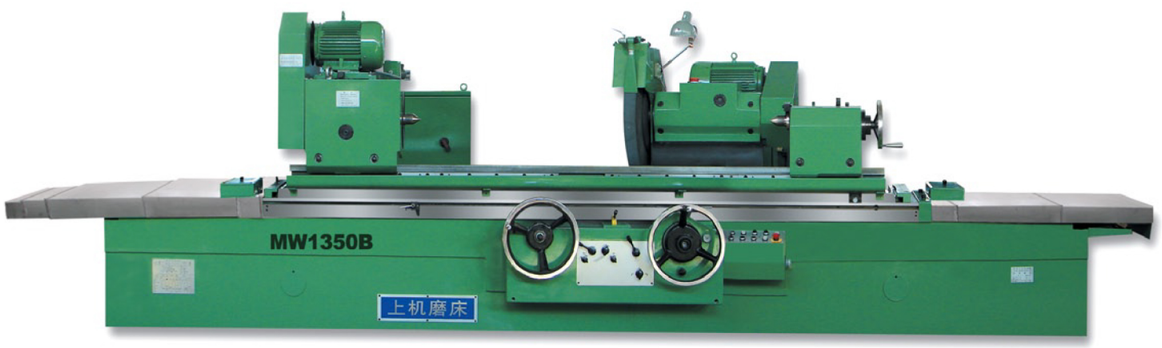
Φ500mm大型外圆磨床系列

MW1350B外圆磨床



机床用途与性能特征

- MW1350B型外圆磨床适用于磨削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，亦可用手轮传动。
- 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，亦可用手轮实现粗细两种进给。
- 砂轮架和工作台导轨采用静压润滑。
- 配置Φ750×75×Φ305砂轮进行高效强力磨削，其磨削效率快、精度高。
- 工件、砂轮、液压泵、冷却泵，分别由独立电机驱动。
- 机床各运动部件具有电器、液压和机械连锁结构，操作安全可靠。

Main Applications and Structural Features

- MW1350B Cylindrical Grinder is designed for grinding cylindrical or tapered surface of rotational parts. It is highly adaptable for single and small batch production.
- The table logitudinal traverse is actuated by hydraulic means at infinitely variable speed or operated by handwheel.
- Auto intermittent micro-infeed and rapid approach and withdrawal of the wheelhead can be effected hydraulically; while rough- & fine-feed realized by handwheel.
- The worktable and wheelhead guideways are hydrostatically lubricated.
- Grinding wheel of Φ750×75×Φ305 is used for high-efficient heavy grinding with rapid speed and high accuracy.
- Workpiece, wheel, hydraulic pump, coolant pump, are driven separetely by their individual motors.
- Each motion part of the grinder is controlled by electric, hydraulic, mechanical interlocking mechanisms, thus the grinder can be operated with ease and safety.

MW1350B

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～Φ500 mm
可磨最大工件长度Max. grinding length	1000/1500/2000/3000/4000 mm
中心高Center height	270 mm
最大工件重量Max. workpiece weight	2000 kg
砂轮尺寸(外径×宽×内径)Wheel size (O.D.×W×I.D.)	Φ750×75×Φ305 mm
砂轮主轴转速Wheel–spindle speed	870 r/min
工作台最大移动量Max. worktable traverse	1080/1603/2100/3200/4200 mm
工作台最大移动速度Max. worktable travel speed	3 m/min
砂轮线速度Wheel peripheral velocity	35 m/sec
砂轮架快速进退量Wheelhead rapid approach and withdrawal traverse	100 mm
自动周期进给量(粗／细)Automatic intermittent infeed (fine/coarse)	0.02/0.0025 mm
手动微量进给量(粗／细)Manual microfeed (fine/coarse)	0.02/0.0025 mm
油泵排量Hydraulic pump displacement	25 mL/r
油泵压力Hydraulic pump pressure	1.6 Mpa
冷却液流量Coolant flow	50 L/min
电机总功率Total motor power	20.63 kw
砂轮电机功率Wheel head motor power	15 kw
机床重量（约）weight(Almost)	8300/8600/9900/11350/14000 kg
外型尺寸(长×宽×高)Overall dimensions (L×W×H)	(5800、7000、8600、10240、12000)×2140×1550

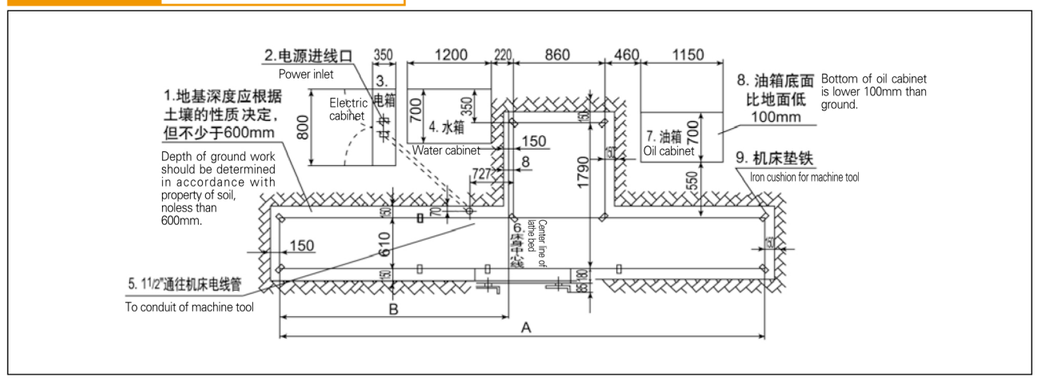
机床主要附件 Main Accessories

全套电器设备	Complete set of electric equipment	
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	12/12/12/18/22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(可磨长度)Open–type steady–rest(length to be ground)	(1500/2000/3000mm)1/2/3套set
磁性分离器Magnetic separator	1套set

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

圆度Roundness	3～5μm
纵截面内尺寸一致性Uniformity of dia. in longitudinal section	8μm
表面粗糙度Surface roughness	Ra0.32μm
表面波纹度Surface waviness	1.6μm

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