



广州市敏嘉制造技术有限公司

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Improve production
we support customized machine tool solution



JIANYE GROUP CO., LTD.

AMK202/203/204 CNC Grinding Machine



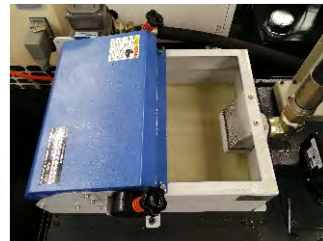
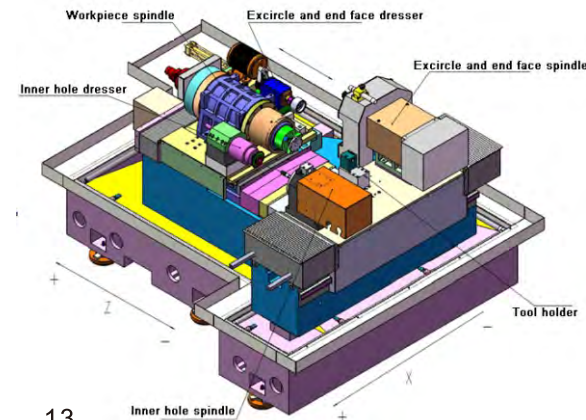
Heidenhain Grating scale close-loop device keep dimensions tolerance 0.005mm



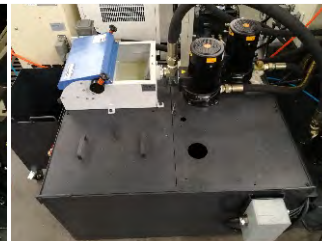
Natural granite bed improve manufacturing accuracy



The machine inside structure



Magnetic separator



High pressure water pump and filter tank



Filter lubrication device



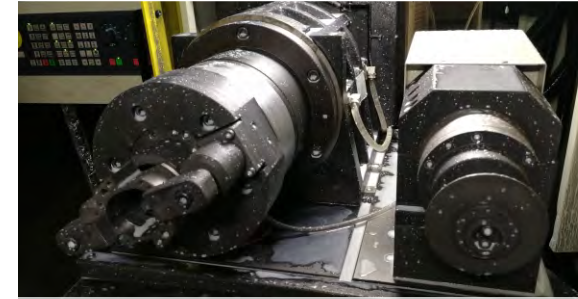
Air and oil pressure gauges



Compressed-air dryer



Oil cooler

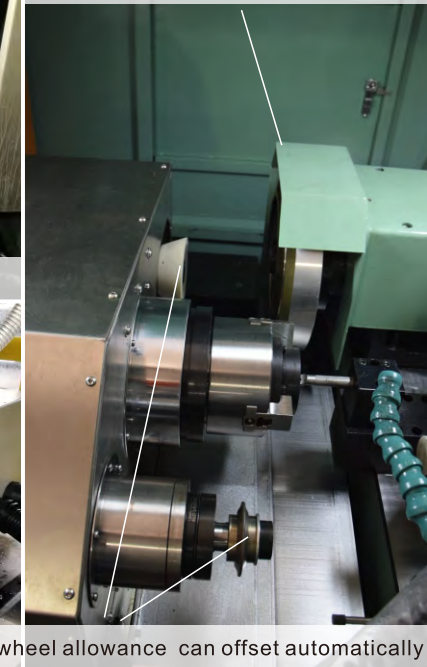


Customized clamping with workpiece



When dresser finish the grinding wheel dressing ,wheel allowance can offset automatically

Excircle and end face grinding wheel



TECHNICAL SPECIFICATION :

Model	AMK204	
Capacity		
Diameter of grinding inner hole	mm	φ10~φ100
Max.grinding inner hole length	mm	150
Diameter of grinding excircle	mm	φ200
Length of grinding excircle	mm	150
Accuracy		
Dimensions tolerance	mm	0.005
Roundness	mm	0.005
Surface roughness	μm	Ra≤0.4
Diamond grinding wheel spindle		
Size of inner hole diamond grinding wheel	um	φ100×φ25×30
Max. speed of diamond grinding wheel	rpm	10000
Spindle		
Speed of workpiece spindle	rpm	0~100
Power of workpiece motor spindle	KW	11
Speed of excircle and end face grinding wheel	rpm	50~3000
Size of excircle grinding wheel	mm	φ350×32×φ127
Max. speed of inner hole grinding wheel	rpm	24000
Travel		
X/Z axis travel	mm	600/300
Other		
Weight	KG	6200
Machine size (LxWxH)	mm	3100x2000x2400



Automatic line solution

SWM1503/1505/1510/1520/1510A

CNC External Thread Grinding Machine



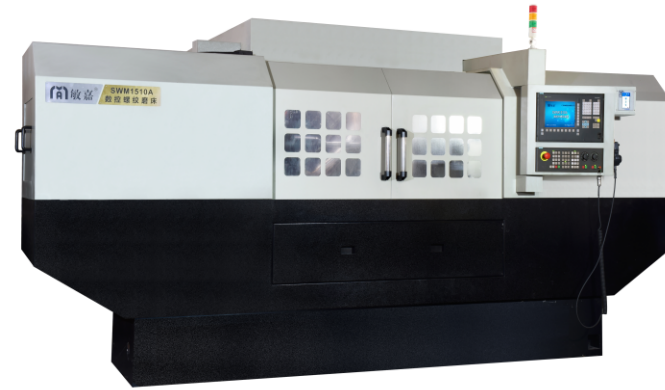
SWM1503



SWM1505



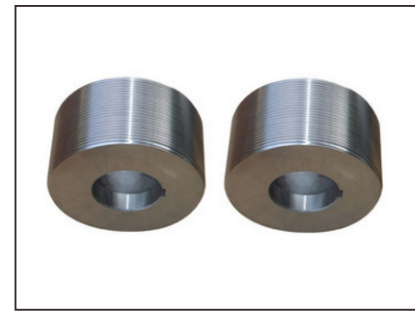
SWM1510



SWM1510A



Ball screw



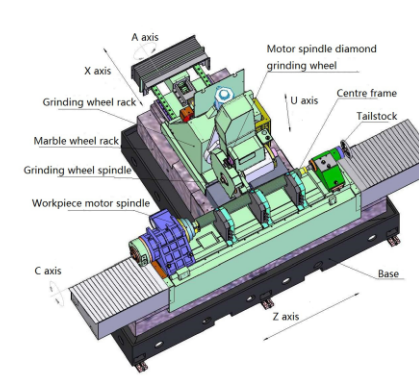
Rolling tool



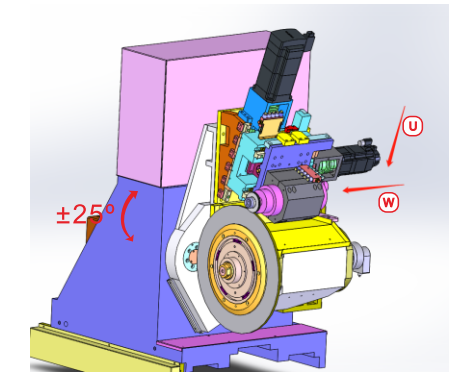
Extruder screw



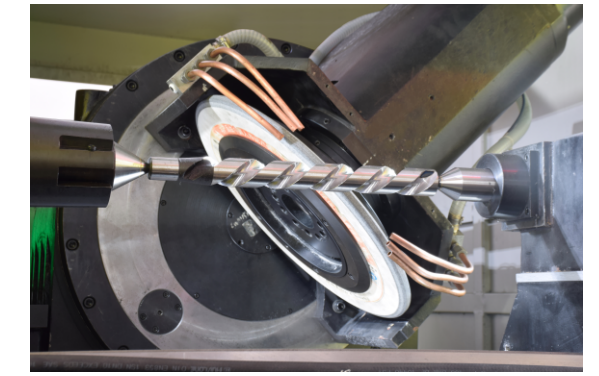
Worm shaft



The machine inside structure



Option: Add U and W axis on cross sliding table



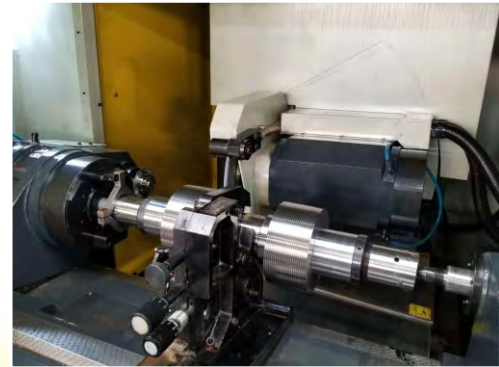
SWM1510A: Grinding wheel lead angle $\pm 90^\circ$ on rotary table

TECHNICAL SPECIFICATION :

Model		SWM1503	SWM1505	SWM1510	SWM1520	SWM1510A
Capacity						
Max.length of grinding thread	mm	300	500	1000	2000	1000
Max.grinding diameter	mm	100	350	350	350	200
Max.distance between center	mm	320	520	1200	2200	1200
Max.workpiece weight	kg	50	50	50	50	50
Max.lead angle		$\pm 20^\circ$	$\pm 25^\circ$	$\pm 25^\circ$	$\pm 25^\circ$	$+20^\circ \sim -160^\circ$
Spindle						
Grinding wheel size(OD*TH*ID)	mm	$\phi 500/10 \sim 25/\phi 305H6$	$\phi 500/10 \sim 25/\phi 305H6$	$\phi 500/10 \sim 25/\phi 305H6$	$\phi 500/10 \sim 25/\phi 305H6$	$\phi 500/25 \sim 50/\phi 200H6$
Grinding wheel spindle speed	min-1	50-3000	50-3000	50-3000	50-3000	50-3000
Grinding wheel motor power	kw	7.5	7.5	7.5	7.5	15
Dressing wheel size(OD*TH*ID)	mm	$\phi 80 \times \phi 25 \times 30$	$\phi 80 \times \phi 25 \times 30$	$\phi 80 \times \phi 25 \times 30$	$\phi 80 \times \phi 25 \times 30$	$\phi 150 \times 30 \times \phi 25$
Dressing wheel Max. spindle speed	min-1	10000	10000	10000	10000	10000
Straight axis						
X/Z axis travel	mm	350/500	350/750	350/1200	350/2250	350/1200
Feed rate	m/min	8	8	8	8	8
Machining precision						
Grinding trapezoid screw	mm	5 levels(accord with std. JB/2886-2008)				
Grinding ball screw	mm	P2 levels(accord with std. GB/T17587.3-1998)				
Tooth surface roughness	μm	Ra0.4	Ra0.4	Ra0.4	Ra0.4	Ra0.4
Other						
Total power	kw	20	20	20	20	20
Machine weight	T	8.5	10.5	12	14	14
Machine size(L/W/H)	mm	3300x3000x220	2900x3400x2800	2800x4100x2600	3400x6200x3800	3500x4700x2500

FEATURES:

- ▶ The machine grinding wheel can finish external thread with V and trapezoid thread type.
- ▶ Turntable set up lead angle A-axis $\pm 25^\circ$ with automatic, in addition, optional lead angle $\pm 90^\circ$ for grinding large angle and pitch thread(SWM1510A).
- ▶ Wearing capacity with automatic compensation (Grinding amount 0.01-0.02mm for one time)
- ▶ Diamond dressing wheel install on cross sliding table, interpolating and dressing accord with U-axis and W-axis to realize, so A-axis don't need back to zero position when grinding wheel dressing, that will improve dressing precision and working effective for machine(OPTION).



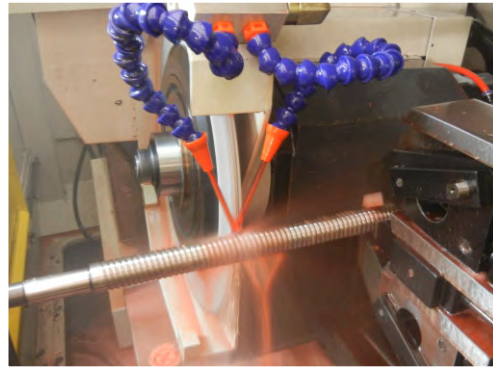
Improve a pair rolling tool precision with grinding on double station support



Correct balance for long shaft on workpiece support



Provide special fixture with customized workpiece



Powerful main spindle for high stock removal rates



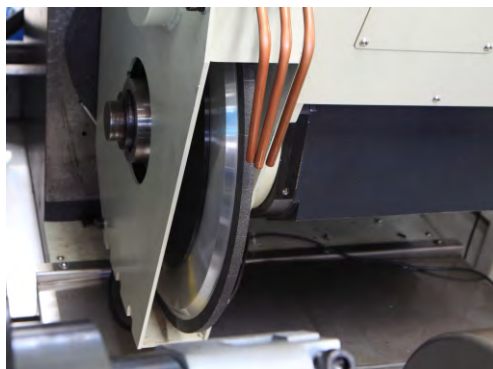
T type natural granite



Digital scales and encoders, supported by a sturdy base and prismatic guide



Diamond dressing wheel



Highly efficient grinding with CBN or ceramic tools specific dressing unit

CONFIGURATION INTRODUCTION:



Magnetic separator



Filter lubrication device



High pressure water pump and filter tank



Oil mist absorber



Air and oil pressure gauges



Compressed-air dryer

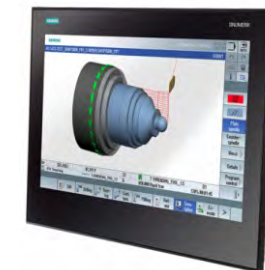


Oil cooler



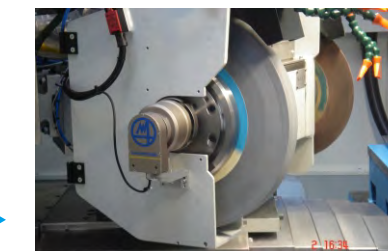
Hydraulic system

CONFIGURATION OPTIONS:



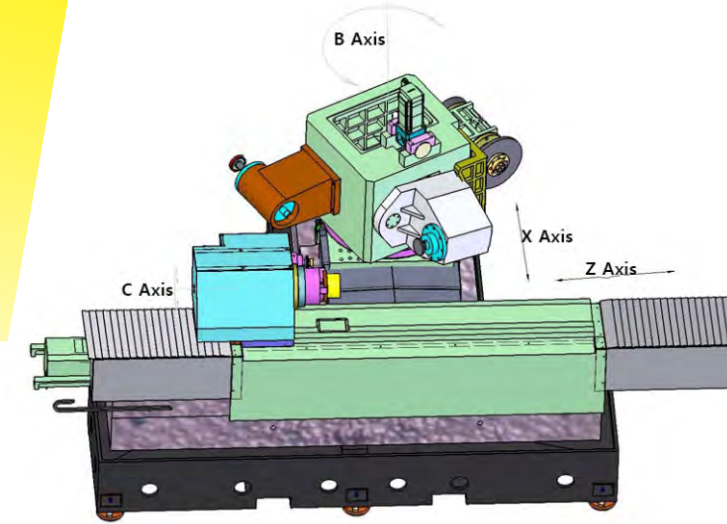
DXF-Reader in Siemens system from CAD/CAM into machining program (G code) automatically

The balancer let grinding wheel adjust balance quickly and reduce vibration



Wireless integrated measuring unit for shaft. This unit automatically swivels into the work area for use and then retracts to a standby position once inspection is complete.

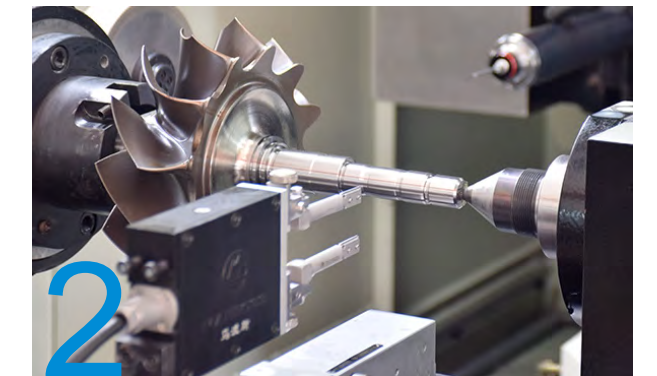
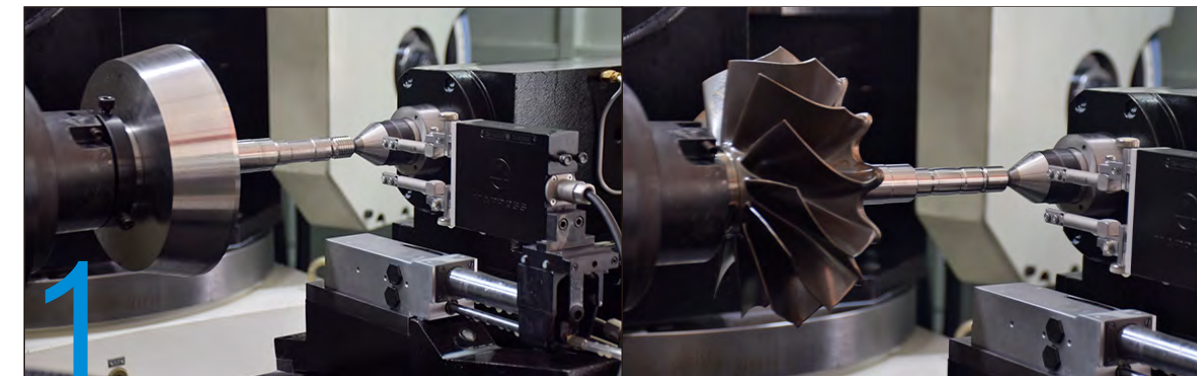
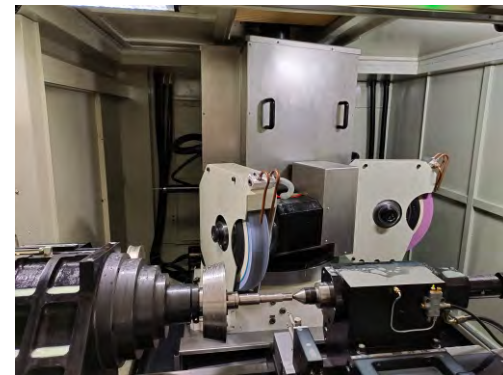
WNM1505 CNC Complex Grinder Center



The machine inside structure

TECHNICAL SPECIFICATION :

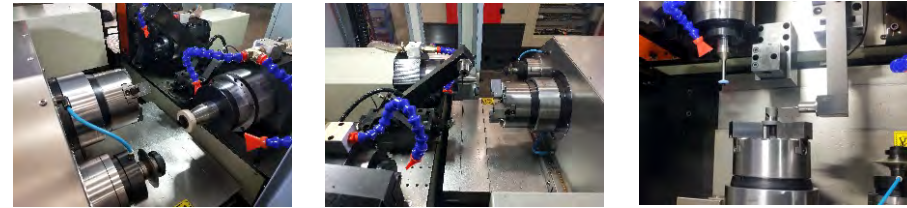
Model	WNM1505	
Capacity		
Max.installation diameter	mm	400
Max. Grinding length	mm	500
Max.Grinding diameter	mm	300
Grinding inner hole diameter	mm	Φ 15-Φ 150
External thread grinding diameter	mm	Φ 10-Φ 300
Max.lead angle		±25°
Travel		
Max.length of worktable travel (Z axis)	mm	800
Max.length of turntable travel (X axis)	mm	450
Rapid feed	m/min	8
Other		
Total power	KW	47.5
Weight	T	15
Machine Size(L×W×H)	mm	3900×3000×2900



1. Measuring cylinder size after grinding
2. Finding ARC surface grinding start point by probe

- ▶ This machine can grind cylindrical ,inner hole ,thread for complex precision workpiece.
- ▶ 4- station hydraulic turntable can change 4 type grinding wheel automatically.

SMK204 CNC Internal Thread Grinding Machine

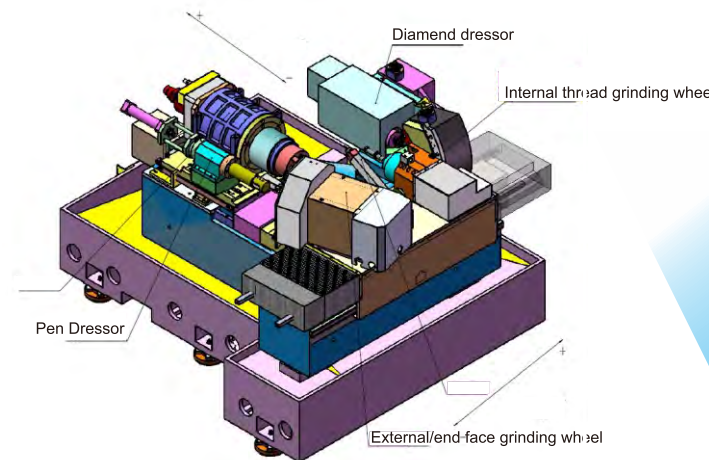


TECHNICAL SPECIFICATION :

Model		SMK203	SMK204
Capacity			(Interpolation dressing)
Max.grinding diameter	mm	150	150
Max.grinding length	mm	150	150
Max.grinding internal thread diameter	mm	φ10-100	φ10-100
Max. lead angle		±25°	±25°
X/Z/W worktable travel	mm	600/300/-	600/300/60
Spindle			
Workpiece spindle speed	RPM	0-100	0-100
Internal thread grinding wheel speed	RPM	500-24000	500-24000
External/end face grinding wheel speed	RPM	50-3000	50-3000
Dressing wheel speed	RPM	50-10000	50-10000
Internal thread grinding wheel diameter	mm	φ8-50	φ8-50
External/end face grinding wheel diameter	mm	φ400	φ400
Dressing wheel inner diameter	mm	φ25	φ25
Accuracy			
Dimension tolerance	mm	0.005	0.005
Surface roughness	μm	Ra≤0.4	Ra≤0.4
Other			
Machine size	mm	3100*2000*2400	3100*2000*2400
Machine weight	Kg	6200	6200



Screw nut



AM850F-6/8/12/16 Multi-spindle Vertical Machine Center



TECHNICAL SPECIFICATION :

Model		AM850F-6	AM850F-8	AM850F-12	AM850F-16	AM520F/16
Capacity						
Worktable size	mm	560×1260	560×1260	560×1260	560×1260	1000×600
Max. loading worktable	kg	800	800	800	800	/
Spindle						
Spindle nose to table distance	mm	125-525	125-525	125-525	125-525	/
Number of spindle	mm	6	8	12	16	16
Spindle mount		ER40	ER40	ER40	ER40	/
Drilling diameter	mm	2-20	2-20	2-20	2-20	/
Power of spindle motor	kw	6x2.2	2x11	4x7.5	11	11
Max.spindle speed	rpm	5000	3500	3500	3500	3500
Spindle arrangement		2x3	2x4	2x3	4x4	/
Travel						
X/Y/Z axis travel	mm	1000/320/400	900/320/400	900/320/400	1000/320/400	200/560/400
X/Y/Z axis rapid feed	m/min	16/16/10	16/16/10	16/16/10	16/16/10	16/16/10
Others						
Weight	kg	5200	5300	5400	5500	6500
Machine size(L×W×H)	mm	3470x2250x2400	3470x2250x2400	3470x2250x2400	3470x2250x2400	1500x3100x2800

AM520F/16 Multi-spindle Vertical Machine Center (exchange table)

