

## 提拉式数控插齿机

CNC Serration Machine Series

- ★ 主要用于中型内、外圆柱齿轮切削加工；
- ★ 机床为数控插齿机，四轴三联动。
- ★ 机床具备刀具提拉功能、工作台采用滚动轴承定心。主运动由交流变频电机驱动，切削时通过交流伺服电机驱动立柱移动实现径向进给；因机床具备刀架提拉机构，特别适合加工深孔内齿，同时大幅提升双联齿轮及不同齿厚的内、外齿加工效率。可根据切削需要设置循环次数及每次循环的径向切入量。



YKT5132提拉式数控插齿机



YKTM5140六轴提拉式数控插齿机



YKT5150提拉式数控插齿机



YKT5180A提拉式数控插齿机

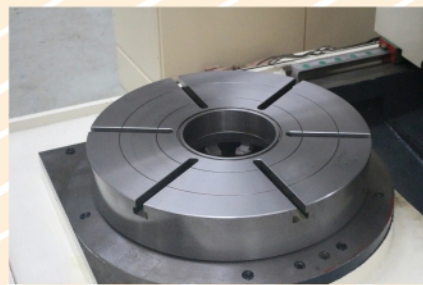
- ★ It is mainly applied to machine midsize internal and External cylindrical gears.
- ★ The machine is a CNC gear shaper which has 4 axes with the simultaneous movement of 3 axes.
- ★ The machine possesses the function of cutter head lifting, the worktable adopt rolling bearing structure. The main motion is driven by AC frequency inverter motor, the radial feed achieved by columnar movement and driven by AC servo motor during cutting, because of the function of cutter head lifting, this kind of machine especially suitable for cutting deep hole gears with internal tooth, and enhance the efficiency of cutting duplex gear and the different depth of internal or External gear. Users can set up the cycles and radial feed of each cycle according to demand.



主要技术规格 Specifications	YKT5132	YKT5150	YKT5180A
最大加工外齿直径 (mm) Max. diameter of external	320	500	800
最大加工内齿直径 (mm) Max. diameter of internal	220+D <sub>刀</sub>	600	1100
最大加工模数 (mm) Max. module	8	10	12
最大加工齿宽 (mm) Max. face width	90	200	250
插齿刀冲程长度 (mm) Max. stroke length	100	220	270
插齿刀冲程速度 (str/min) Stroke speed	125~1250	40~400	30~240
插齿刀让刀量 (mm) Cutter relieving	≥0.3	≥0.5	≥0.5
刀架提拉行程 Axial slide travel range of cutter head	300	400	500
插齿刀行程位置调整量 (mm) Adjusting amount of stroke position	-	-	-
插齿刀安装轴颈直径 (mm) Diameter of cutter neck	31.743	31.743	44.443
刀轴直径 (mm) Spindle diameter	85	100	120
工作台面直径 (mm) Diameter of worktable	420	700	900
工作台孔径 (mm) Diameter of worktable bore	120	140	320
工作台可倾斜角度 Sloping angle of worktable	-	-	-
插齿刀轴心线至工作台轴心线距离 (mm) Distance between axis of cutter spindle and worktable	-110~265	-40~400	0~750
机床主轴端面至工作台面距离 (mm) Distance between the nose of spindle and worktable surface	115~515	150~770	150~920
机床总功率 (kw) Total power	22	35	38
机床重量 (Kg) approx. Total weight	12000	16000	21000



深孔加工



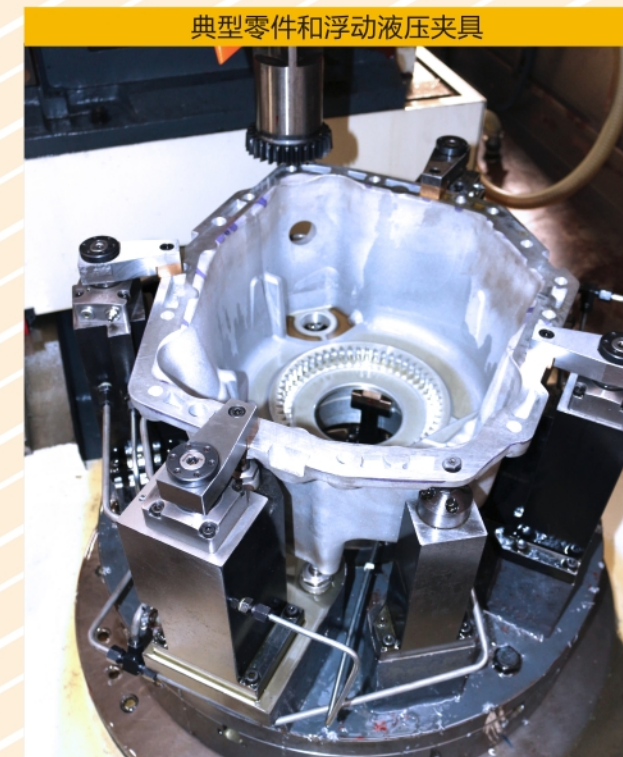
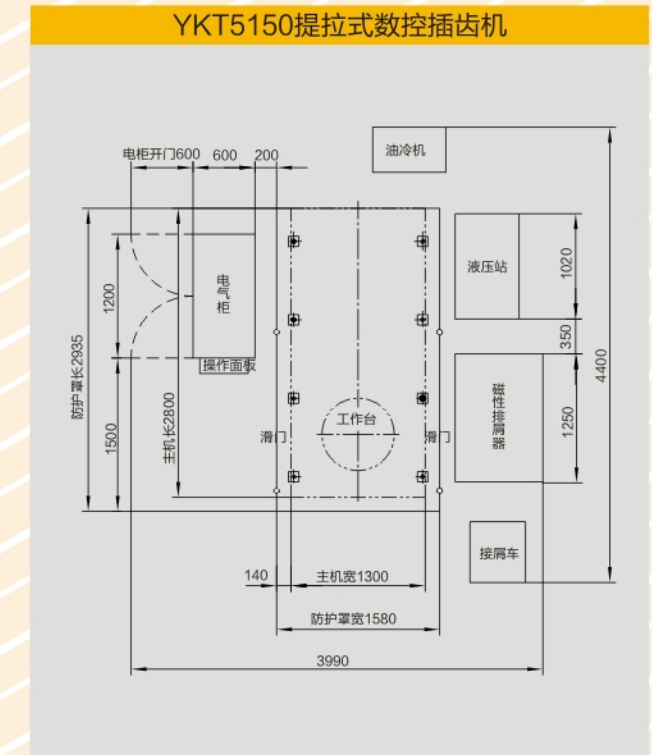
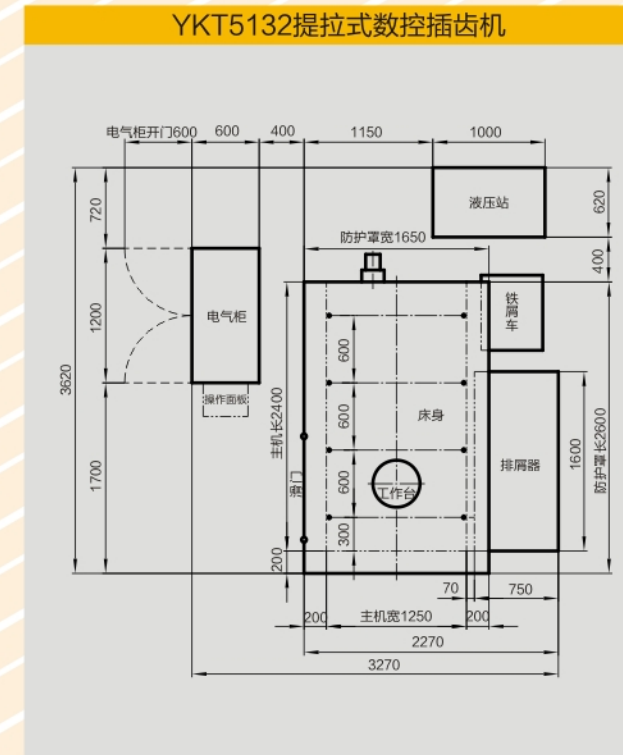
主轴轴承和直线导轨



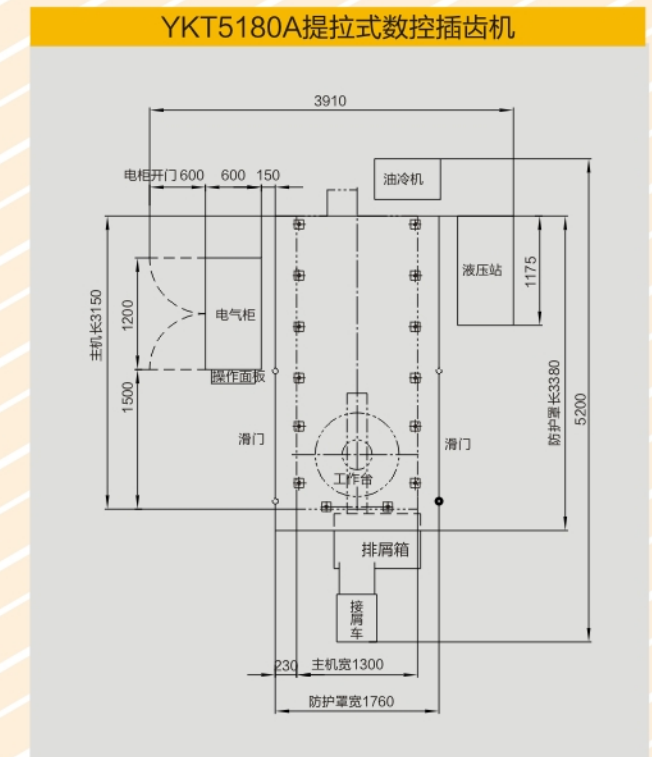
可配机床尾座

标准配置	Standard Accessories	选项配置	Optional Accessories
数控系统: 西门子828D	CNC system:828D Siemens	液压夹具	Hydraulic fixtures
主轴变频: 施耐德变频器	Spindle frequency convertor:Schneider	接刀杆	Cutter adaptor
液压装置一套: 外置 机床尾部	One set hydraulic convertor:External,behind machine	全防护防护罩	Full cover
冷却、排屑装置一套: 外置 机床右侧	One set cooling and chip conveyor:External,right side		
集中润滑装置: 间歇式	Centralized lubricating system:By intermittent		
电气柜: 外置 机床左侧	Electrical cabinet:External,left side		
标准接刀杆: YKT5132 2件 Morse 4#	Standard cutter adaptor:Morse 4#,2pieces for YKT5132		
YKT5150 3件 Morse 5#	Morse 5#,3pieces for YKT5150		
YKT5180A 3件 Morse 5#	Morse 5#,3pieces for YKT5180A		
随机附件箱	Accessory box		
半封闭防护罩	Half cover		
机床垫铁	Machine sizing block		

### 机床平面布置图



典型零件和浮动液压夹具



YKT5180A 提拉式数控插齿机