

# M1332B 外圆磨床

## Cylindrical Grinder

### 用途与特征

- M1332B型外圆磨床是在MB1332B型系列半自动外圆磨床的基础上派生设计而成的。该机床适宜于磨削IT6-IT5精度的圆柱形或圆锥形的回转体工件。
- 机床工作台纵向移动由液压无极传动，也可手轮传动。
- 砂轮架横向移动具有液压快速进退、周期进给和手动微量进给。
- 工件、砂轮、油泵和冷却泵分别由单独电机驱动。
- 砂轮主轴轴承采用两组由三块轴瓦组成的滑动轴承。
- 砂轮修整器置于尾架上，手动调节修整量



### Main Application and Features

- M1332B Cylindrical Grinder is designed on the basis of MB1332B series Semi-auto Cylindrical Grinder. It is suitable for grinding cylindrical or conical parts, for its accuracy IT6-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 microfeed.
- Work, wheel, oil-pump and coolant pump respectively driven by their individual motor.
- Two sets of sliding bearings consisting of three-shoes used as wheel spindle bearings.
- Wheel dresser mounted on the tailstock, with dressing amount adjustable by hand.

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## Cylindrical Grinder

### 规格及主要技术参数

### Main specifications

机床规格	Grinding capacity	Φ320 x 500 1000 1500 2000 3000mm	
可磨直径	Grinding diameter	用中心架 With steady-rest	最小/最大Min./Max. 10/60mm
		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	150kg	
最大磨削长度	Max. grinding length	500 1000 1500 2000 3000mm	
顶尖距	Distance between centers	500 1000 1500 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	250 750 1250 1750 2750mm	
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.	7° 5° 4° 3° 1.5°
工作台最大纵向移动量	Max. long. worktable travel	550 1050 1550 2050 3050mm	
砂轮尺寸	Wheel dimensions(O.D. X W X I.D.)	最大Max.	Φ600×75×Φ305mm
		磨耗至Wom to	Φ450×75×Φ305mm
砂轮线速度	Wheel peripheral velocity	35m/s	
砂轮主轴转速	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coarse/精fine	2/0.5mm
手轮一格砂轮架移动量	Wheelhead displacement pre div. of handwheel	粗coarse/精fine	0.01/0.0025mm
机床电气总功率	Total electric power	15kw	
外形尺寸 (长×宽×高)	Overall dimensions(L × W × H)	长(L)	2460 3360 4360 6760 9180mm
		宽(W)	1810 1810 1810 1874 1874mm
		高(H)	1665 1665 1665 1665 1665mm

### 工作精度

### Working Accuracy

圆度 Roundness	≤1500 0.0015mm >1500 0.0025mm
纵截面内径的一致性 Uniformity of dia. in longitudinal section	≤1500 0.005mm >1500 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
开式中心架 Φ320×500、750、1000mm Open-type steady-rest	1套 set 1500mm 1套 set 2000mm 2套 sets 3000mm 2套 sets
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

### 平衡轴

平衡轴 Balancing mandrel	1套 set
机床垫铁 Leveling wedges	Φ320×500mm 9套 sets 750mm 9套 sets 1000mm 11套 sets 1500mm 13套 sets 2000mm 15套 sets 3000mm 18套 sets

### 特殊附件

### Special Accessories

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

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