

INTERNAL THREAD GRINDING MACHINE : RIR



MAIN TECHNICAL DATA

- Max. diameter of piece: 275 mm
- Max. diameter of thread: 225 mm.
- Max. length of thread: 350 mm.
- Max. helix angle: 20 °.
- Pitch range to be ground: 1-300 mm.

TECNICAL FEATURES

BASE

- Amply sized perlitic cast iron with the internal ribs necessary to ensure good machine rigidity and vibration-free running.
- Designed with large spaces for collecting coolant and a sloping outlet to facilitate coolant removal and machine cleaning.
- Coolant flushing around the base to eliminate the accumulation of swarf.

TABLE -"Z" AXIS

- Table driven by digital type A.C. servo motor and precision ball screw.
- Guides covered with antifriction blades to allow them appropriate lubrication and stick slip free stroke even at slow speeds.
- Lubrication is carried out through independent circuit.
- Stroke reading by high precision linear glass scale.
- Max. stroke speed: 6.000 mm/min.

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.

Pol. Ind. San Lorenzo, nº 4. Apdo. P.O. Box 11
20870 ELGOIBAR-GUIPUZCOA-SPAIN
Tel: 00 + 34 943 74 33 00
Fax: 00 + 34 943 74 32 16
webmaster@doimak.es www.doimak.es

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 .

