

### 切削滚压数控镗床

#### Skiving and Roller Burnishing Machine

该设备适用于加工圆柱形深孔工件，如各种机械液压油缸。设备主要用于镗削加工和滚压加工，机床采用工件不动镗刀转动的镗削工艺，镗削时采用前排屑，镗削方式既可以是推镗也可以是拉镗，由镗杆尾端受油，头架排屑。滚压分为前推滚压和后拉滚压，采用韩国SRB的高速刮镗滚压头，可高效加工油缸，一改镗削珩磨加工油缸的传统工艺，生产效率是传统工艺的5-6倍。用冷拔管生产油缸，切削滚压速度可达到0.8米每分，用热轧管生产油缸，切削滚压速度可达到0.3米每分，一次成型。设备的床身采用优质铸铁铸造而成。主轴由交流变频电机驱动，调速范围宽。进给系统由交流伺服电机驱动，能适应各种深孔加工工艺的需求。工件顶紧采用液压装置。设备配有自动排屑系统，铁屑自动收集到废屑箱。此设备既适合大批量生产，也适合小批量单件生产。

Skiving and Roller Burnishing Machine is applicable for machining deep hole of cylinders , such as various mechanical hydraulic cylinders . This machine is mainly used for boring and rolling processing . machine tool introduces the technology of rotating boring cutter, not work piece. Front chip removal method is adopted and chip is removed from machine tool head. Boring methods could be pulling and pushing. This machine is refueled through boring bar. Rolling methods could also be pulling and pushing. Fast -speed SRB rolling head from Korea are used and this rolling head could process the cylinders with 5-6 times efficiency than traditional technology. For cold drawn tubes, the boring and rolling speed could be up to 0.8 meters per minute and for hot rolled pipe, the speed could be up to 0.3 meters per minute. The bed of this machine is made from high-quality cast iron. Main shaft/Spindle is driven by AC variable frequency motor with wide speed range . Feed system is driven by AC servo motor , and being able to adapt to the needs of a variety of deep-hole processing technology . Top tightening device of work piece is with hydraulic systems. The machine is equipped with automatic chip removal system , and the iron is collected to litter bins automatically . This machine is suitable for both mass production and small quantities of single-piece production .





## 产品参数 / Product parameters

技术参数 Technical Parameters			
工件尺寸 Tube Size	内径 ID.	Mm	Φ63-Φ250
	外径 OD.	Mm	Φ70-Φ300
	加工长度 Length	Mm	900-6000
速度 Speed	主轴转速 Main Shaft Speed	r/min	50-1500
	定位座移动 Positioning Seat Stroke	Mm	6000
	主轴箱移动 Main Shaft Head Stroke	Mm	8000
功率 Power	主轴伺服 Main Shaft Servo Power	Kw	37/56
冷却系统 Cooling System	油箱容积 Oil Tank Volume	L	4150+1850
	高压泵流量 High Pressure Pump Flow	L/min	864
	过滤器精度 Filter Accuracy	Um	50
电机总功率 Total Power		Kw	90
长*宽*高 LengthxWidthxHeight		mm	18820*2475*2200
数控系统 Numerical Control System		西班牙法格 FAGOR SYSTEM	
Z轴行程 Z Axis Stroke		mm	6600