

WSK022

数控蓝宝石滚磨机

WSK022 CNC Sapphire Tumbling Mill



技术参数参数 Technical Parameters

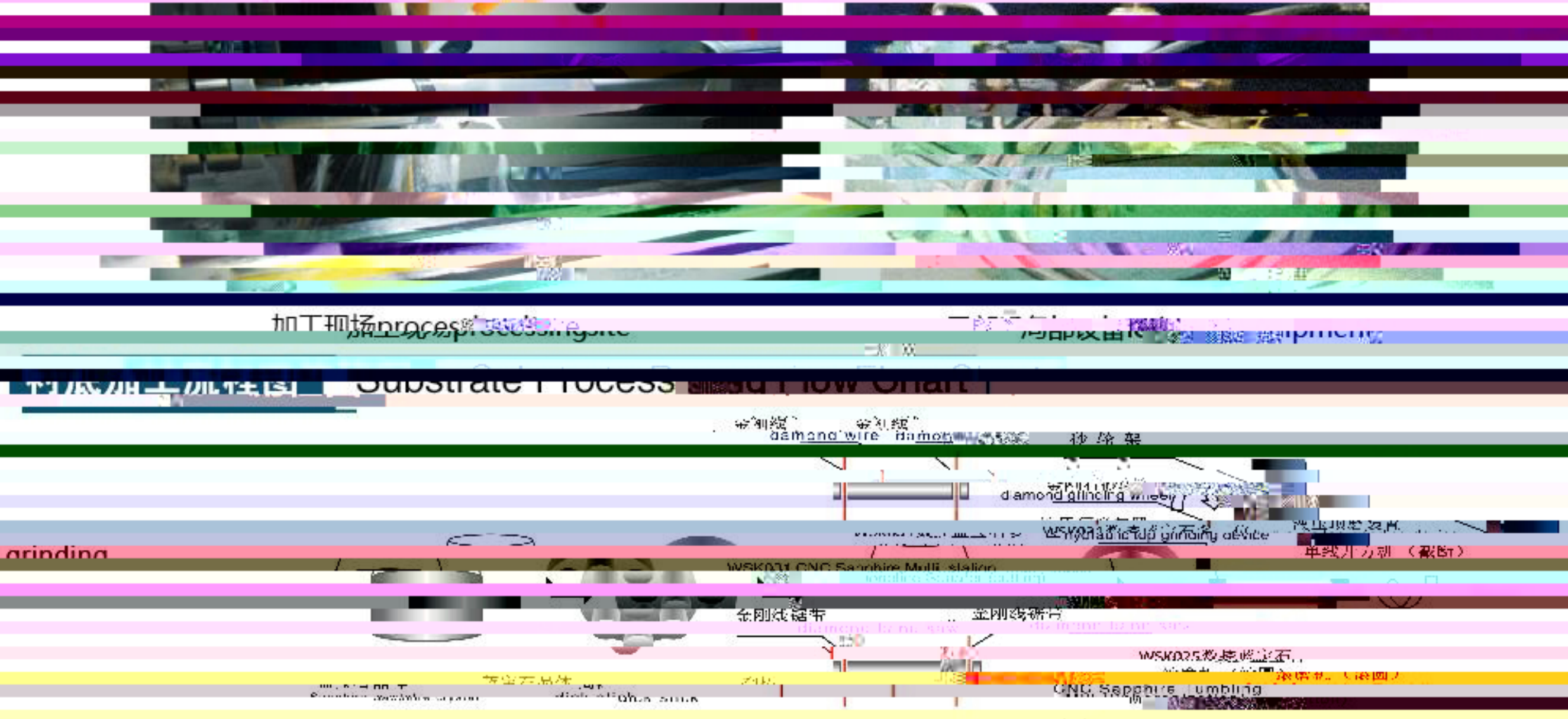
加工工件参数 Work piece parameters	
砂轮线速度 Linear speed of grinding wheel	50m/s (max)
金刚石砂轮尺寸 Size of diamond grinding wheel	Φ300(Φ150)×Φ72 / mm
头架可回转角度 Rotary angle of headstock	±30°
尾架顶头行程 Top travel of tailstock (max)	±50mm (max)
砂轮架电机功率 Motor power for grinding carriage	0.3kw
头架电机功率 Motor power of headstock	0.75kw
头架主轴转速 Speed of headstock spindle	6~1000 r/min (stepless speed regulation)
头架回转精度 Rotary accuracy of headstock	±0.001mm/100mm
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
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	5~35℃
振动 Vibration source	磨床自身原力
磨削精度 Grinding accuracy	±0.005mm
圆度 Roundness	±0.005mm
纵截面内尺寸一致性 Dimensional uniformity within longitudinal section	±0.005mm
表面粗糙度 Surface roughness	Ra 0.1um

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，有良好的吸振和热平衡性能。
- 工件长度变化在100mm中，可不移动尾架，其夹紧力随工件长度变化可任意调整。
- 磨削加工晶棒时可实现一次装夹完成粗磨、半精磨、精磨，到尺寸出山。
- 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, sapphire rods, etc.
- Headstock, tailstock adopts special hydraulic clamping type grinding.
- Applies imported two-axis linkage CNC system, within PLC control, touch screen display.
- Worktable longitudinal movement and grinding wheel transverse movement adopt servo motor ball screw drive.
- Casing is casted as a whole, high strength, low stress, good vibration absorption and heat balance.
- Length change of work piece shall be within 100mm, tailstock can be fixed, hydraulic top force of it can be whatever adjusted.
- Grinding crystal bar, can realize one-time automatic grinding, semi-finishing grinding, finishing grinding to size.
- Electric cabinet connects with body, avoiding repeated disassembly, ensuring reliable connection.



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