

TECHNICAL DATA:

Workpiece diameter max.	50	mm
For automatic loading max.	M10	mm
Grinding length max.	230	mm
Clamping length max.	500	mm
Lead angle	+/- 7	°
Wheel diameter	200 – 250	mm
Wheel width max.	20	mm
Wheel drive	2	kW
Cutting speed max.	45	m/s
Workpiece speed max.	1000	1/min
Relief frequency max.	5	Hz

(technical changes reserved)

PRODUCT INFORMATION

As the smallest all-purpose SMS thread grinding machine, the type **RAG** is used for precision grinding all types of external threads of small dimensions. These can include small threading tools such as cutting taps, forming taps and thread gauges. The stable basic structure of the machine enables high productivity and precision (machine basis: Reishauer thread grinding machine type RAG).

The machine is equipped with the latest drive and control technology (digital servo drives: Bosch-Rexroth, precision length measurement systems: Heidenhain). Thanks to the workpiece-specific user interface by SMS (HMI), the CNC control system (Bosch Rexroth MTX) can easily be programmed by the operator in the dialogue system and ensures short setup times. Equipped with modern CNC dressing technology, the machine is highly flexible and can grind all types of threads - also with special profiles.

For series production, the machine can be equipped with an optional automatic loading system - consisting of an integrated robot (Fanuc) and a pallet station or magazine installation for Reishauer cassettes. The machine is also available as a 3-axis version with a table-mounted dressing unit.

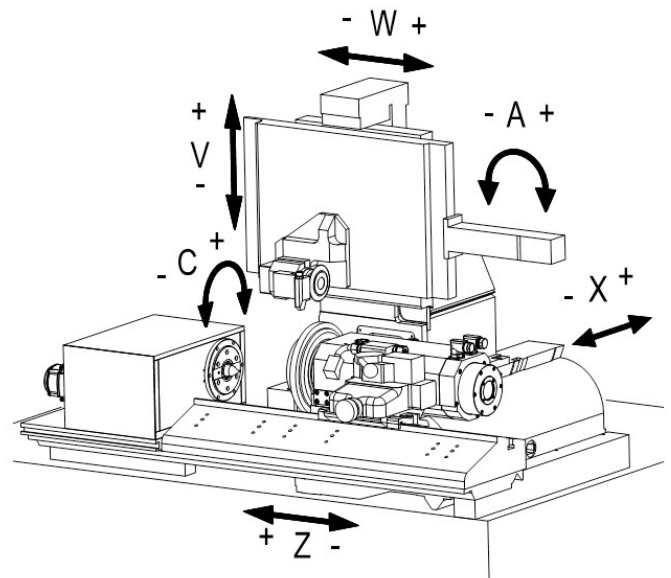
For dressing/profiling single-ribbed as well as multi-ribbed grinding wheel profiles, a variety of dressing units (for diamond form rolls as well as diamond profile rolls) are available.

Available options:

- Various dressing units
- Automatic loading system (FANUC)
- Motor spindle with enhanced power

The machine can be equipped with max. 6 CNC axes:

Workpiece drive	(C-axis)
Workpiece slide	(Z-axis)
Grinding support	(X-axis)
Dressing axis radial	(V-axis)
Dressing axis axial (optional)	(W-axis)
Helix angle (optional)	(A-axis)



Machining example: Forming tap (ISO) M1,2

Lead p:	0,25 mm
Thread length:	4,5 mm
Chamfer angle:	8,5°
Dressing:	CNC roll
Cycle time:	2,1 min.

