



The saddle and the transverse feeding movement transmission chain wheel frame

The inner circle grinding tool is mounted on the support, in order to ensure work safety, the inner circle grinding wheel motor starting and internal grinder bracket position with interlocking function. Only when the bracket and turn to the working position, the motor can be started. Then, the grinding wheel rack rapid advance and retreat handle automatically locked in situ, cannot move fast enough.

Adjust the machine and grinding of ladder shaft steps, the table also can be driven by hand wheel A, as shown in figure 3-47. In order to avoid table longitudinal movement with hand wheel rotation operator A rapid bumps, uses the mutual lock cylinder. Shaft VI inter locking oil cylinder and a hydraulic system connected, table movement oil pressure to push the shaft VI on a double gear to move, so that the gear Z18 and Z72 disengage. Therefore, the longitudinal motion hydraulically powered work table when the A does not rotate handwheel. When the table without hydraulic drive, interlock cylinder cavity through the oil pool, the action of the spring in the cylinder, so that the 18/72 gear pair meshing transmission again, turn the handwheel to A, 15/72 and 18/72 through the gear pair and a gear rack pair, can be achieved manually longitudinal linear movement of working table.

The transverse feed movement, can shake the hand wheel to achieve the B, as shown in figure 3-47, can also be driven by hydraulic cylinder plunger feeding, automatic feed implementation cycle. Transverse manual feed crude feed and strives for, coarse feed, E will handle is pushed forward, turn the handwheel by B 50/50 44/88, gear pair and screw the grinding wheel frame transverse coarse feed motion, hand wheel B to 1 weeks, the grinding wheel frame transverse mobile 2mm, handwheel B dial D is divided into 200 lattices each lattice, the amount of feed for the 0.01mm: fine feed, will handle E pulled to the position shown by 20/80 and 44/88, the gear pair meshing transmission, then the wheel frame transverse fine feed handwheel B to 1 weeks, the grinding wheel frame transverse mobile 0.5mm, dial each grid feed rate is 0.0025mm. Fixed distance grinding method. A group of grinding workpiece, in order to simplify operation and save time, usually in the first trial grinding workpiece to achieve the required diameter, adjust the dial block F position, make it reach the needed diameter on transverse feed grinding, coinciding with the fixed to the bed before positioning cover claws on the collision. Therefore, the grinding workpiece just shake the subsequent horizontal feed wheel (or start the hydraulic automatic feed), block F touch in the positioning claw, stopping the feed (automatic stopping the feed or hydraulic), it can achieve the grinding diameter required, the process is called fixed distance grinding. Grinding wheel wear adjustment method. When the grinding wheel wear or after dressing, because the diameter of workpiece block F control becomes large, then, must adjust the grinding wheel rack stroke end position, also is adjusting dial D block F position. The adjustment method is: pull the knob C, making it and the pin is disengaged handwheel on B, clockwise rotation knob C, after 48/50 Z12 gear pair drives the gear rotation, gear z110 Z12 and dial D meshed, so the dial D clockwise rotation. Dial D should be determined according to the number of lattice turned, workpiece size variation caused by the grinding wheel diameter decreases. Pin adjusting properly after the pin hole knob C into the handwheel on B, C and B to make the knob handwheel as a whole.