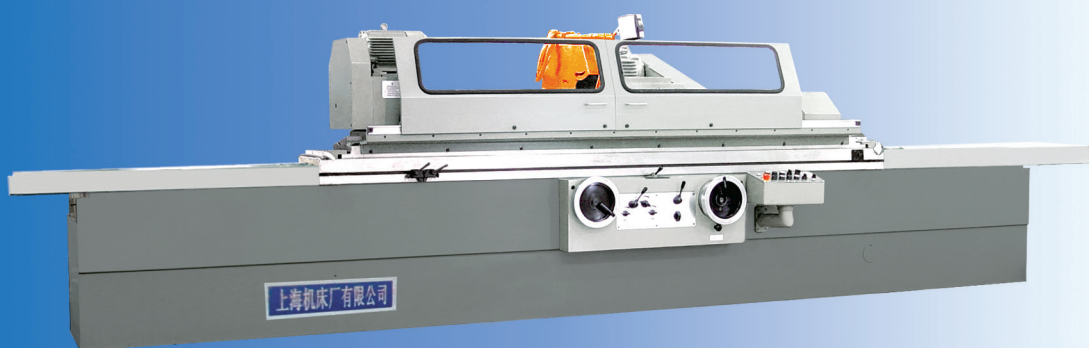


MC1332/H 外圆磨床

Cylindrical Grinder

用途与特征

- 本磨床是在M1332B×2000、3000外圆磨床的基础上派生设计而成的。
- 该系列机床适宜于磨削IT6至IT5精度的圆柱形或圆锥形的回转体工件，机床纵向移动由液压无级传动，也可用手轮传动。横向移动具有液压快速进退、周期进给和手动微量进给，头架采用交流变频电机，可无级调速。
- 砂轮、油泵和冷却泵分别以单独的电机驱动。
- 本系列机床有2000、3000两种不同顶尖距的规格，用户可按需要选用。



Main Application and Features

- MC1332 Cylindrical Grinder is designed on the basis of M1332B series Semi-auto Cylindrical Grinder.
- It is suitable for grinding cylindrical or conical parts which accuracy is IT6 to IT5. Worktable longitudinal travel driven by hydraulic at infinitely-variable-speed, or driven by handwheel. Wheelhead cross travel provided with hydraulic rapid advance & withdrawal, intermittent feed, manual micro-feed. Workhead adopt AC frequency motor to realized stepless speed adjusting.
- Wheel, Oil pump and coolant pump are driven by individual motor.
- This machine has two specifications which are 2000mm and 3000mm. Users can choose in accordance with their requirements.

MC1332/H 外圆磨床

Cylindrical Grinder

规格及主要技术参数

Main specifications

机床规格	Grinding capacity			Φ320 x 2000 3000mm
可磨直径	Grinding diameter	用中心架 With steady-rest	最小/最大 Min./Max.	10/90mm
		不用中心架 Without steady-rest	最小/最大 Min./Max.	8/320mm
工件最大重量	Max. workpiece weight			500kg
最大磨削长度	Max. grinding length			2000/3000mm
顶尖距	Distance between centers			2000/3000mm
中心高	Center height			180mm
在尾架上修整砂轮时最大磨削长度	Max. grinding length when dressing wheel on tailstock			1750/2750mm
上工作台最大回转角度	Max. upper worktable swing angle	顺时针 C.W.		2° 1.5°
		逆时针 CC.W.		3° 1.5°
工作台最大纵向移动量	Max. long. worktable travel			2050/3050mm
砂轮尺寸	Grinding wheel dimension (O. D. x W x I. D.)	最大 Max.		Φ600 × 75 × Φ305
		磨耗至 Worn to		Φ450 × 75 × Φ305
砂轮线速度	Grinding wheel peripheral velocity			35m/s
砂轮主轴转速	Grinding wheel spindle speed			1100r/min
丝杆最大移动量	Max. leadscrew travel			231mm
快速进退量	Rapid advance and withdrawal amount			50mm
手轮一转砂轮架移动量	Wheelhead displacement per rev. of handwheel	粗/精 Coarse / Fine		2/0.5mm
手轮一格砂轮架移动量	Wheelhead displacement per div. of handwheel	粗/精 Coarse / Fine		0.01/0.0025mm
机床电气总功率	Total electric power			16kw
外形尺寸 (长×宽×高)	Overall dimension (L x W x H)	长 (L)		6760 9180mm
		宽 (W)		1895 1895mm
		高 (H)		1725 1725mm

工作精度 Working Accuracy

圆度 Roundness	0.0025mm
纵截面内直径一致性 Uniformity of dia. in longitudinal section	0.008mm
表面粗糙度 Surface roughness	Ra 0.32 μm
表面波纹度 Surface waviness	0.001mm

主要附件 Main Accessories

砂轮外圆修整器 Wheel periphery dresser	1套 set
砂轮卡盘 Wheel chuck	2套 sets
卸砂轮拔头 Wheel extractor	1套 set
吊杆 Hooking rod	1套 set

特殊附件 Special Accessories

托架 Bracket	10套 sets
砂轮平衡架 Grinding wheel balancing stand	1套 set

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由于技术不断发展, 本样本仅供参考 具体参数与配置以签订的合同为准 2022年9月
Considering continuous development of technology, above information is for reference only.