过滤机Paper-tape filter	1套set
镶块顶尖Carbide tipped center	1件1pc
磨顶尖装置Center grinding attachment	1套set
开式中心架Open-type steady-rest	1/2套set
磁性分离器Magnetic separator	1套set

机床工作精度(标准试件) Working Accuracy(Criterion Tyr the Piece)

圆度Roundness	0.001 ~ 0.002 mm
纵截面内尺寸一致性Uniformity of dia. in longitudinal section	0.005 ~ 0.0064 mm
表面粗糙度Surface roughness	Ra0.04 μ m

安装基础图 Foundation Layout

