

中型数控产品



B1-ZX001汽车零件加工生产线具有高精度、高效率、高可靠性和高柔性自动化加工的特点，能够实现刹车盘自动装夹，完成粗车、精车、铣削、钻孔、攻丝、镗孔、双面车、双面磨，并采取了多项物流机构上工件位置的可靠性检测手段，实现了工件从毛坯到成品的全自动化加工过程。该生产线由1台CHA563立式复合车削中心、1台CDKA513A数控倒立车床和1套自动化物流传送机构串联组成，可以满足目前市场上流行的大部分刹车盘加工的需求。将来，在物流机构上增加上料、下料机械手后，可以实现整个加工过程无人化操作，满足现代化加工的需求。

B1-ZX001 production line for auto parts processing has the characteristics of high precision, high efficiency, high reliability and highly flexible automated processing, which can make the automatic clamping of brake discs and finish the rough turning, finish turning, milling, drilling, tapping, boring, double-side turning and double-side grinding. It also applies the reliability testing methods of work piece positions on several logistics mechanisms so as to achieve the fully automatic machining process of work pieces from raw materials to the finished products. This line is composed of one CHA563 vertical compound turning center, one CDKA513A CNC inverted lathe and one set of automatic logistics transmission mechanism in series, which meets the machining requirements of the most commonly used brake discs in the markets currently. Adding loading and unloading manipulator on the logistics mechanism in the future will realize the unmanned operation during the whole machining process meeting the demands of modern machining.

B1-ZX001 汽车零件加工生产线 B1-ZX001 Production Line for Auto Parts Processing



CDKA513A 数控倒立车床

CDKA513A CNC Inverted Lathe

CDKA513A 数控倒立车床主要用于盘套类批量化零件的加工生产，如刹车盘、刹车鼓等。该机床采用一个倒立式主轴和对应的双面车削单元、双面磨削单元，有C、E、W、Z、X共5个轴，可以实现C、Z、X三轴联动，机床配有高可靠性的自动上、下料物流机构贯穿机床，可以实现工件自动上、下料，一次装夹完成两面的车削基准面、双面车、双面磨、加工工序。

CDKA513A CNC inverted lathe is mainly used in the processing and machining of batch of disc parts, such as brake disc, brake hub, etc. This machine applies one inverted spindle and the corresponding double-side turning unit and double-side grinding unit with C, E, W, Z and X five axes and can achieve C, Z and X three-axis machining simultaneously. This machine is equipped with a high reliability and automatic loading and unloading logistics mechanism to cross the machine for the automatic loading and unloading of work pieces. One time of clamping will enable two sides of turning datum plane, double-sided turning, double-sided grinding and machining process.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	CDKA513A
床身上回转空间 Rotary space on bed	mm	Φ660
主轴卡盘外径 Outer Diameter of spindle chuck	mm	Φ305
转速 Rotation speed	rpm	30~3000
最大扭矩 Max. torque	Nm	420
双面车 Double-sided turning		
最大车削厚度 Max. turning thickness	mm	50
双面车快速进给速度 Rapid feed speed of double-sided turning	m/min	15
双面磨 Double-sided grinding		
最大磨削厚度 Max. grinding thickness	mm	60
双面磨快速进给速度 Rapid feed speed of double-sided grinding	m/min	15
整体尺寸 (长×宽×高) Overall dimension (L×W×H)	mm	4251×2300×3007
机床总重 Total weight of machine	kg	12500



CHA563 立式复合车削中心

CHA563 Vertical Compound Turning Center

CHA563立式复合车削中心是一台通用机床，主要用于盘套类批量化零件的全自动加工生产，不仅可以加工刹车盘、刹车鼓，还可以加工回转类和非回转类零件的车削、钻削加工，如泵壳体等。该机床配置高性能双通道数控系统，采用一正、一倒立式主轴和分别对应的独立动力刀塔，可以进行X、Z和C轴三轴联动，机床两侧配有高可靠性的自动上、下料物流机构，可以一次装夹完成两面的车、铣、镗、钻、攻丝加工工序。

CHA563 vertical compound turning center is a universal machine, which is mainly used in the fully automatic machining and production of batch of disc parts. It not only can machine brake discs and brake hubs, but also can process the turning and drilling of rotational and non-rotational parts, like pump shell, etc. This machine is equipped with good performance dual-channel NC system and adopts one regular and one inverted vertical spindle and the corresponding separate power turret respectively. It is able to achieve X, Z and C three-axis machining simultaneously. A high reliability and automotive loading and unloading logistics mechanism is equipped on both sides of the machine, which enables the two-side machining process of turning, milling, boring, drilling and tapping after one time of clamping.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	规格 Specifications
床身上回转空间 Rotary space on bed	mm	Φ660
主轴卡盘外径 Outer diameter of spindle chuck	mm	Φ305
最大加工直径 Max. machining diameter	mm	Φ370
最大加工长度 Max. machining length	mm	250
转速 Rotation speed	rpm	30~3000
最大扭矩 Max. torque	Nm	420
刀塔形式 Turret mode		VDI 40
刀具数量 The number of tools	把 Set	12
机床整体尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	4920×2330×3007
机床总重 Total weight of machine	kg	14000



CDHA512/CDHA513 倒立车削中心

CDHA512/CDHA513 Inverted Turning Center

CDHA51系列倒立车削中心由倒立式主轴和配备动力头的回转刀架组成，通过增加Y轴可以使其加工范围得到扩充。主轴采用交流电机驱动，可实现无级变速，机电一体化的结构节省了空间。并可配备有送料机构和工件翻转器，特别适合盘套类零件的批量化加工。

CDHA51 series inverted turning center is composed of an inverted spindle and the rotary turret equipped with power unit. Its machining range can be extended by adding Y axis. The spindle is driven by AC servo motor which can achieve the infinitely variable speeds and save the space for the structure of mechanical and electrical integration. It can be also equipped with feed mechanism and work piece flip device, which is especially suitable for the batch machining of disc and sleeve parts.

技术参数

Technical parameters

项 目 ITEM	单 位 UNIT	规 格 Specifications	
		CDHA512	CDHA513
床身上回转空间 Rotary space on bed	mm	Φ330	
主轴卡盘外径 Outer Diameter of spindle chuck	mm	Φ254	Φ305
主轴转速范围 Rotation speed range of spindle	r/min	30~4000	30~3000
主轴最大扭矩 Max. torque of spindle	Nm	420	
X/Y/Z轴行程 X/Y/Z-axis stroke	mm	1170/±50/420	
X/Y/Z轴快速进给速度 X/Y/Z-axis rapid feed speed	m/min	30/12/30	
主轴电机功率 Motor power of spindle	kW	22/15(10min/cont) 30/25(10min/cont)	
回转刀具电机功率 Motor power of rotary tool	kW	5.5/3.5(30min/cont)	
机床外观尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	4100×1530×2900	
机床重量 Weight of machine	kg	8200	



CHA56 系列立式复合车削中心

CHA56 Series Vertical Compound Turning Center

CHA56 系列立式复合车削中心是通用机床，主要用于盘套类批量化零件的全自动加工生产，不仅可以加工刹车盘、刹车鼓，还可以加工回转类和非回转类零件的车削、钻削加工，如泵壳体等。该机床配置高性能双通道数控系统，采用一正、一倒立式主轴和分别对应的独立动力刀塔，可以进行X、Y、Z和C轴任意三轴联动，机床两侧配有高可靠性的自动上、下料物流机构，可以一次装夹完成两面的车、铣、镗、钻、攻丝加工工序。

CHA56 series vertical compound turning center is a universal machine, which is mainly used in the fully automatic machining and production of batch of discs and sleeve parts. It can not only machine brake plates and brake hubs, but also can process the turning and drilling of rotational and non-rotational parts, like pump shell, etc. This machine is equipped with good performance dual-channel NC system and adopts one regular and one inverted vertical spindle and the corresponding separate power turret respectively. It is able to achieve three-axis machining simultaneously from any three of X, Y, Z and C axis. A high reliability and automotive loading and unloading logistics mechanism is equipped on both sides of the machine, which enables the two-side machining process of turning, milling, boring, drilling and tapping after one time of clamping.

技术参数

Technical parameters

项 目 ITEM	单 位 UNIT	CHA563		CHA564	
床身上回转空间 Rotary space on bed	mm	Φ660		Φ780	
主轴卡盘外径 Outer diameter (OD) of spindle chuck	mm	Φ305		Φ420(Φ457选配/option)	
最大加工长度(上/下刀塔) Max. machining length (upper/lower turret)	mm	250		185/150	
X1/X2轴快速进给速度 X1/X2-axis rapid feed speed	m/min	30(60选配/option)		30	
Y1/Y2轴快速进给速度 Y1/Y2-axis rapid feed speed	m/min	----		30(60选配/option)	
Z1/Z2轴快速进给速度 Z1/Z2-axis rapid feed speed	m/min	30		24/30	
主轴转速 Rotation speed of spindle	rpm	30~3000		30~2500(30~1800)	
最大扭矩 Max. torque	Nm	420		605	
刀塔形式 Turret mode		VDI 40		VDI 40	
动力刀具转速 Rotation speed of power tool	rpm	100~4000		100~4000	
机床整体尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	4920×2330×3007		4650×2850×3420	
机床总重 Total weight of machine	kg	14000		17800	



XHAE788 精密立式加工中心

XHAE788 Precision vertical machining center model

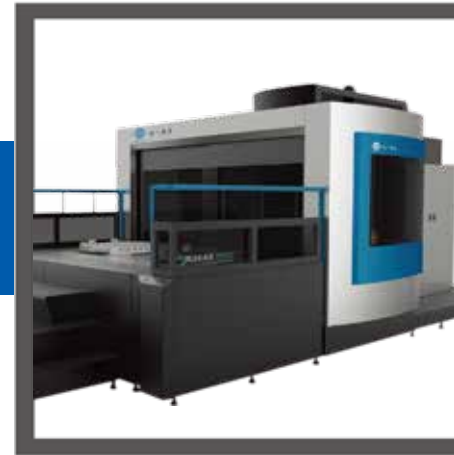
XHAE788 精密立式加工中心是我厂新开发的三轴(可选五轴)立式加工中心系列产品。机床为门型布局结构, 主轴为高速内装电主轴单元, 三向进给配有绝对值光栅尺, 配置高性能数控系统, 形成闭环控制。可选配双轴转台, 组成五轴任意四轴联动机床。具有高刚性、高精度、高速、大扭矩、高承载、多功能、优异的操作接近性等特点, 可满足各行业高效、高精加工的要求, 具有较高技术含量。

XHAE788 Precision vertical machining center model is a kind of -axis (5 axes optional) series product which is newly-developed by our plant. It is designed as portal-type layout and high-speed electro-spindle. Three axes of the machine are all adopted absolute linear measuring system as close-loop to measure the position and this machine is equipped with high-performance NC system. Table with additional 2 axes can be optional thus achieve 5 axes simultaneously controlled. This machine features high rigidity, high precision, high speed, large torque, heavy load, multifunction, excellent operability, etc. This machine is of high technology content and it can meet all industries' requirements in terms of high-efficiency and high-precision machining

技术参数

Technical parameters

整机结构形式 Layout of complete machine	单位 UNIT	门型结构 Portal type	
主轴规格 Spindle taper hole		ISO 40 (7:24)	ISO 50 (7:24)
工作台尺寸 (L × W) Table size	mm	1600 x 800	
主轴转速 Spindle speed	r/min	12000	6000
主轴电机功率 Power of spindle motor	KW	22/18.5 (15min./Cont.)	30/25 (30min./Cont.)
X/Y/Z 向工作行程 Stroke of X, Y, Z axes	mm	1400 / 800 / 710	
X/Y/Z 向快速 Rapid feed of X, Y, Z axes	m/min	36 / 36 / 32	
刀库容量 Capacity of tool magazine	把 Piece	24	24
执行标准 Standard used		GB/T 20957-2007 《精密加工中心检验条件》 GB/T 20957-2007 Test conditions for precision machining centers	
外形尺寸 (L×W×H) Overall dimension of machine	mm	4580x4200x3780	4580x4200x3780
机床重量 Weight of machine	t	18	19



XHAE76 型卧式加工中心

XHAE76 Horizontal Machining Center

XHAE76 型卧式加工中心是大型精密复杂零件加工的通用机床, 适用于黑色金属及有色金属的加工。机床刚性好、精度高、扭矩大、速度快, 可满足对零件进行粗精加工要求, 可对大型零件进行铣、镗、钻、铰、攻丝等多工序加工, 一次装夹即可完成工件四面加工以及数控联动加工。机床还提供多种功能配置选项, 以适应用户的广泛需求。

XHAE76 horizontal machining center is a general purpose machine for machining large scale precision complex parts, which applies to the machining of ferrous and nonferrous metals. This machine is with good rigidity, high precision, large torque and high speed and can meet the rough and finish machining requirements of parts. It can finish milling, boring, drilling, reaming, tapping and other multi-process machining to large scale parts and one time of clamping can finish four-side machining of work piece and CNC linkage machining. This machine is also equipped with a variety of functional configuration options so as to meet a wide range of demands of users.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	XHAE7610	XHAE7612
工作台规格 Specification of table	mm	1000x1000	1250x1250
工作台最大承重 Max. load of table	Kg	3000	4000
主轴锥孔 Taper hole of spindle		BT50/7:24	BT50/7:24
主轴转速范围 Rotation speed range of spindle	r/min	20~6000	20~6000
主电机功率 Power of the main motor	kW	22/26(cont/30min)	22/26(cont/30min)
主轴最大扭矩 Max. torque of spindle	Nm	1200(30min)	1200(30min)
X/Y/Z向行程 X/Y/Z stroke	mm	1600/1200/1050	2000/1400/1250
B向分度工作台 (op.NC工作台) B indexing table (op.NC table)		1 x360° (nx360°)	1 x360° (nx360°)
X/Y/Z快速移动速度 X/Y/Z rapid moving speed	m/min	24/24/20	20/20/20
X/Y/Z向进给速度 X/Y/Z rapid feed speed	m/min	1~20	1~20
刀库容量 Capacity of tool magazine	位 PC	60 (op. 80, 100, 120)	60 (op. 80, 100, 120)
APC容量 APC Capacity	工位 position	2	2
机床重量 Weight of machine	t	30	38
机床外观尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	8790×5260×4021	9615×5910×4271



TH63 系列卧式加工中心

TH63 Series Horizontal Machining Center

TH63系列卧式加工中心是一种装有自动换刀装置(ATC)的中型加工中心机床。具有铣、镗、钻、扩孔、刚性攻丝等多种加工能力。机床可配备1度/分数控分割台或90度/分液压转台,工件在一次装卡后可自动完成多个工序的加工。适用于多品种、中、小批量工件的生产,特别适用于航空航天、汽车、液压组件、气动组件、仪器仪表、轻工轻纺、电子器件和机械制造等行业的复杂中小型箱体、盖、板、壳、盘等零件的加工。

TH63 series horizontal machining center is a medium-sized machining center equipped with automatic tool changer (ATC) with various machining application, such as milling, boring, drilling, reaming, rigid tapping and so on. This machine can be equipped with 1° index table or 90° hydraulic rotary table and the work piece can finish several-process machining automatically after one time of clamping. It is suitable for the production of many varieties, medium and small quantities of work piece, especially for the machining of complex medium and small-sized boxes, covers, boards, shells, plates and other parts in the industries like aerospace, automotive, hydraulic components, pneumatic components, instruments, light industry and textile, electronic devices and machinery manufacturing, etc.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	TH6350
工作台面 Table area	mm	500x500
主轴锥孔 Taper hole of spindle		NO.40(7:24)
X/Y/Z向行程 X/Y/Z stroke	mm	560/450/500
X/Y/Z快速移动速度 X/Y/Z rapid moving speed	m/min	24
主轴最大转速 Max.rotation speed of spindle	r/min	6000
主电机功率 Power of the main motor	KW	11/15
刀库容量 Capacity of tool magazine	把Piece	40(op. 30)
机床外形尺寸 Overall dimension of machine	mm	3250x2825x2485
机床重量 Weight of machine	kg	约6500 About 6500



XKA73 系列数控立式床身铣床

XKA73 series CNC vertical bed milling machine

XKA73 系列数控立式床身铣床是立柱移动式床身铣床,配有德国海德汉的光栅尺、交流主轴电机和交流伺服驱动装置组成的闭环伺服系统。可以进行三轴联动,解决了三维复杂面的加工问题。它具有高刚度、高精度、高性能、高可靠性和加工范围广等特点,并可配刀库和数控转台。普遍适用于航天、船舶、军工、汽车、轻工、机械、模具等行业的黑色及有色金属的加工。

XKA73 series CNC vertical bed milling machine is the moving column bed milling machine which is equipped with the closed loop servo system composed of the linear scale of HEIDENHAIN Germany, AC spindle motor and AC servo drive unit. It can achieve three-axis machining simultaneously so that the problem of machining complex three-dimensional surfaces can be settled. It has the characteristics of high rigidity, high precision, good performance, high reliability and broad machining range, etc. and can be equipped with tool magazine and CNC rotary table. This machine is commonly applied to the machining for ferrous and non-ferrous metals in the industries such as aerospace, marine, military, automotive, light industry, machinery, mold and so on.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	XKA738	XKA7310
工作台面尺寸(宽×长) Size of table surface (W×L)	mm	800×2500	1000×3000
主轴转速范围 Rotation speed range of spindle	r/min	40~4000	40~4000
X/Y/Z向行程 X/Y/Z stroke	mm	2500/800/900	3000/1000/900
主轴锥孔 Taper hole of spindle	ISO	No. 50	No. 50
X/Y/Z快速进给速度 X/Y/Z rapid feed speed	m/min	10	10
主电机功率(AC) Power of the main motor (AC)	kW	22	22
X、Y、Z进给电机扭矩 X、Y and Z feed motor torque	Nm	55	55
机床外形尺寸(长×宽×高) Overall dimension of machine (L×W×H)	mm	7720×5125×3810	9720×4425×3705
机床重量(约) Weight of machine (about)	t	28	35



XKA71系列数控床身铣床

XKA71 series CNC Bed Milling Machine

XKA71系列数控床身铣床是使用范围很广的铣床。主轴前锥孔为国际标准 (ISO) № 40和50, 可安装各种圆柱铣刀、圆片铣刀、角度铣刀、端面铣刀等刀具, 还可借助弹簧夹头安装小规格直柄铣刀。可选配数控回转工作台 (即A轴), 可以任意三坐标联动, 实现铣削具有螺旋曲面的零件。

XK(H)A71系列机床与同类产品相比, 具有承载大、主轴扭矩大等特点。

XKA71 series CNC bed milling machine is the most commonly used milling machine. The taper hole of spindle adopts № 40 and 50 of international standard (ISO), which can be equipped with various cylindrical milling cutters, wafer milling cutters, angle milling cutters, end-surface milling cutters and other types of cutters. What is more, small-sized straight shank cutters can be installed with a spring chuck. CNC rotary table (i.e. A-axis) can be used optionally and any three coordinates can be linked so as to mill the parts with helical surfaces.

Compared with similar products, XK (H) A71 series machine has the characteristics of large load, big spindle torque, etc.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	XKA714		XKA715	
		XKA714	XKA714C	XKA715	XKA715C
工作台面积(宽×长) Working surface (W×L)	mm	(400×1100,400×1700)		(500×1250,500×1700)	
工作台最大承载重量 Max. load capacity of table	kg	1500		2000	
X轴行程 X axis travel	mm	600,(1200)		900,(1200)	
Y轴行程 Y axis travel	mm	450		520	
Z轴行程 Z axis travel	mm	500		550	
主轴至工作台面距离 Distance from spindle to table surface	mm	60~560		215~765	
低档主轴转速 Low speed of spindle	r/min	100~800(100~1200)	50~800	100~800(100~1200)	50~800
高档主轴转速 High speed of spindle	r/min	500~4000(500~6000)	200~3200	500~4000(500~6000)	200~3200
主轴锥孔 Taper hole of spindle		ISO40	ISO50	ISO40	ISO50
切削进给速度 Cutting feed speed	mm/min	X, Y: 6~3200 Z: 3~1600			
快速移动速度 Rapid feed speed	mm/min	X, Y: 8000 Z: 4000			
主轴电机功率 Spindle motor power	kW	5.5	7.5	7.5	
主轴扭矩 Spindle torque	N.m	175	235	235	
进给电机扭矩 Feed motor torque	N.m	FANUC X\Y:12 Z:22 SIEMENS X\Y:11 Z:16			

※ Note: () 中为选项 () is optional



CXHA6130 车铣复合加工中心

CXHA6130 Turning & Milling Compound Machining Center

CXHA6130 车铣复合加工中心是带有铣主轴、车主轴、背车主轴、下刀塔 (选项) 和自动换刀装置的车铣复合加工中心。可进行车、铣加工, 能够五轴联动, 从而使机床可以实现多种类、多工序复杂零件的连续加工。

CXHA6130 turning & milling compound machining center is the machining center equipped with milling spindle, turning spindle, back-turning spindle, lower turret (optional) and ATC unit. It can deal with the turning and milling machining and make five-axis linkage so as to enable the continuous machining of many varieties and multi-process complex parts of the machine.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	规格 Specifications
车主轴/背车主轴卡盘直径 Turning spindle/ chuck diameter of back-turning spindle	mm	Φ305/Φ254
最大加工直径 Max. machining diameter	mm	Φ600
最大加工长度 Max. machining length	mm	400
棒料作业能力 Working capacity of bars	mm	Φ65
X1 /X2轴行程 X1 /X2-axis stroke	mm	700/215
Y轴行程 Y-axis stroke	mm	-200~+150
Z1/ Z2/ Z3轴行程 Z1/ Z2/ Z3-axis stroke	mm	1350/1200/1200
B轴 B-axis	deg	±120°
车主轴转速 Rotation speed of turning spindle	rpm	35~3200
背车主轴转速 Rotation speed of back-turning spindle	rpm	35~4200
铣主轴转速 Rotation speed of milling spindle	rpm	35~12000
刀库容量 Capacity of tool magazine	把 Set	20/40(选项) 20/40(optional)
机床整体尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	4500x3020x2950
机床总重 Total weight of machine	kg	18000



XKA5032A、XKA5040A 系列数控立式升降台铣床

XKA5032A and XKA5040A CNC vertical knee-type milling machine

XKA5032A、XKA5040A 系列数控立式升降台铣床是一种使用很广的机床,它可以使用各种圆柱铣刀、角度铣刀及端面铣刀完成直线切削,组成各种往复循环或按坐标位置加工孔,也可以铣削具有曲线轮廓的零件,如凸轮、样板、模具、叶片、弧形槽等。

XKA5032A and XKA5040A CNC vertical knee-type milling machine are the commonly used machines, which are able to finish line milling by using various cylindrical milling cutters, angle milling cutters and end-surface milling cutters to form various reciprocating circle or process the holes based on the positions of coordinates. It can also mill the parts with curved profile, such as cam, model, die & mold, blade, curved groove, etc.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	XKA5032A	XKA5040A
工作台工作面积 (长×宽) Working area of table (L × W)	mm	1320x320	1700x400
工作台最大承载重量 Max. load weight of table	kg	320	500
X/Y/Z向行程 X/Y/Z stroke	mm	780/300/380	900/375/450
主轴转速 Rotation speed of spindle	r/min	30~1500	30~1500
主轴锥孔 Taper hole of spindle	ISO	No.50	No.50
立铣头最大回转角度 Max. rotary angle of vertical milling head	度 degree	±45°	±45°
快速移动速度 Rapid moving speed	mm/min	X,Y:6000; Z:3000	X,Y:6000; Z:3000
主轴电机功率 Power of spindle motor	kW	7.5	11
机床外形尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	1929x2055x2216	2310x2220x2394
机床净重 (约) Net weight of machine (about)	kg	3000	5000



XKA6032A 型数控卧式升降台铣床

XKA6032A CNC horizontal knee-type milling machine

XKA6032A 型数控卧式升降台铣床是一种使用很广的机床,它可以使用各种棒状铣刀、圆片铣刀及端面铣刀完成直线铣削,组成各种往复循环或按坐标位置加工孔,也可以铣削具有曲线轮廓的零件,如凸轮、样板、模具、叶片、弧形槽等。

XKA6032A CNC horizontal knee-type milling machine is a commonly used machine, which is able to finish line milling by using various rod milling cutters, wafer milling cutters and nose milling cutters to form various reciprocating circle or process the holes based on the positions of coordinates. It can also mill the parts with curved profile, such as cam, model, mold, blade, curved groove, etc.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	规格 Specifications
工作台工作面积 (长×宽) Working area of table (L × W)	mm	1320x320
工作台最大承载重量 Max. load weight of table	kg	320
X/Y/Z向行程 X/Y/Z stroke	mm	780/350/300
主电机功率 Power of the main motor	kW	7.5
主轴转速级数 Step of spindle rotation speed		18
快速移动速度 Rapid moving speed	mm/min	X/Z:6000 Y:3000
主轴转速 Rotation speed of spindle	r/min	30~1500
机床外形尺寸 (长×宽×高) Overall dimension of machine (L×W×H)	mm	1929x2055x2120
机床净重 (约) Net weight of machine (about)	kg	3000



ZH51 钻削系列

ZH51 Drilling Machine Series

ZH51 钻削系列是一种装有自动换刀装置 (ATC)并配有数控系统的小型立式钻削加工中心机床。主要用于钻削加工工序, 同时还可用来进行铰、镗、扩孔、攻丝等多种加工。具有定位精度高、加工效率高、应用范围广、自动化程度高等特点。可以根据用户要求, 组成自动化程度高、节拍快、满足大批量高效生产的柔性加工线。

ZH51 drilling series machine is a kind of small-sized vertical drilling machining center equipped with automatic tool changer (ATC) and NC system, which is mainly used in drilling process and also in milling, boring, reaming, tapping and so on. This machine has the characteristics of high precision, high machining efficiency, broad application range, high degree of automation, etc. It can make a flexible machining line with high degree of automation and fast beat that meets the requirements of highly efficient and large quantities of production according to the customer's requirements.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	ZH5120C	ZH5120D	ZH5125C
最大钻孔直径 Max. drilling diameter	mm	20	20	25
最大攻丝直径 Max. tapping diameter	mm	M16×2	M16×2	M18×2
X/Y/Z向行程 X/Y/Z stroke	mm	500/400/300	500/400/300	500/400/300
X/Y/Z快速移动速度 X/Y/Z rapid moving speed	m/min	36	48	36
工作台面积 Table area	mm	630×400	630×400	630×400
主轴转速 Rotation speed of spindle	rpm	60~10000	60~12000	60~10000
主轴锥孔 Taper hole of spindle		NO.30(7:24)	NO.30(7:24)	NO.40(7:24)
刀库容量 Capacity of tool magazine	把 Set	10/14 (选配) 10/14 (optional)	14	10
机床外形尺寸 Overall dimension of machine	mm	2280×1780×2350	2280×1780×2350	2200×1820×2500
机床重量 Weight of machine	Kg	2200	2200	2200



数控立式内圆珩磨机

CNC Vertical Internal Cylindrical Honing Machine

数控立式内圆珩磨机机床适用于加工机床参数范围内的各种通孔、盲孔及沟槽孔等。对各类铸铁件、钢件、青铜件等均能加工。本机床特别适合于气缸、连杆模具导套、液压件、压缩机件等精密孔的珩磨加工。

CNC vertical internal cylindrical honing machine applies to processing various through holes, blind holes, trench holes, etc. within the range of machine parameters. It can also machine all types of iron castings, steel pieces, and bronze work pieces and so on. This machine is particularly suitable for the honing of cylinder, rod mold guide sleeve, hydraulic parts, compressor parts, and other precision holes.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	2MK228A/1	2MK225/2
最大珩孔直径 Max. honing hole diameter	mm	Φ80	Φ50
最大珩孔深度 Max. honing hole depth	mm	100	100
主轴转速范围 Rotation speed range of spindle	r/min	170~1000	200~1220
主轴最大往复速度 Max. reciprocating speed of spindle	次/分 Times/min	365	365
工作台面积 Table area	mm	250×350	250×350
主电机转速 Rotation speed of the main motor	r/min	1420	1420
主电机功率 Power of the main motor	Kw	3	2.2
外形尺寸(长×宽×高) Overall dimension (L×W×H)	mm	1100×1450×2350	1000×1320×2400
机床重量 Weight of machine	kg	约2200/About 2200	约2200/About 2200



B3HM-002 两轴三工位龙门式数控珩磨机

B3HM-002 Two-axis Three-working-position Portal CNC Honing Machine

B3HM-002两轴三工位龙门式数控珩磨机为数控精密立式内圆珩磨机床，适用于制冷行业的压缩机缸体孔、支撑套孔、连杆孔、活塞销孔、汽车增压器行业的增压器以及汽车、摩托车行业小型零件的精密内孔的珩磨加工。

B3HM-002 two-axis three-working-position portal CNC honing machine is CNC precision vertical internal cylindrical honing machine, which applies to the honing of cylinder hole, supporting sleeve hole, rod hole, piston pin hole of compressors in refrigeration industry, turbochargers in automotive turbocharger industry, and the precision holes of small parts in automobile and motorcycle industries.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	B3HM-002
最大珩孔直径 Max. diameter of honing hole	mm	Φ40
最大珩孔深度 Max. honing hole depth	mm	100
主轴转速范围 Rotation speed range of spindle	r/min	400~2000
主轴往复次数 The number of times of spindle reciprocating	次/分 Times/min	80~400
工作台工位数 Quantity of work piece positions on table	个 piece	3
工作台旋转一个工位时间 The time for table to rotate one position	秒 S	5.8
工作台工件回转直径 Rotation diameter of work piece on table	mm	Φ400
工作台最大回转直径 Max. rotation diameter of table	mm	Φ700
机床外形尺寸 overall dimension of machine	mm	2600x2300x2800
机床重量 Weight of machine	Kg	约4000/About 4000



B3HM-033 液压双进给数控立式内圆珩磨机

B3HM-033 Hydraulic Double Feed CNC Vertical Internal Cylindrical Honing Machine

B3HM-033液压双进给数控立式内圆珩磨机为液压双进给数控立式内圆珩磨机床，主轴的往复和进给由液压驱动。工作台由伺服电机驱动，可实现并排孔准确定位，连续加工。主要用于加工汽车发动机缸体、液压缸等大深孔的珩磨加工。

B3HM-033 hydraulic double feed CNC vertical internal cylindrical honing machine is hydraulic double feed CNC vertical internal cylindrical honing machine. The reciprocating and feed of spindle are driven hydraulically. The table is driven by a servo motor, which can achieve the accurate positioning of side-by-side holes and continuous machining. This machine is mainly applied to the honing of automobile engine cylinder, hydraulic cylinder and other large and deep holes.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	数值 Value
最大珩孔直径 Max. honing hole diameter	mm	Φ100
最大珩孔深度 Max. honing hole depth	mm	200
主轴转速范围 Rotation speed range of spindle	r/min	50~1000
主轴最大行程 Max. stroke of spindle	mm	350
主轴往复最大速度 Max. reciprocating speed of spindle	m/min	25
进给推杆的最大行程 Max. stroke of feed push rod	mm	40
工作台移动行程 The moving stroke of table	mm	1000
工作台面积 Table area	mm	730× 500
机床外形尺寸（主机） Overall dimension of machine (main machine)	mm	2360×1825×4685
机床重量 Weight of machine	Kg	约4500 About 4500



B3HM-022 数控顺序珩磨机

B3HM-022 CNC Sequence Honing Machine

B3HM-022数控顺序珩磨机适用于机床参数范围内的压缩机缸体、汽车制动泵、连杆、模具导套、液压阀体等精密内孔的珩磨加工。对各类铸铁件、钢件、青铜件等均能加工。机床采用模块化设计，可根据用户零件的工艺要求为用户提供最佳的加工方案。

B3HM-022 series CNC sequence honing machine applies to the honing of compressor cylinder, auto braking pump, connecting rod, mold guide sleeve, hydraulic valve body, and other precision inner holes. It can also machine all types of iron castings, steel pieces, and bronze pieces and so on. The machine is designed in module and is able to provide the optimum machining program to users according to the process requirements of parts from users.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	数值 Value
最大珩孔直径 Max. diameter of honing hole	mm	Φ32
最大珩孔深度 Max. honing hole depth	mm	60
主轴最大往复速度 Max. reciprocating speed of spindle	m/min	16
主轴个数 The number of spindles	个 Piece	7
工作台工位数 Quantity of work piece positions on table	个 Piece	8
工作台旋转一个工位时间 The time for table to rotate one position	秒 S	0.69
工作台工位回转直径 Rotation diameter of table position	mm	Φ600
工作台台面直径 Diameter of table surface	mm	Φ800
主轴电机功率 Motor power of spindle	kw	1.1
主轴减速器比率 Ratio of spindle reducer		5: 1
主机外形尺寸 (主机) Overall dimension of machine (main machine)	mm	1460×1420×2970
机床重量 Weight of machine	kg	约3500 About 3500



B3HM-007 数控立式内圆珩磨机

B3HM-007 CNC Vertical Internal Cylindrical Honing Machine

B3HM-007数控立式内圆珩磨机是两轴三工位数控立式内圆珩磨机床，主轴采用液压往复和液压进给，工作台为精密端齿盘液压回转工作台。主要用于加工摩托车缸体孔、通机缸体孔、液压缸等孔的精密珩磨加工。

B3HM-007 CNC vertical internal cylindrical honing machine is a two-axis three-working-position CNC vertical internal cylindrical honing machine. The spindle applies hydraulic reciprocating and hydraulic feed and the table is the hydraulic rotary table with precise curvic coupling. It is mainly applied to the precise honing of cylinder hole of motorcycle, cylinder hole of general purpose engines, hydraulic cylinder, etc.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	B3HM-007
最大珩孔直径 Max. honing hole diameter	mm	Φ100
最大珩孔深度 Max. honing hole depth	mm	150
主轴转速范围 Rotation speed range of spindle	r/min	80~500
主轴最大行程 Max. stroke of spindle	mm	250
主轴往复最大速度 Max. reciprocating speed of spindle	m/min	25
进给推杆的最大行程 Max. stroke of feed putter	mm	40
主轴个数 The number of spindles	个 piece	2
工作台工位数 Quantity of work piece positions on table	个 piece	3
工作台工位回转直径 Rotation diameter of work piece on table	mm	Φ600
工作台最大回转直径 Max. rotation diameter of table	mm	Φ900
机床主机外形尺寸 Overall dimension of main machine	mm	2180×1400×3347
机床重量 Weight of machine	Kg	约4000/About 4000



B3HM-028 双轴双进给数控立式内圆珩磨机

B3HM-028 Two-axis Double Feed CNC Vertical Internal Cylindrical Honing Machine

技术参数

Technical parameters

项目 ITEM	单位 UNIT	数值 Value
最大珩孔直径 Max. diameter of honing hole	mm	Φ100
最大珩孔深度 Max. depth of honing hole	mm	150
主轴转速范围 Rotation speed range of spindle	r/min	无级80~500(stepless)
主电机功率 Power of the main motor	Kw/r/min	4/1000
主轴往复最大速度 Max. reciprocating speed of spindle	m/min	25
进给推杆的最大行程 Max. stroke of feed push rod	mm	40
工作台面积 Table area	mm×mm	300×500
主轴最大行程 Max. stroke of spindle	mm	250
机床外形尺寸(主机) Overall dimension of machine (basic machine)	mm	2540×1650×3800
机床重量 Weight of machine	kg	约4500 About 4500



B3HM-015 立式液压内圆珩磨机

B3HM-015 Vertical Hydraulic Internal Cylindrical Honing Machine

B3HM-015立式液压内圆珩磨机为立式液压内圆珩磨机，主轴采用液压往复和液压进给，工作台的移动由液压驱动。主要用于加工大型缸孔，最大加工孔径Φ180mm，最大珩孔深度为220mm。

B3HM-015 vertical hydraulic internal cylindrical honing machine is a vertical hydraulic internal cylindrical honing machine. The spindle applies hydraulic reciprocating and hydraulic feed and the moving of table is driven hydraulically. It is mainly used in machining large cylinder holes. And the Max. diameter of machining hole is Φ180mm and the Max. depth of honing hole is 220mm.

技术参数

Technical parameters

项目 ITEM	单位 UNIT	数值 Value
最大珩孔直径 Max. diameter of honing hole	mm	Φ180
最大珩孔深度 Max. depth of honing hole	mm	220
主轴转速范围 Rotation speed range of spindle	r/min	40~200
主电机功率 Power of the main motor	kW	7.5
主轴往复最大速度 Max. reciprocating speed of spindle	m/min	20
进给推杆的最大行程 Max. stroke of feed push rod	mm	40
工作台移动行程 Moving stroke of table	mm	900
机床外形尺寸(主机) Overall dimension of machine (basic machine)	mm	3200×2185×4060
机床重量 Weight of machine	kg	约3000 Appro. 3000



B3HM-016 两轴三工位数控立式内圆珩磨机

B3HM-016 Two-axis Three-working-position CNC Vertical Internal Cylindrical Honing Machine

技术参数

Technical parameters

项目 ITEM	单位 UNIT	数值 Value
最大珩孔直径 The max honing hole diameter	mm	Φ75
最大珩孔深度 The max honing hole depth	mm	150
主轴转速范围 Speed range of spindle	r/min	100~1200
主轴往复次数 Number of times of spindle reciprocation	次/分(双行程) Times/min(double stroke)	30~150
主轴箱最大引进+往复行程 The max. introduction + reciprocating stroke of spindle	mm	250
主轴箱往复及引进速度 The reciprocating and introduction speed of spindle	m/min	18
进给推杆的最大行程 The Max. stroke of feed putter	mm	30
进给速度范围 Range of feeding speed	mm/min	0~2
工作台最大回转直径 Max rotation diameter of table	mm	Φ700
主旋电机功率/转速 Power/speed of the main rotation motor	kW/转/分 kW/r/min	3.7/1500
进给电机 Feed motor	kW/转/分 kW/r/min	0.40/375
往复电机 Reciprocating motor	kW/转/分 kW/r/min	3/2000
机床外形尺寸(长×宽×高) Dimension of machine (L×W×H)	mm	2240x1200x2900
机床重量 Weight of machine	kg	约4000 About 4000

铁路机床产品

