

MA1420/H 万能外圆磨床

Universal Cylindrical Grinder

用途与特征

- 本机床用于磨削内、外圆柱形和圆锥形的工件，最适宜单件小批及成批生产的车间使用。
- 工件、外圆砂轮、内圆砂轮、油泵和冷却分别由独立电机传动。机床工作台纵向移动可由液压无级传动，也可由手轮传动，砂轮架横向进给移动具有液压快进移动和自动周期进给及手动进给几种形式。



Main Application and Features

- This machine is mainly used for grinding internal, external cylindrical and conical surface of parts. It is ideal for single piece and small & medium-batch workshop.
- Workpiece, internal and external grinding wheel, oil-pump, coolant pump are driven separately by their individual motors. Worktable longitudinal traverse is actuated at infinitely variable speed by hydraulic means or by hand operation. Wheelhead cross feed is provided with hyd. rapid approach & withdrawal, auto. intermittent feed, manual feed.

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规格及主要技术参数

Main Specifications

机床规格	Grinding capacity				Φ200 x 500,750mm
可磨直径	Grinding diameter	外圆(O. D.)	用中心架with steady-rest	最小min/最大max	8/60mm
			不用中心架without steady-rest	最小min/最大max	8/200mm
		内圆(I. D.)	用中心架with steady-rest	最小min/最大max	35/100mm
			不用中心架without steady-rest	最小min/最大max	25/100mm
工件最大重量	Max. work weight				50kg
最大磨削长度	Max. grinding length		外圆(O. D.)		500,750mm
			内圆(I. D.)		125mm
中心高	Center height				135mm
砂轮主轴转速	Wheel spindle speed				1670r/min
砂轮尺寸	Wheel dimensions(O.D. X W X I.D.)		最大Max.		Φ400 x 50 x Φ203mm
			最小Min.		Φ280 x 50 x Φ203mm
砂轮线速度	Wheel peripheral velocity				35m/s
内圆磨具砂轮尺寸	Wheel size for int. grinding attachment		最大Max.		Φ50 x 25 x Φ13mm
			最小Min.		Φ16 x 20 x Φ6mm
工作台纵向最大移动量	Max. worktable longitudinal trave				550, 800mm
机床电气总功率	Total motor power				8.2kw
外形尺寸(长×宽×高)	Overall dimensions(L x W x H)		500mm		2500 x 1800 x 1650mm
			750mm		3000 x 1800 x 1650mm
机床重量	Machine weight		500mm		3200kg
			750mm		3700kg

工作精度

Working Accuracy

外圆圆度	0.0015mm
O.D. Roundness	
纵截面内直径一致性	0.005mm
Uniformity of dia. in longitudinal section	
表面粗糙度	Ra0.32 μm
Surface roughness	
内圆圆度	0.0025mm
I.D. Roundness	
内圆表面粗糙度	Ra0.63 μm
I.D. Surface roughness	
卡盘上磨外圆圆度	0.0025mm
Q D roundness by chuck	

主要附件

Main Accessories

全套电器设备		1套set
Complete set of electric equipment		
全套冷却设备		1套set
Complete set of coolant equipment		
砂轮外圆修整器		1套set
Wheel peripheral dresser		
砂轮压紧盘		2套sets
Wheel hub		
砂轮平衡轴		1套set
Wheel balancing arbor		
内圆磨具		1套set
Int grinding attachment		
测量桥板		1套set
Measuring bridge-plate		
开式中心架		1套set
Open-type steady-rest		
机床垫铁		
Leveling wedge	500mm	9套sets
	750mm	11套sets

特殊附件

Special Accessories

砂轮平衡架		1套set
Wheel balancing stand		
圆弧修整器		1套set
Radius dresser		
磨杆		5套sets
Extension bar		
闭式中心架		1套set
Close-type steady-rest		
四爪卡盘		1套set
Four-jaw chuck		
KN型四爪卡盘结合法兰		1套set
(KN type) four jaw chuck with flange		
端面外圆修整器		1套set
Wheel periphery and End-face dresser		

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由于技术不断发展, 本样本仅供参考 具体参数与配置以签订的合同为准 2022年9月
Considering continuous development of technology, above information is for reference only.