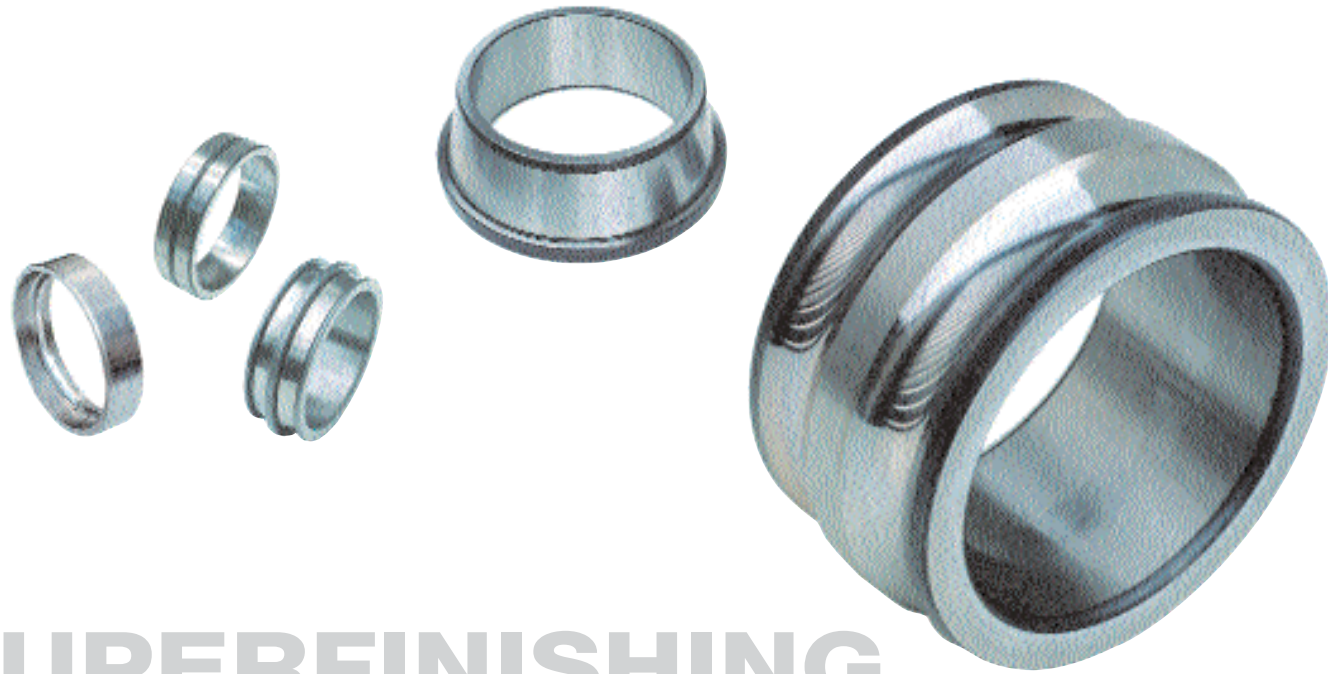


SUPERFINISH-Machines
Supfina Race 715 and Race 717
Machining of Roller Bearing Races



supfina Race 715 Race 717



SUPERFINISHING

Supfina Race - Machining of Roller Bearing Races

Operational area

The Supfina Race 715 and Race 717 are designed for the Superfinishing of IR/OR roller bearing races with a diameter of up to 160 mm. Past experiences and advantages of the established Supfina 725 and Supfina 727 line for greater ring diameters were implemented into this new machine concept.

The Race 715 and Race 717 differ in the Superfinishing units they each utilize. Depending on the race geometry, either the Race 715 with linear oscillator or the Race 717 with circular oscillator, is used.

Applications

Race 715 – with linear oscillator

- Cylinder roller bearing
- Tapered roller bearing
- Needle bearing
- CARB®-bearing

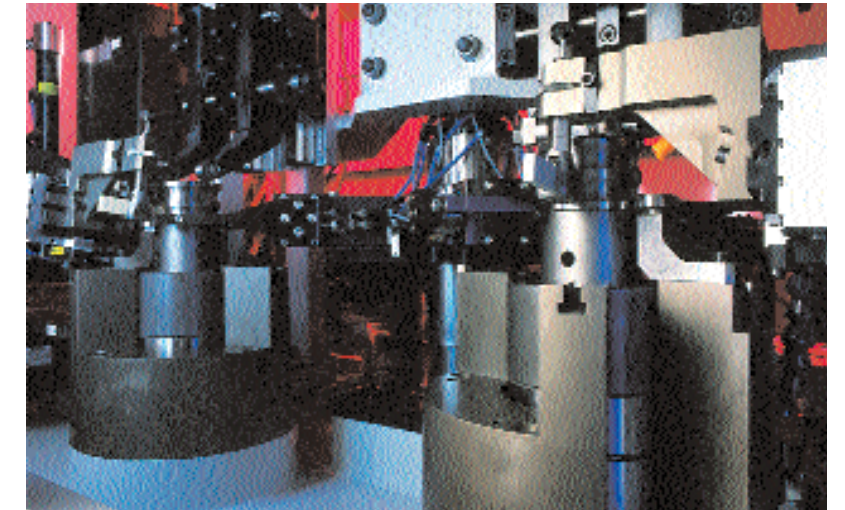
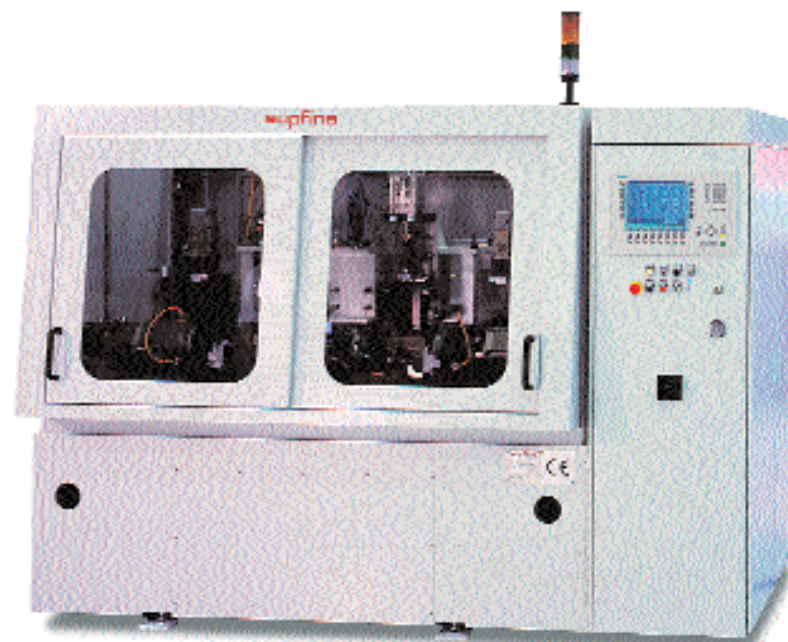
Race 717 – with circular oscillator

- Grooved ball bearing
- Angular ball bearing
- Spherical roller bearing

supfina Race 715 and Race 717

Operational area

	IR	AR
Bore diameter-Ø	25 – 110 mm	–
Outer-Ø	–	52-160 mm
Number of machining stations	2	
Contact angle	±55°	
Race width	max. 55 mm	



Working space of the Race 717 with 2 machining stations

Functional area

Through the machine's modular design it is possible to customize it according to a customer's specific demands. Depending on the stage of expansion a set-up time of less than 9 minutes can be achieved. The set-up process itself is limited to a few, easy to learn hand movements. As in other Supfina machines hardly any workpiece dependent spare parts are necessary.

The workpieces are fed into the machine transported and machined horizontally. The part transport within the machine is completed without the relative movement between workpiece and support. Consequently damages and wear-out are avoided. The centrally arranged part handling grips, lifts and transports four roller bearing rings simultaneously. Compared to traditional systems the loading time is reduced by over 50 %.

The two machining stations are on the front side of the machine and easy to access. The operator is able to monitor all processes.

The modern control supports the set-up and automatic operation. To guarantee reproduceable quality parameters the Superfinishing know-how is saved in the vast technology memory.

Advantages of the new machine generation

- High productivity with minimal down time
- Minor spare part costs
- Set-up time < 9 minutes
- Simple operator guidance
- Integrated Superfinishing Know-how
- Optimal operator accessibility
- Small foot print

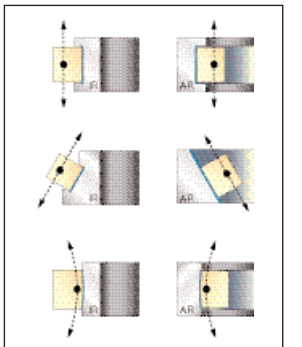
Common traits of both machines

- 2 machining stations
- 2 Superfinishing units
- Vertical workpiece spindles
- Variable centering system
- Automatic loading and unloading
- Multi-step, automatic operating procedure
- Modern control with technology memory
- Integrated electrical cabinet
- Multi-area tools

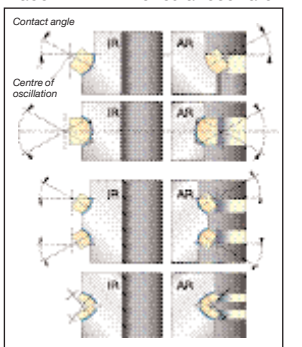
Optional machine equipment

- NC-positioning of Superfinishing units
- NC-controlled spindle drive
- Automatic contact angle positioning
- Swivelling unit for machining tapered parts
- Central lubrication
- Attachment for tape machining

Race 715 – with linear oscillator




Race 717 – with circular oscillator




The modular arrangement and remarkable flexibility enable various shapes and geometries of races to be superfinished in one clamping operation. The flexible concept enables the machines to be retooled for differing IR- and OR bearing shapes.




For further information about
the world's largest range of
Superfinishing-Machines
and Superfinishing Attachments
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