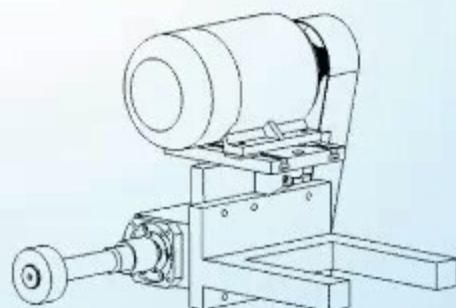
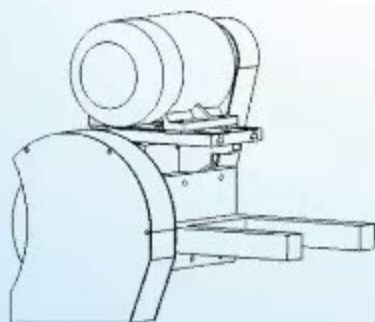


FY250/1 FY300/1 刀架安装式磨头
FY250/1 FY300/1 TURRET-MOUNTED GRINDER
ATTACHMENT



特点

- 安装方便。可直接安装在车床刀架上。
- 主机设计合理，重量轻、低噪音、低温升、低振动、高精度。
- 可磨削传统磨床上无法加工的工件。
- 可磨削车床本体上的锥孔，顶尖，卡爪加持位等。
- 可在车床上磨削外圆、内圆、端面、外锥面及内锥孔，如莫氏锥孔、公制锥孔、7:24锥孔。
- 磨头砂轮可换成切割片成为切割机，换成抛光轮成为抛光机。

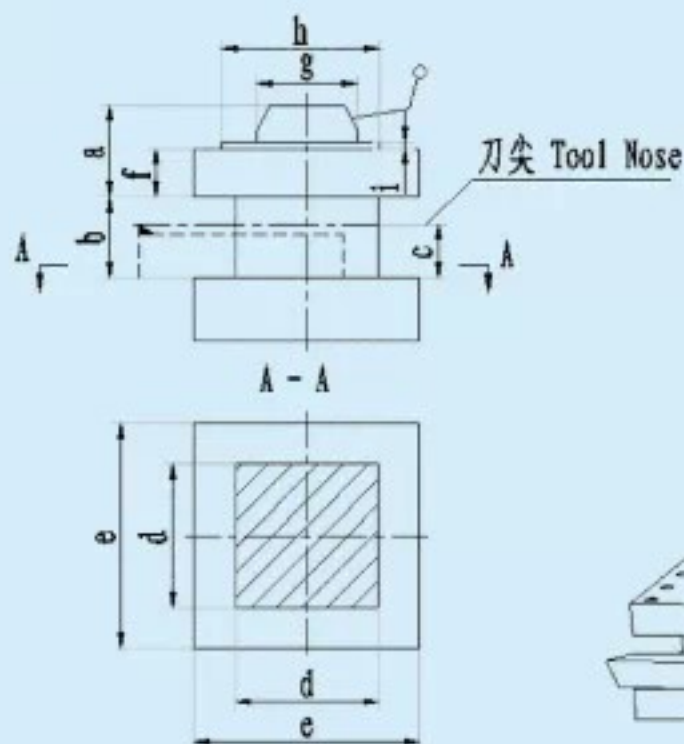
Features

- Easy to install. It can be mounted directly on the lathe turret.
- Reasonable design, light weight, low noise, low temperature rise, low vibration, high precision.
- Workpiece that can not be processed on conventional grinder can be grinded.
- Tapered bore, center, claw on lathe itself can be grinded.
- It can grind cylindrical, inner circle, face, outer cone and inner tapered bore, such as the Morse taper, metric tapered bore, 7:24 taper.
- Abrasive wheel can be replaced for cutting disc, polishing wheel, It is used for cutting and polishing.

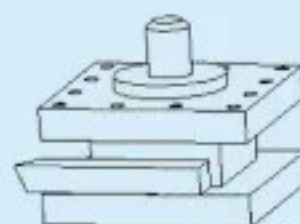


刀架示意图

Turret diagram

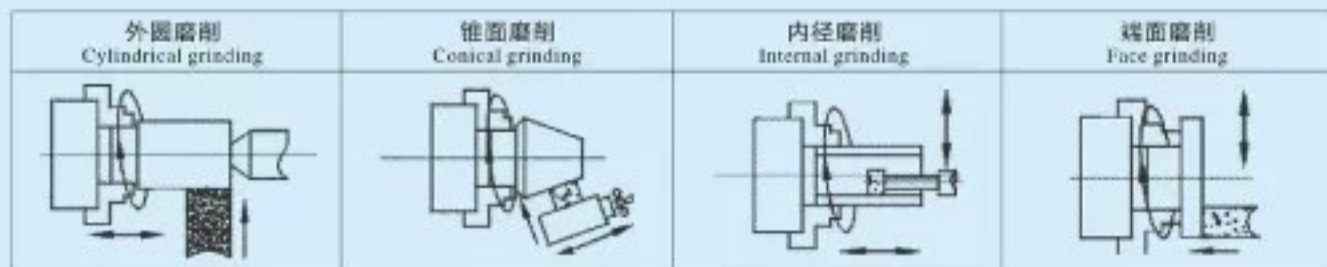


a	
b	
c	
d	
e	
f	
g	
h	
i	



磨削类型

Grinding Type



主要参数

Main Parameter

参数PARAMETER \ 型号TYPE	FY250/1	FY300/1
主轴类型 Spindle type	滚动轴承 Bearings	滚动轴承 Bearings
主轴直径mm Spindle diameter mm	Φ35	Φ50
外圆磨削主轴转速rpm Cylindrical Grinding Spindle rpm	2145	2228
内圆磨削主轴转速rpm Internal Grinding Spindle rpm	6265	6265
砂轮线速度m/s Wheel linear velocity m/s	35	35
内磨深度mm Internal Grinding Depth mm	220	270
电机功率kw Motor power kw	1.5/2.2	3
砂轮尺寸mm Wheel Size mm	Φ250 × 25(20-32) × Φ75	Φ300 × 40(25-40) × Φ75
内圆砂轮尺寸mm Inner Wheel Size mm	Φ80 × 20 × Φ20	Φ80 × 20 × Φ20
重量Kg Weight Kg	65	95
外型尺寸 mm Size mm 长 × 宽 × 高 Lenght*wide*height	404 × 425 × 485	511 × 475 × 560

随机附件：砂轮，砂轮平衡轴，卸砂轮拔头。

Accessories: wheel, wheel balance shaft, wheel unloading pulling head.

选购附件：砂轮平衡架，手持式砂轮平衡仪，砂轮修整器。

Optional accessories: wheel balancing stand, wheel balancing handheld instrument, dresser.



FYK 系列中高机

FYK SERIES CROWNING GRINDER ATTACHMENT



中凸Convex crown



中凹Concave crown



螺旋Threads



圓柱Cylinder



梯形Taper ends

特点

●磨削工件广泛

可磨削橡胶、聚氨酯PU胶、硅树脂胶、塑料、金属、非金属及其他多种纤维材料辊。

●操作简单

触摸屏输入磨削参数，操作简单，方便。

●磨削精度高

最小磨削中高0.01mm，最大中高8mm。

●多种磨削参数输入方式

有三种磨削参数输入方式，即车床参数输入方式，磨削时间输入方式，磨头纵向移动速度输入方式（如编码器）。

●多种曲线磨削

中高中凹曲线可为抛物线，圆周曲线，正弦曲线，两端锥面，中间为平面曲线。

●磨削曲线矫正

- 可矫正机床本身精度及因调整原因加工工件出现的缺陷。
- 可矫正中高磨削辊类工件出现的中高对称性缺陷。

Features

●Widely used

It can grind rubber, polyurethane PU glue, silicone rubber, plastics, metals, non-metallic materials and a variety of other fiber roll.

●Easy to operate

Touch screen operation -----replace the traditional buttons control panel.

●Precision grinding

The convex / concave crown height range is from 0.01 mm to 8.00 mm.

●Various modes of grinding parameters input

There are three modes of grinding parameters input, ie lathe parameter input, grinding time input and grinding longitudinal movement speed input mode (such as encoders).

●Multiple curve grinding

The convex / concave crown height can be parabolic curve, circular curve, sinusoidal curve and taper ends curve.

●Grinding curve correction

- To correct the grinding defects generated by the machine tool itself.
- To correct the symmetry of convex / concave crown height curve.

曲线校正

Curve Correction

机床本身精度及调整问题造成工件加工形状

To correct the grinding defects
generated by the machine tool itself

■ 工件带锥/Workpiece taper



校正前加工形状
Workpiece shape before
correction

校正后工件形状
Workpiece shape after
correction

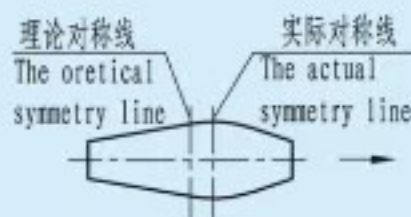
■ 工件大小头/Ends of different sizes



校正前加工形状
Workpiece shape before
correction

校正后工件形状
Workpiece shape after
correction

■ 中心偏移/Center offset



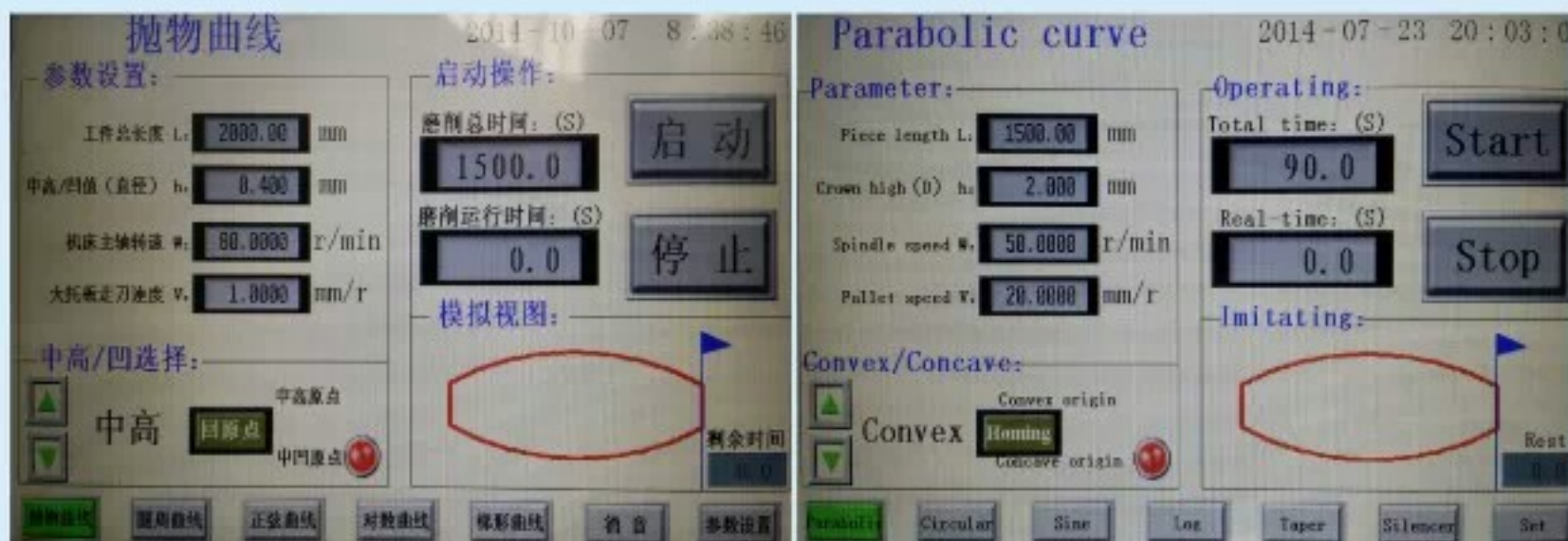
中心偏移/Center offset



中心对称/Centrosymmetric

界面

Interface



主要参数

Main Parameter

型号TYPE 参数PARAMETER	FYK250	FYK350	FYK500
可磨削中高类型 Grinding type	中凸Convex crown 中凹Concave crown 梯形Taper ends 圆柱Cylinder	中凸Convex crown 中凹Concave crown 梯形Taper ends 圆柱Cylinder	中凸Convex crown 中凹Concave crown 梯形Taper ends 圆柱Cylinder
中高值mm Crown height mm	0.01--8	0.01--8	0.01--8
主轴类型 Spindle type	滚动轴承 Bearings	滚动轴承 Bearings	滚动轴承 bearings
主轴直径mm Spindle diameter mm	Φ35	Φ50	Φ70
主轴转速rpm Spindle rpm	2145	1528	1070
砂轮线速度m/s Wheel linear velocity m/s	28	28	28
电机功率Kw(P) Motor power kw	2.2(3)	4(5)	7.5(10)
砂轮尺寸mm Wheel size mm	Φ250×32×Φ75	Φ350×40×Φ127	Φ500×50×Φ203
重量Kg Weight Kg	170	250	
外型尺寸mm Size mm 长×宽×高 Lenght*wide*height	580×455×390	860×570×600	865×725×715

随机附件：砂轮，砂轮平衡轴，卸砂轮拔头，砂轮修整器。

Accessories: wheel, wheel balance shaft, wheel unloading pulling head, dresser.

选购附件：砂轮平衡架，手持式砂轮平衡仪。

Optional accessories: wheel balancing stand, wheel balancing handheld instrument.

