

POLYTOP

Exporter from china

HIGH PRECISION GRINDING MACHINES SERIES:

Features:

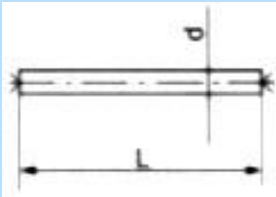


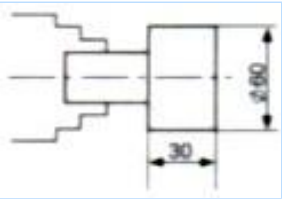
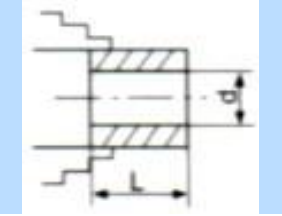
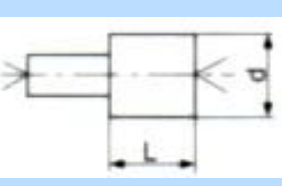
- Stable running without noise can be achieved because of adopting screw pump in hydraulic system.
- High rotating precision and strong rigidity can be obtained by sleeve-type whole-tile high precision moving hydraulic bare shaft system on the spindle of wheel head.
- Slideway is covered by the plastic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

SPECIFICATION

| MODEL Specification | | PTMMG1320 PTMMGB1320 | PTMMG1332 PTMMGB1332 | PTMMG1420 PTMMGB1420 | PTMMG1432 PTMMGB1432 |
|---|--|-------------------------|-------------------------|-------------------------|-------------------------|
| | | 500 750 1000 | 500 750 1000 | 500 750 1000 | 500 750 1000 |
| Center height (mm) | | 125 | 180 | 125 | 180 |
| Max. length of workpiece between centers (mm) | | 520 765 1080 | 520 765 1080 | 520 765 1080 | 520 765 1080 |
| Max. workpiece diameter for external | | 240 (mm) | 350 (mm) | 240 (mm) | 350 (mm) |
| Max. grinding length (mm) | | 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) |
| Internal grinding range (mm) | | -- | -- | ∅13~∅80 | ∅16~∅125 |
| Depth of internal grinding (bigger than ∅45mm) (mm) | | -- | -- | 110 | 140 |
| Max. weight of workpiece between centers | | 50(kg) | 100(kg) | 50(kg) | 100(kg) |
| Grinding wheel | Dimensions (outer diameter ∅ width ∅ bore) | 400∅(32~50)∅203 (mm) | | | |
| | Max. linear velocity | 35 (m/sec) | | | |
| Swivelling angle of table | Clockwise | 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∅ |
| Taper hole of spindle (Morse) | Workhead | Morse 4# | | | |
| | Tailstock | Morse 3# | | | |
| Total power (kw) | | 4.775 | 4.775 | 5.325 | 5.525 |
| Net weight (kg) | | 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 |
| | W (mm) | 2000 | | | |
| | H (mm) | 2100 | | | |

WORKING ACCURACY

| NO | Inspection character | Test piece diagram and grinding condition | Inspection item | PTMMG1320 PTMMGB1320 | | | PTMMG1332 PTMMGB1332 | | | PTMMG1420 PTMMGB1420 | | | PTMMG1432 PTMMGB1432 | | |
|----|---|---|---|-------------------------|-------|-------|-------------------------|-------|-------|-------------------------|-------|-------|-------------------------|-------|-------|
| | | | | 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) | 0.001 | 0.001 | - | 0.001 | 0.001 | - | 0.001 | 0.001 | - | 0.001 | 0.001 | - |
| | | | L=750 d=75 | - | - | 0.002 | - | - | 0.002 | - | - | 0.002 | - | - | 0.002 |
| | | | l=350 d=35 Consistency of diameter in longitudinal section (mm) | 0.003 | 0.003 | - | 0.003 | 0.003 | - | 0.003 | 0.003 | - | 0.003 | 0.003 | - |
| | | | L=750 d=75 | - | - | 0.005 | - | - | 0.005 | - | - | 0.005 | - | - | 0.005 |
| | | | L=350 d=35 L=750 d=75 roughness (µm) | Ra:0.04 | | | | | | Ra:0.01 | | | | | |

| | | | | | | | | |
|----|---|---|---------------|--|------------------------------|-------------------------------|------------------------------|-------------------------------|
| P2 | The grinding accuracy of short test Piece on chuck |  | ii | circularity (mm) | ii | ii | 0.002 | 0.002 |
| | | | ii | roughness (µm) | ii | ii | Ra≤0.04 | Ra≤0.04 |
| P3 | The accuracy of test internal grinding on chuck |  | L=50 d=30 | circularity (mm) | ii | ii | 0.002 | 0.002 |
| | | | L=100 d=60 | roughness (µm) | ii | ii | Ra≤0.04 | Ra≤0.04 |
| P4 | The accuracy for external grinding for Plunge-in test piece |  | L=30 d=25 | Consistency of diameter in grinding a batch of spare parts | Fixed distance grinding 0.01 | Fixed distance grinding 0.012 | Fixed distance grinding 0.01 | Fixed distance grinding 0.012 |
| | | | L=30 d=40 | | Automatic gauge 0.004 | Automatic gauge 0.005 | Automatic gauge 0.004 | Automatic gauge 0.005 |