

Doimak

EXTERNAL THREAD GRINDING MACHINE : RER



The RER serial belongs to the last generation of CNC grinding machines, designed for the grinding of external threads.

Main features:

- High precision and excellent fiability.
- Automatic calculus of the wheel profile and of the path of dressing.
- Automatic swivel of the wheelhead $\pm 45^\circ$.
- Possibility of grinding long pitches.
- Generation of different profiles: Metric, Whitworth, Trapezoidal.
- Easy to use, due to the fact that the programmation it is made trough the screens.

TECHNICAL FEATURES

- Distance between points : 500 mm, 1.000 mm, 1.500mm, 2.500 mm, 3.000mm.
- Heights of centers: 200 mm.
- Wheel head tilting: $\pm 45^\circ$.
- Range of selectable pitches: 1 to 300 mm.

QUALITY

ISO -1

WHEEL DRESSER (with 2 axis cnc controlled).

- "X1" axis: Dressing unit - Feeding movement
Vertical stroke with infinitely variable speed between 0 and 2.000 mm/min.
Sizing system by encoder.
Resolution: 0,001 mm.
- "Z1" axis: Dressing unit.
Horizontal stroke with infinitely variables speed between 0 and 2.000 mm/min.
Sizing system by encoder.
Resolution: 0,001 mm.
- Dressing cycle and the wheel wear compensation are both programmable.



GRINDING CYCLES AVAILABLE

- Outside reciprocating cycle.
- Outside squared cycle.
- Grinding of taper threads.
- Wheel dressing.
- Wheel wear compensation.
- Taper correction by sections.
- Pitch correction.
- Parameter modification during work.

CNC CONTROL SIEMENS SINUMERIK 840 D

SOFTWARE

- It is a set of sub-programmes corresponding with each grinding cycle, being managed all of them through the main program developed by DOIMAK to these special purposes.

DOIMAK - 20870 ELGOIBAR-GUIPUZCOA-SPAIN

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BASE

- Amply sized perlitic cast iron with the internal ribs necessary to ensure good machine rigidity and vibration-free running.

TABLE -"Z" AXIS

- Table driven by digital type A.C. servomotor and precision ball screw.
- Guides covered with antifriction blades – turcite .
- Stroke reading by high precision linear glass scale.

WORKHEAD -"C" AXIS-

- Spindle index by digital type A.C. direct motor.
- The synchronizing of spindle rotation with table stroke is carried out by means of CNC control.
- Possibility for controlling part rotation in one or several different positions.
- Spindle speeds are infinitely variable between 0,5 ÷ 270 rpm.
- Angular positioning though encoder of high resolution.

TAILSTOCK

- Two pieces device with upper side laterally movement for taper correction. A graduated dial is available for this purpose.
- Sleeve mounted on bronze bearings, manually operated by lever.

WHEEL HEAD SLIDE -"X" AXIS

- Slide driven by digital type A.C. servo motor and precision ball screw.
- Slide stroke reading by glass scale.
- Maximum tilting on both sides: $\pm 45^\circ$.
- Spindle driven by 11 kW powered, A.C.direct motor.
- Speed variator of 11 kW to keep constant peripheral speed on grinding wheel.
- Spindle mounted on high precision preloaded angular contact ball bearings.
- Guides covered with antifriction blades – turcite .

