



SUPERFINISH

Machining with vertical workpiece axis

Superfinishing of synchronous gears with stone or tape; machining of inner hub of tape pulleys with finishing tape (lead-free).

- Standard vertical machine, capable of being set up for stone and tape finish-machining
- Workpiece mount in mandrel chuck
- Universal range of uses

Loading and unloading system:

- Manual
- Infeed and discharge tapes with two-way gripper system



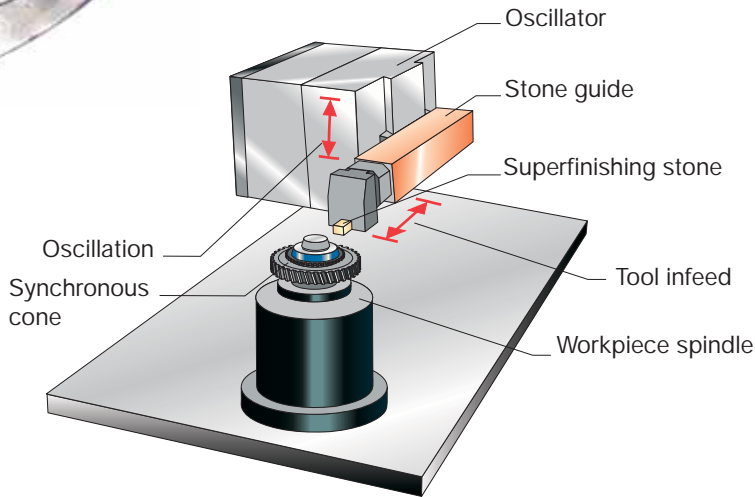
supfina 662

Max. workpiece Ø:

175 mm

Approx. workpiece height:

80 mm



The Supfina 662 is designed for the superfinishing of bearings, sealing seats or synchronising cones on workpieces with a vertical axis.

The modular machine design permits to be equipped for stone or tape finish-machining.

Tape finishing takes place with the tape being advanced continuously.

The principal components of the machine are:

- Vertical workpiece spindle with infinitely adjustable drive
- Mechanical oscillator (up to 1500 Double Strokes per min), mounted on a traversing slide

- Stone application cylinder with holder for machining with superfinishing stones
- Alternative: Tape finishing unit with continuous tape advance
- SPC system with technology data memory
- Automation by means of double-gripper unit and infeed and discharge tape
- The machine is distinguished by virtue of its robust construction and simple, fast tool changing facility



Tape pulley

Sealing seat machining, lead-free with finishing tape



Results

Preliminary machining:
After superfinishing:

Hard turned to Ra 3 μm
Ra < 0.4 μm , lead-free with circumferential machining marks

Cycle time:

28 seconds

Synchronising gear

Stone machining of the synchronising cone



Results

Preliminary machining:
After superfinishing:
Cycle time:

Ground to Ra 0.35 - 0.45 μm
Ra < 0.15 μm
30 seconds