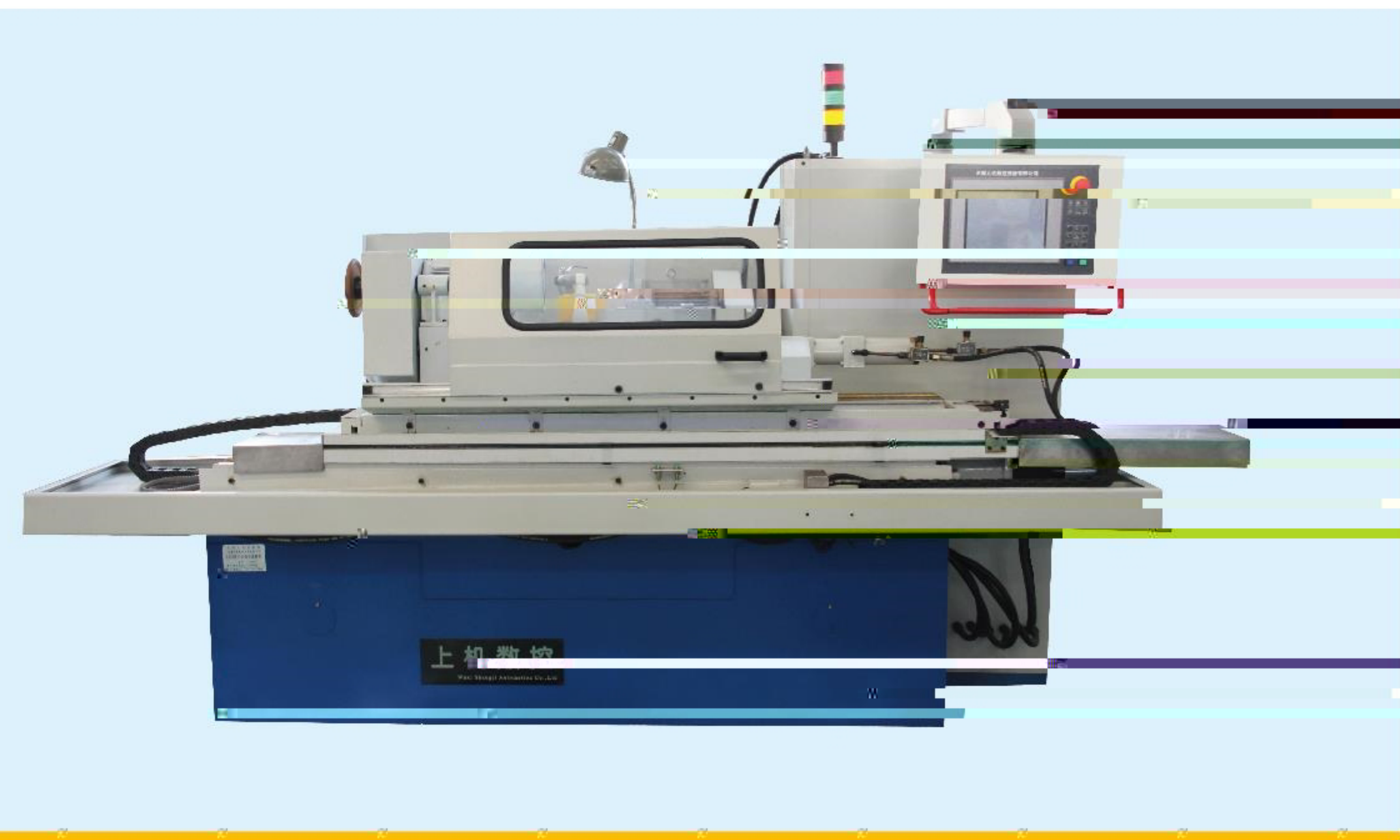




数控蓝宝石滚磨机

WSK022 CNC Sapphire Tumbling Mill



主要技术参数 Main Parameters

加工工件参数 Workpiece parameters	
适用工件直径 Applicable diameter	125mm

主要参数 Main parameters	
中心高 Central height	125mm
砂轮线速度 Linear speed of grinding wheel	30m/s (max)
金刚石砂轮尺寸 Size of diamond grinding wheel	Φ300(Φ) × 150(Φ) × 12 (mm)
头架可回转角度 Rotating angle of headstock	±30°
尾架顶尖行程 Top travel of tailstock (max)	150mm (max)

砂轮架电机功率 Motor power of grinding carriage	3kW
头架电机功率 Motor power of headstock	0.75kW
头架主轴转速 Spindle speed of headstock	1000 r/min (constant speed)
头架回转精度 Rotary accuracy of headstock	±0.004mm

数控轴 Axis	X轴: 砂轮架进给 X axis: grinding carriage feed Z轴: 工作台进给 Z axis: worktable feed
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电源供给及配套设施 Power supply and matched facility	
供电电压 Power supply and voltage	交流 AC 380V/50Hz
相对湿度 Relative humidity	小于 less than 75%
环境温度 Environment temperature	0-35℃
振源 Vibration source	磨床自身原机

磨削精度 Grinding accuracy	
圆度 Roundness	≤ 0.08mm
纵截面内尺寸一致性 Dimensional uniformity within longitudinal section	0.1mm
表面粗糙度 Surface roughness	Ra 0.5um

机床用途与性能特征

- 本机床用于磨削太阳能行业单晶硅棒料及蓝宝石晶棒等材料，可磨经切方后2寸~8寸棒料外圆（磨2寸圆棒无需更换金刚石砂轮）。
- 头架、尾架采用特制液压夹紧方式磨削。
- 采用进口二轴联动数控系统，内置PLC，触摸屏液晶显示。
- 工作台纵向移动及砂轮架横向移动采用伺服电机，实现丝杠拖动。
- 机床床身为高强度铸钢整体铸造，采用高刚度结构，有良好的吸振和热稳定性。
- 工件长度变化在100mm内，可不移动尾架，直接顶紧即可。
- 顶压紧力可任意调整。
- 磨削加工晶棒时可实现一次装夹自动完成粗磨、半磨、精磨、到尺寸退出。
- 电器电柜与床身刚性连接，避免灰尘刮屑飞溅，保证电气连接可靠。

Main Applications and Structural Features

- This equipment is applied in the PV industry, processing monocrystalline silicon rods and sapphire bars. It can grind the outer diameter of 2-inch to 8-inch rods after square grinding (no need to change diamond grinding wheel for grinding 2-inch round rods).
- Headstock and tailstock adopt special hydraulic clamping type grinding.
- Applies imported two-axis linkage CNC system, with PLC and touch screen display.
- Worktable longitudinal movement and grinding wheel transverse movement adopt servo motor ball screw drive.
- Casing is casted as a whole with high strength, low stress deformation, with good vibration absorption and good performance of shock absorption and heat stability.
- Length change of work piece shall be within 100mm, can be directly clamped without moving tailstock.
- Grinding force can be adjusted arbitrarily.
- While grinding crystal rods, it can realize one-time clamping to complete rough grinding, semi-grinding, fine grinding, and dimension exit.
- Electric cabinet connects with body, avoiding repeated disassembly, ensuring reliable connection.



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