

JR-CX型

适用于车削、铣削、磨削

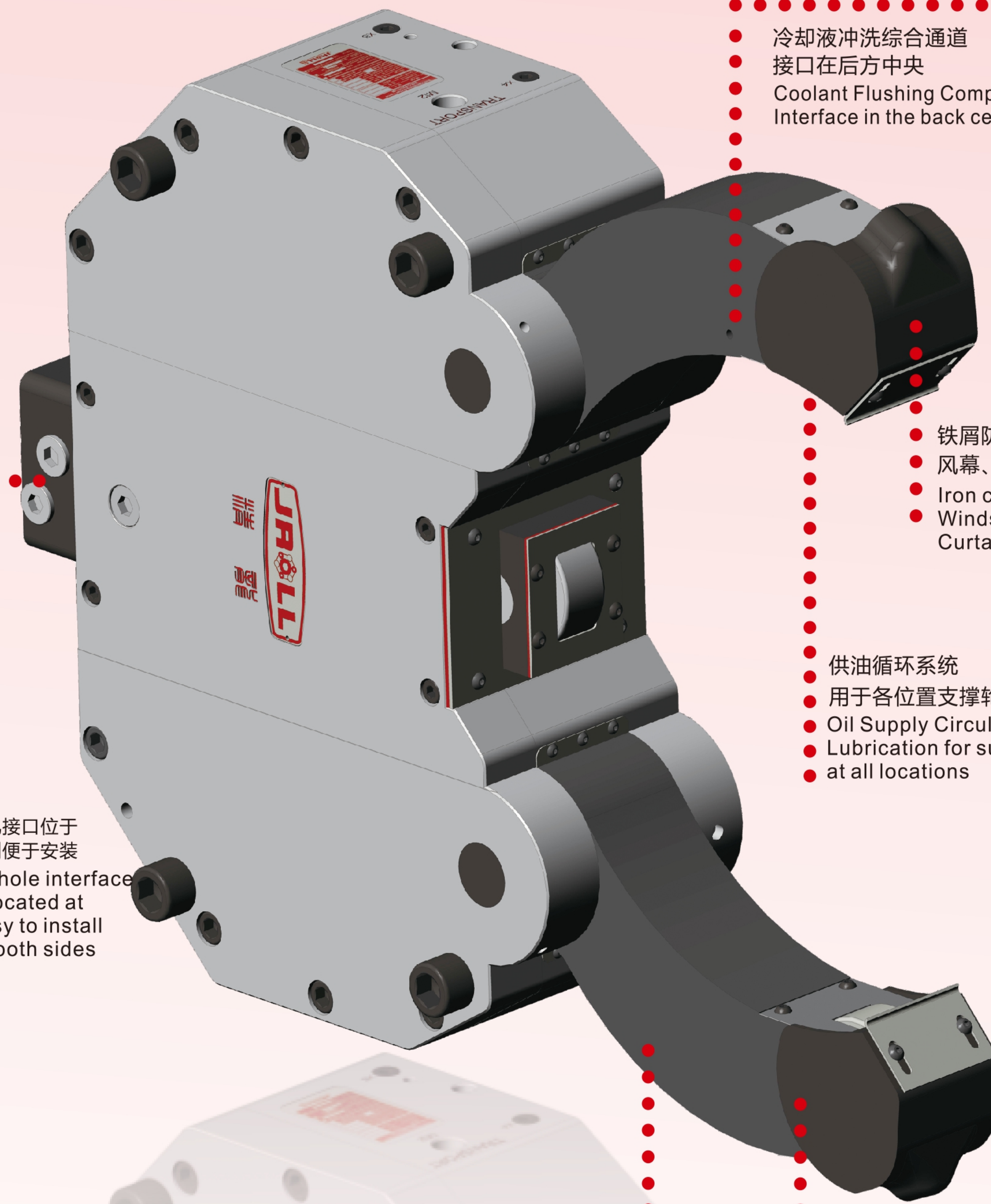
自定心中心架



- 油孔接口位于
- 两侧便于安装
- Oil hole interface
- is located at
- Easy to install
- on both sides

专利的中心架 / 手臂张开机构
无弹簧无磨损 / 超紧凑型设计
PATENT CENTER FRAME/ARM OPENING MECHANISM
SPRING-FREE WEAR-FREE/ULTRA-COMPACT DESIGN

采用高强度独特的材料和专业的热处理工艺
Using unique high strength materials
and professional heat treatment
process



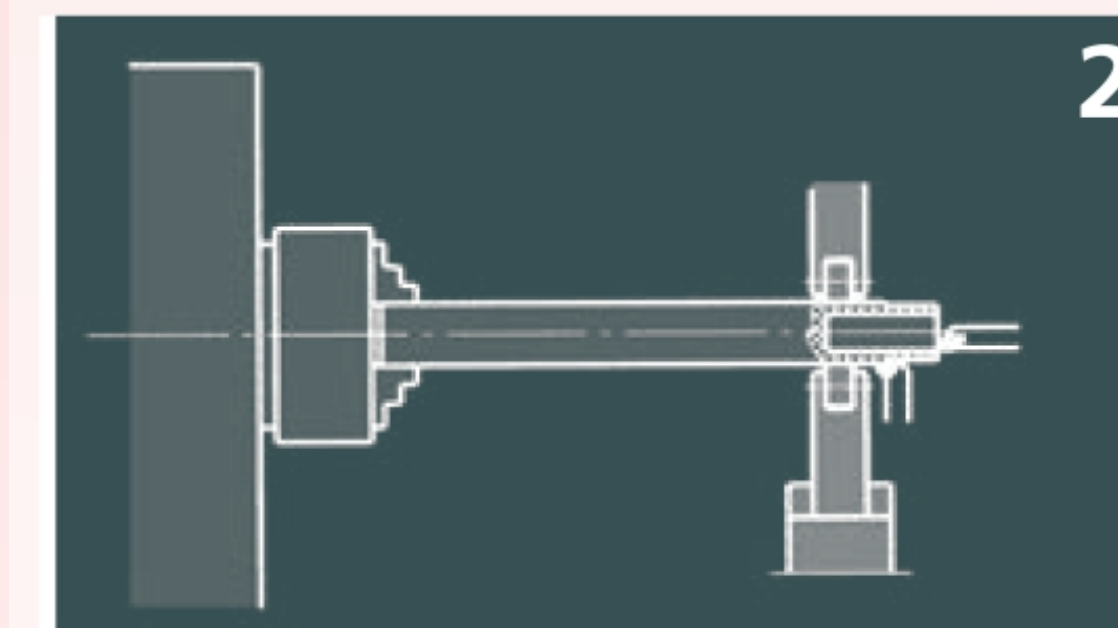
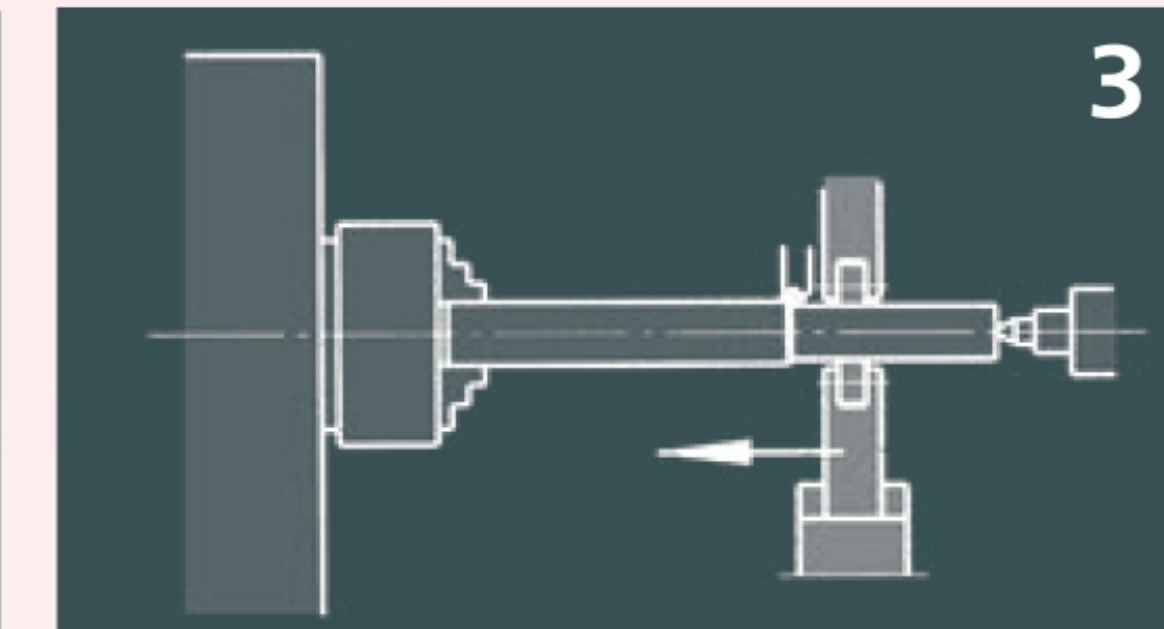
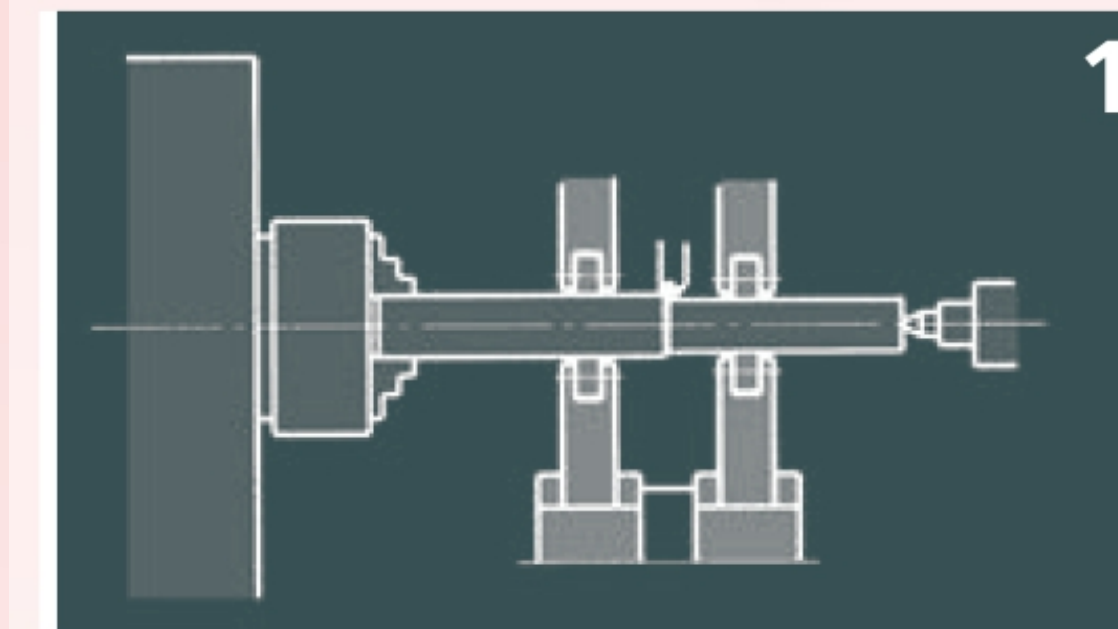
- 冷却液冲洗综合通道
- 接口在后方中央
- Coolant Flushing Comprehensive Channel
- Interface in the back center

- 铁屑防护
- 风幕、水幕专利系统
- Iron chip protection
- Windscreen and Water
- Curtain Patent System

- 供油循环系统
- 用于各位置支撑轮的润滑
- Oil Supply Circulation System
- Lubrication for support wheels
- at all locations

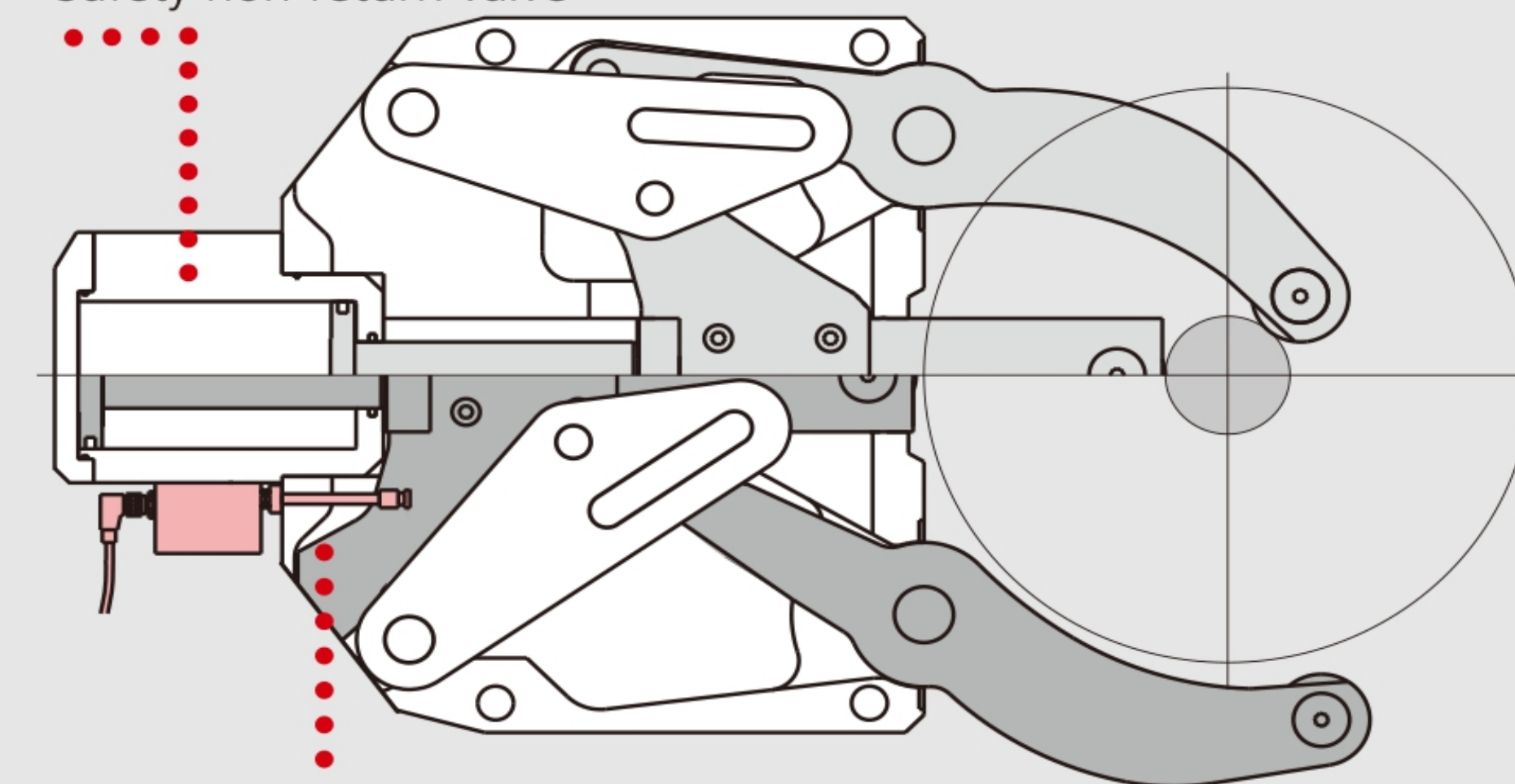
- 更换滚轮简单方便
- 无松动部
- Easy and convenient to
- change rollers
- No loose part

固定或跟刀式应用 Fixed or travelling application



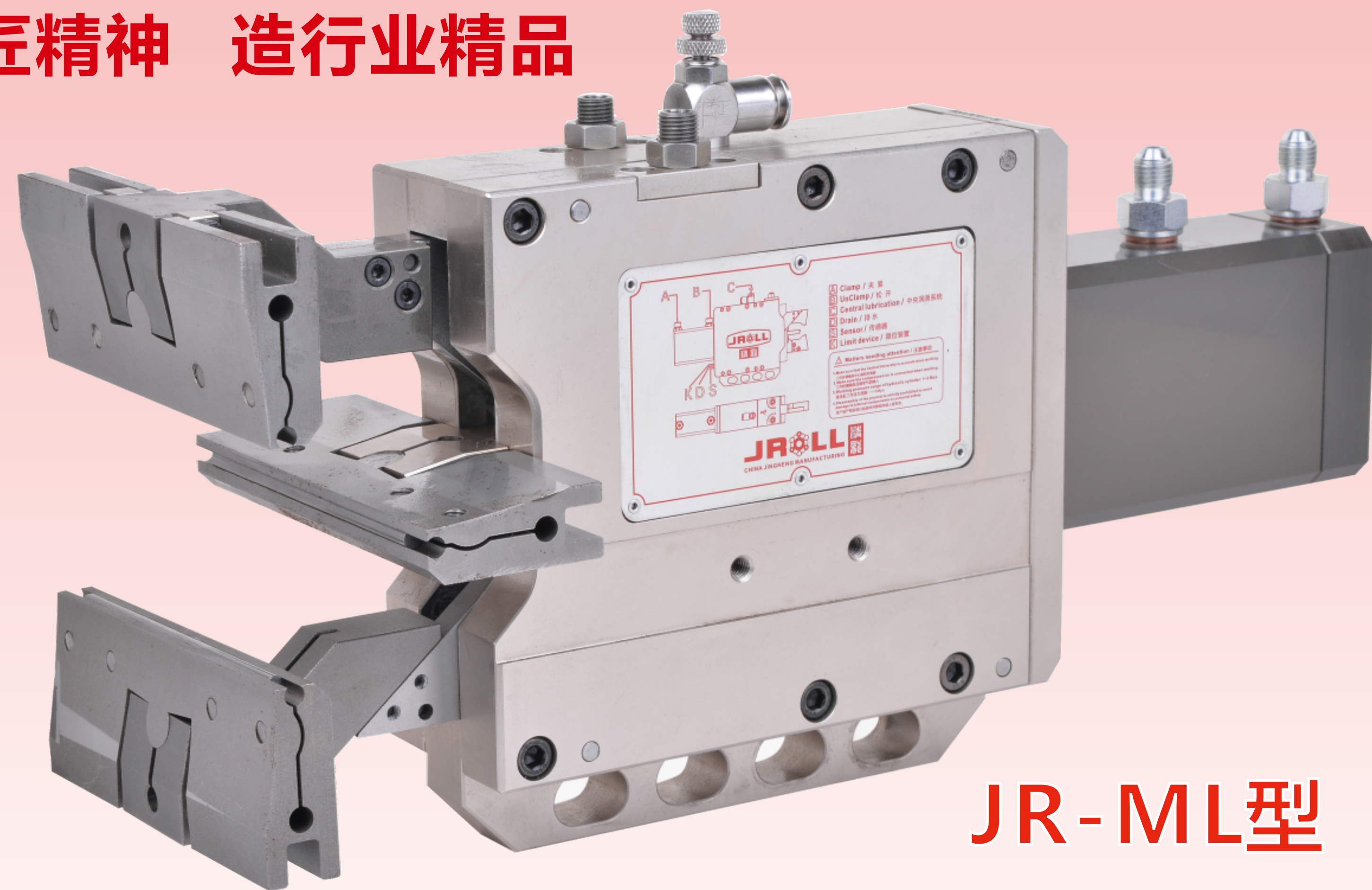
- 1. 双中心架固定式应用
- 2. 用于端部加工的中心架固定式应用
- 3. 中心架跟刀式应用
- 1. Tandem Steady Rest **fixed**
- 2. Steady Rest **fixed** for end machining
- 3. Steady Rest **travelling**

安全单向阀
Safety non-return valve

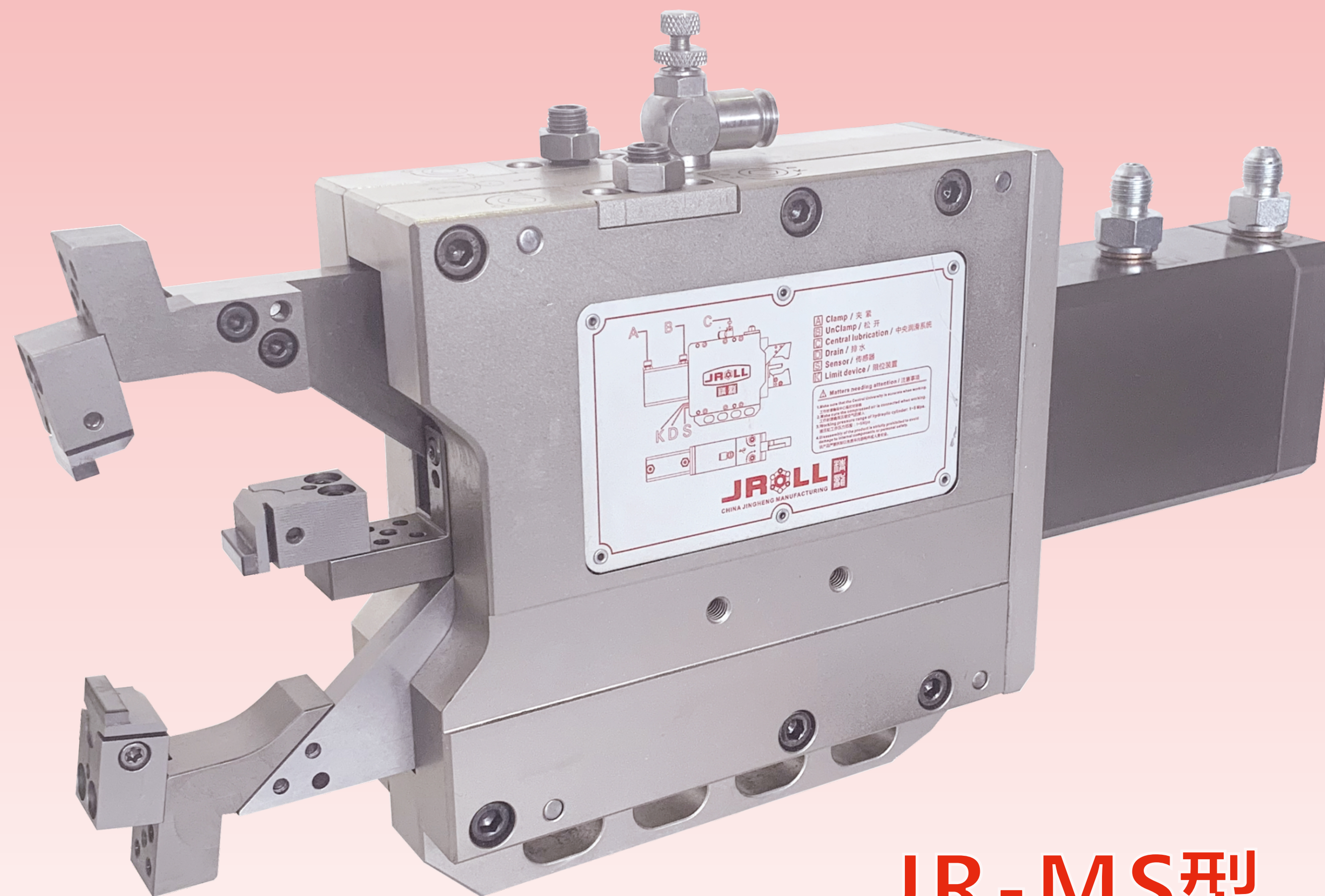


行程控制（不含接近开关）
Stroke control (proximity switch not included)

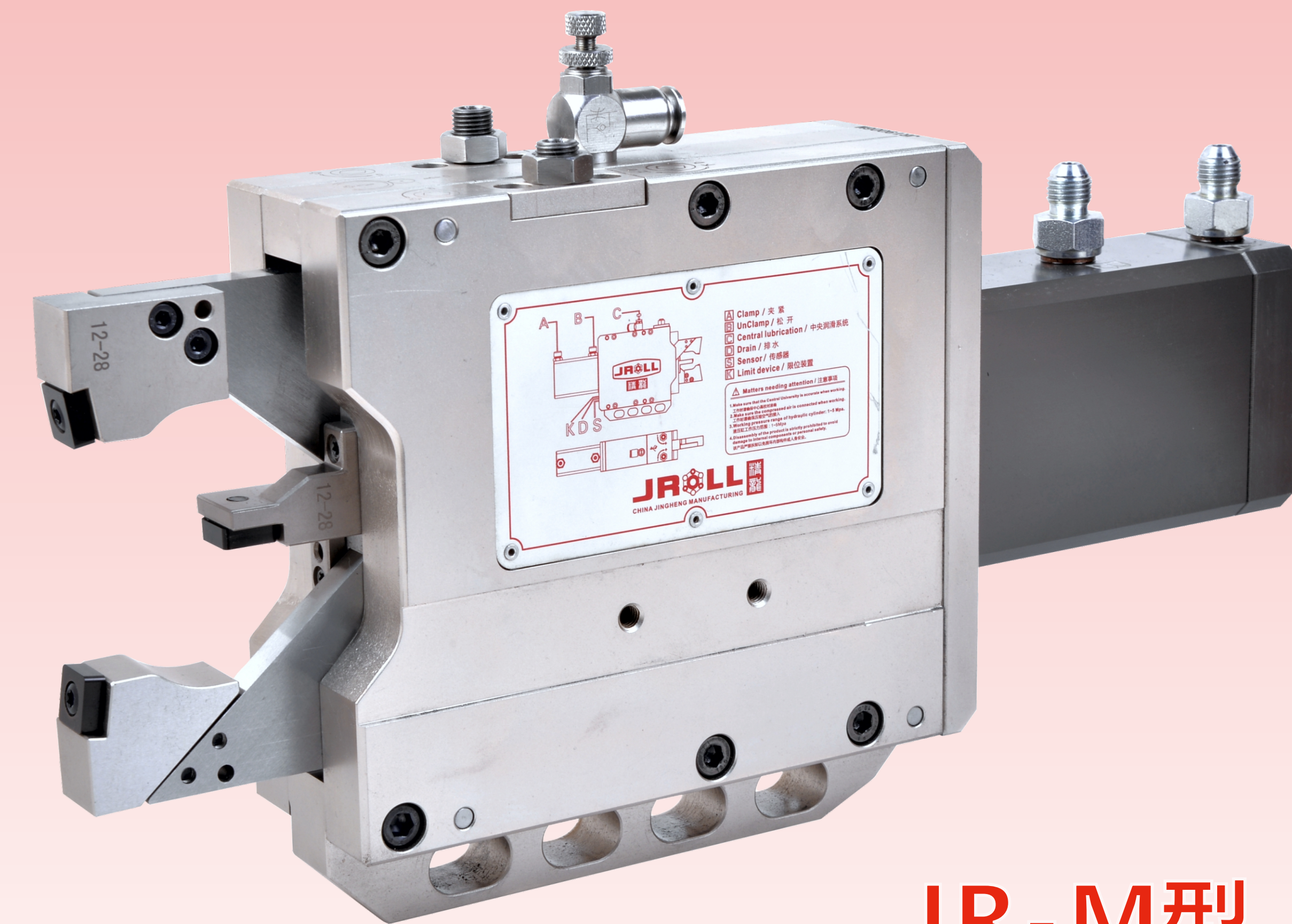
自定心高精密磨削中心架



JR-ML型



JR-MS型



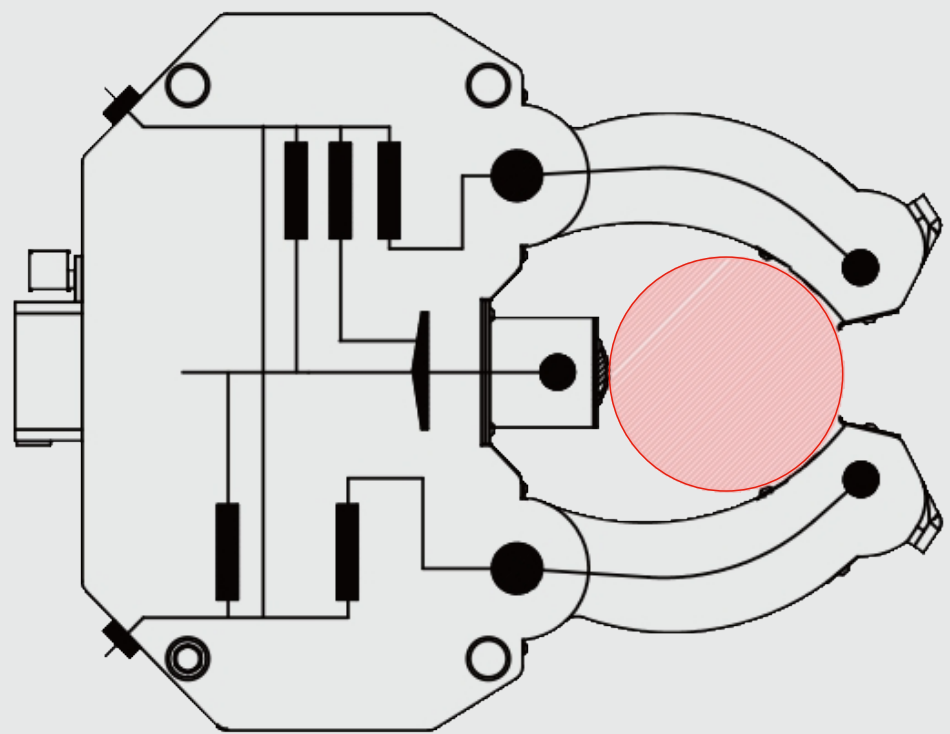
JR-M型

主要运用：外径、螺杆、丝杠精密磨削；

特点：随动跟踪控制工件、磨削中心可进行精密微调、可回退臂、适合随动磨削、超高精密正压气悬轨道。

配置 Configuration

集中润滑系统



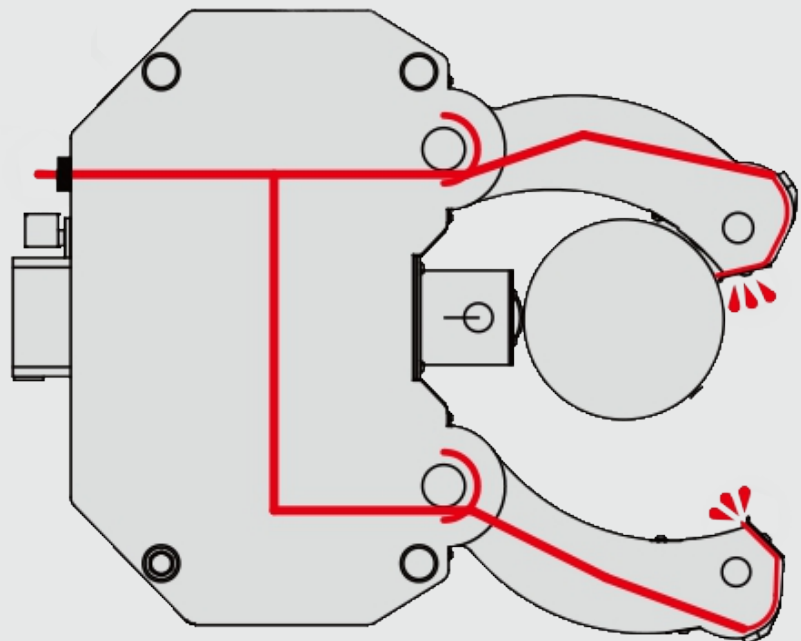
集中油润滑-选配(所有型号)

- 用于恶劣工作条件下, 大切削量
- 用于随动式的中心架应用
- 推荐使用我们带有定时器的完全分离的润滑单元
- 润滑间隔5~20分钟
- 最小/最大操作压力10 到 45bar
- 润滑油: 粘度46mm²/s(粘度等级ISO)

Option of central oil lubrication (all types)

- For heavy working conditions and high build up of swarf
- For travelling Steady Rest applications
- The use of our separate complete lubrication unit with timer control is recommended
- Lubricating intervals 5 - 20 min
- Min./max. operating pressure 10 to 45 bar
- Oil: Viscosity of 46 mm²/s (viscosity class ISO)

冷却液/气体供给



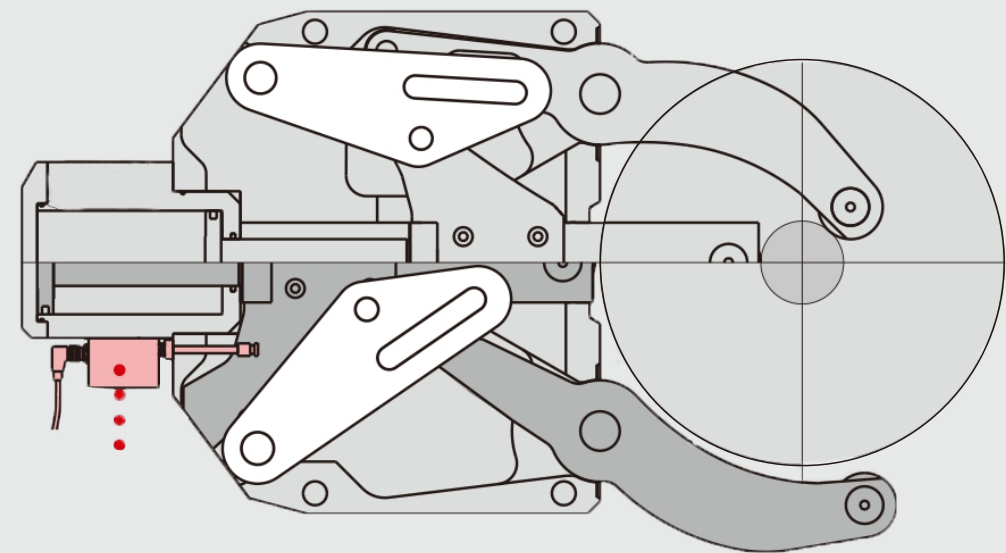
冷却液 / 气体供给 (选配)

- 内置管道, 中央连接冷却剂或空气接口连接到中心架臂上
- 中心架的基本配置
- 从尺寸和更大的尺寸冷却剂通过中心的手臂

Coolant/air feed (all types)

- Built-in channels to feed coolant or air from a central connecting port to the Steady Rest arms
- Basic equipment for steady rests
- From size and larger with coolant through the center arm

线性直径测量系统



选配线性直径测量系统

- 夹持臂的位置可由线性直径测量系统监测
- 避免与工件, 转塔, 装载装置等碰撞
- 由于可以控制手臂只张开到需要的位置, 这样能缩短中心架工作循环时间
- 输入: 24V输出: 4~20 mA
- 输入: 24V输出: 0~10 V

Option linear diameter measuring system

- The position of the clamping arms is monitored by the linear measuring system
- Avoids collision with workpieces, turret, loader etc.
- Reduced cycle time due to position controlled opening of the arms to the requested opening only.
- In: 24 V Out: 4 – 20 mA
- In: 24 V Out: 0 – 10 V

恒压系统 (伺服驱动)



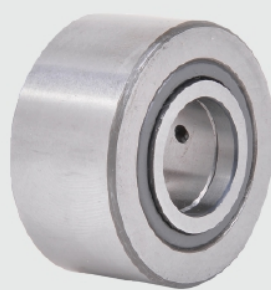
性能特点

- 伺服控制增加方式节能能耗高达90%
- 低噪音、零升温
- 压力稳定效率高
- 结构超紧凑体积小粘度等级ISO

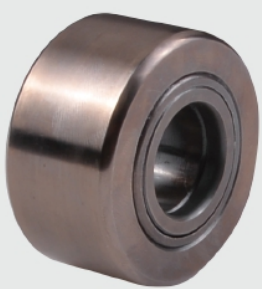
Performance characteristics

- Servo control increases the energy saving up to 90%.
- Low noise, zero temperature rise.
- The pressure is stable and efficient.
- The structure is ultra-small and small in size and viscosity grade ISO.

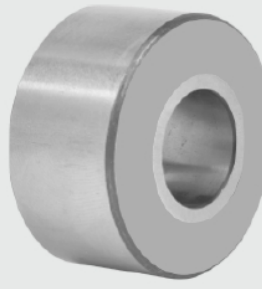
普通型 (钢) Ordinary (steel)



特殊处理自润滑型 Special treatment self-lubricating type



硬质合金型 Cemented carbide type



滚轮(所有型号)

- 支撑轮 (铜材料) (标准): 工件表面未硬化处理

Rollers (all types)

- Rollers steel (standard): Surface of workpiece not hardened

提供可选材料:

- 特殊处理自润滑型: 一种特殊的热处理技术使滚轮的寿命大幅度提高
- 合金支撑轮: 工件表面硬化处理

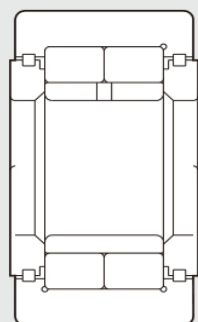
Provide optional materials:

- Special treatment self-lubricating type: A special heat treatment technology can greatly improve the life of the roller.
- Alloy Support Wheel: Hardening of Workpiece Surface

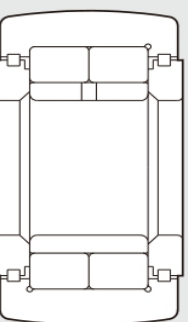
原装滚轮 Original roller



圆柱形 cylindrical



腰鼓型 spherical



窄圆型 narrow



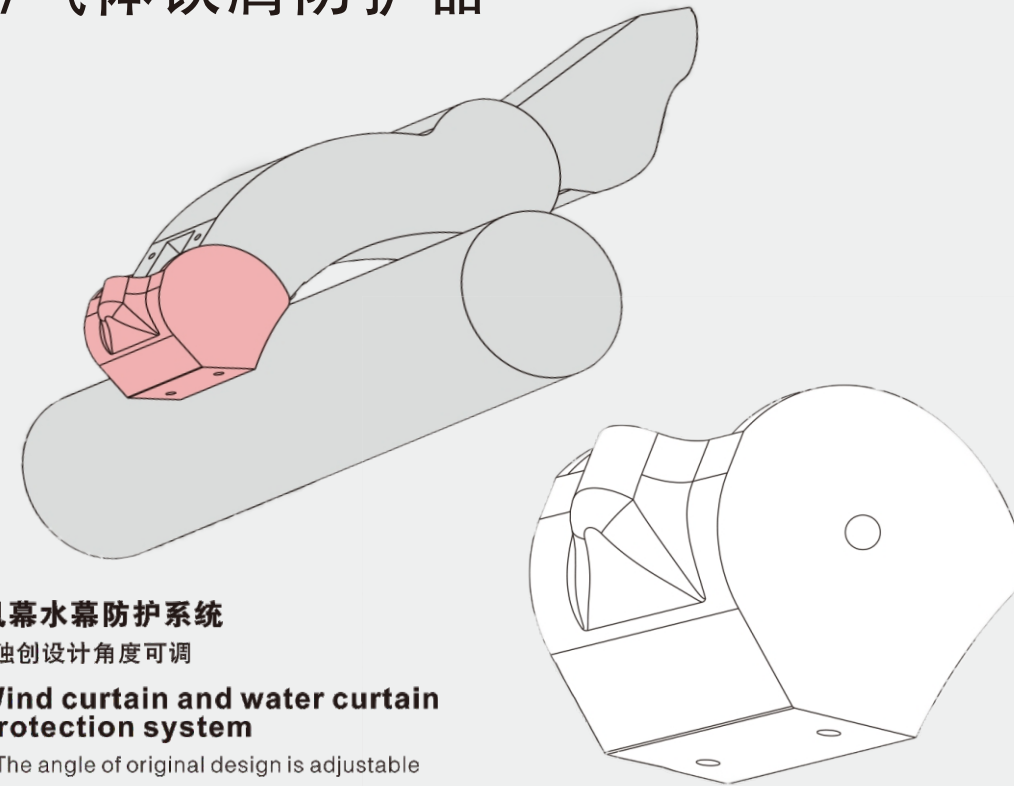
滚轮-选配 (所有型号)

- 滚子(精度等级P05)是专为中心架设计的
- 特殊的密封保证了最高的精度和使用寿命
- 标准配置: 圆柱型滚轮1套
- 选配: 腰鼓型滚轮 (用于跟刀式应用的中心架), 合成材料滚轮, 硬质合金滚轮

Option of rollers (all types)

- rollers (precision class P05) specially developed for our Steady Rests
- Special sealing ensures highest precision and service life
- Standard equipment: 1 set of cylindrical rollers
- Option: Spherical rollers (for travelling Steady Rests), synthetic material rollers, carbide rollers

冷却液/气体铁屑防护器



风幕水幕防护系统

- 独创设计角度可调

Wind curtain and water curtain protection system

- The angle of original design is adjustable

专利的冷却液 / 气体铁屑防护系统带冲刷喷嘴

- 防止夹紧滚轴与铁屑接触
- 双冲洗喷嘴可保持前方和后方的刮板清洁

仅用于带冷却液/气体供给的中心架。

优点:

- 恒定的定心精度
- 切屑不会造成工件及滚轴的损伤
- 减少滚轮的磨损=更少成本

Patented Cooling Liquid/Gas Iron Scrap Protection System with Scouring Nozzle

- Keeps roller clamping area free from chips
- Double flushing nozzles keep front and rear scrapers clean

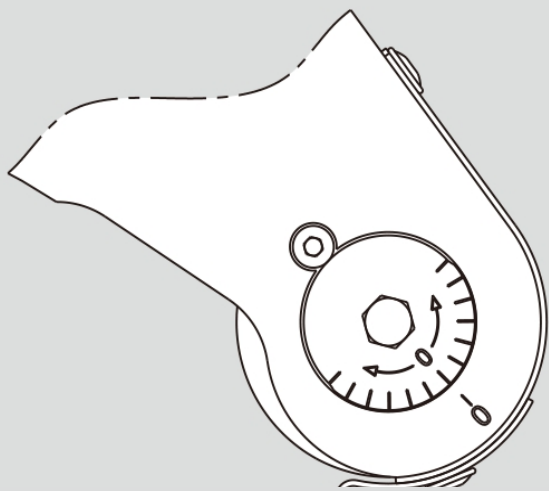
Only for steady rests with coolant / air feed.

Benefit:

- Constant centering accuracy
- No damage of workpiece and rollers caused by chips/swarf
- Less roller consumption = less costs

偏心微调

Eccentric fine adjustment



中心线微调装置-选配(所有型号)

- 在中心架的两个手槽上的偏心滚轮销可以在中心线上快速微调
- 这样就避免了解锁和调节支架上的整个中心架的微调动作
- 仅用于调整打开的中心架

Option fine adjustment of center line (all types)

- Eccentric roller pins on the two Steady Rest arms allow a quick fine adjustment of the center line
- This avoids to unlock and adjust the entire Steady Rest on the bracket for small adjusting movements
- Adjustment of open steady rest only!

配置 Configuration

应用/客户利益

- 磨床上轴类工件支承
- 尤其合适曲轴和凸轮轴加工
- 通过精调机构，可实现中心架快速调整到磨削中心
- 适合随动磨削

标准装置

- 基本磨削中心架
- 在传输盒中交付
- (针对中间块，夹紧套和平板套的平板保持器不在供货范围内,参见下面针对配置的概述)

APPLICATION/CUSTOMER BENEFITS

- Bearing of Shaft Workpiece on Grinding Machine
- Especially suitable for crankshaft and camshaft processing
- By fine-tuning mechanism, the center frame can be quickly adjusted to the grinding center.
- Suitable for follow-up grinding

STANDARD DEVICE

- Basic Grinding Center Frame SRG
- Delivery in transmission boxes
- (For the middle block, the clamping jacket and the flat jacket are not within the scope of supply. See the following overview of configuration.)

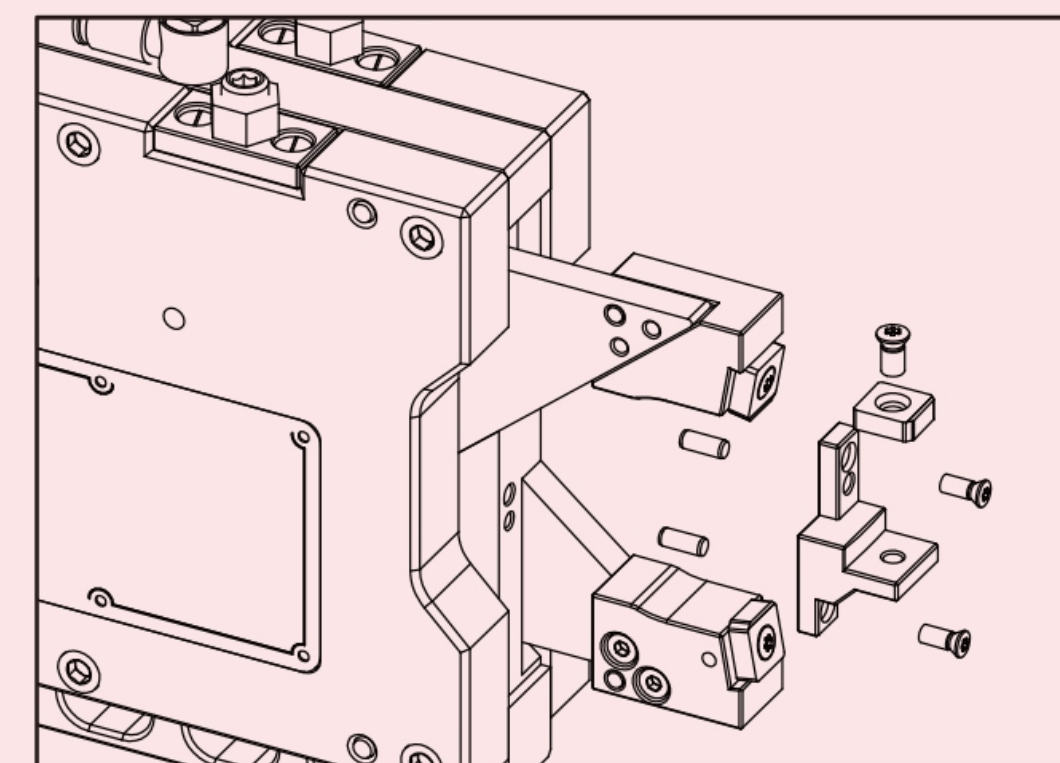
技术特性

1. 磨削中心水平精调机构
2. 磨削中心垂直精调机构
3. 可回退中心架臂
4. 避免垃圾和冷却液的压缩空气接口
5. 用接近开关监控最终位置（开关未包含）
6. 自动漏泄水气系统

TECHNICAL CHARACTERISTICS

1. Horizontal fine-tuning mechanism of grinding center
2. Vertical fine-tuning mechanism of grinding center
3. Retractable central arm
4. Avoid the compressed air interface between garbage and coolant
5. Monitor the final position with proximity switch (switch not enclosed)
6. Automatic water and gas leakage system

大致配置 ROUGH CONFIGURATION



选择平板保持器 Selection of Flat Holder

针对中间件的平板保持器(*)

- 包含平板保持器中间件 (包含安装材料)
- 3种版本有效: 0度, ± 5 度, ± 7 度
- 可旋转180度

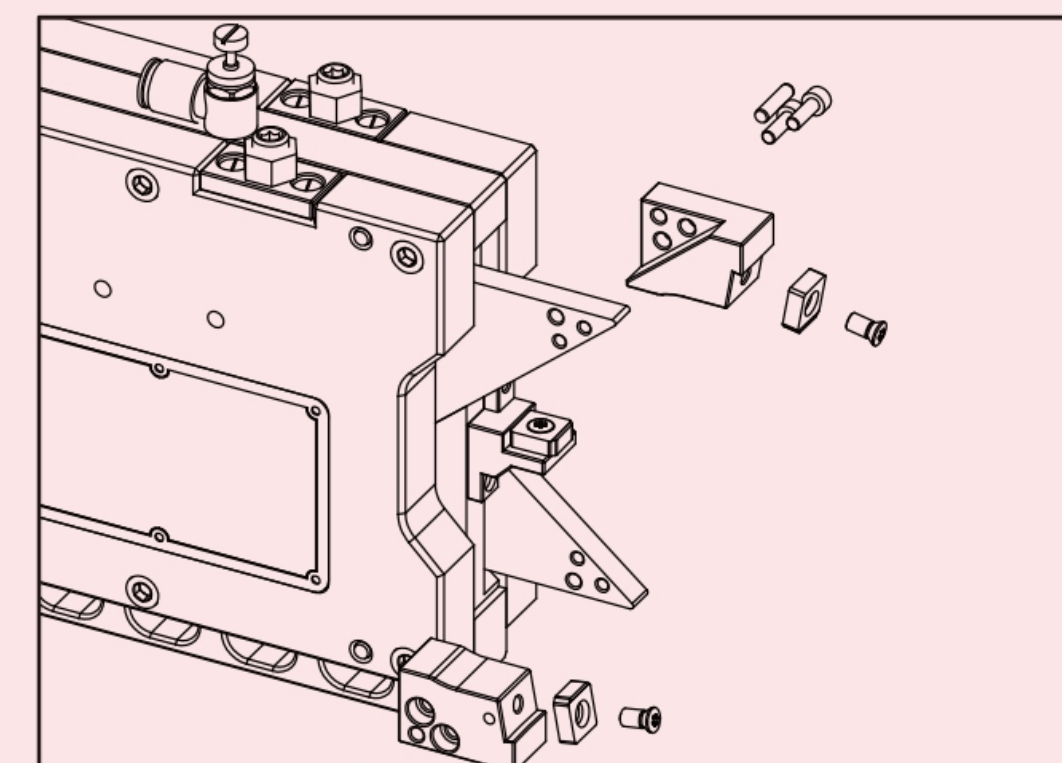
Flat holder for middleware (*)

- Containing Flat Holder Middleware (Including installation materials)
- Three versions are valid: 0 degree, +5 degree, +7 degree.
- Rotating 180 degrees

*包台针对带有安装材料的中间件的平板保持器

**包含针对带安装材料中间件的平板保持器和夹紧臂的巢

**柚包含3个平板和3个安装螺栓



选择夹紧套 Choose clamping sleeve

针对夹紧臂的夹紧套(**)

- 包含2个针对夹紧臂的巢和一个针对中间件的平板保持器 (包含安装材料)
- 通过不同的夹紧套来涵盖不同夹紧范围

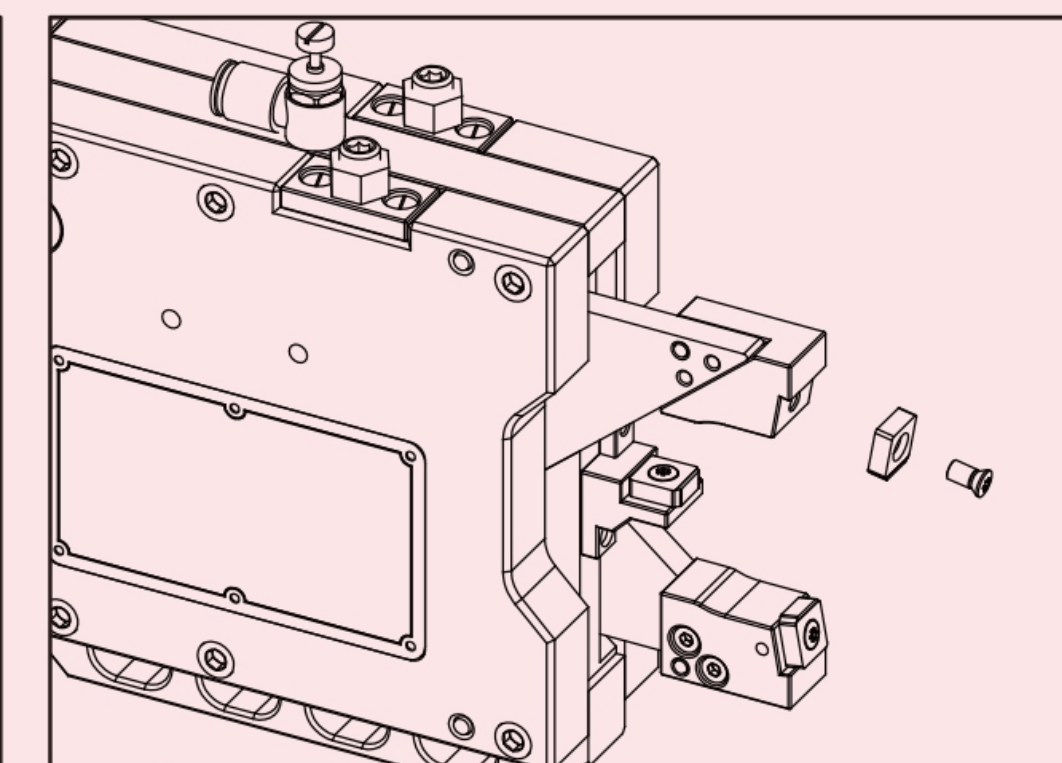
Clamping sleeve for clamping arm (**)

- Contains two nests for the clamping arm and one center for the clamping arm. Flat holder for middleware (including mounting material)
- Covering different clamping ranges through different clamping sleeves

* The balcony is designed for flat-plate holders with middleware with mounting materials.

** Contains nests for flat holders and clamping arms with mounting material Middleware

** Pomelo contains three flat plates and three mounting bolts



选择平板套 Selection of flat cover

平板套 (***)

- 包含带3个安装螺栓的3个平板
- 如下所示中心架的标准夹紧范围
- 针对夹紧范围-5mm的特殊偏置

Flat Sleeve (***)

- Three flat plates with three mounting bolts
- The standard clamping range of the center frame as shown below
- Special bias for clamping range - 5mm

