Machine Name : Internal and external cylindrical grinder

Brand : STUDER

Machine Model : KC33 1000U

Stock No. : 65339

Ex-factory Date : To be supplemented



Main Technical Parameters:

CNC System: FANUC

Top distance :650/1000mm

Distance between centers: 175mm

X-axis: 285mm

Z-axis :800/1150mm

Automatic rotary shaft :1 degree tooth indexing

grinding wheel linear speed :50m/s

internal grinding Spindle speed: 40,000 RPM

Speed range :1-650 rpm

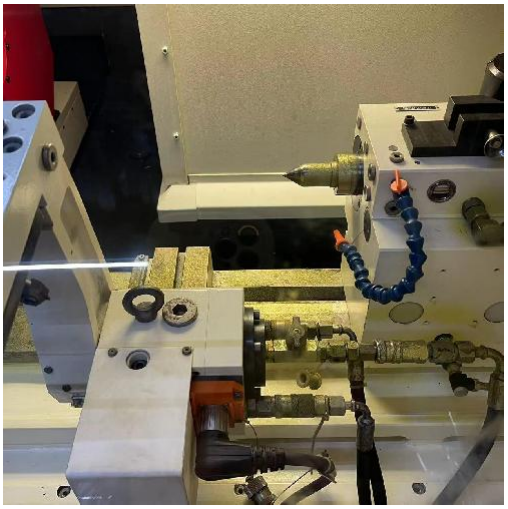
Internal diameter of spindle through hole: 50mm

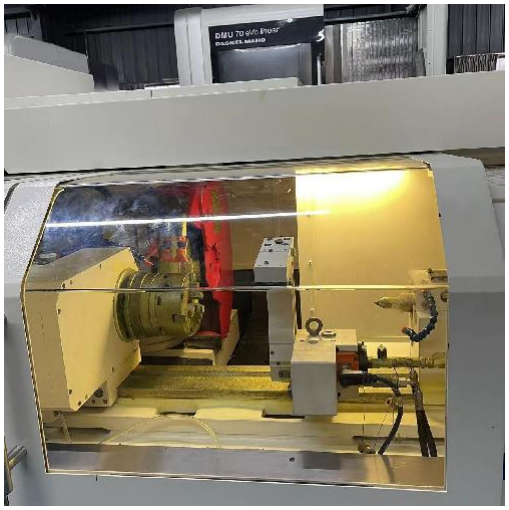
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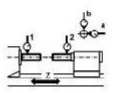
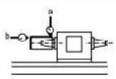
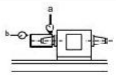
Mach.-No.:

机床的精度 *Geometry of machine*

序号 No.	测试项目 Measuring object	示意图 Sketch	示值偏差 Deviation Permissible 允许值 mm	示值偏差 Deviation Actual 实际值 µm
1	工作台在相对于其各坐标轴的平行度 a) 水平方向 b) 垂直方向 *Parallelity, i.e. straightness of the table surfaces in relation to the ways, guideway* a) *horizontal* b) *vertical*		a) 10 / 650 或/or 15 / 1000 b) 15 / 650 或/or 20 / 1000 局部公差 *Local tolerance* 5 / 200	3 17 2
2	工作主轴锥孔轴线的径向跳动 *Concentric running of the workpiece spindle bore.*		a) 3 b) 6 / 100	1 1
3	工作主轴轴线对Z轴方向移动的平行度 a) 水平平面内 b) 垂直平面内 *Parallelisms of workpiece spindle axis to Z-axis movement* a) *in the horizontal plane* b) *in the vertical plane*		a) 6 / 100 b) 8 / 100	2 2
4	尾架套筒锥孔轴线相对Z轴方向移动的平行度 a) 水平平面内 b) 垂直平面内		a) 6 / 100 b)	3 3

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测试证书
Test Certificate

序号 No.	测试项目 Measuring object	示意图 Sketch	示值偏差 Deviation Permissible 允许值 μm/mm	Actual 实际值 μm
5	工件头和尾孔轴线和主轴套筒锥孔轴线沿Z轴方向移动的等高度 a) 在水平平面内 b) 在垂直平面内 *Equality of the spacing between the workpiece spindle / the tailstock quill axis and the Z axis movement.* *a)* *on the horizontal plane* *b)* *on the vertical plane*		a) 20	5
			b) 20	10
*6	外圆砂轮主轴锥孔的向心跳动 *Concentric running of the grinding wheel receiving taper.*		a) 5	1
			b) 5	1
*7	内圆砂轮主轴锥孔的向心跳动 *Concentric running of the grinding wheel receiving taper.*		a) 5	1
			b) 5	1

