

PLANOMAT XT 612 ESSENTIAL

The economic machine for high precision surface grinding

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Everything, what's required for surface grinding

The economic 3-axis machine for high-precision surface and profile grinding

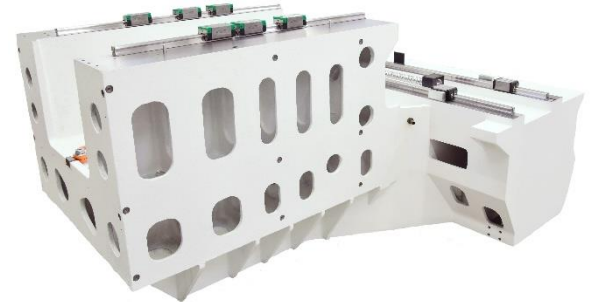
- Table size 600 x 1.200 mm
- Siemens CNC control
- BLOHM single piece production with graphical operator guidance
- Grinding technologies
 - Reciprocate grinding
 - Creep feed grinding



DESIGN FEATURES

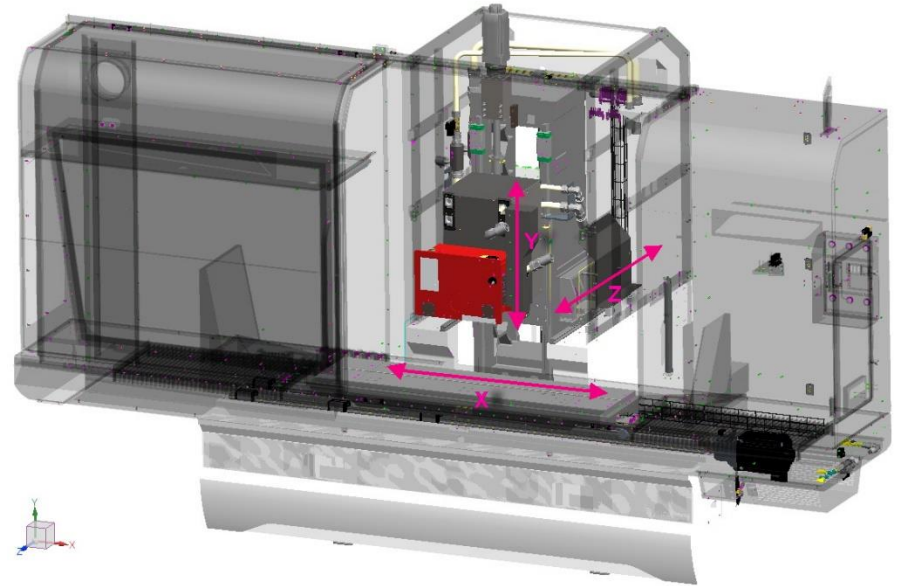


- Extreme rigid ductile cast iron components
- Elevated Z-axis guideways
- Linear guideways in all machine axes
- Re-circulating ball screws for all machine axes
- Grease lubricated grinding spindle with BLOHM transverse stop
- Housing and coolant sump designed as welded part
- Large sliding door on the outside of the enclosure
- Maintenance doors on the left and right hand side



TECHNICAL DATA

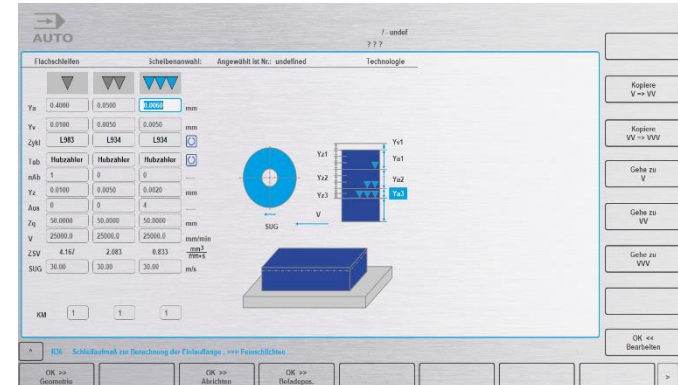
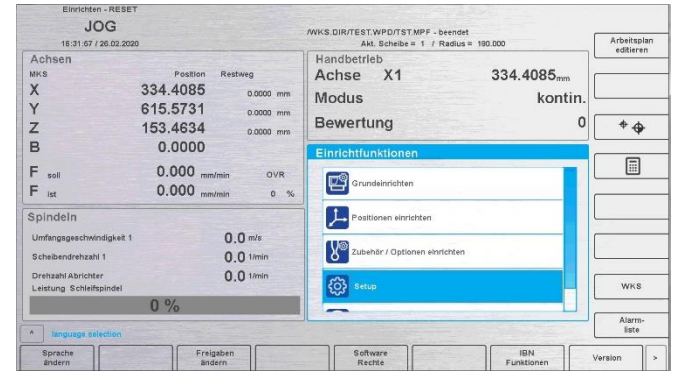
- X-axis
 - Speed 30...30.000 mm/min
- Y-/ Z-axis
 - Speed 4...2.000 mm/min
- Grinding spindle drive 11 kW, max. 3.500 U/min
- Grinding wheel dimension 400 x 100 x127 mm
- Table load max. 1.500 kg



PROGRAMMING

The BLOHM operator interface with graphical operator guidance adapts the control system perfectly to the needs of profile and contour grinding applications

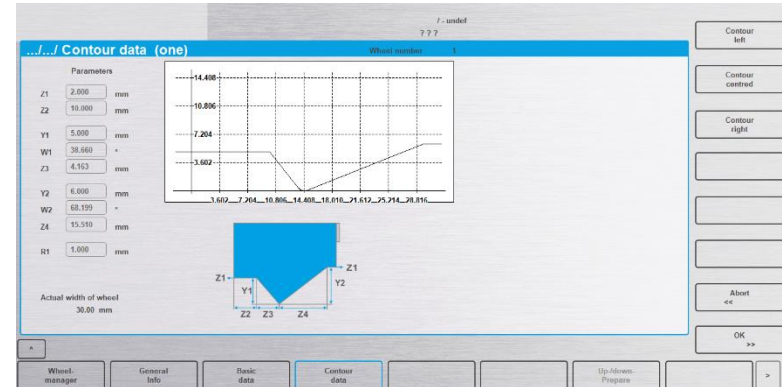
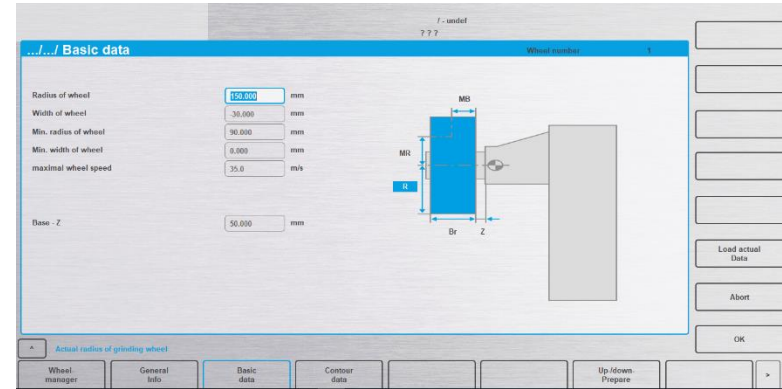
- User friendly with comfortable programming functions
- Particularly suitable for the production of single parts and small series
- Simple set-up of machine and parameter
- Quick adaptation of grinding and dressing cycles with graphical support
- Tool management for 50 grinding wheels and 15 dressing tools



PROGRAMMING

The wheel management comprises

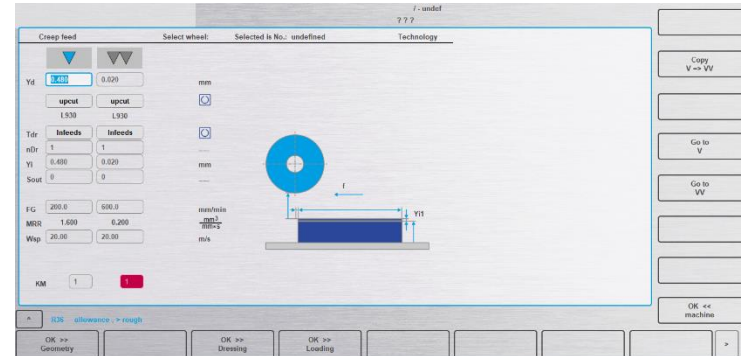
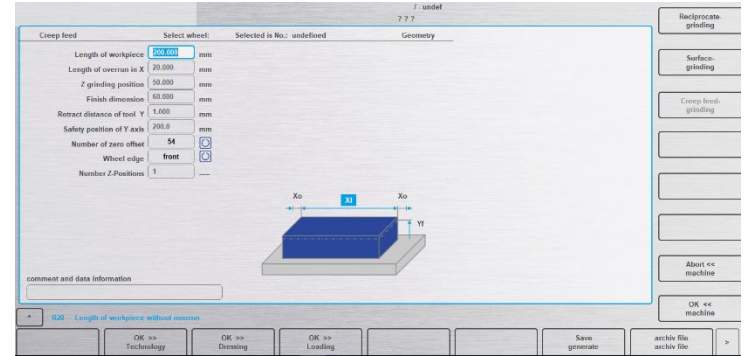
- Input of basic wheel data
- Storage of contour data
- 6 parametric standard contours are available
- Storage of free or via GripsProfile generated contours



PROGRAMMING

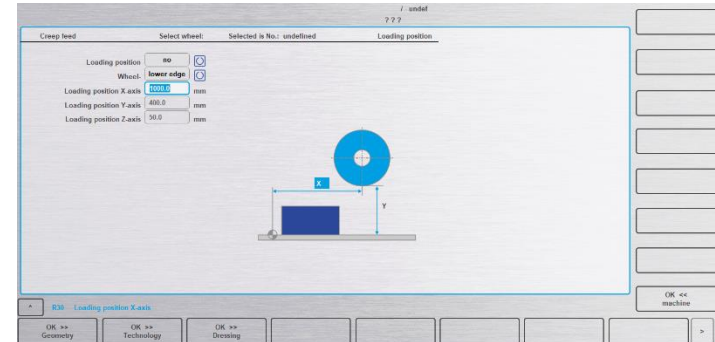
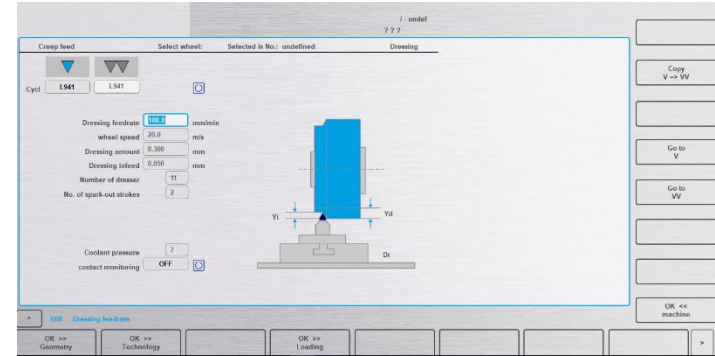
The preparation of the machine program can be started once the grinding wheel, dresser and zero-off sets are set-up. This is done by using the following input screens

- Input of workpiece geometry
 - Possibility to store up to 8 workpiece geometries, incl. the process parameter using the function „save generate“
- Selection of grinding method
 - Reciprocate plunge grinding
 - Surface grinding
 - Creep feed grinding
- Input of technology data



PROGRAMMING

- Input of technology data for dressing, incl. selection of dressing method
 - L941 = Straight dressing
 - L820 = Standard dressing contours
 - L901 = Plunge dressing
 - L920 = Contour parallel dressing
 - L923* = Contour parallel dressing GripsProfile
 - L944* = Face dressing
 - › * Optional
- Input of loading position
 - Position will be approached automatically once machining is completed
- Data entry is completed by pushing the soft-key „OK<<machine“ and the screen to input the start position is called up

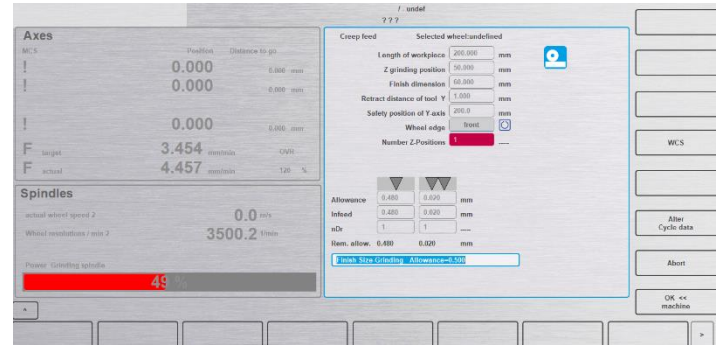
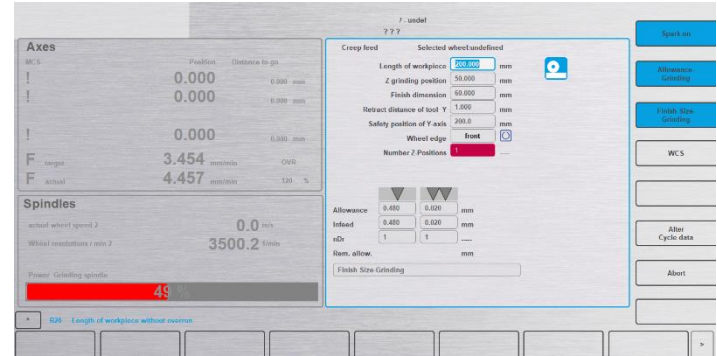


PROGRAMMING



The start position for machining the workpieces can be established by the following methods:

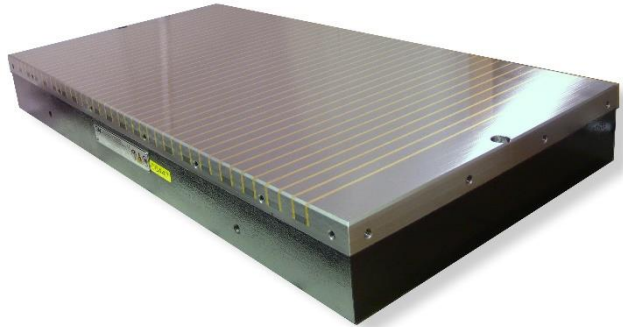
- Spark on
 - Allowance grinding
 - Finish size grinding
- Select method and adjust parameter if required
 - Conduct operations to establish start position or enter data and confirm
 - Data entry will be completed by pushing the soft key „OK<<machine“
 - Push cycle start to machine the workpiece



READY TO GRIND

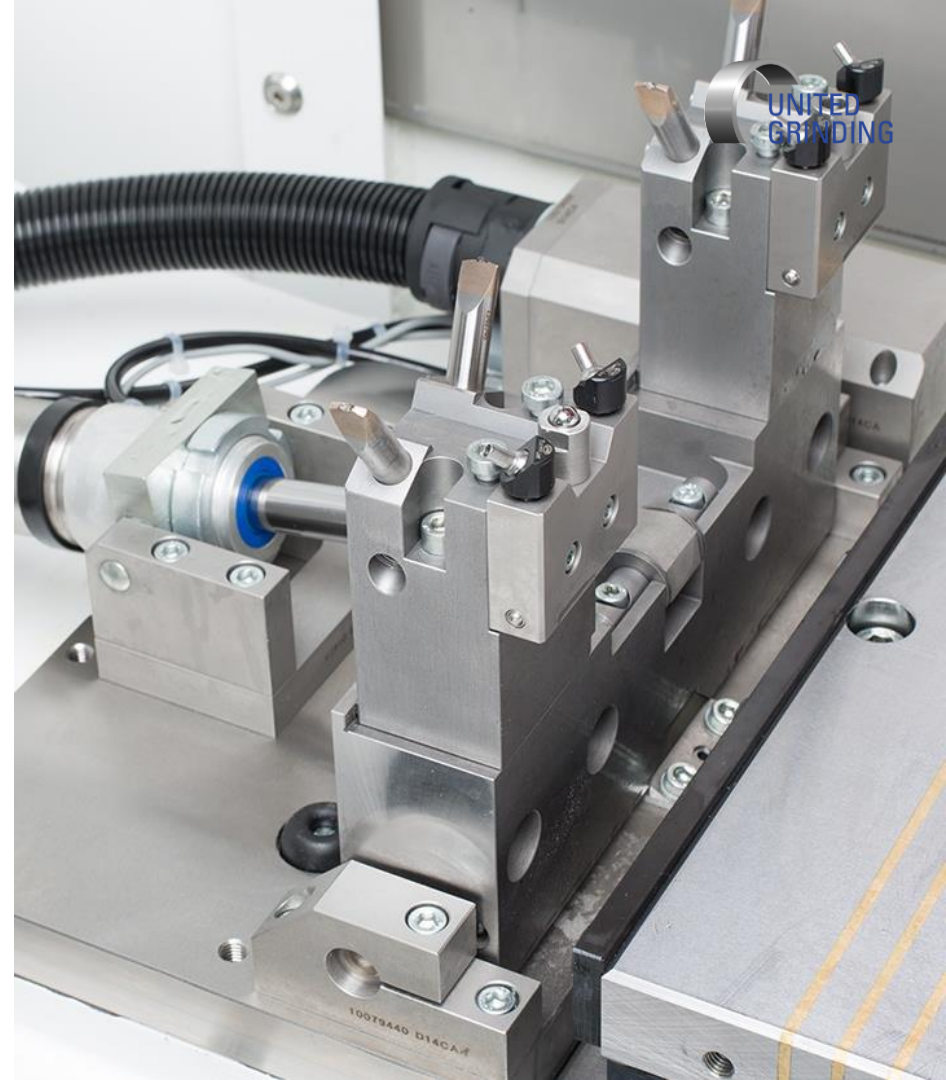
Ready to grind with a defined scope of supply for surface grinding

- Electro-permanent magnetic chuck 1200 x 600 mm, DQ 18
- Diamond holder with single point diamond
- Preparation for manual balancing unit
- Band filter coolant filtration system 100 l/min, 3 bar, tank volume 500 l



OPTIONS

- Automatic grease lubrication system for guideways and re-circulating ball screws
- Linear scales for Y- / Z-axis
- Electro-permanent magnetic chuck 1200 x 600 mm, DQ 13
- Riser for magnetic chuck
- Universal dressing unit, tiltable type, incl. pneumatics
- Profile dressing attachment PA-T 40, PA-TLR 40, PA-T 150S or PA-T 200S
- Manual balancing unit
- Coolant mist exhaust units



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