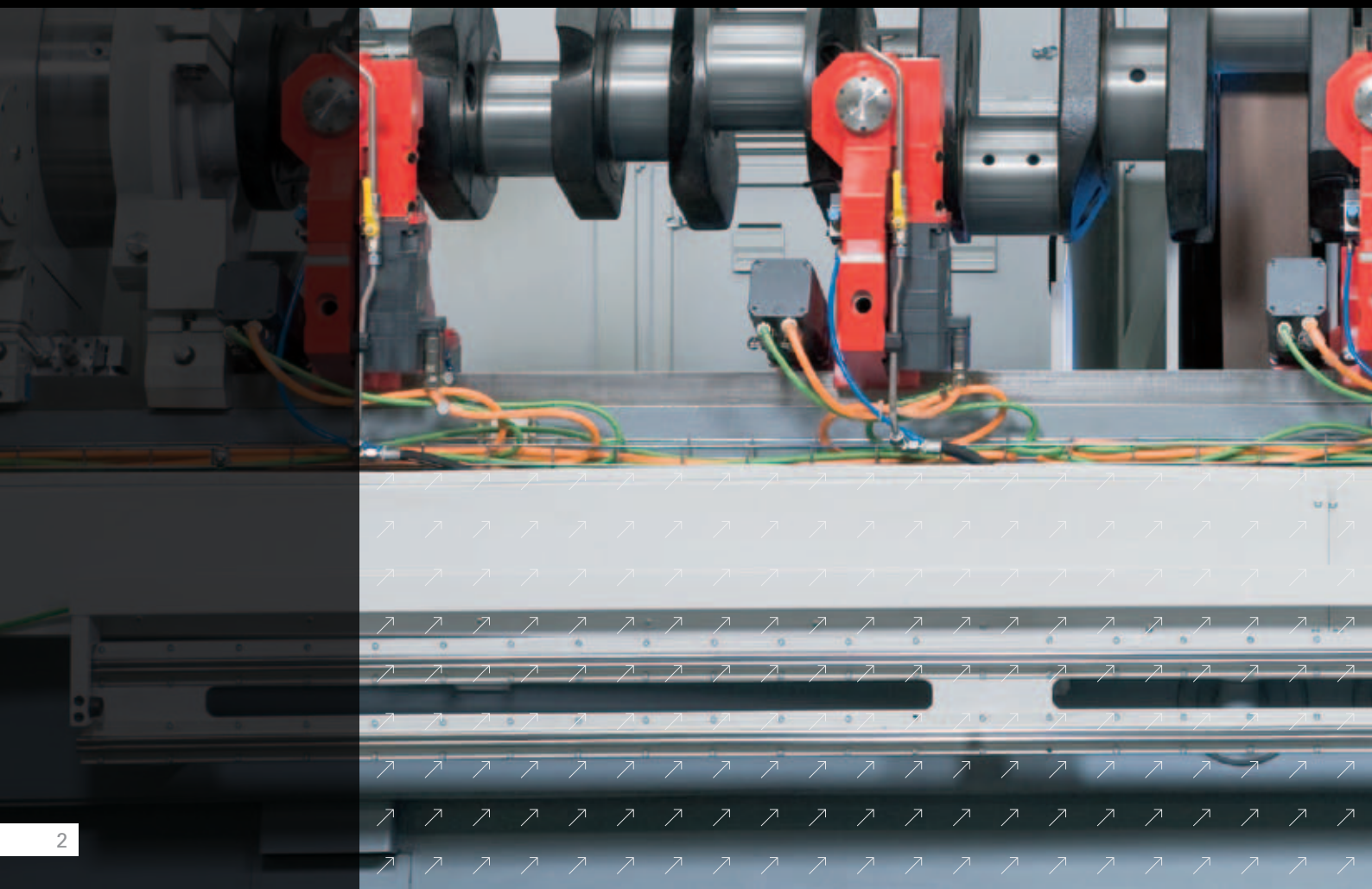


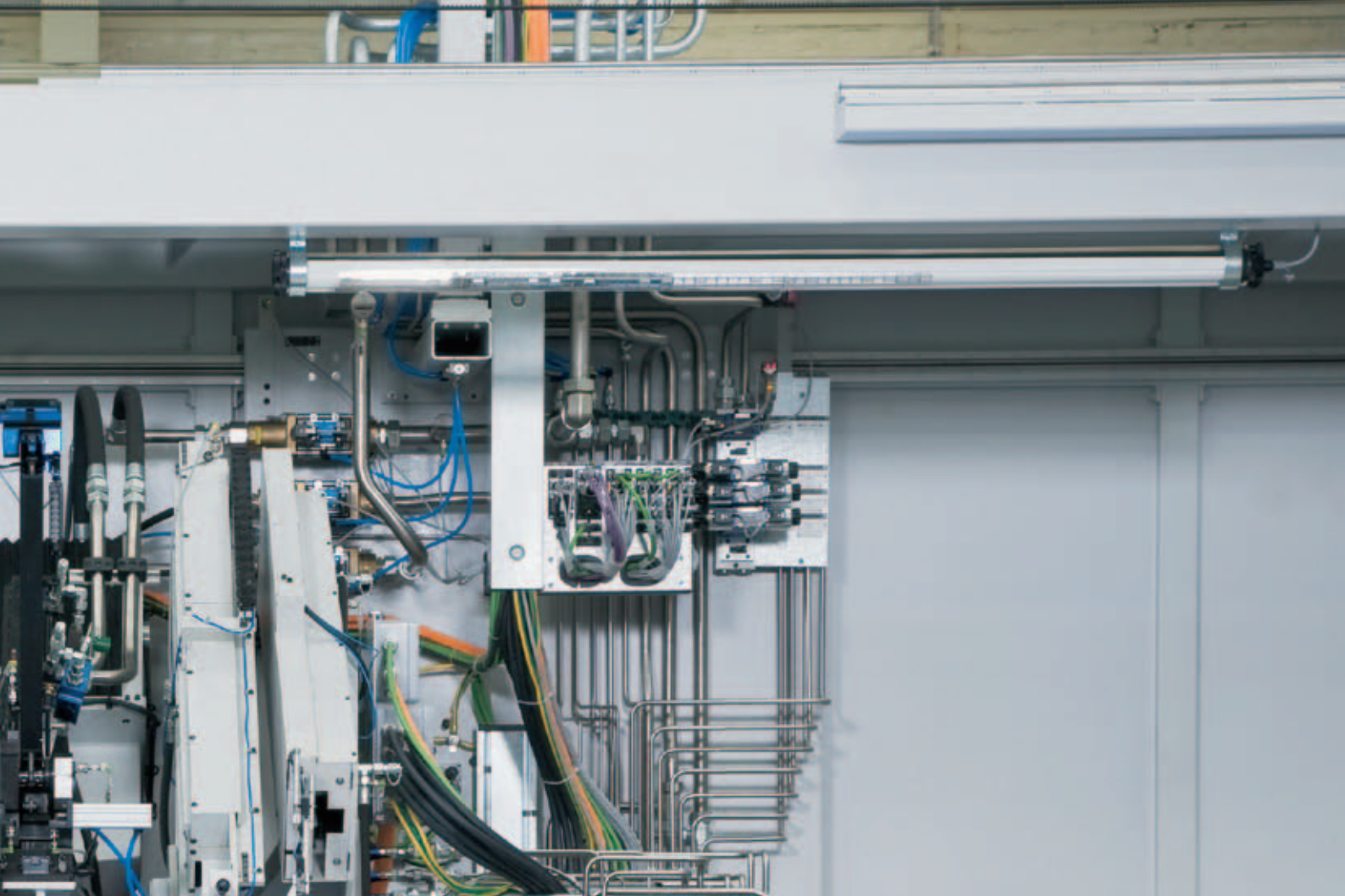
Heavy-Duty
Crankshaft Grinders
PM 430
PM 460



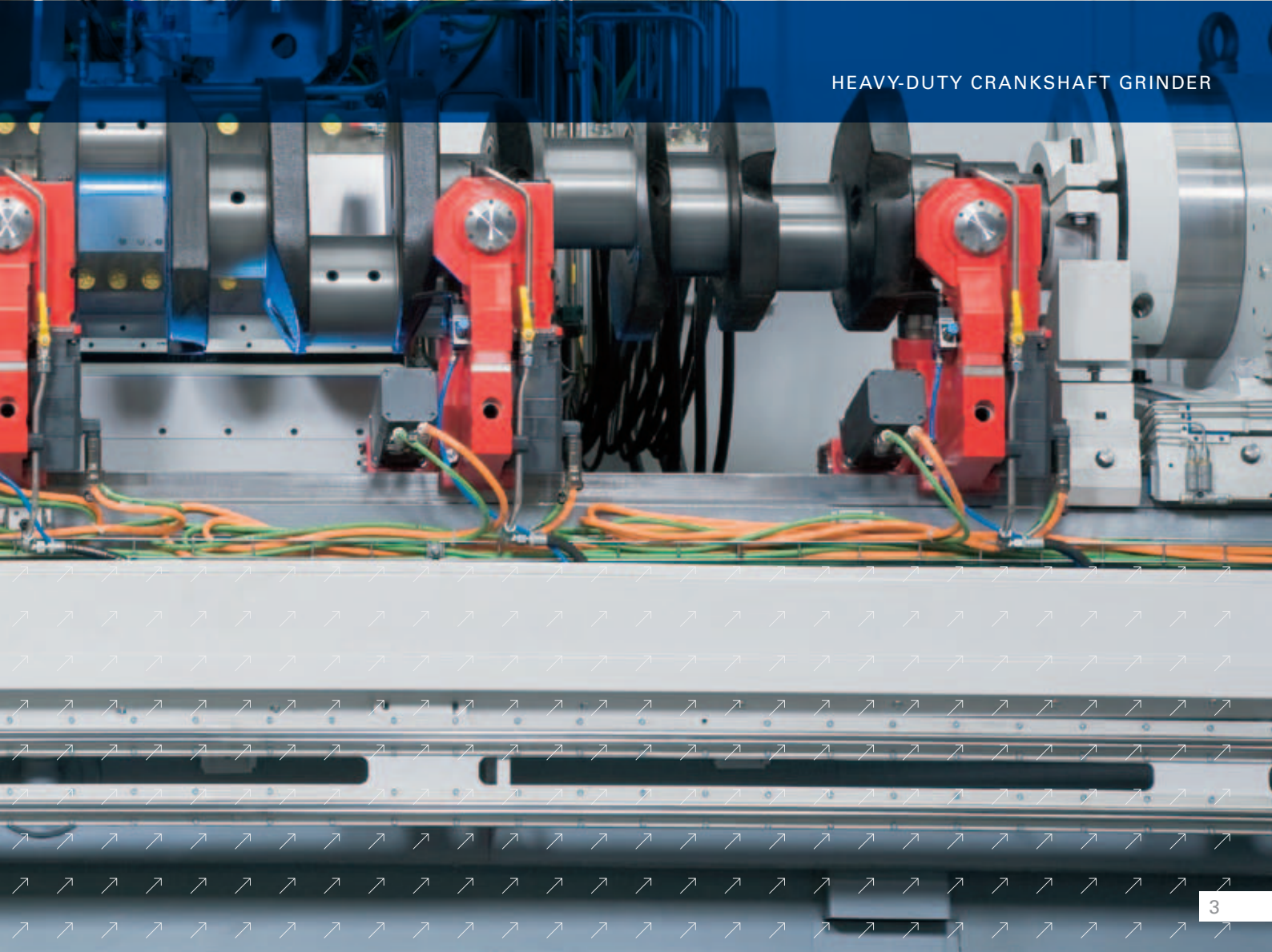
A world first:
Pendulum grinding of
heavy-duty crankshafts.
Grinding of main and pin
bearings on one machine,
using traditional
corundum or CBN
grinding wheels. High
productivity rates and
flexibility. Fully automatic,
semi-automatic or manual
grinding processes.
A new generation of
grinders with all the
features of cutting edge
grinding technology.

P M 4 3 0
P M 4 6 0





HEAVY-DUTY CRANKSHAFT GRINDER



Series PM 430 / 460.

The PM 4 series machines feature linear motors and hydro-static guideways in X- and Z-axis, making them highly dynamic and guaranteeing excellent grinding results. The workpiece is driven from both ends, using either drivers or hydraulic chucks, depending on the application. The work spindle is directly driven by a torque motor.

The grinding spindle is designed like a motor spindle with a maximum power rating of 100 kW. Higher torque rates are achieved with an optional auxiliary motor and belt-based speed transmission. All operator interfaces are easy to use, allowing for quick workpiece change-overs and resulting in high output rates. The machine is completely enclosed and features automatic front doors that provide easy access to the machining area.

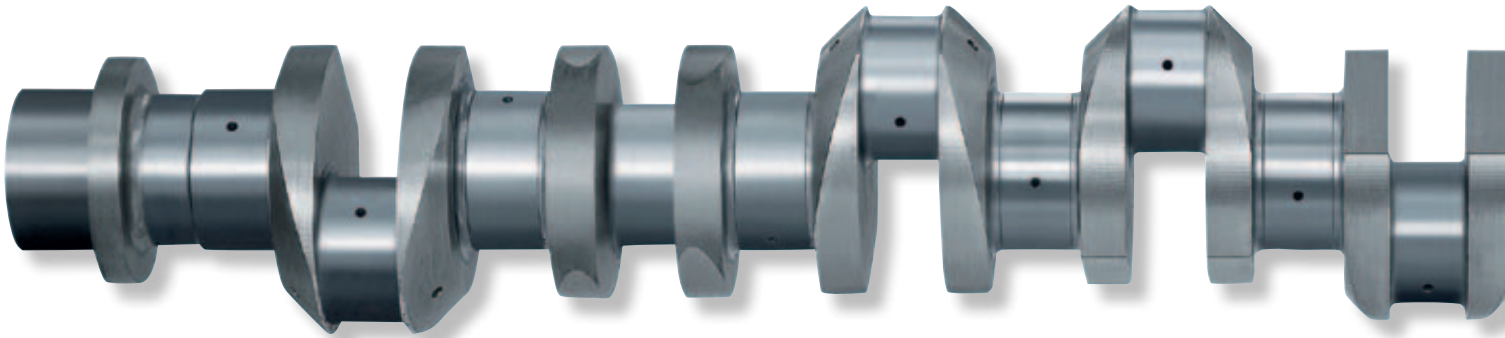
P M 4 3 0
P M 4 6 0





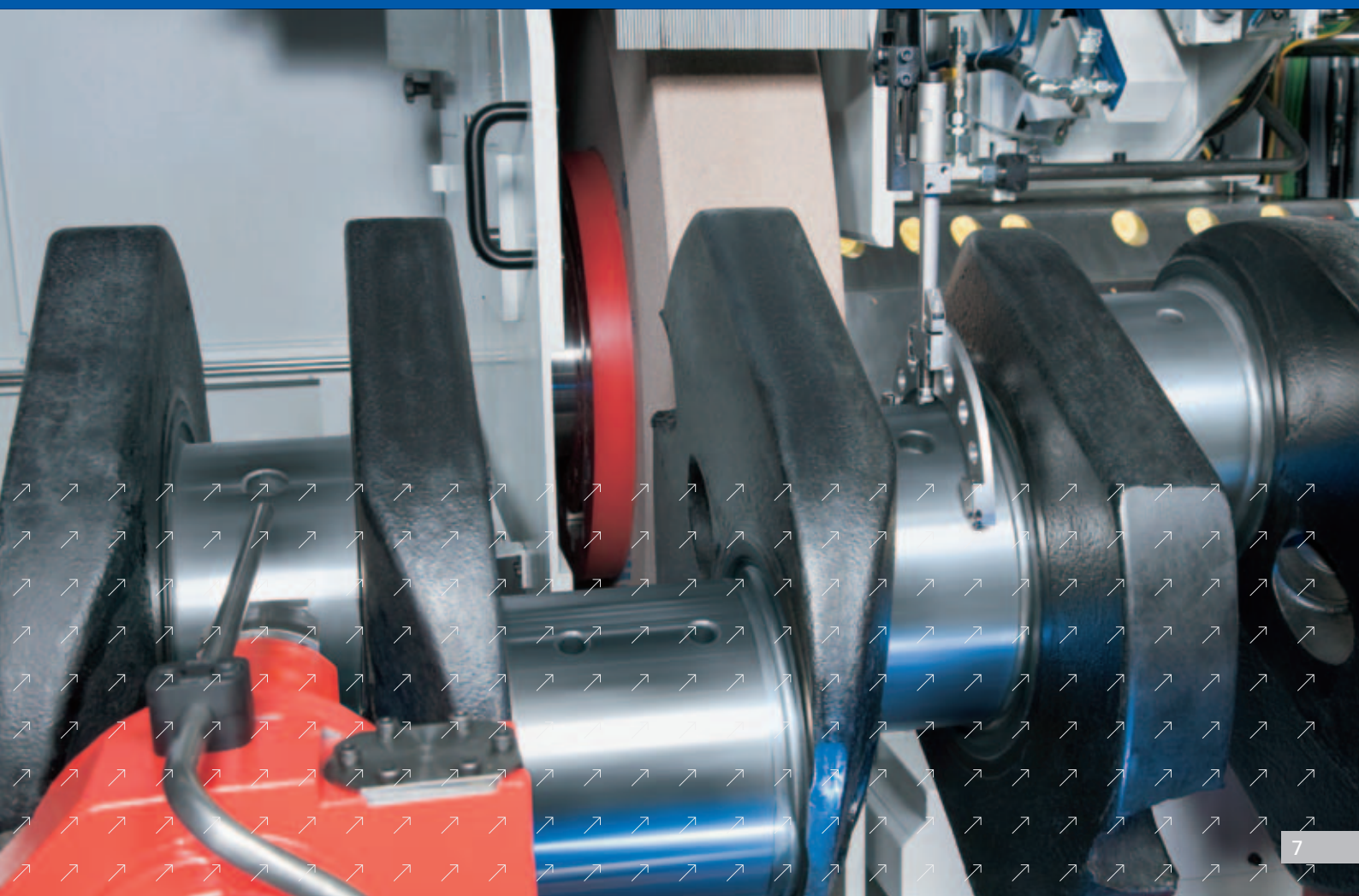
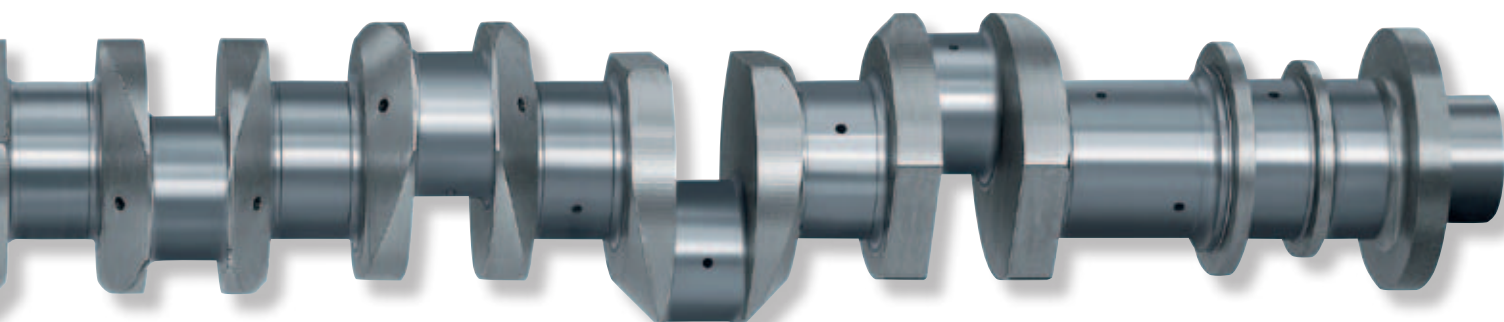
Quality – productivity – flexibility.

- In-process diameter gauging for the highest possible precision and to carry out roundness checks on the machine
- Universal axial and radial alignment of the shaft prior to grinding, to ensure the highest possible component quality and maximum flexibility
- Rigid twin-axis NC steady rests with force transfer into the work table, offering support and maximum stock removal rates



P M 4 3 0
P M 4 6 0



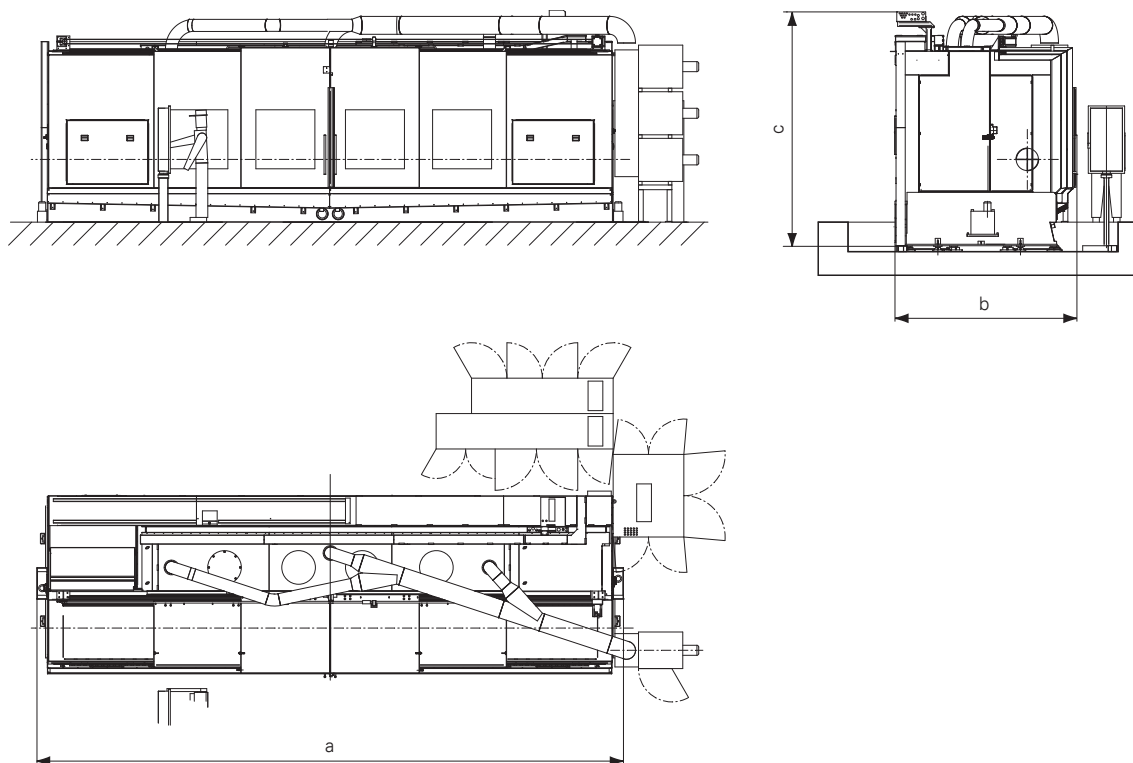


Technical Data.

Capacity		PM 430	PM 460
Workpiece length, max.	mm in	3,000 118	6,800 268
Workpiece weight, max.	kg lb	3,000 6,614	5,000 11,023
Swing diameter, max., with corundum wheel*	mm in	750 29.5	750 29.5
Swing diameter, max., with CBN wheel*	mm in	500 20	– –
Stroke radius, max.*	mm in	175 7	175 7
Grinding center above the bottom edge of machine	approx. mm approx. in	1,470 58	1,470 58
Main bearing diameter, max.	mm in	300 12	300 12
Grinding wheels			
Diameter, corundum wheel*	mm in	1,400 55	1,400 55
Diameter, CBN wheel*	mm in	900 35.5	– –
Max. wheel width			
– corundum	mm in	200 8	200 8
– CBN	mm in	80 3	80 3
Cutting speed, max.			
– corundum wheel	m/s	45	45
– CBN wheel	m/s	125	–
Coolant			emulsion
Drives			
X- and Z-axis		SIEMENS linear motor	
Feed force X / Z	Nm ft-lb	5,190 3,828	5,190 3,828
Rapid-traverse rate X / Z	m/min ipm	25 / 15 984 / 591	25 / 15 984 / 591
Control system			
SIEMENS SINUMERIK 840 D solution line			
Dimensions and weights			
Length a	mm in	7,550 297	9,950 / 12,000 391.5 / 472.5
Width b	mm in	3,100 122	3,100 122
Height c	mm in	4,000 157.5	4,000 157.5
Weight	kg lb	38,500 84,878	41,000 / 50,000 90,390 / 110,231

* It is also necessary to have individual checks, taking account of workpiece geometry and aspects of back rest and oscillation

Floor plan PM 430 / PM 460



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