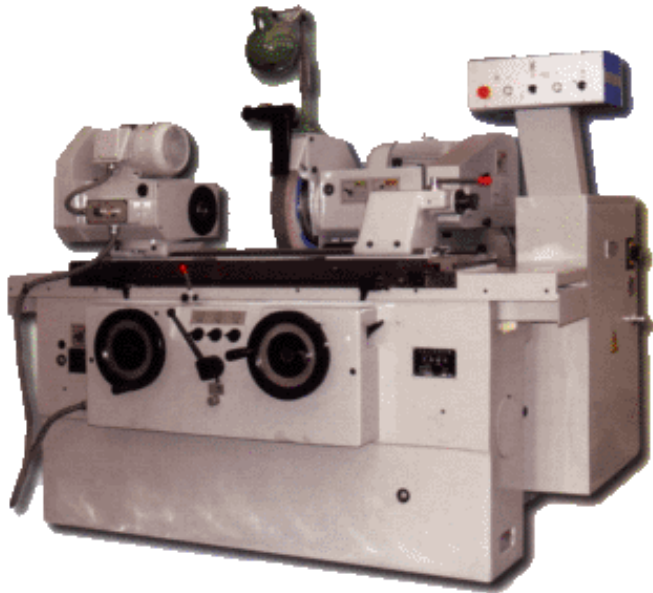


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CYLINDRICAL GRINDING MACHINES SERIES:



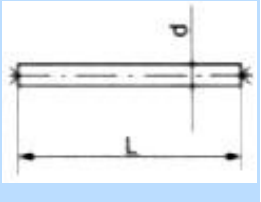
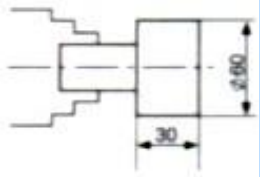
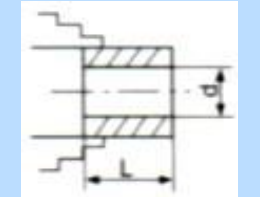
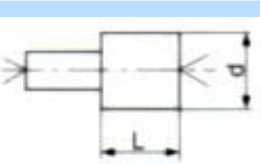
Features:

- Stable running without noise can be achieved because of adopting screw pump in hydraulic system.
- High rotating precision and strong rigidity can be obtained by sleeve-type whole-tile moving hydraulic bare shaft system on the spindle of wheel head.
- Slideway is covered by the plastic so it can gain slow speed running and high immunity to vibration.
- The machine has high precision, reasonable integral layout, beautiful shape. Centralized and imaginary operating lever are easy and safe for operating.
- PTBMB (semi-automatic) grinding machine can perform semi-automatic precision cutting, longitudinal grinding to make high precision parts by using limited stroke or controlled by process gauge in small batch or mass production.
- PTBMB (semi-automatic) all grinding function and sequences of action during processing cycle are controlled by programmable logical controller (PLC).

SPECIFICATION

MODEL Specification		PTMM1320 PTMMB1320	PTMM1332 PTMMB1332	PTMM1420 PTMMB1420	PTMM1432 PTMMB1432	PTMMS1320 PTMMBS1320	PTMMS1332 PTmMBS1332
		500 750 1000	500 750 1000	500 750 1000	500 750 1000	500 750 1000	500 750 1000
Center height (mm)		125	180	125	180	125	180
Max. length of workpiece between centers (mm)		520 765 1080	520 765 1080	520 765 1080	520 765 1080	520 765 1080	520 765 1080
Max. workpiece diameter for external (mm)		240	350	240	350	240	350
Max. grinding length (mm)		500 750 1000	500 750 1000	500 750 1000	500 750 1000	500 750 1000	500 750 1000
External grinding range		∅5~∅200(mm)	∅5~∅320(mm)	∅5~∅200(mm)	∅5~∅320(mm)	∅5~∅200(mm)	∅5~∅320(mm)
Internal grinding range (mm)		--	--	∅13~∅80	∅16~∅125	--	--
Depth of internal grinding (bigger than ∅45mm)		--	--	110(mm)	140(mm)	--	--
Max. weight of workpiece between centers (kg)		50	100	50	100	50	100
Grinding wheel	Dimensions (outer diameter ∅ width ∅ bore)	400∅(32~50)∅203 (mm)					
	Max. linear velocity	35 (m/sec)				50 (m/sec)	
Swivelling angle of table	Clockwise	9∅ 8∅ 3∅	9∅ 8∅ 3∅	9∅ 8∅ 3∅	9∅ 8∅ 3∅	9∅ 8∅ 3∅	9∅ 8∅ 3∅
	Counter-clockwise	9∅ 8∅ 7∅	9∅ 8∅ 7∅	9∅ 8∅ 7∅	9∅ 8∅ 7∅	9∅ 8∅ 7∅	9∅ 8∅ 7∅
Taper hole of spindle (Morse)	Workhead	Morse 4#					
	Tailstock						
Total power (kw)		4.975	4.975	5.525	5.525	4.975	4.975
Net weight (kg)		2500 3000 3500	2500 3000 3500	2500 3000 3500	2500 3000 3500	2500 3000 3500	2500 3000 3500
Overall dimensions	L (mm)	2750 2870 3700	2750 2870 3700	2750 2870 3700	2750 2870 3700	2750 2870 3700	2750 2870 3700
	W (mm)	2000					
	H (mm)	2100					

WORKING ACCURACY

NO	Inspection character	Test piece diagram and grinding condition	Inspection item	PTMM1320 PTMMS1320 PTMMB1320 PTMMBS1320			PTMM1332 PTMMS1332 PTMMB1332 PTMMBS1332			PTMM1420 PTMMB1420			PTMM1432 PTMMB1432			
				500	750	1000	500	750	1000	500	750	1000	500	750	1000	
P1	The grinding accuracy of test piece between centers		L=350 d=75 circularity (mm)	0.0015	0.0015	-	0.0015	0.0015	-	0.0015	0.0015	-	0.0015	0.0015	-	
			L=750 d=75 Consistency of diametr in longitudinal section (mm)	-	-	0.0025	-	-	0.0025	-	-	0.0025	-	-	0.0025	-
			L=350 d=35 longitudinal section (mm)	0.005	0.005	-	0.005	0.005	-	0.005	0.005	-	0.005	0.005	-	-
			L=750 d=75 roughness (µm)	-	-	0.008	-	-	0.008	-	-	0.008	-	-	0.008	-
				Ra _z 0.32												
P2	The grinding accuracy of short test Piece on chuck		ii circularity (mm)	ii			ii			0.0025			0.0025			
			ii roughness (µm)	ii			ii			Ra _z 0.32			Ra _z 0.32			
P3	The accuracy of test internal grinding on chuck		circularity (mm)	ii			ii			0.0025			0.0025			
			L=50 d=30 Consistency of diametr in longitudinal section (mm)	ii			ii			0.005 -			- 0.01			
			L=100 d=60 roughness (µm)	ii			ii			Ra _z 0.63						
P4	The accuracy for external grinding for Plunge-in test piece		L=30 d=25 Consistency of diametr in grinding a batch of spare parts	Fixed distance grinding 0.02												
			L=30 d=40	Automatic gauge 0.01												