

SUPERFINISH

Horizontal machining of crankshafts

supfina 720/3

Max. distance between centers:	850 mm
Max. stroke:	100 mm
LxBxH per station:	3 x 2.5 x 2.5m
Loading height:	1225 mm



supfina 720/3

Our offer → your benefit

Horizontal machine design

- Excellent accessibility to all components
- Clear view of the machining process
- User-friendly

Modular design with one or more stations

- Adaptable equipment according to workpiece geometry and surf

Loading by gantry or overhead transfer

- Straightforward integration into the flow of workpieces along the entire production line

Optimized tape management with tapes up to 300 m in length and automatic used-tape disposal, even during automatic operation

- Reduction in non productive times through prolonging of tape replacement cycles and tapedisposal, time parallel to production

Of horizontal configuration, the Supfina 720 is designed for the mass production of the most wide ranging types of crankshaft.

Loading takes place from a position above the machine and is performed by a gantry which places the workpiece directly onto pre-positioning V-supports between the centers of the tailstock and headstock.

Under NC control, the crankshaft is clamped between the centers and set into a rotary motion which is superimposed by a short-stroke oscillating movement.

As an option, the crankshaft can be traversed between centers to permit the bearings to be machined in sections.

All the machining parameters are available at the touch of a key in the data memory of the machine control system.

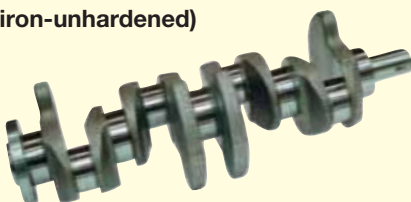
Single- or multi-stage processing can be carried out, depending on the quality required of the workpiece. Therefore, the machine consists of modular stations and superfinishing units equipped with special machining shoes.

A system for in-progress gaging during the prefinishing stage is available as an option.



For the machining of crankshafts with closely spaced bearings, the main and pin bearing units are mounted in two planes

Crankshaft (GGG 60 modular iron-unhardened)



Results

Ra < 0.1 μm

Rz < 2 μm

Two-stage process

Cycle time including loading, 50 s

Results Grinding / Finishing

