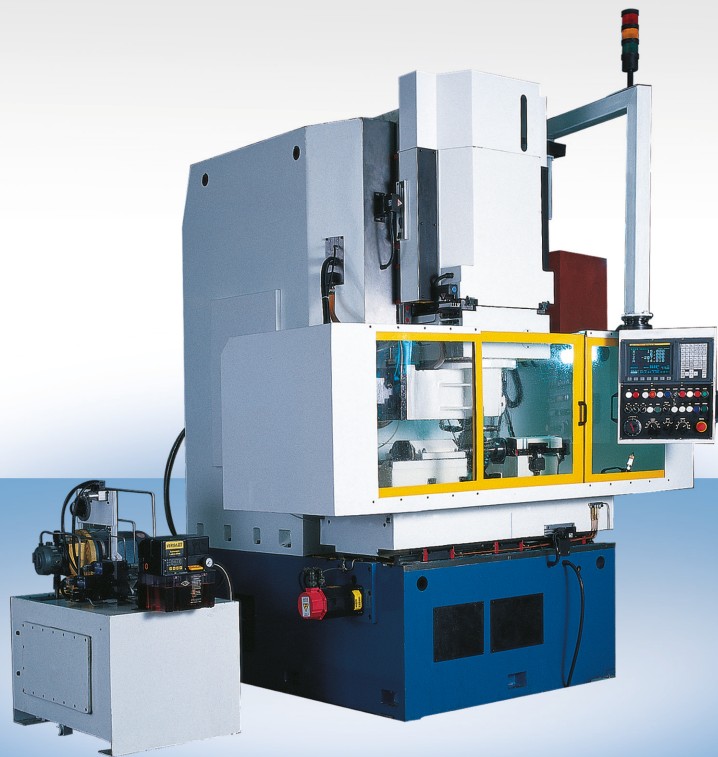




YW4240CNC 型 数控剃齿机

CNC Gear Shaving Machine Model YW4240CNC



主要特点：

Main features:

● YW4240CNC型数控剃齿机用于直齿、斜齿和连轴齿轮的精加工，适用于汽车、拖拉机、工程机械等行业的成批大量生产。剃后精度可达GB10095-8-8-6级以上。表面粗糙度Ra0.8以下。

YW4240CNC type of numerical control shaving machine is used in the finish machining of straight gear, helix gear and coupling gear. It is applied in the batch and large-scale production trades such as auto, tractor, engineering mechanism and motorcycle. The precision after shaving can be to the grade of GB10095-8-8-6. The roughness of the surface will be under Ra0.8.

● 机床剃齿加工的整个循环过程由计算机控制，CRT显示。机床如若发生故障，能够自诊断，并通过屏幕显示出来，便于操作者快速准确排除。在机床显著位置可安装有三色灯提示机床所处的工作状态，数控系统采用FANUC（液晶）系统并有与笔记本电脑传输接口（RS232C），在机床的循环加工中可带有电磁锁使防护门无法打开，任何按键无法使循环终止（除急停按钮外），以保证工件的安全加工，任何切削参数必需由专人才可改动。机床的控制站由双回转（控制箱自身回转和悬臂大回转）组成，操作方便。

The whole circulation of the shaving is controlled by computer and showed by CRT. If the tool is failure, it can diagnose by itself and showed by the screen, which make the operator eliminate the failure quickly and well. In the distinct position of the tool can be equipped with the three-colors light. The light can clew the working position of the tool. The numerical control tool adopts FANUC (liquid crystal) system and has transmitted entrance (RS232C) with the notebook computer. During the circle machining of the tool, electromagnetism lock makes the safeguard door not open. In addition, any button may not stop

the circulation (except for the urgent stop) to ensure the safety of the machining. Only the person who specially assigns for the task can change the cutting specification. The control center of the tools is consisted of double gyration (control box gyration and cantilever gyration). The operation is convenient.

● 机床为五轴数控，分别是：刀具主轴旋转（W轴），刀具径向进给（Z轴），刀具切向进给（Y轴），工作台轴的进给（X轴）和刀架回转（A轴）。机床通过自主开发并具有自主知识产权的控制软件来控制。X、Y、Z轴进行三维联动的插补，使得剃刀与工件沿着设计好的空间曲线作相互运动。将工件齿面加工成各种要求的齿向曲线。操作界面实现了数控剃齿机真正意义上参数编程：前台填参数，后台生成加工程序。

The machine adopts the five-axis CNC mode, namely the rotation of cutter spindle (W-axis), radial feeding of cutter (Z-axis), tangential feeding of cutter (Y-axis), feeding of worktable shaft (X-axis), and rotation of cutter holder (A-axis). The machine is controlled by independently developed control software with proprietary intelligent property rights. The X-axis, Y-axis, and Z-axis perform three-dimensional linked interpolation so that the shaving cutter and the workpiece make mutual movement along the designed space curve to process the workpiece tooth surface into all kinds of required tooth curves. The operation interface realizes the truly parametric programming for the CNC gear shaving machine: Filling in the parameters on the foreground and generating processing program on background.

● 机床的润滑系统由连续润滑系统和间歇润滑系统组成：连续润滑系统分别润滑X轴进给齿轮箱、Y轴进给齿轮箱、Z轴蜗轮箱、刀架齿轮箱。间歇润滑系统分别润滑X轴、Y轴、Z轴的滚柱直线导轨及滚珠丝杆。机床X、Y、Z轴及活动尾架（右尾架）均采用高精度（Accuracy class G3）、高刚度（Preload class V3）滚柱直线导轨。机床X、Y、Z轴滚珠丝杠为高精度、高刚度。

the lubricant system is consisted of continuous lubricant system and intermittent lubricant system:The continuous lubricant system lubricates X axes feeding gear box,Y axes,Z axes worm gear box and cutter rest gear box.The intermittent lubricant system lubricates the ball beeline guide and ball guide screw of X axes, Y axes,Z axes .The X axes, Y axes,Z axes of the tool and active frame(right) adopt SCHNEEBERGER high precision(Accuracy class G3),high rigidity(Prelord class V3)ball beeline guide. X

axes, Y axes,Z axes ball guide screws of the tool are high precision and high rigidity

● 机床刀架主轴可采用刀具快换结构（碟簧锁紧、液压松开）、或进口液塑螺母锁紧刀具。

The cutter rest principal axis of the tool can adopt changing rapidly structure(plate spring lockable,loosen with hydraulic pressure)or imported plastic nut lockable cutter.

● 机床的床身立柱、刀架、框架均经过精心设计，特别是对机床的结构刚性及热变形均有特别的考虑。因此整机刚度高，加工精度高，外形高大、流畅、美观，宜人性好。

机床具有轴向、径向、切向、对角四种剃削方式。本机床通过独自开发的系统控制软件可进行鼓形齿和小锥度齿的剃削。

机床主要参数：

Main specification:

工件：最大外径	Workpiece : The max. diameter	mm	400
最大模数	The maximal modulus	mm	8/6(plunge)
最大齿宽	The maximal number of teeth	mm	140
刀具：最大外径	Cutter: The maximal diameter	mm	250
最大刀宽	The maximal width of the cutter	mm	50
安装孔径	The fixed hole diameter	mm	63.5
最大顶尖间距：	Maximal Dist. between centers	mm	500
工件与剃齿机中心距	center distance between workpiece and shaving machine	mm	125-335
X轴轴向进给：最大行程	X axes axial feeding:The maximal travel	mm	150
速度：快速	Rapid feeding	mm/min	1-500
工进	Feeding	mm/min	10-150
最小增量	The minimum increment	mm	0.001
Y轴切向进给：最大行程	Y axes (tangental feeding):The max travel	mm	40(±20)
速度：快速	Rapid feeding speed	mm/min	1-125
工进	Feeding speed	mm/min	10-80
最小增量	The minimum increment	mm	0.001
Z轴径向进给：最大行程	Z axes radial:The maximal journey	mm	210
速度：快速	Rapid feeding speed	mm/min	0.1-500
工进	Feeding speed	mm/min	0.2-4
最小增量	Minimum increment	mm	0.001
A轴转角范围：	A axes rotation range	deg	±20°(在Z轴中心距125-270及Y轴0处)
最大转速	The maximal Speed	rpm	3.02
最小增量	The minimum increment	deg	0.001
主轴转速：	The speed of the spindle	rpm	50-400(variable)
主电机（主轴电机）	Main Motor	kw	7
X轴伺服电机	X axes servo motor	kw	1.6
Y轴伺服电机	Y axes servo motor	kw	1.6
Z轴伺服电机	Z axes servo motor	kw	1.6
A轴伺服电机	A axes servo motor	kw	0.75

规格、参数若有改变，恕不另行通知，客户如有特殊要求，敬请垂询。

All the specifications are subject to revision without notice in advance .Please contact the manufacturer for special request on the machine.

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