

Jones & Shipman

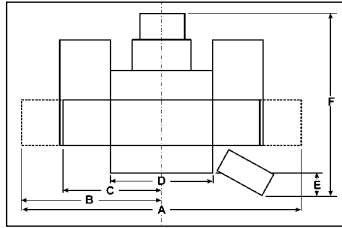
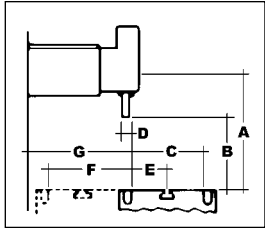
CNC SURFACE GRINDING MACHINE
with GE-Fanuc® Control System



524 CNC 500 x 200 Table Capacity

TECHNICAL DETAILS

REF: 524CNC/UK/0403



Wheelhead Capacity

A - Max./ Min.	505 / 85mm
B - Max. with new Std. wheel	378mm
C -	200mm
D -	10mm
E -	100mm
F -	192mm
G -	240mm

Base Plan

A - 2060mm	D - 770mm
B - 1030mm	E - 230mm
C - 750mm	F - 1510mm

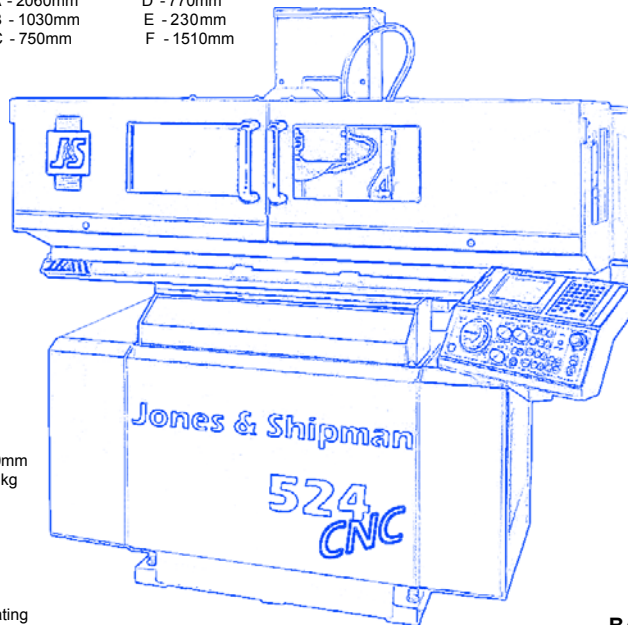


TABLE (X AXIS)

Working surface (grinding capacity): 500 x 200mm
 Max. table load (including chuck if used): 160 kg
 Longitudinal traverse hand/hydraulic (max.): 610mm
 Traverse speed range (per min.): 2-25m
 Width of tenon slot: 14.4mm
 Distance from floor to table: 1025mm

- Hydraulically powered table traverse operating on vee and flat slideways
- Proximity switch operated reverse dogs

WHEELHEAD

Vertical movement (max.): 505mm
 Capacity between wheel & table (Std. new wheel): 378mm
 Size of grinding wheel: Standard: 254 x 19 x 76,2mm bore
 Size of grinding wheel: Maximum: 254 x 32 x 76,2mm bore
 No Cost wheel size Options: 170 to 200 x 32 x 31,75mm bore
 Speed of grinding wheel - 50Hz motor: 2400 rpm
 Speed of grinding wheel - 60Hz motor: 2880 rpm
 Wheelhead motor: Standard / Option: 2,25kW / 3,75kW

- Wheelspindle rotates in grease packed angular contact rolling element bearings.

CROSSFEED (Z AXIS)

Feed per graduation of electronic handwheel: 0,0001, 0,001, 0,010, 0,100mm
 Continuous feed range (per min.): 0.06 - 3000mm
 Minimum digital display: 0,0001mm
 Sparkout under wheel: 0 - 99

- AC Servo motor drive with linear scale feedback
- Movements made via precision ballscrew
- Saddle operates on Turcite® coated low friction vee slideways

WHEELFEED (Y AXIS)

Feed per graduation of electronic handwheel: 0,0001, 0,001, 0,010, 0,100mm
 Feed rate (per min.): 0.06 - 3000mm
 Minimum digital display: 0,0001mm

- Wheelhead operates on ball and roller slide assembly for high sensitivity and maximum stiffness
- AC Servo motor drive with linear scale feedback
- Movements made via ballscrew and nut

BASE AND COLUMN

Machine weight (approx.): 1500 kg
 Shipping dimensions (approx.): 9,0m³

- High grade cast iron used for bed, column and major units

EQUIPMENT

STANDARD

GE-Fanuc® CNC controller
 Grinding cycles
 Wheelforming & Dressing cycles
 Special Grind & Dress cycles
 Wheelflange
 Wheel balancing mandrel
 Wheelguard
 Two grinding wheels, 254 x 19 x 76,2mm, one for grinding steel and one for cast iron
 Tableguard
 Emergency stop button
 Safety logic
 Low voltage lighting equipment.
 Standard hand tools.

Each machine is suitable, subject to standard mains tolerance of ± 6%, for 3 phase operation in one of the following groups:
 208/220/230V 50/60Hz,
 380/440V 50Hz or
 460/480/575V 60Hz.
 Control voltage 110V AC / 24V DC.

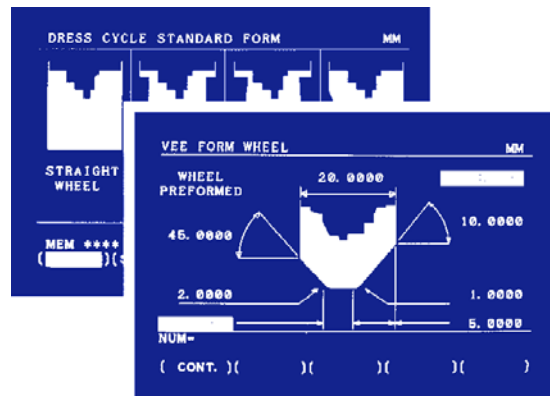
Machine colour: Light Grey & Blue.

ADDITIONAL EQUIPMENT

A comprehensive range of additional equipment is available to suit individual requirements.

OPERATION

The 524 CNC and its operator communicate by an easy to read screen and clearly described keys and controls. Using a combination of graphic and text prompts, the operator is taken through simple digitising style set-up routines to create wheel form/dress and grinding cycles. Suggested parameter values are offered which can be selected or amended as required. Whether constructing a simple or complex machine cycle, the 524 CNC's control system is designed to be always user friendly.



FORM AND DRESS CYCLES

Options presented in the form/dress cycle menu have been carefully constructed to cover all wheelforming demands. Working through a sequence of displays, the operator defines geometric features and dressing frequencies to match the individual needs of the workpiece. If required, the screen displays graphically the finished profile in a prove out mode.

GRIND CYCLES

With the 524 CNC grinding could not be easier. Select one of the graphically presented cycles from the menu and the control takes you through a simple and logical set up sequence. Just type in the required stock removal. Coarse and fine feed change points and feed rates, table speed and sparkout are each suggested as default values which can be accepted or amended.



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