

# M1432B 万能外圆磨床

## Universal Cylindrical Grinder

### 用途与特征

- M1432B型系综合M131W和M1432A的优点进行改进的，是一种手动操纵、电气、液压控制的万能外圆磨床。
- 该机床床身刚性及热变形都优于M1432A，工作台的润滑为小孔节流卸荷形式。砂轮架主轴加粗，电机功率加大。砂轮架油池温升小，磨削率高。
- 机床工作台的纵向移动、砂轮架的快速进退、砂轮自动周期进给等均由操作按钮、电气、液压控制。机床具有工作台手动机构，砂轮架手动横向进给机构和液压脚踏尾架顶尖后退装置。
- 头架在逆时针方向90度范围内可作任意角度调整。摆动头架或工作台或砂轮架的角度即可磨削不同锥度的内外圆锥形工件。将砂轮架体壳上的内圆磨具支架翻下即可磨削内圆零件。具有6套内圆磨杆供选择使用。
- 机床采用具有各运动部件的电气、液压连锁机构、操作安全可靠。外圆砂轮、内圆砂轮装有可靠的安全保护罩。



### Main Application and Features

- M1432B Universal Cylindrical Grinder is an improved and renovated design of its predecessor, M131W and M1432A, with full retainment of their noteworthy merits. It is operated by hand and can be controlled and actuated either by power or by hydraulic system.
- In comparison the machine is superior to M1432A in the following field: Greater rigidity and resistance to temperature change deformation of the machine body; large diameter for the grinding wheel spindle; more power of the grinding wheel and use of small orifice lubricant restrictor for off setting table load for better table lubrication. All these improvements result in higher efficiency and better finish in grinding performance.
- Machine table longitudinal travel, wheelhead rapid approach and withdrawal and automatic periodic cross infeed are driven hydro-electrically by pushing button operation. The machine also has the following functions: hand-operated worktable and wheelhead manually traverse infeed plus hydraulic tailstock quill retraction by foot.
- The headstock can be swiveled in counter-clockwise direction in 90 degree range. By swiveling the headstock, or wheelhead or table, components with different external or internal taper can be ground. By turning down the internal grinding attachment, internal surface of components can be provided for grinding selection. 6 sets of internal cylindrical grinding pin are available.
- All the power moving portions of the machine are interlocked by electro hydraulic mechanism to ensure safety in operatin, External and internal grinding wheels are guarded in sound and strong covers.

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### 规格及主要技术参数

### Main specifications

可磨直径 (外圆/内圆)	Grinding diameter (O. D./I. D.)	Φ8~Φ320/30~100mm
可磨长度 (外圆/内圆)	Grinding length (O. D./I. D.)	1000, 1500, 2000, 3000/125mm
中心高	Center height	180mm
最大工件重量	Max. workpiece weight	150kg
工作台速度	Worktable speed	0.1~4m/min
砂轮架快速进退量	Wheelhead rapid approach and withdrawal	50mm
砂轮线速度	Grinding wheel peripheral speed	35m/s
进给手轮每格刻度值 精/粗	Wheelhead displacement per div. on hand wheel scale ( fine/coarse )	0.0025/0.01mm
内圆砂轮转速	Internal grinding wheel speed	10000r/min
油泵压力	Hydraulic pump pressure	6.3MPa
油泵排量	Hydraulic pump capacity	10ml/min
冷却液流量	Coolant pump capacity	25L/min
电机总功率	Total motor power	10KW
砂轮电机功率	Wheelhead power	5.5KW
机床重量	Machine weight	3370, 3830, 4300, 6200kg
外形尺寸 (长×宽×高)	Overall dimensions(L×W×H)	3360, 4360, 6760, 9180×1810×1515mm

### 工作精度 Working Accuracy

圆度 Roundness	≤1500 0.0015mm
(外圆/内圆) (outer circle/inner circle)	>1500 0.0025mm/0.0025mm
纵断面内直径的一致性 Dia.uniformity in the long. section	≤1500 0.005mm
(外圆/内圆) (outer circle/inner circle)	>1500 0.008mm/0.010mm
表面粗糙度 Surface roughness	
(外圆/内圆) (outer circle/inner circle)	Ra0.32 μm/0.63 μm

### 主要附件 Main Accessories

全套电器设备 Full set of electric equipment	1套 set
全套冷却设备 Full set of coolant equipment	1套 set
砂轮外圆修整器 Wheel periphery dresser	1套 set
砂轮压紧盘 Wheel hub	2套 sets
砂轮平衡轴 Wheel balancing mandrel	1套 set
开式中心架 Open-type steady-rest	≤1500 1套 set >1500 2套 sets
机床垫铁 Leveling wedges	1000×11套 sets 1500×13套 sets 2000×15套 sets 3000×18套 sets

### 特殊附件 Special Accessories

闭式中心架 Close-type steady rest	1套 set
砂轮平衡架 Grinding wheel balancing stand	1套 set
圆弧修整器 Radius dresser	1套 set
端面修整器 End-face dresser	1套 set

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