

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	
磨削长度Grinding length	500mm(max)
适用磨削直径Applicable grinding diameter	2寸~8寸inch
主要参数Main parameters	
中心高Central height	125mm
砂轮线速度Linear speed of grinding wheel	25m/s(max)
金刚石砂轮尺寸Size of diamond grinding wheel	Φ300x(15~30)xΦ127mm...
头架可回转角度Rotary angle of headstock	±90°
尾架顶尖行程Top travel of tailstock(max)	250mm(max)
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Spindle speed of headstock spindle	6~180r/min(变频调速/变频调速)
头架回转精度Rotary accuracy of headstock	±0.01mm/100mm
轴向窜动Axial channeling moves	≤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
相对湿度Relative humidity	≤85%
环境温度Environmental temperature	0~35℃
振动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≤0.5μm

机床用途与性能特征

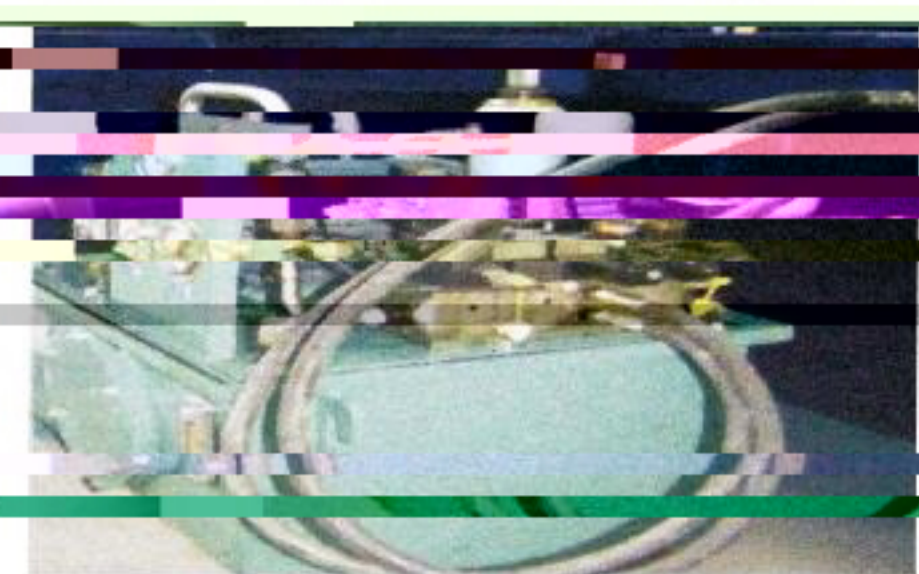
- 本机床用于磨削太阳能灯管、单晶硅棒、蓝宝石衬底材料，可磨经切后2寸~8寸棒材的外圆（磨2寸圆棒无需更换金刚石砂轮）。
- 头架、尾架采用特制液压顶紧夹具方式磨削。
- 采用进口二轴联动数控系统，内装PLC，触摸屏液晶显示。
- 工作台纵向移动及砂轮架横向移动采用伺服电机滚珠丝杠拖动。
- 机床床身为高强度、低应力的铸铁整体铸造，采用高刚度结构，有良好的吸振和热平衡性能。
- 工件长度变化在100mm内，可不移动尾架，其夹具的液压顶紧力可任意调整。
- 磨削加工是棒材时可实现自动变速循环（粗磨、精磨、到尺寸退出）。
- 电器柜与床身刚性连接，避免多次拆卸联线，保证电气连接可靠。

Main Applications and Structural Features

- This equipment is specially for the RMJ type processing of monocrystalline silicon and sapphire bar, which can grind outer circle of 2-8 inch bar after cutting.
- Headstock, tailstock applies special hydraulic top clamp type grinding.
- Applies imported two-axis linkage CNC system, within with PLC touch panel display.
- Worktable longitudinal movement and grind wheel transverse apply servo motor ball screw.
- Casing is made by high strength, low stress casting, cast iron with high stiffness, sturdy and good vibration resistance and good balance.
- Length change of work piece shall be within 100mm, tailstock can be fixed, hydraulic top force of jig can be whatever adjusted.
- While grinding crystal bar, simple automatic grinding circulation can come into use (just forward, coarse grinding, finish grinding to exist).
- Electric cabinet connects with body, avoiding repeated disassembly, ensuring reliable connection.

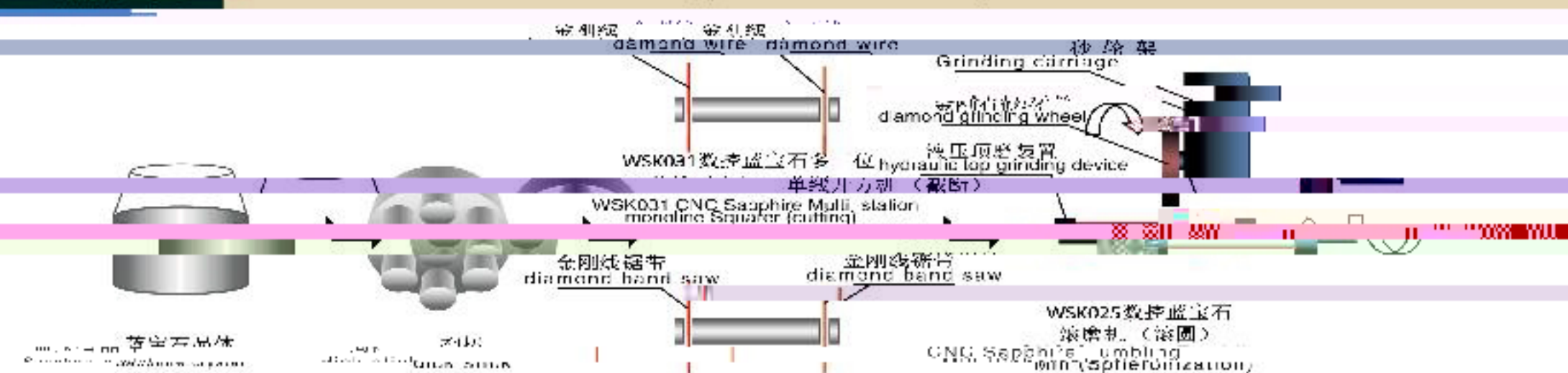


加工现场processingsite



局部设备localequipment

加工流程图 Substrate Process and Flow Chart



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