

PALMARY

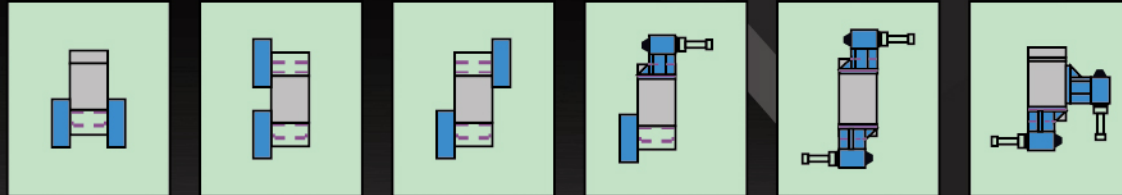
CNC

CYLINDRICAL GRINDER
MULTI-SPINDLE WHEELHEADS TYPE

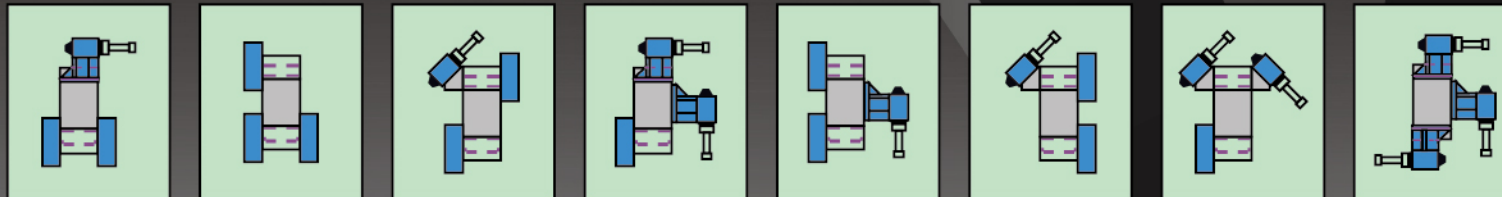
OCD-M2 / M3 series

Grinding wheel Versions

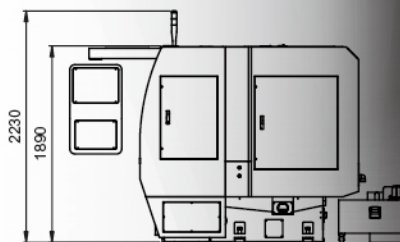
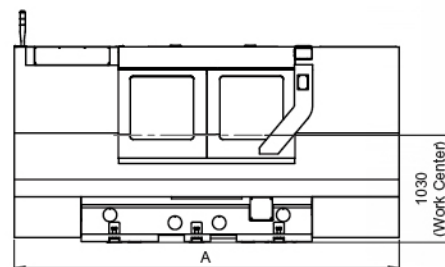
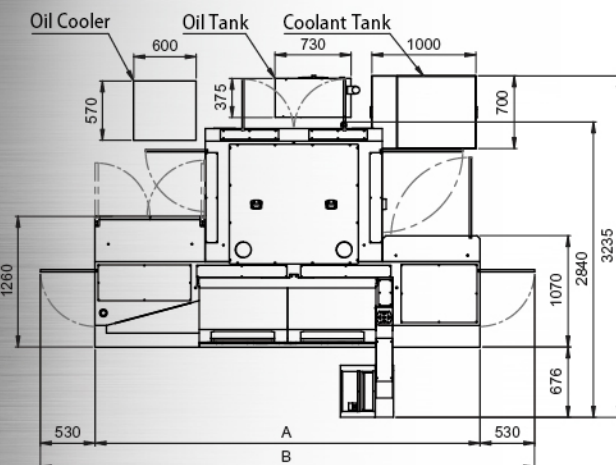
OCD-M2 series



OCD-M3 series



• Dimensions (unit: mm)



Model	Size	A	B
OCD-3235M		3100	4180
OCD-3265M		3700	4780
OCD-3295M		4300	5380



Outstanding Features:

- CNC Cylindrical Grinder Multi-spindle Wheelheads type provide for various size workpiece grinding application. To grind the inner dia., outer dia. & end face at one time clamping, not only could save the cycle time but also for better grinding accuracy.
- The machine distance between centers has 350, 650, and 950 mm on choice. The swivel over table is 320mm and max. workpiece load held by between centers is 150kg.
- The swivel wheelhead (B-axis) was driven automatically and has the min. setting angle 0.0003 degrees which allows the prompt position and superior grinding accuracy results.
- The wheelhead swivel position accuracy could be less than 1" (the angle unit: 1 second) for the customer's high accuracy requirements.
- Machine could equip with 2 no. grinding wheels (OCD-M2 series) or 3 no. grinding wheels (OCD-M3 series) for kinds of different industry need.



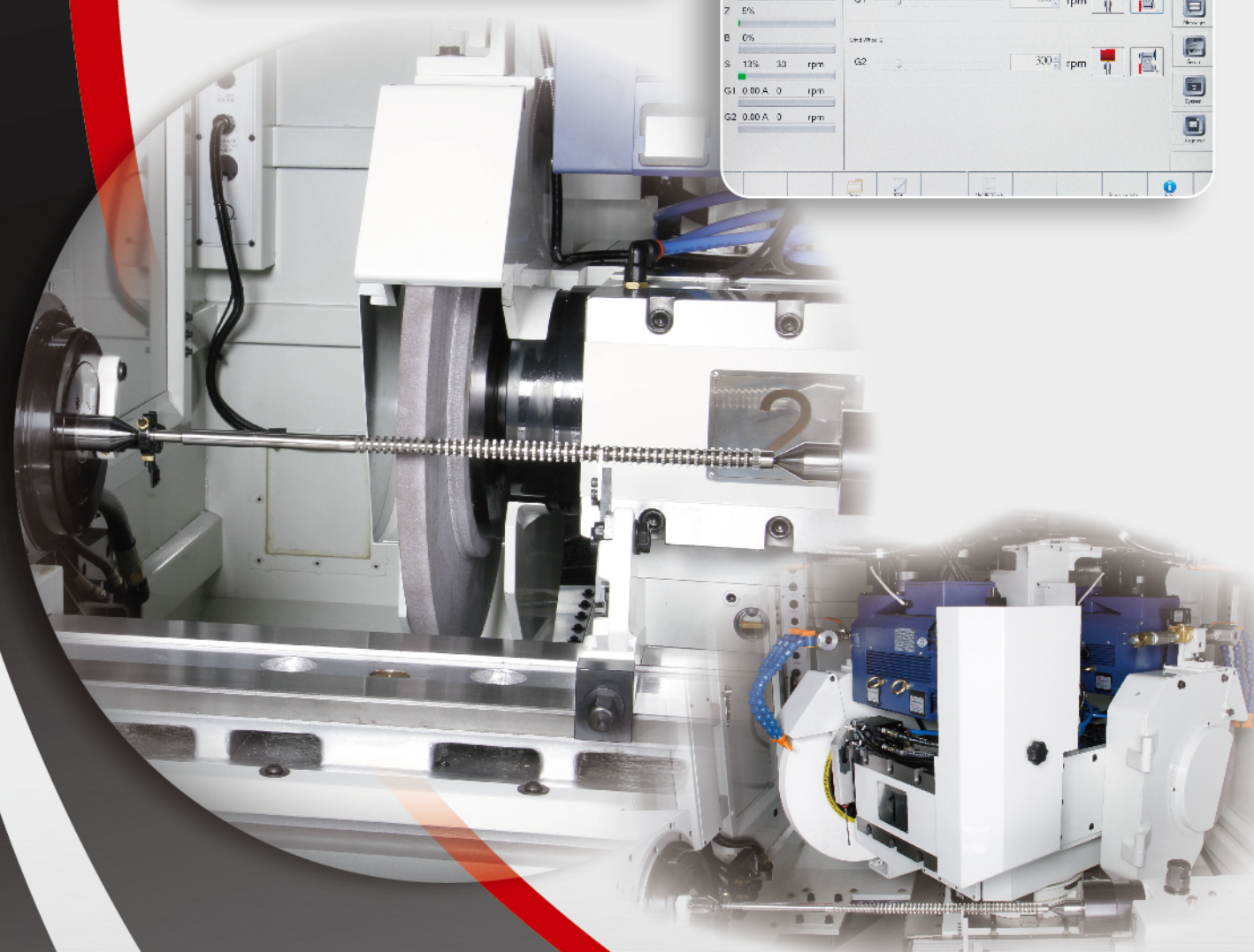
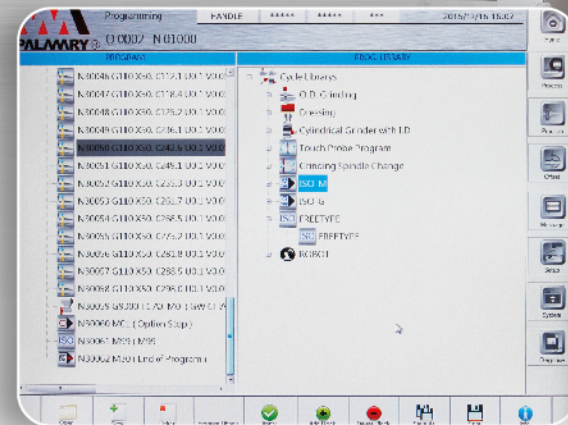
AFFORDABLE GRINDERS (U.S.A.)
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PALMARY

CNC CYLINDRICAL GRINDER MULTI-SPINDLE WHEELHEADS TYPE

OCD-M2/M3 series



Specification

		OCD-3235M	OCD-3265M	OCD-3295M
Swing Over Table			Max. Ø320 mm	
Distance Between Centers		350 mm	650 mm	950mm
Max. Grinding Diameter			Max. Ø300 mm	
Max. Load Held Between Centers			150 kg	
OD. Wheel (Straight Type)	OD. x W x ID.		Ø510 x 50 x Ø203.2 mm	
	Linear Velocity		2,000 m/min. (33 m/s)	
	Speed		1,248 rpm	
OD. Wheel (Angular Type)	OD x W x ID		Ø510 x 75 x Ø203.2 mm	
	Linear Velocity		2,000 m/min. (33 m/s)	
	Speed		1,248 rpm	
ID. Wheel Spindle	G.W. Speed		14,000~30,000 rpm	
	G.W. Diameter		Ø43~Ø60 mm	
	G.W. Max. Linears Velocity		2700 m/min	
	Swivel Angle		-40° ~ +220°	
B-Axis Wheelhead Swivel Base	Repeatability Accuracy		< 1" (1 sec. - Angle Unit)	
	Swivel Time 0°~180°		< 3s	
	Min. Setting Angle		0.0003°	
X-Axis Wheelhead	Rapid Moving		6 m/min.	
	Min. Setting Value		0.001 (Opt. 0.0001) mm	
	Rapid Moving		6 m/min.	
Z-Axis Table	Min. Setting Value		0.001 (Opt. 0.0001) mm	
	Swivel Angle		0° ~ 8.5°	
	Centers Taper		MT. 4	
Workhead	Spindle Speed		10 ~ 300 rpm	
	Swivel Angle		-30° ~ +90°	
Tailstock	Centers Taper		MT. 4	
	Moving Distance		35 mm	
Controller			FANUC	
Motor	G.W. Spindle		5.5 kw 4P (7.5 hp)	
	ID. Spindle (Build-In Type)		15	
	B-Axis Wheelhead Swivel Base (Servo Motor)		0.75 kw (1.0 hp) Tc : 2.0 Nm	
	X-Axis Wheelhead (Servo Motor)		1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Z-Axis Table (Servo Motor)		1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Workhead Spindle (Servo Motor)		1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Hydraulic Lubrication Pump		0.75 kw 4P (1.0 hp)	
	Hydraulic System		0.18 kw 4P (0.24 hp)	
	Coolant Pump		60L	
Capacity	Hydraulic Tank		42L	
	Build-in Type Spindle Coolant Tank		15L	
Power Supply			34.2KVA	
Machine	Dimensions	3,100 x 3,995 x 2,227mm	3,700 x 3,995 x 2,227mm	4,300 x 3,995 x 2,227mm
	Net Weight	8,500Kg(Estimated)	10,000Kg(Estimated)	12,000Kg(Estimated)

• OCD-M2 choose 2 no. grinding wheels. OCD-M3 choose 3 no. grinding wheels.