

# H393

## 数控随动磨床

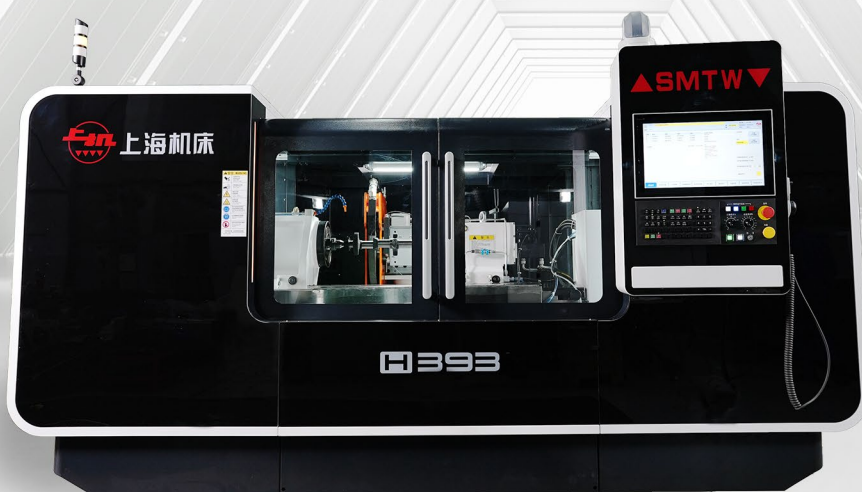
CNC orbiting grinder

### 用途与特征

H393数控随动磨床（执行《高精度外圆磨床 精度检验》标准）主要是用于各种机械设备上偏心轴类零件和异形长轴类零件的大批量加工的专用生产型设备。采用FANUC Oi-TF(PLUS)数控系统和PC屏，配备搭载直线电机的砂轮架进给X轴和搭载力矩电机的头架回转C轴，分别配备高精度光栅尺和角度编码器，实现X-C轴联动加工，满足异形零件的高精度联动磨削需求；搭载伺服电机控制工作台移动的Z轴，可实现一次装夹工件，完成多档偏心轴外圆表面的自动循环磨削；配置电主轴CBN砂轮和金刚滚轮修整器，实现高速磨削，极大的提高加工效率；配备自动量仪，实现自动对刀及测量工件的功能。该机床同时具备砂轮自动进给、工作台自动跳档、工件转速自动切换、砂轮自动修整及自动补偿和循环动作安全连锁等多种功能。

### Application and Features

H393 CNC orbiting grinder (complying the "Precision Inspection of High Precision Cylindrical Grinding Machine" standard) is a specialized production equipment which is primarily designed for the mass production of eccentric shaft components and irregular long shaft components used in various mechanical equipment. The machine adopts FANUC Oi-TF (PLUS) CNC system and PC screen and has linear motor for wheelhead X-axis feed and torque motor for headstock C-axis rotation. It is equipped with high-precision grating rulers and angle encoders, enabling X-C axis linkage processing to meet the high-precision linkage grinding requirements of irregular parts. The Z-axis, equipped with a servomotor-controlled table movement, enables automatic cycle grinding of the cylindrical surfaces of multiple eccentric shafts in one-time workpiece clamping. The machine is equipped with a motorized spindle, CBN grinding wheel and diamond roll dresser, high-speed grinding is achieved, greatly improving processing efficiency. The machine is also equipped with an automatic gauge, enabling automatic tool alignment and workpiece measurement. It owns various functions such as automatic grinding wheel feed, automatic jump direction of the worktable, automatic workpiece rotation speed switching, automatic grinding wheel dressing and compensation, and safety interlocking of cyclic actions.



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## 规格及主要技术参数 | SPECIFICATIONS AND MAIN TECHNICAL PARAMETERS

最大磨削直径	Max. Grinding diameter	320 mm
最大偏心距	Max. eccentricity	30 mm
最大工件重量	Max. workpiece weight	50 kg
中心高	Center height	200 mm
砂轮电机功率	Wheel motor power	15 KW
砂轮线速度	Wheel peripheral speed	80 m/s

## 工作精度 | WORKING ACCURACY

圆度	Roundness	0.002 mm
纵截面直径一致性	Longitudinal conformity	0.002 mm
外圆粗糙度	Cylindrical surface roughness	Ra0.2 $\mu$ m

## 机床附件及选购件 | ACCESSORIES AND PTIONS

自动测量仪	Automatic measuring device
砂轮动平衡仪	Wheel dynamic balance device

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