



YA4220CNC/ YA4232CNC 数控径向剃齿机

CNC plunge Gear Shaving Machine model YA4220CNC/YA4232CNC



主要特点：

Main features:

本机床为齿轮精加工机床，用于直齿圆柱齿轮，斜齿圆柱齿轮和连轴齿轮的精加工，可以加工鼓形齿和小锥度齿。机床刀具头架的径向进给采用无间隙加预紧力的滚珠丝杠结构，刀架及尾架采用高刚度轴承结构，径向进给采用伺服电机驱动，数控系统选用进口数控系统。机床的刚性好、效率高、工作可靠、性能齐全、操作调整方便，特别适用于大批量生产汽车、拖拉机、摩托车、机床等行业使用。

● 机床剃齿加工仅为径向剃削方式。

● 机床采用工作台固定、尾架直接坐落在固定的工作台面，刀架滑板作径向切入的布局形式。由于减少了工作台运动中间环节，使径向方向的刚性得以增强，满足了径向剃齿对机床的高刚性的要求。

● 刀架及尾架的主轴均采用高速、高精度、高刚性轴承支撑形式，以适应工件齿轮的高精度、高效率加工。

● 机床具有切向调整装置，可实现小锥度补偿，来解决径向剃齿产生小锥度时只能靠刃磨刀具的缺陷，延长刀具寿命。

● 刀具主轴可采用变频调速（转速范围：30至400rpm）。

● 采用预载荷的大直径、高精度滚珠丝杠副，配以高刚性的丝杠支撑座，驱动刀架滑板作垂直上下运动。

● 本机床为单轴数控，配置MITSUBISHI E70型数控系统。

● 整个切削循环过程由计算机控制，可作两次不等速径向切入，解决剃后齿形不对称。也可作连续变速径向切入，实现等负荷剃削。并具有标准径向剃齿循环程序，采用标准代码，可在机编程，也可机外编程，通过RS232C接口传输。

The model YA4220CNC & YA4232CNC Gear Shaving Machine is designed for finishing the spur and helical gear, as well as shaft gears. It also can shave the crown and tapered-tooth gears. The radial feed of cutter headstock is carried out by through a free-backlash pre-load ball screw and driven by a servo motor. The cutter head and tailstocks are provided with the high-rigidity bearings. The machine features high-rigidity, high-rigidity, reliable working, easy to operate and adjust. The machine is recommended for batch and mass production of gears, especially in automobile, tractor, motorcycle and machine manufactures industries.

The machine only can plunge shaving.

The machine worktable is fixed and the tailstock seat on the worktable, the cutter carriage moved up and down for radial feeding. It reduces the worktable moving construction and improves the rigidity. It suit for the plunge shaving mode.

The cutter carriage and spindle of tailstock support by the high-speed high-accuracy high-rigidity bearing. It suit to high-accuracy high- efficient cutting.

The machine have a construction for the small tape compensation, it improved the life of cutter.

The spindle motor is control by frequency converter. (Range:30~400rpm)

Machine used the big size high-accuracy ball screw and high-rigidity seat. It drive the cutter slid up and down.

Machine is single axis CNC machine, equipment the MITSUBISHI E70 CNC system.

The whole cutting circle is control by the CNC system, it can radial feeding by 2 speed, and it will solved the problem of tooth profile asymmetry. And it will get the load cutting. machine had standard plunge shaving program, it can program in the CNC system or make it on the computer and tranfer by the RS232C.

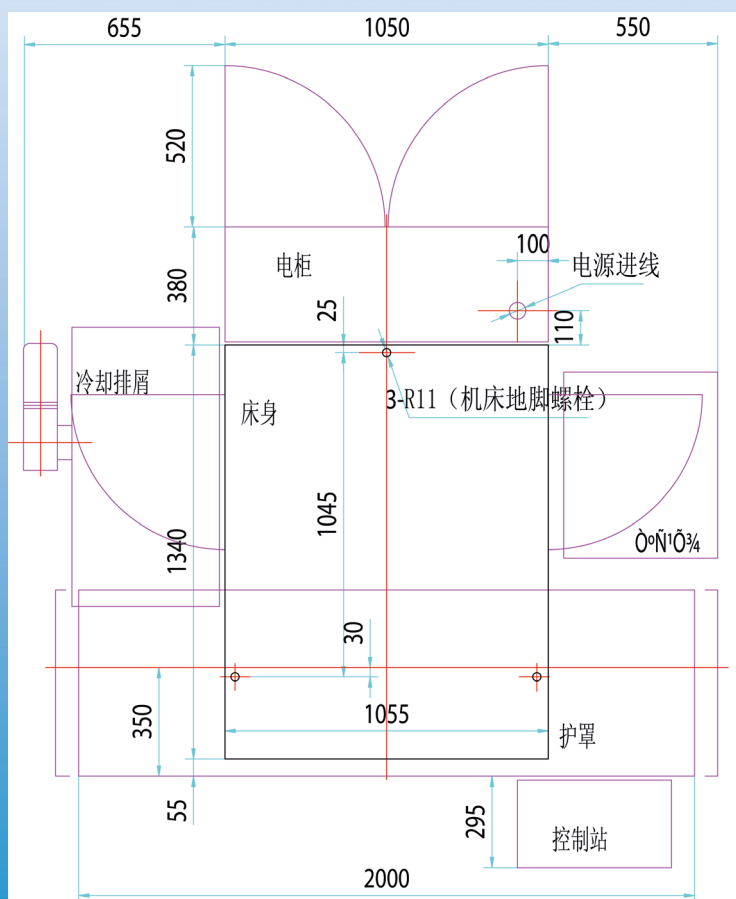
机床主要参数:

Main technical specifications

			YA4220CNC	YA4232CNC型
工件最大外径	Workpiece Max. outer diameter to be Cut	mm	200	320
最大模数	Max. module to be cut	mm	6	6
工件顶尖间最大距离	Max. distance between centers of head-stock and tailstock	mm	500	500
工件与剃齿刀中心距:最大	Distance between centric max:	mm	250	250
最小	Lines of workpiece and cutter min:	mm	115	115
刀架回转角度	Swing angle of cutter head	deg	±30	±30
剃齿刀转速	Rotating speed of cutter(8 steps)	mm/min	55—270(无级)	55—270(无级)
进给量	Radial feed	mm	不等量	不等量
径向进给速度范围	Range of radial infeed	mm/min	0.2—4	0.2—4
径向进给最小增量	Min. increment of radial feed	mm	0.01	0.01
径向进给速度最小增量	Min. increment of radial infeed	mm/min	0.1	0.1
径向进给最大速度	Overall dimensions(L×W×H)	mm/min	240	240
机床外形尺寸(长×宽×高)	Overall dimensions(L×W×H)	mm	2055×2525×2290	2055×2525×2290
机床净重	Net weight, apprex	Kg	4500	4500

机床安装基础图

Foundation Plan



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

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