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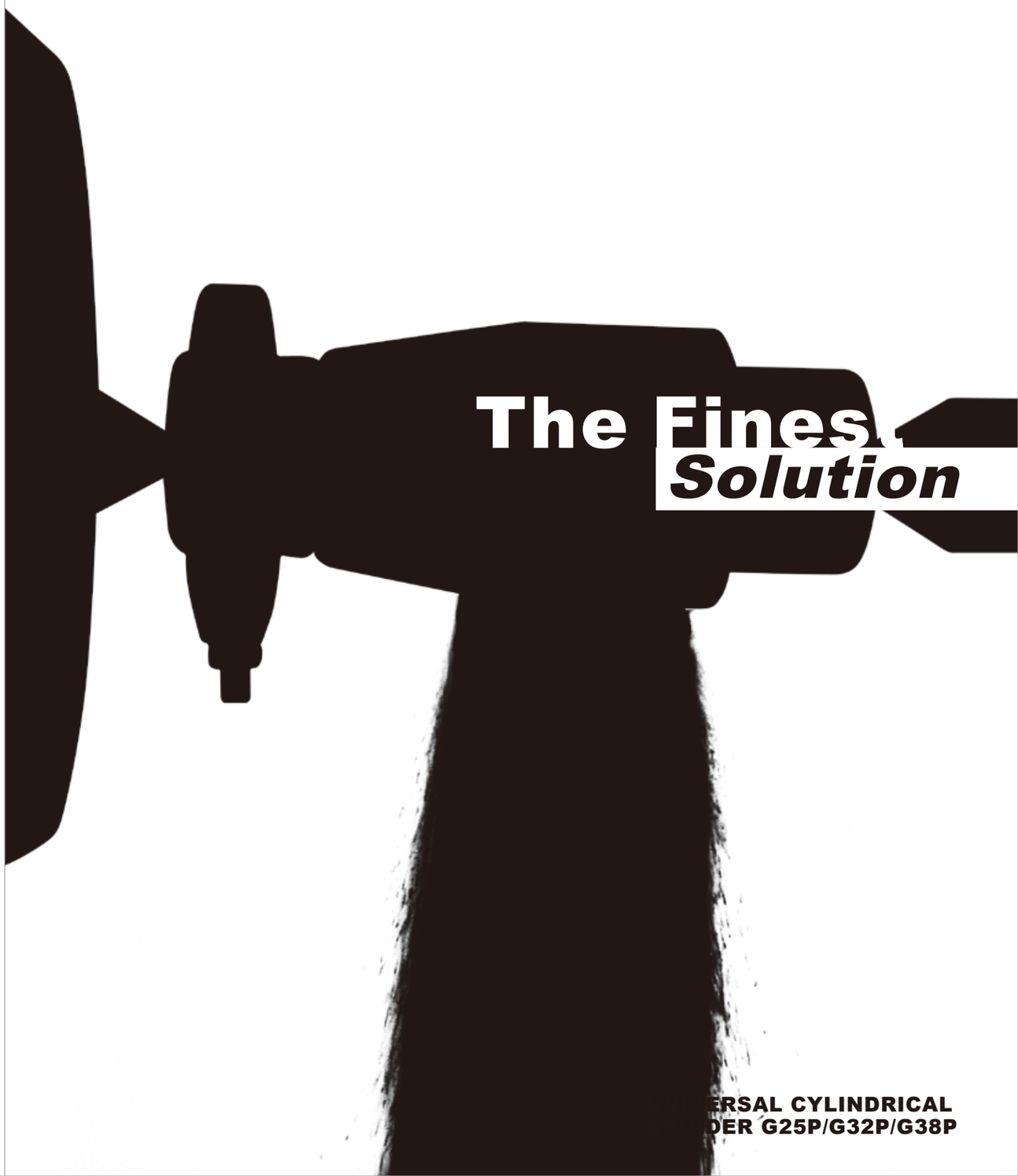
SUPERTEC® *Since 1954*



The Finest *Solution*

ERSAL CYLINDRICAL
DER G25P/G32P/G38P

DESCRIPTION \ MODEL		UNIT	G25P-50M/NC	G32P/G38P(M&NC)			
				60M / NC	100M / 100NC	150M / 150NC	200M / 200NC
GENERAL CAPACITY	Distance between centers	mm(in)	500(20")	600(24")	1000(40")	1500(60")	2000(80")
	Swing over table	mm(in)	Ø260(Ø 10.2")	320 /380 (12.6"/15")			
	Max. grinding diameter	mm(in)	Ø250(Ø 10")	300 /360 (12"/14")			
	Max. Load held between centers	kg(lb)	80(176)	150 (330)			
WHEELHEAD	Swivelling angle (R&L)	degree	±30°	±30°			
	Infeed travel	mm(in)	135(5.3")	245 (9.6")			
	Hand feed travel	mm(in)	90(3.5")	200 (7.8")			
	Top slide travel	mm(in)	180 (7")				
	Automatic rapid travel	mm(in)	45 (1-3/4")				
	Auto increment infeed (CII models)	mm(in)	Ø0.001~Ø0.999 (Ø0.0001~ Ø0.0999")				
	Handwheel per graduation	mm(in)	Ø0.004(Ø0.0002)				
	Handwheel per revolution	mm(in)	Ø2(Ø0.1")				
GRINDING WHEEL	Diameter × Width × Bore	mm(in)	Ø355x38xØ127 (Ø14x1-1/2xØ5)	Ø405X50X Ø127(Ø16"X2"XØ5")			
	Wheel speed	rpm	1960	1650			
TABLE	Swivelling angle (R&L)	degree	±8°	±9°	±7°	±5°	±3°
	Traverse speed (infinitely variable)	mm(in/min)	30~7000 (1-1/5"~275")				
	Handwheel per revolution	mm(in)	10(4")				
WORKHEAD	Swivelling angle (R&L)	degree	±45°	90°			
	Center taper	MT	MT3	MT4 (option MT5, 5C)			
	Spindle speed (infinitely variable	rpm	150/264/356/480	30~350			
TAILSTOCK	Center taper	MT	MT3	MT4 (option MT5)			
	Quill Travel	mm(in)	25(1")				
INTERNAL GRINDING	Spindle speed	rpm	12000/18000 or 25000				
	Max.grinding bore	mm(in)	30~100(1.18"-3.94") or 20-50(0.79"-1.97")				
	Max. grinding length	mm(in)	110 (4.33") or 55 (2.17")				
	Max. chucking length	mm(in)	315 (12-2/5")				
	Max. chuckeng diameter	mm(in)	150(6")				
MOTOR	Wheel spindle motor	HP	5	7½			
	Workhead motor	HP	1/2	2			
	Hydraulic pump	HP	2	2			
	Coolant pump	HP	1/8	1/4			
	Internal grinding motor	HP	2				
MACHINE	Net weight (approx)	kg(lb)	2050(4510)	3800(8580)	4700(10340)	5300(11660)	5700(12540)
	Gross weight (approx)	kg(lb)	2550(5610)	4300(9460)	5200(11440)	5800(12760)	6600(14520)
	Packing dimension (L × W × H)	mm(in)	2250x1650x1900 (89x65x75)	302x230x200 (119"x90"x79")	302x230x200 (119"x90"x79")	430x230x200 (170"x90"x79")	515x230x200 (203"x90"x79")

All specifications and features are subject to change without notice

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The Finest Solution

UNIVERSAL CYLINDRICAL GRINDER G25P/G32P/G38P

The **SUPERTEC** cylindrical grinder has been developed for between-center and chucking applications. Available in manual infeed (M models) or automatic infeed(NC models), this series of grinders offers a 10",12.6"or 15" swing and a choice of 20", 24" , 40" ,60" ,or 80" center distance for various grinding applications. The application is further extended when the optional swing down internal grinding attachment is supplied for internal grinding capability.

All machines feature a Meehanite box-type base, hydrostatic table ways, swiveling workhead and table, variable speed workhead, separate hydraulic system,5 or 7½ HP Spindle motor w/cartridge type spindle, and automatic lubrication for unsurpassed precision and productivity. Models with automatic infeed capability use a Mitsubishi PLC control with a menu-driven LCD touch screen that is easy to learn and easy to set. Operators need only to fill in the blanks to set total grinding amount, rough increment, fine increment, spark-out passes, feeding direction, parking position, wheelhead retract distance then press cycle start to complete the automatic grinding cycle. An optional overhead parallel dresser with automatic compensation system helps to reduce cycle time and obtain better surface finish. These grinders are sure to provide many years of peak performance and accuracy.

G32P-60NC

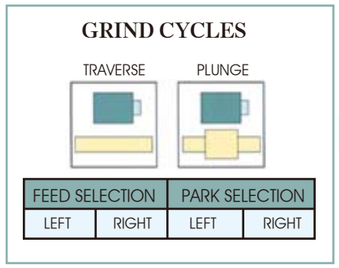
Note:Machine shown with optional accessories.

Mitsubishi PLC control uses a menu-driven LCD touch screen technology for simple operation.(NC Models only)

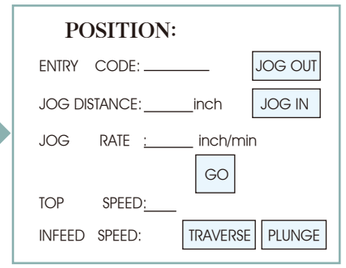
Step 1

Choose the following functions: Grinding Mode Selection Infeed Selection Table Parking Selection Jog Setting or Next Screen

Man Screen



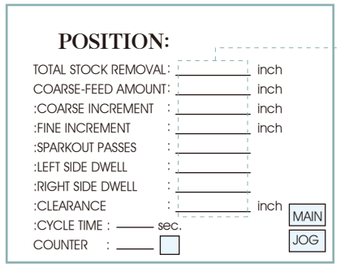
Jog Setting Screen



Data Setting Screen

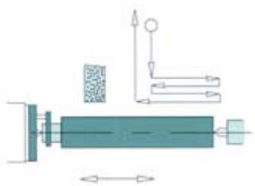
Step 2

Fill in the blanks to set total stock removal, total fine grinding amount, rough increment, fine increment, spark-out passes, and reset distance, then press cycle start to complete the automatic grinding cycle.

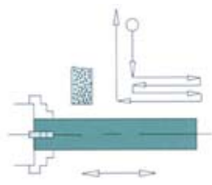


The data input key window will be displayed when touch to input data

Grinding Application

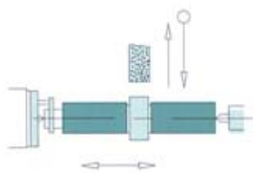


Traverse grinding with 2-centers Support

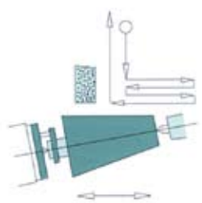


Traverse Grinding with chuck

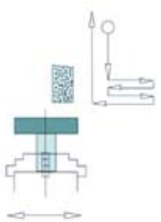
Taper Grinding with Chuck



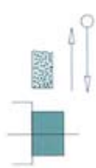
Plunge grinding



Traverse grinding with 2-centers Support



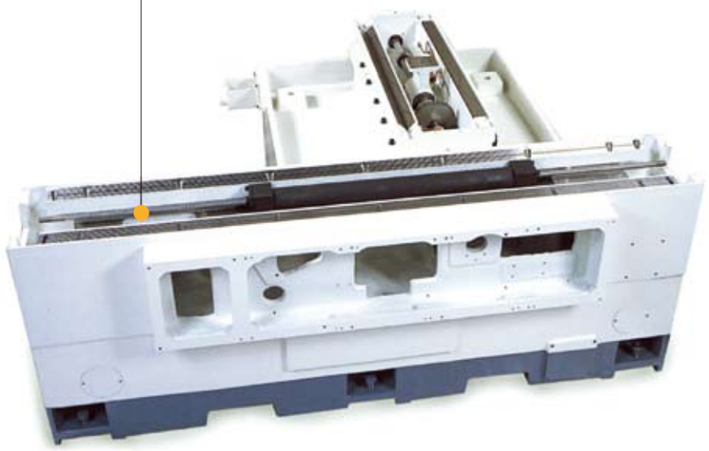
Surface Grinding



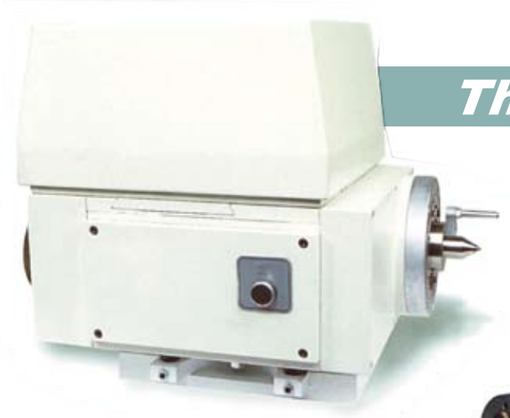
Shoulder Grinding

Machine Base

The heavily ribbed box-type base is made of meehanite castings, ensuring machine stability. Optimal distance between guideways offers excellent table support to increase Z axis positioning accuracy and repeatability.



The Finest Solution



Workhead

The sturdy rigid-designed workhead equiped with precision bearing is electronically controlled giving variable spindle speeds. Workhead swivel 90° counterclockwise to 30° clockwise for various grinding operations. A combination live and dead-type spindle allows for quick changeover from certer to chuck operation or vice versa. A dual oil seal and cover prevents coolant seepage into the workhead

Tailstock

The design of the tailstock is both rigid and robust. Housed in a cast body, the hardened nitralloy steel sleeve is designed to carry a MT3/MT4 center or optional MT5 center. An optional hydraulic tailstock with foot pedal is available for easy loading and unloading of parts.

The Finest Solution

SUPERTEC®
Since 1954

Wheelhead

The one V and one flat guideways are Turcite coated and utilize a hydro static oil lube system. The wheelhead is driven via A.C. servo motor and precision ballscrew for greater accuracy and reliability, as well as ensuring repeatability of ±0.000040". The machines control can be programmed to increments as fine as 0.000010".

Wheel Spindle

Cartridge type wheel spindle is permanently lubricated and equipped with four super precision angular contact class 7 (ABEC) bearings incorporated with 5/7½ HP spindle motor ensure high accuracy.

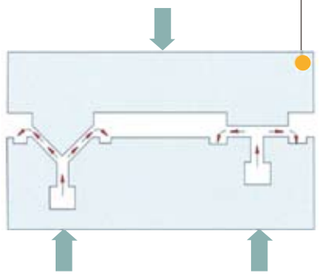
Work table

The rigid table with box-type construction travels on hydro-static ways with a cushion of oil allowing no metal to metal contact. The automatic force lube system operates continuously to ensure smooth movement and consistent accuracy. A Swiveling table dial indicator enables rapid cylindrical correction and taper grinding applications. The table is fully supported in the full travel to avoid overhang.

All specifications and features are subject to change without notice.

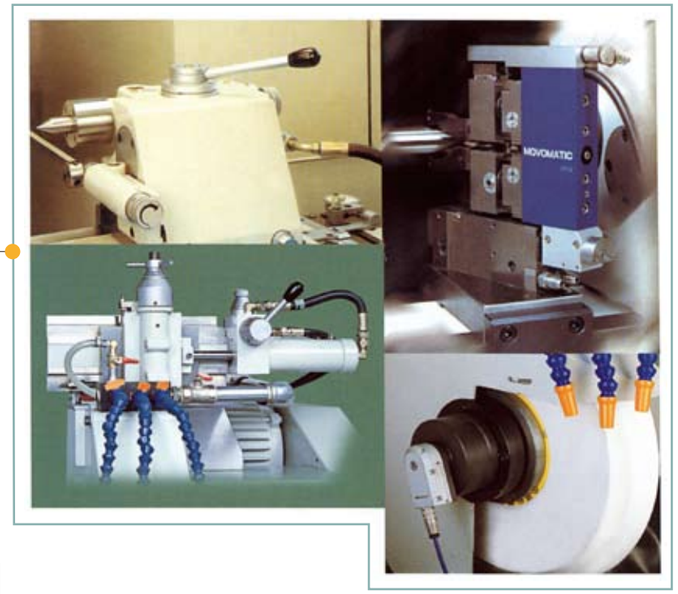
Automatic Lubrication System

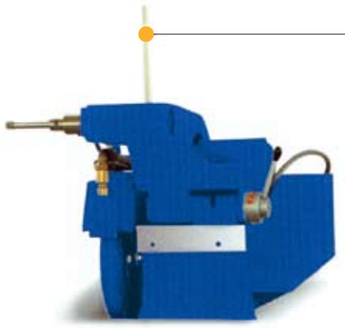
Slideways and leadscrew are continuously lubricated by an auto-lube system to ensure long service life and maintain maximum accuracy. Hydraulics, lubrication systems are separated from machine to eliminate vibration and dissipate heat.



Systems for Automation

A highly-automated grinding system can be customized with a wide selection of optional equipment….including an automatic OD sizing device,hydraulic tailstock with foot pedal, overhead dresser with automatic compensation, tailstock-mounted micro wheel dresser & dynamic wheel balance system...etc.

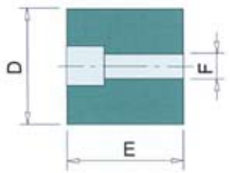




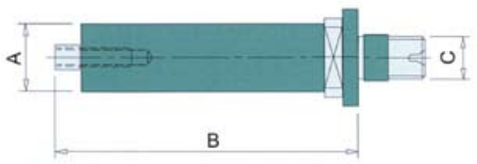
Optional Internal Grinding Attachment

The hinged, swing-down internal grinding attachment swings down into working position easily and quickly. A patented locking device adds safety as it prevents the ID attachment from swinging down abruptly. This unit can grind diameters from 0.79"(20mm) to 3.94"(100mm) to a maximum depth of 4.33"(110mm). It offers wheel spindle capability of 12,000/15,000 or 25,000 rpm.

WHEEL



QUILL



unit;mm(in)

SPINDLE RPM	QUILL			WHEEL SIZE			WORKPIECE	
	A	B	C	D	E	F	DIAMETER	DEPTH
12000/18000	16	51	M14×1.5	25	25	8	30-80(1.18"-3.15")	25-60(0.98"-2.36"
	20	73	M14×1.5	32	32	8	40-80(1.57"-3.15)	32-90(1.26"-3.54")
	24	91	M14×1.5	38	38	8	50-100(1.97"-3.94")	38-110(1.50"4.33")
25000	10	32	M10×1.5	16	16	6	20-50(0.79-1.97")	16-30(0.63"1.18")
	12	38	M10×1.5	19	19	6	25-50(0.98"1.97")	19-40(0.75"-1.57")
	16	48	M10×1.5	22	25	6	30-50(1.18"1.97")	25-55(0.98"-2.17")

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Optional Accessories


2-Point steady rest


3-Point treadly rest


Radius dressing attachment


Angle dressing attacment

3 Jaw scroll chuck	4" / 5" / 6" / 8"
4 Jaw independent chuck	6" / 8"
Fixed back plate	4" / 5" / 6" / 8"
Adjustable back plate	6" / 8"
5C collet closer	manual / air
5C collets	3/64"-1 1/8 (4-20mm)
Radius dressing attachment	
Angle dressing attachment	
Internal grinding attachment	12000/18000rpm or 25000rpm
2-Point steady rest	2.8 (70mm)/4.8" (120mm)
3-Point steady rest	1.6"-4" (40-100mm) /3.2"-5.5" (80-140mm)
Digital readout	one axis / two axis
Balancing stand	straight / toller type
Spare grinding wheel	14"×11/2"×5" /16" ×2"×5"
Spare wheel flange	5" bore
Micro wheel dresser	
Overgead parallel dressing attachment	
Overhead dresser w/auto compensation system	
Hydraulic tailstock w/foot pedal	
MT5 taper on workhead & tailstock	G32/38P only
SBS Dynamic wheel balance system	
Coolant system w/magnetic separator & paper filter	60L/min, 140L
Coolant system w/magnetic separator & paper filter	40L/min,120L
Coolant system w/paper filter	60L/min, 140L
Coolant system w/paper filter	40L/min,120L
Variable speeds	wheelhead / ID attachment


Fixed back plate

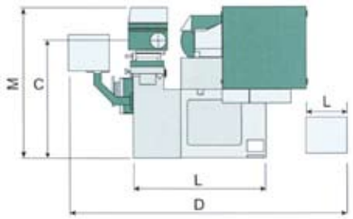

Micro wheel dresser


Coolant system w/mag, sep & paper filter


3 Jaw chuck

Standard Accessories

Balancing arbor	Dial gauge
Wheel extractor	Splash guard
Grinding wheel w/flange	Coolant system
Tool box w/adjusting tools	Auto lube system
Diamond dresser (fixed on table)	Carbide tip centers
Operation manual with parts list	Leveling screws w/blocks
Variable speeds workhead	Halogen Light



Dimensional Drawings

unit: mm (in)

	A	B	C	D	E	F	G	H	I	J	K	L	M
G25P-50M/NC	500	130	1075	1270	1450	N/A	N/A	1950	2400	N/A	N/A	920	1560
G32P-60H/CII	600 (24")	162 (6.38")	1090 (42.91")	2600 (102.36")	1960 (77.17")	390 (15.35")	405 (15.94")	2755 (108.46")	3420 (134.65")	386 (15.20")	279 (10.98")	1220 (48.03")	1397 (55")
G32P-100H/CII	1000 (40")	162 (6.38")	1090 (42.91")	2600 (102.36")	2630 (103.54")	570 (22.44")	585 (23.03")	3785 (149.02")	4855 (191.14")	561 (22.09")	509 (20.04")	1220 (48.03")	1397 (55")
G32P-150H/CII	1500 (60")	162 (6.38")	1090 (42.91")	2600 (102.36")	3690 (145.28")	475 (18.70")	500 (19.69")	4665 (183.66")	6265 (246.65")	796 (31.34")	804 (31.65")	1220 (48.03")	1397 (55")
G32P-200H/CII	2000 (80")	162 (6.38")	1090 (42.91")	2600 (102.36")	4890 (192.52")	456 (17.95")	479 (18.86")	5825 (229.33")	7997 (314.84")	1086 (42.76")	1086 (42.76")	1220 (48.03")	1397 (55")