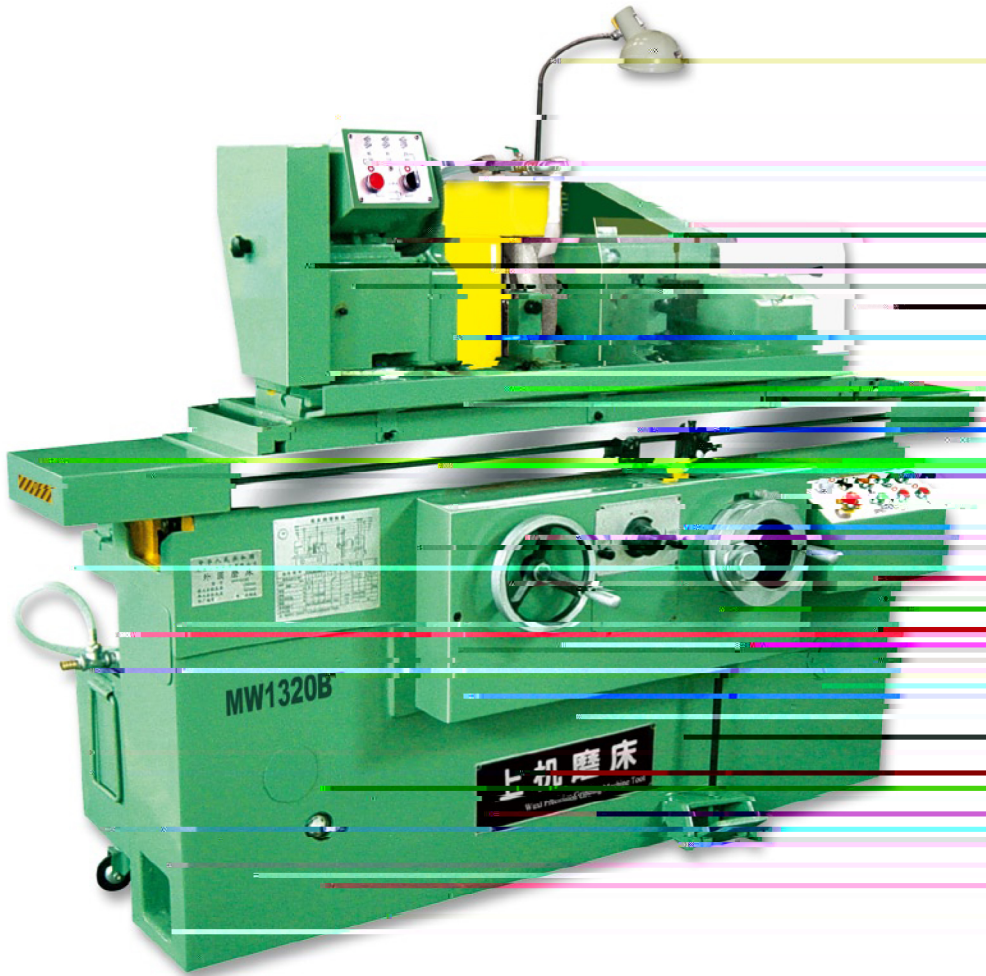


CYLINDRICAL GRINDING MACHINE

MW1320B

外圆磨床



MW1320B

外圆磨床

技术规格参数 Specifications and Technical Parameters

磨削直径范围 D. diameter to be grinded	Φ80-200 mm
最大磨削长度 Max. length to be grinded	520/750/1000 mm
中心高 Height of center	125 mm
顶尖中心距 Distance between centers	520/750/1000 mm
最大工件重量 Max. workpiece weight	50 kg
工作台面最大纵向移动量 Max. longitudinal travel	520/750/1000 mm
工作台面最大倾斜角度 Max. angle of swivel	3°/5°/6°
砂轮架快速进给速度 Rapid traverse speed	100 mm/min
工作台面手轮-转移动量 Traverses per turn of hand wheel	6 mm/turn
砂轮架快速进给速度 Rapid traverse speed	60/85/230/120/170/460 mm/min
头尾架顶尖锥度 Taper of headstock & tailstock	1:20
砂轮架重量 Weight of headstock	125 kg
尾架套筒移动量 Stroke of center lathe	25 mm
砂轮架快速进给速度 Rapid traverse of wheel head	20 mm/min
砂轮架快速进给速度 Rapid traverse of wheel head	100 mm/min
砂轮架快速进给速度 Rapid traverse of wheel head	230/460 mm/min
砂轮架快速进给速度 Rapid traverse of wheel head	100 mm/min
砂轮规格 Max. diameter of grinding wheel	Φ400×(40-50)×Φ203或Φ300×25-30×Φ125 mm
电机总容量 Total power motor	4.24 kw
机床总重量 Overall machine weight	2000/2130/2130/2130/2130/2130/2130/2130/2130/2130 kg
机床重量 Weight of the machine	2500/2900/3000 kg

机床主要附件 Main Accessories

1 冷却液箱 Coolant tank	1套/set
2 砂轮修整器 Grinding wheel dresser	1套/set
3 开式中心架 Open end opening pen	12套/set
4 砂轮平衡架 Wheel balancing stand	1套/set
5 顶尖 Center	2套/piece
6 半圆顶尖 Half center	2套/piece
7 排子夹头 Clamping jaws	1套/set
8 三角皮带-多楔带-平皮带 V-belt Poly-V belt Flat belt	各2件/piece each
9 垫铁 Leveling wedge (skid base)	3件/piece
10 松卸螺帽 Unbucked nut	1件/piece
11 砂轮夹板 Wheel fixers	2套/set
12 内六角套筒扳手 Hex socket wrench	1件/piece

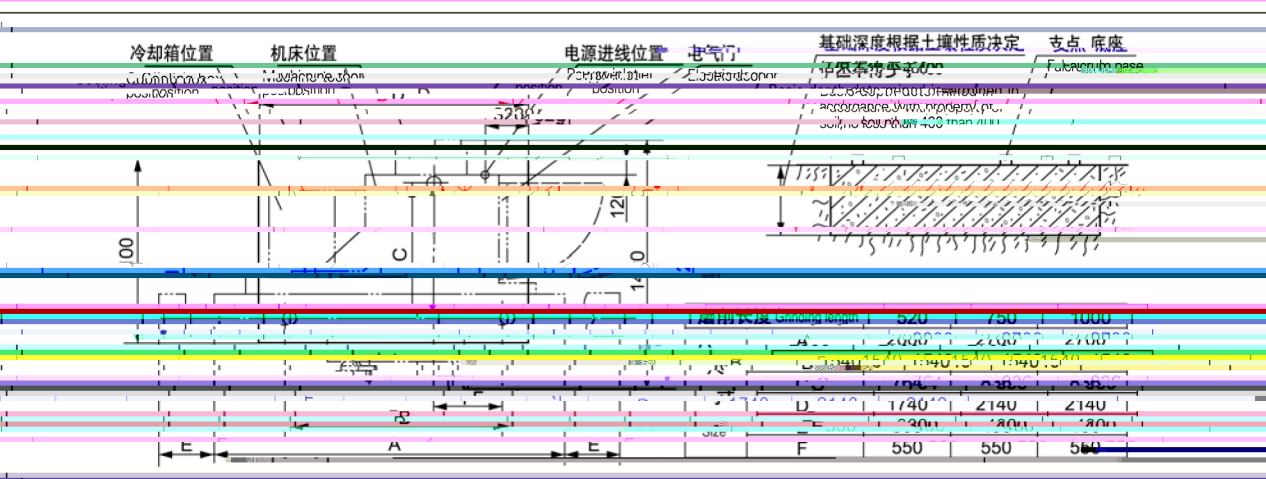
机床可选附件 Extra Accessories

1 圆弧修整器 Circular wheel dresser	1套/set
2 砂轮平衡架 Wheel balancing stand	1套/set

机床主要附件 Main Accessories

圆度 Roundness	0.005 mm
圆柱度 Cylindricity	0.005 mm
粗糙度 Roughness	Ra≤0.32 μm

安装基础图 Foundation Layout



机床用途与性能特征

- 机床结构灵巧、精度稳定，磨削效率高。工件、砂轮、油泵和冷却泵分别由电动机驱动，采用液压驱动和电气控制，操作方便。具有精巧简单特点，适宜于成批及大量生产车间，磨削圆柱形或圆锥形外圆工件。
- 本机床是在M1320的基础上对其主要液压部件进行筒，快速进退油缸、操纵箱、进给机构、油泵等作了重新设计。工作台面回转角度从顺时针3°、逆时针6°增大为顺时针5°、逆时针9°。机床外形方面也作了较大的改进。

Main Applications and Structural Features

- The structure of the machine is delicate, its accuracy is stable and its grinding efficiency is high. Workpiece, wheel, oil pump, and coolant pump are respectively driven by their individual motors. It has hydraulic drive, electric control, so it is convenient to operate it. It is suitable for batch and mass production for grinding cylindrical or conical workpieces.
- It is designed on the basis of M1320, its main hydraulic components, hydraulic cylinders, rapid advance & withdrawal cylinder, control box, pressure valve board and oil pump. The worktable swivel angle from C.W. 3° and C.C.W. 6° is increased to C.W. 5° and C.C.W. 9°. The overall appearance of the machine is also changed.