

MC1363/H 外圆磨床

Cylindrical Grinder

用途与特征

- 本机床为普通型外圆磨床，适用于磨削IT6-IT7级精度的圆柱形回转表面，适用于单件小批量生产场合。
- 机床工作台的纵向移动由液压无级变速传动，也可用手轮传动，砂轮架横向进给由液压作微量自动周期进给和快速进退，也可用手轮实现粗细两种进给。
- 工件回转速度由电气无级调节实现，并由交流变频电机带动。
- 砂轮主轴为静压轴承支承，以提高磨削表面质量。
- 砂轮架横向进给有磁栅数显位移，并配备磨削指示仪，以方便操作。（特殊订货）



Main Application and Features

- MC1363/H Series are conventional cylindrical grinders, mainly used for grinding cylindrical surface which accuracy-class IT6-IT7, it suitable for single-piece or small batch production.
- Worktable long. movement is carried out by hydraulic drive with infinitely variable speed, or by handwheel drive. Wheelhead cross feed is provided with auto. hydraulic micro intermittent-feed and rapid advance & retract, and also with rough and fine feed by handwheel.
- Workpiece rotating speed is realized in accordance with the electric-adjusted infinitely-variable-speed, and driven by AC frequency-conversion motor.
- Wheelhead spindle is equipped with hydro-static bearings, for improving ground surface quality.
- Wheelhead cross feed is provided with DRO display unit for displacement, and also equipped with grinding indicator for the convenience of operation. (For special order)

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规格及主要技术参数

Main specifications

最大回转直径	Max. Swing diameter			630mm
在中心架可磨直径	Grinding diameter by steady rest	最大	max	350mm
		最小	min	30mm
中心高	Center height			370mm
磨削工件长度	Max. Grinding length			2000, 3000, 4000, 5000mm
工件最大重量	Max. work piece weight			3000kg
最小周期进给量	Min. cycle feeding			0.0025mm
头架回转可能性	Workhead rotary			不可能 impossible
主轴回转可能性	Spindle rotary			不可能 impossible
头架拨盘转速 (无级可调)	Workhead driving plate (infinitely variable speed)			10-100 r/min
头尾架顶尖锥孔	Workhead and tailstock center hole			公制#80
手轮一转工作台移动量	Worktable movement per rev. of handwheel			5mm
最大回转角	Max. swing angle	顺时针	C.W.	1° 1° 1° 1°
		逆时针	C.C.W.	3° 3° 3° 1°
砂轮转速	Grinding wheel speed			891r/min
砂轮直径	Grinding wheel diameter	最大	max	Φ750mm
		最小	min	Φ550mm
砂轮线速度	Grinding wheel peripheral velocity			35m/sec

工作精度

Working Accuracy

圆度 Roundness	2000.3000试磨件: Φ100 x 1000 0.0025mm
	4000.5000试磨件: Φ150 x 1500 0.0025mm
纵截面内直径一致性 Dia. uniformity in the long. section	2000.3000: 0.008mm 4000.5000: 0.012mm
表面粗糙度 Surface roughness	Ra0.32μm

主要附件

Main Accessories

中心架 Steady-rest	Φ30~Φ200 Φ200~Φ350	2套 sets 2套 sets
砂轮外圆修正器 Wheel periphery dresser		1套 set
砂轮压紧法兰 Wheel hub		2套 sets
测量桥板 Measuring bridge-plate		1套 set
机床垫铁 Leveling wedges	2000mm HJX81-2 3000mm HJX81-2 4000mm HJX81-2 5000mm M1380/H-77/1	18套 sets 22套 sets 26套 sets 13套 sets

特殊附件

Special Accessories

磨削指示仪 Grinding indicator
磨顶尖装置 Center grinding device
砂轮平衡架 Wheel balancing stand
磁尺 Magnetic scale

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Considering continuous development of technology, above information is for reference only.