

# MM1332 精密外圆磨床

## Precision Cylindrical Grinder

### 用途与特征

- MM1332型精密外圆磨床用以加工对精度及粗糙度有较高要求的圆柱体或圆锥体的回转体工件。机床纵向移动由液压无级传动，也可用手动传动，横向具有液压快速进退，横向进给由手轮进给。
- 机床砂轮架轴承采用动静压轴承，其精度高、刚性好。
- 头架采用交流变频调速，在转速范围内可作无级调速。尾架采用密集滚珠形式，其刚性好。
- 机床配有磨削指示仪，便于对工件进行高精度磨削。



### Main Application and Features

- Model MM1332 precision cylindrical grinder is used for grinding the rotary workpieces such as cylindrical or conical parts which have higher requirements of accuracy and roughness. Longitudinal travel is realized by hydraulic drive at stepless speed, or by handwheel. Rapid hydraulic advance and withdrawal is effected in transverse, and the transversal feed is controlled by handwheel.
- Wheelhead is supported by hydro-static-dynamic hybrid bearings, which have high accuracy and excellent rigidity.
- Workhead has A.C. freq-conversion speed adjusting, so infinitely variable speed is realized within the range of speed. Tailstock is realized by dense-ball type bearing, which has excellent rigidity.
- The machine is equipped with grinding indicating instrument, benefiting high-accuracy grinding.

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### 规格及主要技术参数

### Main Specifications

可磨直径	Grinding diameter 用中心架 with steady-rest	最小Min./最大Max.	10/60mm
	不用中心架 without steady-rest	最小Min./最大Max.	8/320mm
工作最大重量	Max. work weight		150kg
最大磨削长度	Max. grinding length		500 1000 1500 2000 3000mm
中心高	Center height		180mm
头架主轴转速	Workhead spindle speed		20-200 (无级) r/min (stepless)
砂轮尺寸	Wheel dimensions(O.D. x W x I.D.)	最小Min.	Φ450x75x305mm
		最大Max.	Φ600x75x305mm
砂轮线速度	Wheel peripheral velocity		35/17.5m/s
砂轮主轴转速	Wheel spindels speed		1110/555r/min
快速进退量	Rapid advance & withdrawal amount		25mm
上工作台最大回转角度	Max.upper worktable swing angle	顺时针C.W.	3° 3° 3° 2° 1.5°
		逆时针CC.W.	6° 5° 4° 3° 1.5°
外形尺寸 (长x宽x高)	Overall dimensions(L x W x H)	长: L	2500 3400 4400 6760 9180 mm
		宽: W	1810 1810 1810 1870 1870 mm
		高: H	1670 1670 1670 1670 1670 mm

### 工作精度 Working Accuracy

机床规格 Specifications	500	1000	1500	2000	3000
圆度 (mm) Roundness	0.001	0.001	0.001	0.002	0.002
纵断面内直径的一致性 (mm) Uniformity of dia. in longitudinal section	0.003	0.005	0.005	0.006	0.006
表面粗糙度 (Ra μm) Surface roughness	0.04	0.04	0.04	0.04	0.04
表面波纹度 (μm) Surface waviness					0.63

### 主要附件 Main Accessories

电箱 Electric cabinet	1	套set				
润滑油箱 Lubrication oil tank	1	套set				
纸袋过滤器 Paper-tape filter	1	套set				
砂轮外圈修整器 Wheel periphery dresser	1	套set				
开式中心架 Open-type steady-rest	500 1	1000 1	1500 1	2000 2	3000 2	套sets
机床垫铁 Leveling wedge	9	11	13	15	18	块pcs
磨削指示仪 Grinding indicating instrument	1					套set
砂轮压紧法兰 Wheel hub	2					套sets

### 特殊附件 Special Accessories

端面修整器 End-face dresser	1	套set
砂轮平衡架 Wheel balancing stand	1	套set

上海机床厂有限公司市场营销部 Shanghai Machine Tool Works Ltd. Marketing Department

内销 Domestic Section

电话 (Tel) : 021-55228502

售后服务: 021-65494608

传真 (Fax) : 021-65340757

邮箱 (E-mail) : smtw-sales@smtw.com

外销 Export Section

电话 (Tel) : +86-21-65496364、65517713

传真 (Fax) : +86-21-65340757 邮箱 (E-mail) : info@smtw.com

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