



EDHM16S系列中大孔径数控珩磨机

EDHM16S series medium and large hole CNC honing machine

实用、高效珩磨加工
Practical and efficient
honing processing

- 机床整体架构采用单立柱结构，结构紧凑，确保了机床的高刚性和高稳定性。
- 机床冷却系统为循环冷却，采用双油箱设计，磁分式纸带过滤器两级过滤，并使用油冷机强制冷却。
- 主轴往复和旋转运动采用高性能伺服电机控制，速度可实现同步控制，响应速度快。
- 珩磨砂条涨缩装置为伺服双进给结构，采用定量进给控制方式。
- 机床工作台采用高精度双工位液压回转工作台，单轴双工位模式，工作辅助时间为零。
- 采用欧姆龙高性能运动控制器，运行稳定可靠。
- 集成操作平台，配置TFT彩色液晶触控面板。专为珩磨加工定制的人机界面更具人性化。
- 集中润滑系统间歇供油，延长滑动部件使用寿命。

- The overall structure of the machine tool adopts a single-column structure, and the structure is compact, which ensures the high rigidity and high stability of the machine tool.
- Machine tool cooling cycle cooling system, dual fuel tank design, magnetic tape filter two-stage filtration fraction, and an oil cooler forced cooling.
- The reciprocating and rotating movement of the main shaft is controlled by a high-performance servo motor. The speed can be synchronously controlled and the response speed is fast.
- Honing extension system is in double-feed design, adopts servo feed structure and quantitative feed control.
- The machine table is duplex hydraulic rotary table, single axis duplex position mode, the work auxiliary time is zero.
- The machine is controlled by OMRON high-performance motion controller, stable and reliable operation.
- Integrated platform, with TFT liquid crystal color touch panel. The human-machine interface especially made for honing shows humanistic feature.
- Intermittent oil lubrication system, to extend the service life of the sliding member.

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规格参数

Specifications parameters

项目Item	EDHM16S	EDHM25S
珩孔直径范围 Honing diameter	Φ30mm~Φ160mm	Φ100mm~Φ250mm
主轴最大往复行程 Max. spindle reciprocating stroke	600mm	1200mm
最大珩孔深度 Max. honing depth	320mm	700mm
主轴旋转方式 Spindle rotation mode	伺服电机，配减速机 Servo motor, with reducer	
主轴转速范围 Range of spindle speed	10-200r/min	
主轴往复形式 Spindle reciprocation mode	伺服电机往复，滚珠丝杠线轨传动 Servo motor, ball screw, Line rail	
主轴往复速度 Spindle reciprocating speed	2.5-30m/min	
珩磨头进给方式 Honing head feed mode	伺服电机丝杠传动/液压比例控制定压双进给 Coarse: Servo motor, Fine: Hydraulic proportional constant pressure double feed	
工作台驱动方式Table driver mode	液压转台/自动线 Hydraulic rotary table/Autoline	
工作台工位数 Number of stations in table	2	
工作台尺寸Dimension of table	Φ650mm	600x1100mm
加工精度honing accuracy	圆柱度Cylindricity: ≤0.01mm, 粗糙度Roughness: Ra0.2 μm	
电气控制系统 CNC system	欧姆龙NX1P2控制系统、EtherCAT总线技术 OMRON NX1P2, EtherCAT BUS Technology	
液压系统Hydraulic unit	2.2KW变量泵，配风冷机 2.2 KW variable pump, air cooler	
冷却系统Cooling unit	分离水箱、磁辊纸带两级过滤恒温冷却系统、配油冷机 Separate tank, magnetic drum 2-stage paper filter, constant temperature cooling system, with oil cooler	
测量系统Measuring system	日本东京量仪V2，在线测量 V2 On-line measuring system from Tokyo, Japan	
珩磨头及珩磨连杆 Honing head and connection rod	双进给珩磨头，珩磨砂条涨缩压力分级可控 Double-feed honing head, controllable extension/retraction pressure of honing sticks in different stages	
珩磨夹具 Honing fixture	下压式油缸，可选配移动式胶套包容夹具 Down-pressing cylinder, optional movable rubber sleeve containment fixture	
机床颜色Machine color	机座：深灰色、其他：白色 Base: dark grey; other: white	
机床总功率 Total power	30KVA	40KVA
机床净重 Net weight	6000KG	8000KG
机床外形（长×宽×高） Overall dimensions (L×W×H)	1850×2285×4100 mm	3120×3615×4810