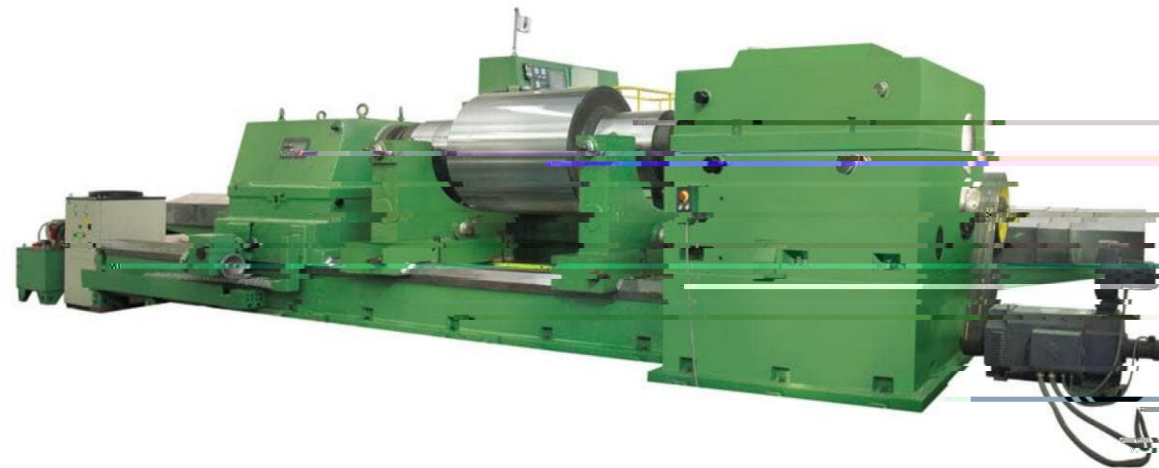


MK84160/MK84200 数控轧辊磨床



机床用途与性能特征

- MK84160/MK84200机床适用于冶金、造纸、有色金属加工行业，被带轮线辊子的修磨，也可用于辊颈的磨削加工。
- 该机床也可以同样适用于加工其它大型精类工件的外圆、端面、锥面以及中高车削的磨削加工。
- 机床采用西门子840D/810D操作系统，经万选经古伊服电机通过无背隙蜗轮蜗杆、滚珠丝杠传动，
- 并且可选装数控测量装置，实现高精度的测量，机床的重复定位精度可达 $\pm 0.001\text{mm}$ ，轴采用伺服电机驱动，蜗轮蜗杆一齿轮齿条传动，u轴(中高微量进给机构)由伺服电机通过无背隙蜗轮—蜗杆—偏心套杠杆机构驱动，实现秒级主轴的微量进给。
- 机床可选装伺服空心轴(轴)与数控测量装置配合使用，用以校正工件安装时轴线的偏差。
- 配以翻箱机构和软着陆装置(选配)，可以对带轴承的孔辊进行辊面修磨。

Main Applications and Structural Features

- MK84150/MK84200 machine tool can be widely applied in the fields of metal turning, grinding, and processing of various precision parts.
- This machine can also be applied to process circular outer shaftlike workpiece, endface and conical surface.
- It is driven by series motor through worm gear and ball screw.
- Raster glass measuring device is provided to achieve the X-axis closed-loop control accuracy or resetting for machine tool.
- The main drive gear and worm gear are high-precision (high micro feed mechanism) is driven by servo motor through no back-gap worm-worm gear-eccentric sleeve lever mechanism, implement the micro feeding.
- It can match servo center rest (U1 axis) with CNC measuring device to calibrate the deviation of axes.
- Set with repacking unit and soft lander (optional) to grind the face for the roller with bearing box.

技术规格参数 Specifications and Technical Parameters

最大顶尖距 Max. from top	3, 5, 10, 15, 20, 30, 40 mm
工件最大重量(托架支承) Max. weight of workpiece (Supporting by bracket)	500 kg
工件转速 Speed of Workpiece	4~40 转/分 circ./min
砂轮最高线速度 Highest speed grinding	15 米/秒 m/sec
拖板纵向移动速度 Movement speed of dragging table vertical	0.02~0.022
砂轮架横向移动最大距离 Max. horizontal distance of grinding wheel	350 mm
砂轮架横向快速进给速度 Speed of horizontal movement distance	300 毫米/分 mm/min
磨削进给量 Intensity of intensive	≤ 2 mm
连续横向进给速度 Speed of continuous horizontal feed	0.002 ~ 1.2 毫米 / 分 mm/min
周期横进给 Periodical horizontal feed	0.002 ~ 1.2 毫米 / 分 mm/min
手动进给微量进给装置 Shallow manual feed (micro electronic hand wheel)	0.001 毫米 / 转 mm/rev
砂轮架纵向行程范围 Vertical adjustment of grinding wheel frame	250, 400, 600, 800 mm
尾架纵向移动速度(机动) Stern frame vertical movement speed (mobile)	1800 毫米 / 分 mm/min
手动速度 Manual speed	1.2 毫米 / 转 mm/rev
尾架顶尖套筒调节距离 Stern frame top sleeve adjusting distance	450 mm
中心架支承直径 Supporting dia.	Φ300 ~ Φ600, Φ600 ~ Φ900 mm

主要电机 Main motor

砂轮电动机功率(Wheel motor power)	75千瓦
拖板移动电动机扭矩(Table moving motor torque)	72牛·米
砂轮架横进给电机扭矩(Wheel frame transverse feeding motor torque)	16.9牛·米
测量进给电机的扭矩(Torque of measuring feed motor)	4.2牛·米
尾架套筒调整电动机功率(Tailstock sleeve adjusting motor power)	1.5千瓦
CNC中高磨削电动机扭矩(Torque of high grinding motor)	0.5牛·米
静压导轨及滑座电动机功率(Static pressure guide and slideway motor power)	1.5千瓦
静压导轨及滑座电动机功率(Static pressure guide and slideway motor power)	5.5千瓦

加三作友 "Willing to be friends"

圓柱型中磨削 Grinding cylindrical roller	0.005mm
圓盤式磨削 Superficial grinding	0.005mm
圓柱度 cylindricity	0.005mm
表面粗糙度 (工件与砂轮适宜时) surface roughness (grinding workpiece and wheel appropriate)	0.025mm
曲线磨削 Curved grinding	0.005mm
批生产 (用托架支承, 中重量) Batch production (with support, medium weight)	0.002mm
大批生产 (用托架支承, 重量) Mass production (with support, weight)	0.002mm
六齿粗磨 Six-tooth rough grinding	0.01mm



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