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CB型直动测量装置，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 Structure Features

MK84100/MK84125 CNC roll grinder is equipped with CB type automatic measuring device.Center rest of tailstock with U1 axis can adjust axes for workpiece after mounted on machine tool.The machine is widly used especially in the fields of metallurgy,nonferrous metals processing and paper making.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	MK84100	MK84125	MK84125
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	4000		4000	
	中心架支承直径(mm) Supporting dia.	Φ100～Φ480		Φ150～Φ780	
	拖板纵向移动速度(mm / min) Vertical moving speed of planker	50～4000		50～4000	
	砂轮主轴：三层动平衡(kg) Three-layer dynamic balanced grinding wheel wt.	1000		1000/1200	
	横向移动最大距离(mm) Max horizontal distance	280mm		250mm	
	横向移动最大速度(mm / min) Max horizontal distance	4000		4000	
砂轮架 Wheel frame	连续横进给(mm / min) Continuous horizontal feed	3.382～4.2			
	周期横进给(mm / 行程) Periodical horizontal feed	3.382～4.2			
	电子手轮进给量(mm / 一个刻度) Electronic manual pulse handwheel	0.001		0.001	
	砂轮规格(外×宽×内)(mm) Grinding wheel specification(out×width×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	45	45
	中凸(凹)量(mm) Quantity of crowning	≤2		≤2	
	测量装置测量范围(mm) Range of measuring device	150～1000		150～1250	
	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 planker vertical movement	2.5		2.5	
	中高伺服电机(kw) Middle and high servo motor	0.9		0.9	
加工精度 machining accuracy	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(工件与砂轮匹配)Roughness of surface(workpiece matched with grinding wheel)			Ra0.2μm	
	辊型误差(用托架支承，中高量0.1mm) Camberrid profile(support with bracket)			0.002/1000mm	

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