

Lean Selection shaft

CIRCULAR GRINDING WITH MULTIPLE GRINDING WHEEL



Lean Selection shaft – functional and economical

The Lean Selection shaft is an economical machine concept for grinding flutes and flat surfaces and for diameter machining with multiple grinding wheels. It grinds in combined operations in straight and/or in angled infeed operations.

Work piece geometries

The Lean Selection shaft can be used to grind the following work piece geometries:

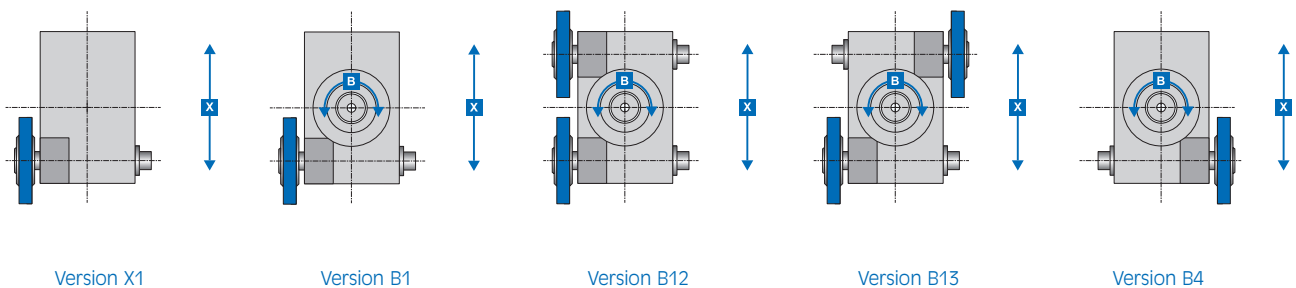
- Diameter
- Flutes
- Tapers
- Shoulders
- Plunges
- Chamfers

Advantages of Lean Selection shaft

- Rough and finish grinding in a single clamping set-up, saving time and increasing accuracy.
- High rate of utilization thanks to CBN abrasive and oil (optionally emulsion) as a coolant.
- Proven CBN grinding technology with cutting speeds of up to 140 m/s and high feed rates, resulting in short cycle times.
- JUNKER 3-point mounting interface for fast changeover and excellent grinding wheel concentricity.
- HF high-power grinding spindle (42 kW drive capacity) is extremely low-maintenance thanks to lifetime lubrication and air seal.
- Ergonomical machine concept with automatic or manual loading from above.
- Sophisticated, high-performance, user-friendly CNC controls.
- The work piece program can be created directly at the controller or at an external programming station.
- High dimensional accuracy due to in-process measurement.



Wheel head versions



Technical specifications

Work piece	Grinding wheel diameter: max. 290 mm Grinding length: max. 500 mm Clamping length: max. 500 mm Work piece weight: max. 15 kg
Workhead	Speed range: 0 – 500 rpm C-axis: Resolution 0.0001° Mounting interface of various clamps: Drivers, clamping chucks
OD grinding spindles	Drive capacity: 42 kW
X-axis	Infeed: Resolution: 0.0001 mm
Z-axis	Feed rate: Resolution: 0.0001 mm
B-axis	Swiveling movement of wheelhead: 210° (180° ± 15°)
Dimensions	L x W x H (without peripherals): 3,340 x 2,815 x 2,120 mm



Straight infeed grinding



Angled infeed grinding