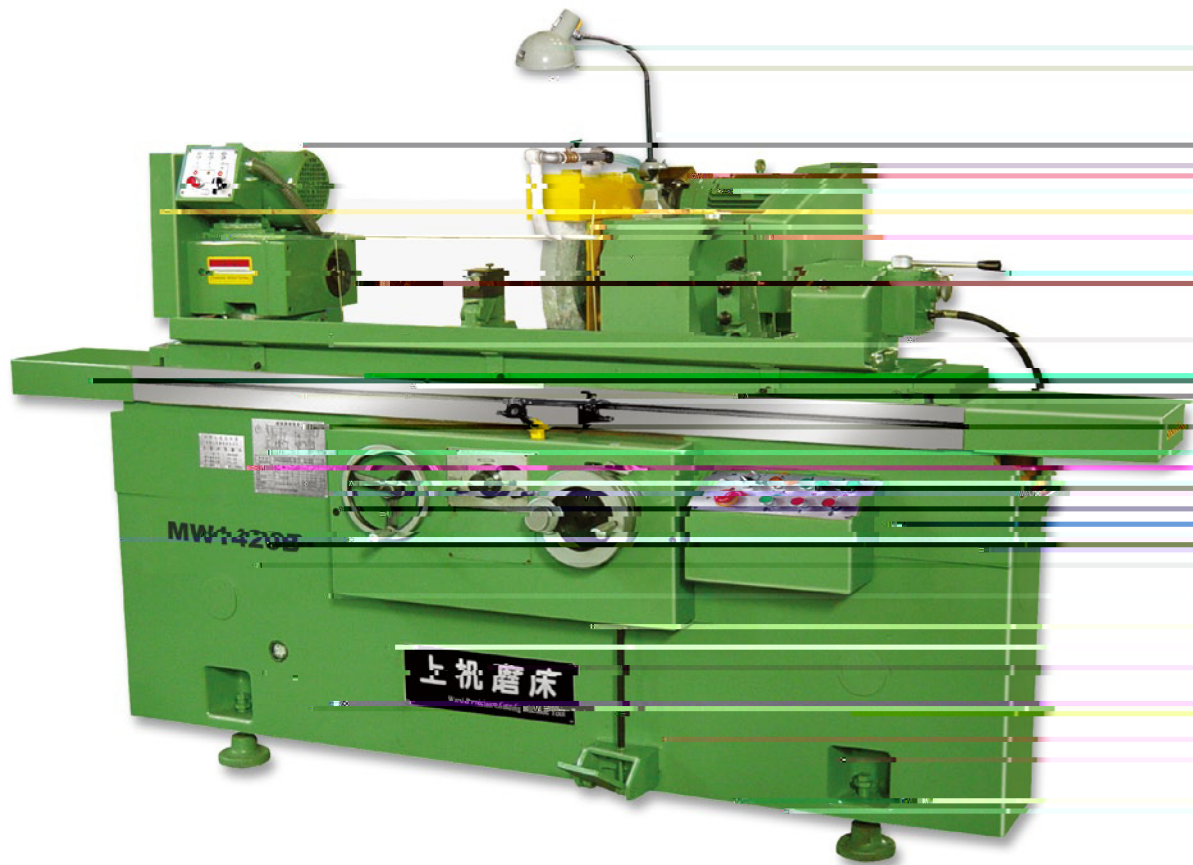


MW1420B

万能外圆磨床



机床用途与性能指标

- 本机床适用于磨削圆柱形和圆锥形的外圆和内孔，也可磨削轴向端面，宜用于批量生产及各种机加工行业使用，具有精度高、刚性强、磨削效率高、操作方便等特点，结构先进，造型美观。
- 本系列机床的主轴套纵向磨头安装在可移动的砂轮架和头架上，外圆砂轮采用 $\Phi 400 \times 40 \times \Phi 203$ ，提高了磨削效率及砂轮耐用度。头架空套可转动，砂轮架空套带微量进给装置，可实现微量进给，低噪音专用油泵，供油平稳，噪音低，主台液路在往复，具有抖动装置，可实现小进给频率换向功能，提高切入磨削工件时的表面质量。

Main Applications and Summary of Features

- The machine is suitable for grinding external and internal cylindrical and cone and end faces. It can be used for medium, large and small batch production of parts or in maintenance shop. Beside its advanced structure and beautiful appearance, the features include high accuracy, strong rigidity, high grinding efficiency, ease in operation, etc.
- The series grinding disc are all fully built with blades and driven longitudinally traveling by hydraulic or manual control and a discharge wheel head and work head will be in a position to grind in a range of grinding work with grinding efficiency and high productivity. When the spindle of work head is rotating, the work head can be moved horizontally and vertically in a range of 100mm and 150mm respectively. The work head can be moved with a low noise hydraulic cylinder and a worktable gear drive all sliding. Hence the required automatic reversing function is thus realized to improve surface grinding quality when a workpiece is ground with planar feed.

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技术规格参数 Specifications and Technical Parameters

磨削孔径范围 Diameter to be ground	485~800 mm
最大磨削长度 Max. length to be ground	114~800 mm
中心高 Height of center	125 mm
顶尖中心距 Distance between centers	520/550/600 mm
最大工件重量 Max. workpiece weight	50 kg
工作台最大纵向移动量 Max. longitudinal travel	560/600/650 mm
工作台最大回转角度 Max. angle of swivel	-5° ~ +9° / -3° ~ +9° / -3° ~ +7°
工作台纵向移动速度 Longitudinal traverse speed	0.3~4 m/min
工作台横向移动速度 Transverse per worm drive speed	0.5 m/min
头架主轴转速 Spindle speed	60, 65, 230, 420, 470, 460 r/min
头架顶尖锥度 Taper of headstock centers	1:50
头架卡盘直径 Dia. of headstock chuck	175 mm
尾架顶尖锥度 Taper of tailstock center	1:50
砂轮架快速移动量 Rapid travel of wheel head	20 mm
手轮-砂轮架移动量 Wheel-travel of wheel head	1 mm
微进手轮-砂轮架移动量 Micro-feed travel of wheel head	0.005 mm
砂轮架转速 Spindle speed of wheel head	223/230/235 r/min
砂轮架移动量 Travel of wheel head	150 mm
砂轮架规格尺寸 Dimensions of grinding wheel	3400×400×50 / 3230×400×50 / 3170×400×50
砂轮重量 Wheel weight	120 kg
机床外形尺寸 Overall dimensions	2200×850×1250/2200×850×1250/2200×850×1250
机床重量 Machine weight	2200 kg

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 I amper rest stand	1套 set
4	砂轮平衡轴 Wheel balancing shaft	1套 set
5	三代式座 Three- jaw chuck	1套 set
6	顶尖 Center	2件 piece
7	半圆顶尖 Half center	2件 piece
8	桃子夹头 Driving dog	1套 set
9	三角皮带、多楔带 平皮带 V belt Poly-V belt Flat belt	各 7件 pieces each
10	垫铁 Levelling wedge (skum base)	3件 pieces
11	松卸螺帽 Unlocked nut	105件 pieces
12	砂轮夹板 Wheel clamps	2套 sets
13	中座连接轴 Middle shaft connecting rod	1件 piece
14	1角云台角手扳扳子 Socket wrench	11件 pieces
15	滤板 B plate	1套 set

材料力学附注

1. 回部转码器 `IrregularWordMapper` 1套set
2. 词频统计器 `IrregularWordStats` 1套set

มหาวิทยาลัยราชภัฏวไลยอลงกรณ์ จ. สิงห์บุรี

圓度 roundness	圓周度
圓柱度 cylindricity	圓柱度
圓柱度 cylindricity	圓柱度

អានុវត្តន៍ កាលបរិច្ឆេទ: ២៥/០៤/២០២០

