

MK84100/MK84125 数控轧辊磨床

CNC ROLL GRINDER

技术规格参数 Specifications and technical Parameters

	项 目 Items	MK84100 MKZ84100	MK84125 MKZ84125
加工范围 Machining scope	最大磨削直径(mm) Max grinding dia.	1000	1250
	顶尖距(m) Center distance	4.5, 6, 7, 9	4.5, 6, 7, 9, 10, 12, 15
	工件最大重量(t) Max weight of workpiece	25	25/35
	工件转速(转/分) Workpiece speed (rev/min)	25	25/35
	尾架纵向移动速度(mm/min) Vertical moving speed of tailstock	0~300	0~300
	中心架支承直径(mm) Support dia.	Φ100~Φ450	Φ100~Φ700
	拖板纵向移动速度(mm/min) Vertical moving speed of platen	50~4000	50~4000
	砂轮速度(转/分) Grinding wheel speed (rev/min)	1000	1000/1200
	横向移动最大距离(mm) Max horizontal distance	300mm	300mm
	纵向移动速度(mm/min) Max longitudinal speed	400	400
砂轮架 Wheel frame	连续横进给(mm/min) Continuous cross feed	3.002/0.002	
	周期横进给(mm/行程) Periodical cross feed	3.002/0.002	
	电子干涉仪量测精度(μm) Electronic interferometer accuracy	0.001	0.001
	砂轮规格(外×宽×内)(mm) Grinding wheel specification (out×width×in)	Φ300×75/Φ100×300	Φ300×75/Φ100×300
	最大砂轮线速度(m/s) Max grinding wheel linear speed	45.45	45.45
	中凸(凹)量(mm) Quantity of middle bump	≤2	≤2
	测量装置测量范围(mm) Measuring device range	150, 1000	150, 1250
	头架电机(kw) Headstock motor	45	55
	砂轮电机(kw) Grinding wheel motor	55	75
	砂轮架横进给电机(kw) Motor for horizontal feed	1.5	1.5
	拖板纵向移动伺服电机(kw) Servo motor for platen vertical movement	2.5	2.5
	中高伺服电机(kw) Middle and high servo motor	0.8	0.8
加工精度 machining accuracy	圆度 用托架支承 Roundness support with bracket		0.002mm
	圆柱度(用托架支承) Cylindricity (support with bracket)		0.002/0.003mm
	表面粗糙度 Ra 用托架支承 Surface roughness Ra support with bracket		Ra1.25μm
	轮廓误差(用托架支承, 中高量0.1mm) Contour error (support with bracket)		0.002/0.003mm

机床用途与性能特征

MK84100/MK84125数控轧辊磨床带有C型自动测量装置,尾架侧中心架带有U1轴(选配)工件装夹机床后可以自动校正工件轴心。该机床特别适用于冶金、有色金属加工业和造纸行业的轧辊轮面的修磨。机床采用西门子840D或810D操作系统,横向进给(X)轴、纵向往复(Z)轴、中高(U)轴、测量臂(X1轴)、尾架侧中心架(U1轴)由伺服系统控制,其中X、X1和U1轴带光栅测量装置,实现闭环控制。

Main applications and structure features

MK84100/MK84125 CNC roll grinder is equipped with C-type automatic measuring device.Center rest of tailstock with U1 axis can adjust axes for workpiece after mounted on machine tool.The machine is widely used especially in the fields of metal rolling,nonferrous metal processing and papermaking.It adopts SIEMENS 840D or 810D operation system. Transverse feeding (x) axis,Longitudinal reciprocating (z) axis,medium-high (u) axis,measuring arm (x1 axis),Lateral center of tailstock (u1 axis) are controlled by the servo system.Among which X,X1 and U1 axis with grating measuring devices implement closed-loop control.