WSK022

数控蓝宝石滚磨机

WSK022 CNC Sapphire Tumbling Mill

技术规格参数 Specifications and Technical Parameters

加工工件参数Workpiece parameters	
适用直径Applicable diameter	2-6inch
主要参数Main parameters	
中心高Central height	125mm
砂轮线速度Linear speed of grinding wheel	35m/s(max)/≤(max)
金刚石砂轮尺寸Size of diamond grinding wheel	Φ203(Φ152.38)xΦ127mm
头架可回转角度Rotary angle of headstock	±8°
尾架顶尖行程Top travel of tailstock(max)	25mm(max)
特制尾架主轴Special tailstock spindle	配液压顶紧夹具with hydraulic top clamp
砂轮架电机功率Motor power of grinding carriage	3kW
头架电机功率Motor power of headstock	0.75kW
头架主轴转速Speed of headstock spindle	0-600r/min(变频无级调速)
	(AC frequency conversion stepless speed regulation)
头架回转精度Rotary accuracy of headstock	Z向重复定位精度0.003mm
	轴向重复Axial channeling move≤0.005mm
数控轴Axis	X轴：砂轮架进给X axis: grinding carriage feed
	Z轴：工作台进给Z axis: worktable feed
电源供给及配套设施Power supply and matched facility	
供电电压Power supply and voltage	交流AC 380V 50HZ 50Hz
相对湿度Relative humidity	小于less than 75%
环境温度Environment temperature	0-35℃
振源Vibration source	周围无振源no
磨削精度Grinding accuracy	
圆度Roundness	≤0.08mm
纵截面内尺寸一致性Dimensional uniformity within longitudinal section	0.1mm
表面粗糙度Surface roughness	Ra≤0.5um

机床用途与结构特征

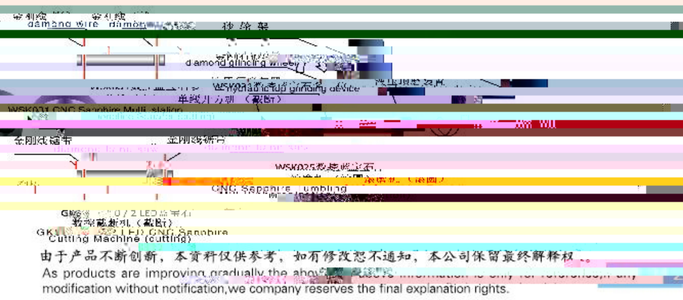
- 本机床用于磨削太阳能行业、单晶硅棒及蓝宝石晶棒等材料，可磨经切方后2寸～8寸棒料的外圆（磨2寸圆棒无需更换金刚石砂轮）。
- 头架、尾架采用特制成顶紧夹具方式磨削。
- 采用进口二轴联动数控系统，内装PLC，触摸屏液晶显示。
- 工作台纵向移动及砂轮架横向移动采用伺服电机，高精丝杆拖动。
- 机床床身为高强度、低应力铸铁整体铸造，采用高刚度结构，有良好的减振和热平衡性能。
- 工件长度变化在100mm内，可不移动尾架，其液压顶紧力可任意调整。
- 磨削加工具备时实现一次装夹自动完成（粗磨、粗磨、精磨、到尺寸退出）。
- 电器电柜与床身刚性连接，避免多次拆卸维修，保证电气连接可靠。

Main Applications and Structural Features

- This equipment is applied in the PV industry, processing monocrystalline silicon, sapphire bar
- circle of 2-6 inch bar and ... char no need to change diamond g...
- Headstock, tailstock applies special ... top clamp type grinding.
- Applies imported two-axis linkage CNC system, within ... PLC touch screen displa...
- Worktable longitudinal movem... grind wheel transverse ... apply servo motor ball screw screw.
- Casing is ... Casing is caste by high-strength, low-stress cast iron ... with stiffness structure and good performance of shock absorption and ... heat balance.
- Length change of work piece shall be within ... mm, tailstock can by fixed, hydraulic top force of jig can be whatever adjusted.
- While grinding crystal ... char, a single set-up automatic grinding circulation can com... (fast forward, coarse grinding, finish grinding to exist)
- Electric cabinet connects with body, avoiding repeated disassembly, ensuring reliable connection.

加工现场process...

特点加工流程图 Substrate Process and Flow Chart



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