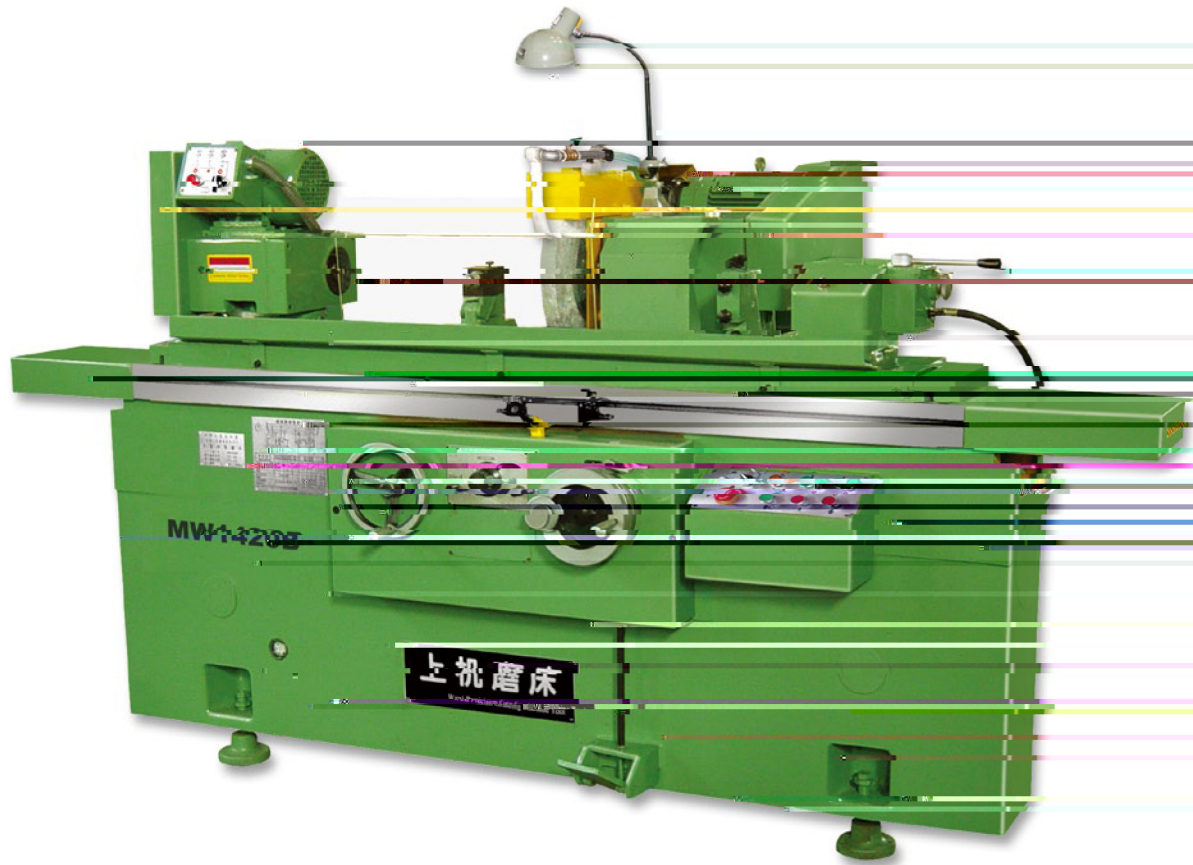


MW1420B

万能外圆磨床



机床用途与性能指标

- 本机床适用于磨削圆柱形和圆锥形的外圆和内孔，也可磨削轴向端面，宜用于批量生产及各种机械加工业使用，具有精度高、刚性强、磨削效率高、操作方便等特点，结构先进，造型美观。
- 本系列机床的工作台纵向行程为1500mm，砂轮架和头架可回转，外圆砂轮采用 $\Phi 400 \times 40 \times \Phi 203$ ，提高了磨削效率及砂轮耐用度。头架空挡可转动，砂轮架空挡微进给，床身导轨部分采用低噪音专用油泵，供油平稳，噪音低，工作台液压往复，具有抖动装置，可实现小进给频繁换向功能，提高切入磨削工件时的表面质量。

Main Applications and Summary of Features

- The machine is suitable for grinding external and internal cylindrical and conical and end faces of shafts. It can be used for medium and small batch production of parts or in finishing shop. Beside its advanced structure and beautiful appearance, the machine has high accuracy, strong rigidity, high grinding efficiency, ease in operation, etc.
- The series grinding disc are able to travel with the disc along the longitudinal travelling by hydraulic or manual control and a work wheel, wheel head and work head can be used in different grinding methods of grinding such as cylindrical grinding, efficiency and wheel flexibility. When the spindle of work head is rotating, the work head can be moved along the spindle to grind the tapered part of the work piece. The work head can be moved with the work piece. Hydraulic control can be used to workable gearboxes and sliding. Furthermore, the reversing function reversing function is thus realized to improve surface grinding quality when a work piece is ground with planar feed.

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技术规格参数 Specifications and Technical Parameters

磨削孔径范围 Diameter to be ground	0813~80 mm
最大磨削长度 Max. length of grinding	520/730/1000 mm
中心高 Height of center	125 mm
顶尖中心距 Distance between centers	520/550/600 mm
最大工件重量 Max. workpiece weight	50 kg
工作台最大纵向移动量 Max. longitudinal travel	560/680/1060 mm
工作台最大回转角度 Max. angle of swivel	-5° ~ +9° / -3° ~ +9° / -3° ~ +7°
工作台液压移动速度 Hydraulic traverse speed	0.3 m/min
工作台手动移动速度 Traverse per turn of hand wheel	5 mm/turn
头架主轴转速 Spindle speed	66, 65, 238, 120, 170, 466 rpm
头尾架顶尖锥度 Taper of headstock & tailstock	M3 x 6 mm
头架卡盘直径 Dia. of chuck jaws	175 mm
尾架顶尖圆锥锥度 Taper of rear stock	75 mm
砂轮架快速移动量 Rapid travel of wheel head	20 mm
手轮-转砂轮架移动量 Turn over feed of hand wheel	1 mm/turn
微进给手轮-转砂轮架移动量 Micro-feed per revolution of hand wheel	0.005 mm/turn
砂轮架转速 Spindle rev./min of grinding wheel	223/284/355 rpm
砂轮架移动量 Travel of wheel head	150 mm
砂轮规格 Max. diameter of grinding wheel	Φ400×(40~58)×Φ223 mm
砂轮规格 Grinding wheel specification	WGA46A60K16L35V25
机床外形尺寸 Overall dimensions	2200×830×1330 mm
机床重量 Weight	2700 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	开式心轴 Open end mandrel	1套set
4	砂轮平衡轴 Wheel balancing shaft	1套set
5	三爪卡盘 Three-jaw chuck	1套set
6	顶尖 Center	2件pieces
7	半轴顶尖 Half center	2件pieces
8	桃子夹头 Driving dog	1套set
9	三角皮带、多楔带 平皮带 V belt Poly-V belt Flat belt	多件pieces each
10	垫铁 Levelling wedge (fukuru base)	3件pieces
11	松开螺母 Unlocked nut	105个pieces
12	砂轮支架 Wheel holders	2套sets
13	中磨接长轴 Middle shaft for intermediate grinding	1套set
14	1号 夹筒及手轮鼓 Socket wrench	11件pieces
15	滤板 B plate	1套set

附件 4-1 附件 4-2

1. 圓筒係數 δ $\delta = \frac{1}{2} \frac{r}{h} \ln \frac{r+d}{r-d}$	1 有 $\delta = 0$
2. 圓柱半徑 r $r = \frac{1}{2} \sqrt{\frac{4r^2}{\pi}}$	1 有 $\delta = 0$

圓度 δ $\delta = \frac{1}{2} \frac{r}{h} \ln \frac{r+d}{r-d}$	1 有 $\delta = 0$
圓柱度 δ $\delta = \frac{1}{2} \frac{r}{h} \ln \frac{r+d}{r-d}$	1 有 $\delta = 0$
圓度度 δ $\delta = \frac{1}{2} \frac{r}{h} \ln \frac{r+d}{r-d}$	1 有 $\delta = 0$

អានបញ្ជីសំនុំទាំងស្រុង៖ [ទីសៀវភៅ](#)

