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Dingshun Heavy Duty Machine Tool

ISO9000质量管理体系认证企业

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Baoshun Machinery

CK8465/P重型精密数控轧辊车床

CNC ROLL TURNING LATHE

CK8465/P（650×3000）

® 江苏鼎顺重型机床有限公司
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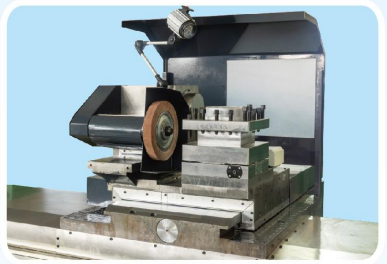
CK8465/P重型精密数控轧辊车床简介　Brief introduction

本机床为数控轧辊车抛一体车床。主要用于液压支架活柱、中缸、激光熔覆后的重载车削及加工后表面抛光，也可用于铸铁、钢质和有色金属轧辊的半精车及精车削加工。该设备为重型卧式平床身四导轨全硬轨结构，机床横向有两个独立的伺服进给轴组成，抛光装置安装于纵向拖板一侧，与横向进给车加工刀架不干涉，分别用于车削及抛光加工。纵向和横向（车削和抛光）移动均采用高精度滚珠丝杠传动，刀架及抛光装置纵向和横向进给运动导轨均采用高刚性矩形导轨，结合四工位重载电动刀架及特制的抛光主轴，提高了机床切削、抛光加工时的高刚性和稳定性；主轴的轴承采用高精度可调整间隙的双列径向短圆柱滚子轴承，因而主轴刚性强、旋转平稳、精度高；尾座是由上、下体两部分组成，上体内装有主轴、套筒和主轴中心调整等机构。下体内装有尾座快速移动机构、尾座整体移动由电机及减速机驱动，尾座后端安装高压泵站，用于尾座到位后液压自动锁紧及松开，具备联锁保护功能。尾座套筒移动采用电机驱动及手动微调两种顶紧方式，尾座具备顶紧测力显示功能，可以根据工件顶紧力需求直观调整工件顶紧力矩。以上高稳定性和高刚性的结构设计，确保机床的整体综合加工精度。运动导轨副采用耐磨贴塑处理和集中润滑系统实施定点定量自动润滑，保证整机的动态响应性；机床的纵向和横向进给导轨采用不锈钢全防护，有利于运动精度的长期保持。

This machine tool is a CNC roll and toss integrated lathe. It is mainly used for heavy duty turning and surface polishing after hydraulic support live column, medium cylinder and laser cladding, and also for semi-finishing and finishing of cast iron, steel and non-ferrous metal rolls. The machine tool is composed of two independent servo feed shafts in the transverse direction. The polishing device is installed on one side of the longitudinal drag plate and does not interfere with the processing tool rest of the transverse feed car. It is used for turning and polishing respectively. The longitudinal and transverse (turning and polishing) movement are driven by high-precision ball screw, and the longitudinal and transverse feed movement guide rails of the tool holder and polishing device are adopted by high-rigidity rectangular guide rails, combined with four-station heavy-duty electric tool holder and special polishing spindle, to improve the high rigidity and stability of the machine tool cutting and polishing. The bearing of the main shaft adopts double-row radial short cylindrical roller bearing with high precision and adjustable clearance, so the main shaft has strong rigidity, smooth rotation and high precision. The tail seat is composed of an upper body and a lower body, and the upper body is equipped with a spindle, a sleeve and a spindle center adjustment mechanism. The lower body is equipped with a quick moving mechanism of the tail seat, the overall movement of the tail seat is driven by the motor and the reducer, and the high pressure pump station is installed at the back of the tail seat, which is used for the hydraulic automatic locking and loosening after the tail seat is in place, with interlock protection function. The tail seat sleeve can be moved by motor drive and manual fine tuning. The tail seat has the function of top tightening force display, and the workpiece top tightening torque can be visually adjusted according to the requirement of the workpiece top tightening force. The above high stability and high rigidity structure design ensures the overall comprehensive machining accuracy of the machine tool. The moving guide pair adopts wear-resistant adhesive plastic treatment and centralized lubrication system to implement fixed-point quantitative automatic lubrication to ensure the dynamic response of the whole machine. The longitudinal and transverse feed rails of the machine tool are fully protected by stainless steel, which is conducive to the long-term maintenance of motion accuracy.



刀架 Tool holder

主轴轴向窜动		≤ 0.015mm
主轴锥孔的径向跳动	靠近主轴端	≤ 0.015mm
	300mm 处	≤ 0.02mm
主轴顶尖的径向跳动		≤ 0.015mm
精车外圆精度	圆度	≤0.012mm
	圆柱度	≤0.015/300
精车端面对外圆的垂直度		≤0.015/100
精车外圆的表面粗糙度		≤Ra0.8 μm
抛光外圆的表面粗糙度		Ra0.3-0.4 μm
重复定位精度	X 轴≤0.01	Z 轴≤0.01mm
单向定位精度	X 轴≤0.015mm	Z 轴≤0.015 mm

机床主要精度 Main accuracy of machine tools

CK8465/P (650×3000)主要规格、技术参数　Performance parameters brief introduce

主要参数 Main paramenters		床头箱 Headstock		进给传动 Feed transmission		尾座移动参数 Tailstock moving parameters		电动机及其它参数 Motor and other parameters	
最大工件直径 Max. Workpiece diameter	Ø650mm	主轴转速范围 Main spindle rotation	1～400r/min	纵向（Z轴）进给电机扭矩 Longitudinal(Z axis) feed motor torque	36Nm	尾座套筒移动量 Tailstock sleeve of mobile content	250mm	交流变频主电机功率 Variable frequency AC motor power	37KW
最大工件长度 Max. Workpiece length	3000mm	主轴转速级数 Spindle speed grade	无级 Stepless	纵向（Z轴）快速移动速度 Longitudinal(Z axis) movement speed	1～3000mm/min	尾座快速移动速度 Rapid speed of tailstock	2000mm/min	床身导轨防护形式 The bed guideway form	不锈钢防护罩 Stainless protective covers
中心高 Center hight	470mm	主轴变速方式 Spindle speed mode	液压自动 Hydraulic auto	横向（X轴）进给电机扭矩 Cross (X axis) feed motor torque	27Nm	尾座套筒移动方式 Tailstock sleeve moving mode	电动/手动 Electric / Manual	机床总功率 Total machine power	55KW
顶尖间最大工件重量 Max. load between centers points	4000Kg	花盘直径(液压) Work holding chuck diameter(hydraulic)	Ø500mm	横向（X轴）快速移动速度 Cross (X axis) movement speed	1～2000mm/min	尾座主轴锥孔尺寸 The tailstock spindle taper hole size	莫氏6号 Mohs No.6	机床外型尺寸（长*宽*高） Overall size (L×W×H)	12160×2920×2250mm
最大切削力 Max. Cutting capacity	40Kn	主轴锥孔尺寸 Size of spindle taper	莫氏6号 Mohs No.6	横向（W轴）进给电机扭矩 Cross (W axis) feed motor torque	18Nm	尾座套筒直径 Tailstock sleeve diameter	Ø200mm	机床重量（约） Gross weight	15000kg
花盘最大扭矩 Max. work holding chuck torque	20000N·m			横向（W轴）快速移动速度 Cross (W axis) movement speed	1～2000mm/min	尾座移动方式 Tailstock moving mode	电动 Electric		
						尾座套筒顶力控制 Tailstock sleeve jacking force control	数显测力 Digital force measurement		
						尾座锁紧方式 Tailstock seat locking method	液压锁紧 Hydraulic locking		

注：标准配置采用数控系统是SINUMARIK 828D，主传动系统同交流变频电机配套，也可按客户特殊需求配置其它数控系统和主传动调速系统。

NOTICE: In standard features , we adopt SINUMARIK 828D as CNC system, the main drive system is equipped with AC frequency conversion motor, and other CNC systems and main drive speed regulation systems can also be configured according to the special needs of customers.

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