

EXTERNAL THREAD HEAVY RANGE GRINDING MACHINE: RER-SP



This model of grinding machine is especially designed for the grinding of threads longer than 3.000 mm. The main difference respect to the RER serial is the following:

RER:

Displacement of the part trough movable table.
Fixed wheel head

RER -HEAVY RANGE:

Fixed table, Fixed part.
Movable wheel head.

This new concept of machine allows the longitudinal dimensioning, much more reduced due to the fact that the part remains fixed.

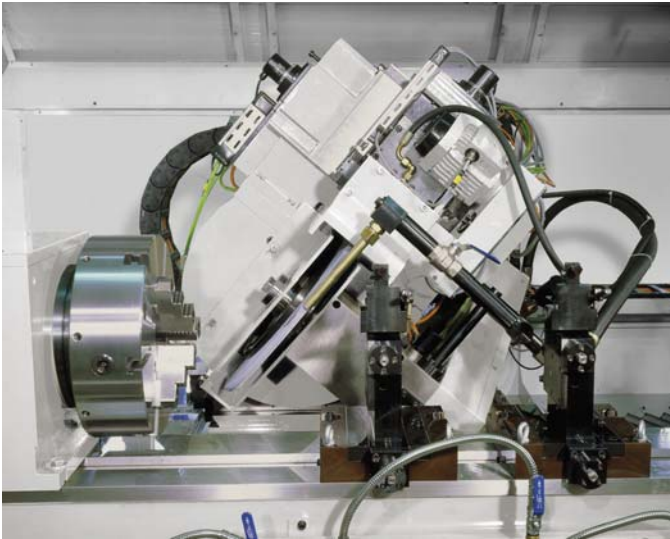
Relating to capabilities it is similar to the RER serial taking in account the precision and fiability, profiling of the wheel, dressing, grinding of long pitches, generation of profiles and facility to use the machine.

TECHNICAL FEATURES

- Distance between points : 4.000mm, 5.000mm and 6.000 mm.
- Heights of centers: 225 mm.
- Wheel head tilting: $\pm 45^\circ$.
- Range of selectable pitches: 1 to 300 mm.

QUALITY

ISO -1



BASE

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

WHEEL HEAD SLIDE -"Z" AXIS

- Mounted directly over the basis.
- Slide driven by digital type A.C. servomotor and precision ball screw.
- It moves on hydrostatic guideways for a uniform displacement of the slide at any speed and with an independent circuit.
- Stroke reading by high precision linear glass scale.

WHEEL HEAD SLIDE -"X" AXIS-

- Slide driven by digital type A.C. servomotor and precision ball screw.
- Slide stroke reading by glass scale.
- Maximum tilting on both sides: $\pm 30^\circ$ automatic.

WORKHEAD -"C" AXIS-

- Spindle index by digital type AC direct motor.
- Through bore of 100 mm dia. With MT n^o 4 at the front of the shaft.
- The synchronizing of spindle rotation with table stroke is carried out by means of CNC.
- Positioning reading by encoder of high resolution pulses/rev.

TAILSTOCK

- Taper correction by means of a graduated dial.
- Sleeve mounted on bronze bearings, manually operated by lever.

CNC CONTROL SIEMENS SINUMERIK 840D

3 Points carbide steady rest, range 20-100 mm

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.

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.

WHEEL DRESSER

Wheel dresser, with 2 axis cnc controlled.

- X1" axis: Dressing unit - Feeding movement
Infinitely variable speed between 0 and 2.000 mm/min.
Sizing system by encoder.
Resolution: 0,001 mm.
- Z1" axis: Dressing unit - Transversal movement
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.
- Support for dressing with diamond roll driven by 0,74 kw A.C. motor power.



DOIMAK - 20870 ELGOIBAR-GUIPUZCOA-SPAIN

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