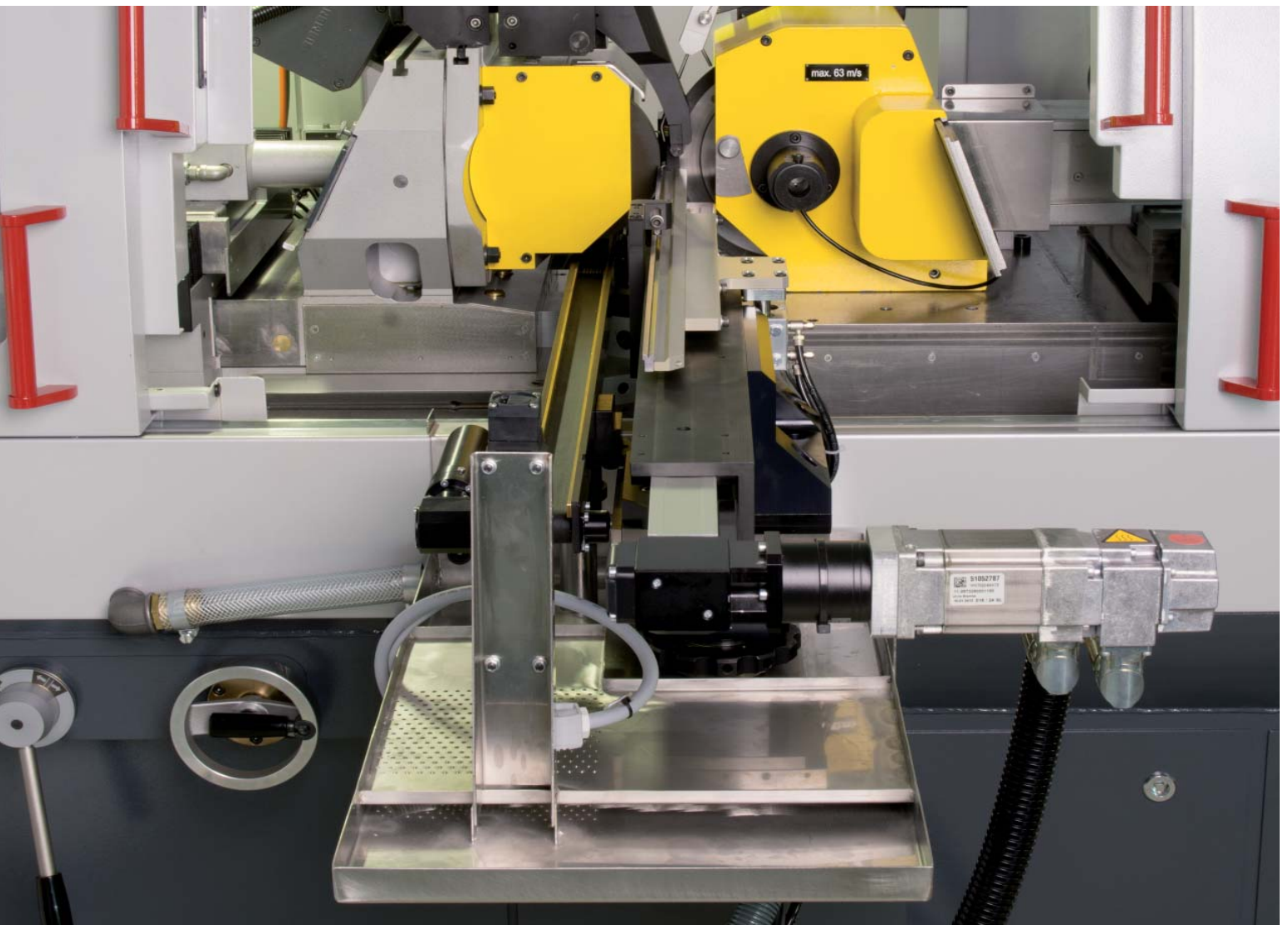


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S W I T Z E R L A N D

Feed unit

Flexible



Semi-automatic workpiece feed unit
for peel and plunge grinding process



Advantages

- The feed unit can be fully automated by connecting a feeder bowl, a cassette or a workpiece-specific loading handling.
- The feed unit can be loaded manually or automatically as needed.
- Short changeover times allow efficient switching between different workpieces.
- Simple and process-oriented programming directly in the grinding program editor.
- Suitable for peel and plunge grinding.
- With the peel grinding method, complete contours (of different diameters and lengths) can be ground in one operation.
- Semi-automatic workpiece loader and flexible stop when plunge grinding.
- Active adjustable axis.
- For simple and complex automation solutions.
- Optionally retrofittable.

Axis values WCS									
	ACT	[mm] TARGET	[mm] Reset	[mm] F	[mm/min] max. P	[V] P	100	[K]	
X1	15.9587	0.0000	0.0000	0	146				
Q1	-14.4938	0.0000	0.0000	0	130				
X2	19.1669	0.0000	0.0000	0	235				
Q2	0.0009	0.0000	0.0000	0	34				
Y	596.5294	0.0000	0.0000	0	1				

Spindle values									
	ACT	[rpm] TARGET	[rpm]	F	[m/sec] max. P	[V] P	100	[K]	
S3	0	0		0	0.0				
S1	0	0		0	0.0				
S2	0	0		0	0.0				

Force measurement during peel grinding

Machining example:



Feed unit when plunge grinding

When plunge grinding the feed unit serves as a feeding axis and according to need can be directly used as a programmable stop. In case of longer cycle times, moving to a loading position during the active grinding process will significantly reduced the cycle time.

Stepped forming punch:

Material: Quenched and tempered steel (surgical steel), hardness ~50 HRC
 Grinding material: CBN
 Method: Peel grinding (complete in 1 operation)
 Option: Feed unit (VE) and concentric attachment
 Total cycle time: 180 s

Feed unit

The feed unit is an NC-controlled, software integrated axis, which can support and control the grinding process. The programmable Y-axis can be loaded outside of the machine and serves as an interface in simple and complex automation solutions.

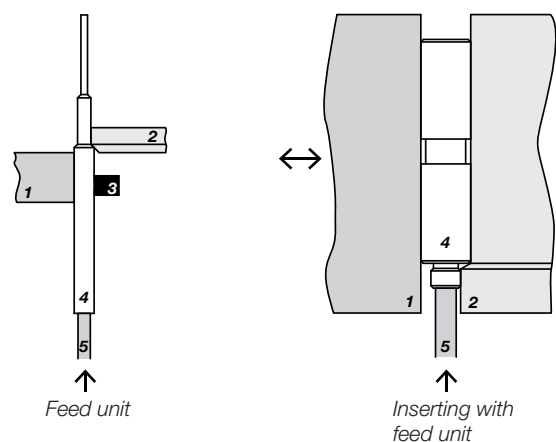
It is suitable for small as well as large series and is perfectly retrofittable.

Feed unit when peel grinding

When peel grinding the feed unit serves as an active and adjustable feeding axis. The resulting forces can be seen on the control panel if necessary.

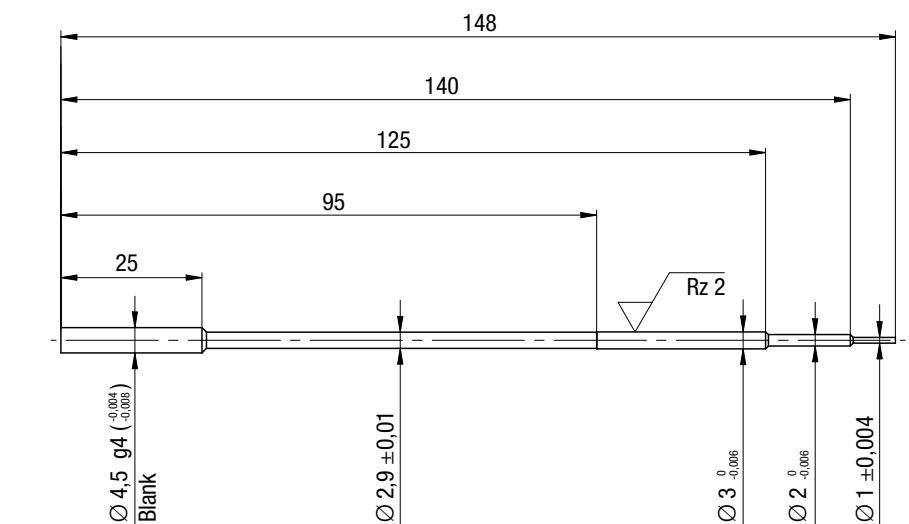
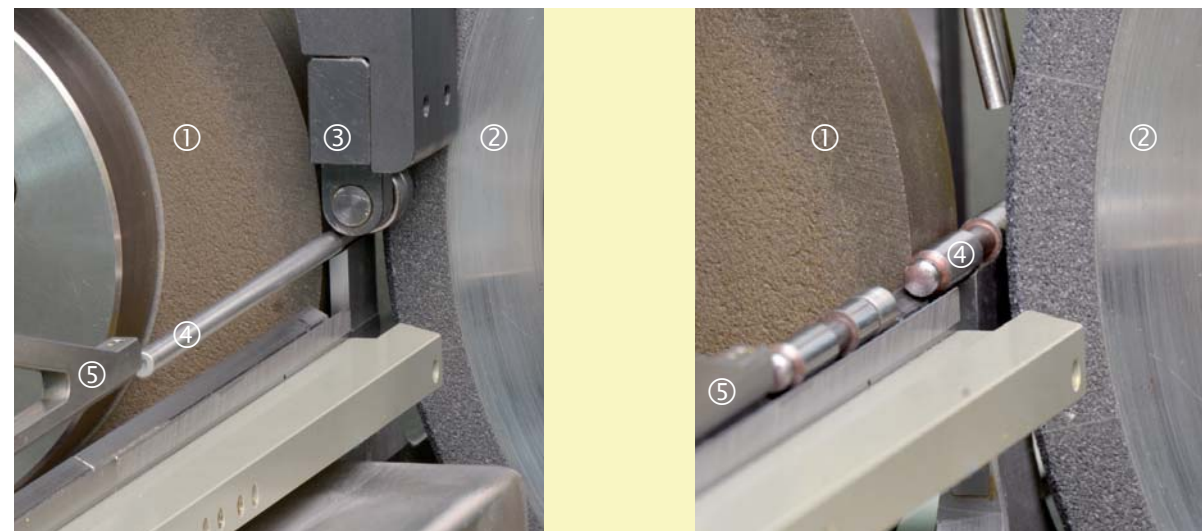
Peel grinding

Plunge grinding



Legend:

- 1 = Control wheel
- 2 = Grinding wheel
- 3 = Concentric attachment
- 4 = Workpiece
- 5 = Feed unit



VE - 7610.2 / Date: 22.10.2013 / Subject to technical modifications



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