

WSK022

数控蓝宝石滚磨机

WSK022 CNC Sapphire Tumbling Mill



■ 技术规格参数 ■ Specifications and Technical Parameters ■

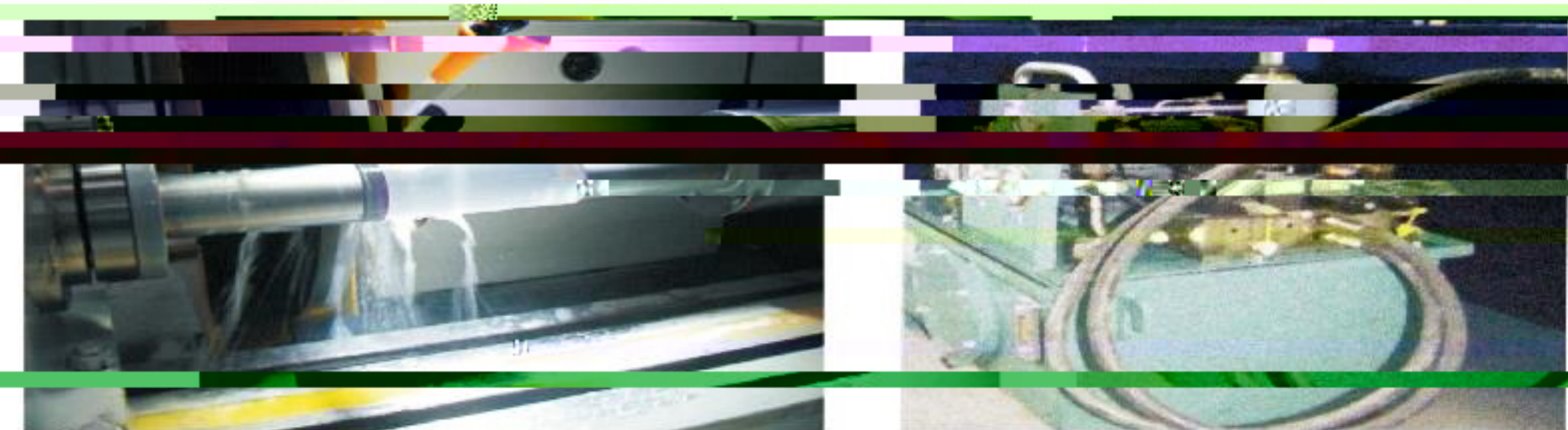
加工工件参数Workpiece parameters	
磨削长度Grinding length	500mm(max)
适用磨削直径Applicable grinding diameter	2寸~8寸inch
主要参数Main parameters	
中心高Central height	125mm
砂轮线速度Linear speed of grinding wheel	25m/s(max) 3(m/s)
金刚石砂轮尺寸Size of diamond grinding wheel	Φ300x(15~30)xΦ127mm
头架可回转角度Rotary angle of headstock	±90°
尾架顶尖行程Top travel of tailstock(max)	250mm(max)
特殊顶紧装置Special clamping device	液压顶紧装置with hydraulic top clamp
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Headstock spindle speed	0~1000rpm (变频调速) (AC frequency conversion speed regulation)
头架回转精度Rotary accuracy of headstock	径向跳动Radial runout<0.004mm
数控轴Axis	
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	≤65%RH
环境温度Environmental temperature	0~35℃
振源Vibration source	周围无振源
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≤0.5μm

■ 机床用途与性能特征 ■

- 本机床用于磨削太阳能行业、半导体材料及蓝宝石材料，可磨削各种规格棒材的外圆（磨削工件无需更换金刚石砂轮）。
- 头架、尾架采用特制液压顶紧夹具方式磨削。
- 采用进口二轴联动数控系统，内装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滚珠丝杠拖动。
- 机床床身为高强度、低应力的铸铁整体铸造，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内，可不移动尾架，其夹具的液压顶紧力可任意调整。
- 磨削加工时可实现一次装夹自动磨削循环（粗磨、精磨、到尺寸退出）。
- 电器柜与床身刚性连接，避免多次拆卸联线，保证电气连接可靠。

■ Main Applications and Structural Features ■

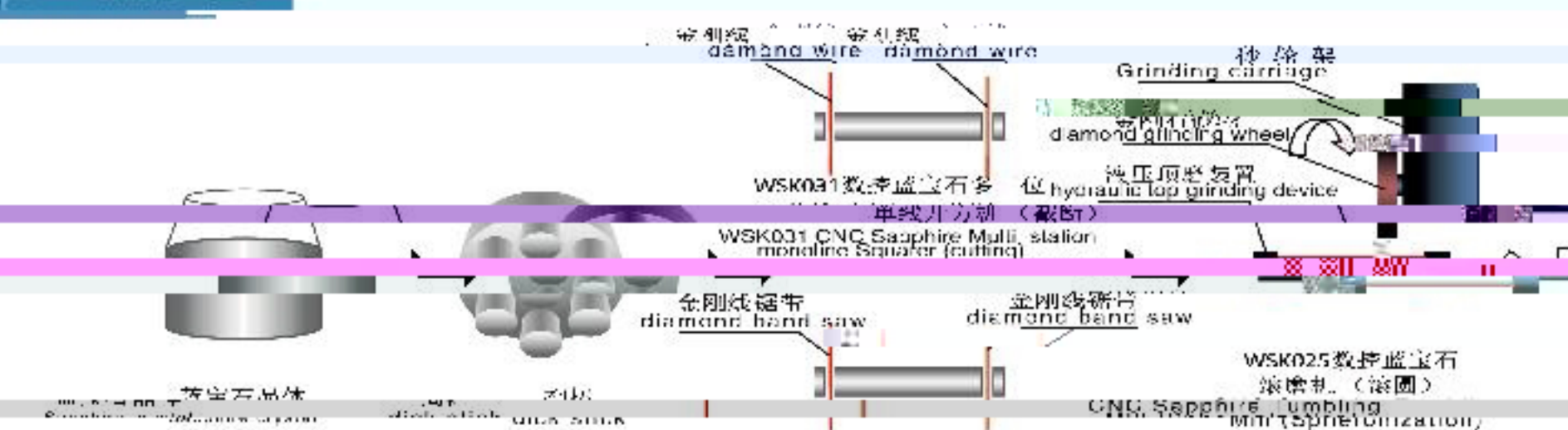
- This equipment is applied in the PV industry, semiconductor materials and sapphire materials, which can grind outer circle of 2-8 inch bar after cutting (no need to change diamond grinding wheel)
- Headstock, tailstock applies special hydraulic top clamp type grinding.
- Applies imported two-axis linkage CNC system, within with PLC touch panel display.
- Worktable longitudinal movement and grind wheel transverse apply servo motor ball screw.
- Casing is made by high strength, low stress cast iron with high stiffness, structure good, vibration absorb and shock absorbing and heat balance.
- Length change of work piece shall be within 100mm, tailstock can be fixed, hydraulic top force of jig can be whatever adjusted.
- While grinding, once the single piece is set, automatic grinding circulation can come into being (rough grinding, finish grinding to exist)
- Electric cabinet connects with body, avoiding repeated disassembly, ensuring reliable connection.



加工现场process site

内部结构internal equipment

■ 加工流程 ■ Substrate Process and Flow Chart ■



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