

Drawing
Peeling
Straightening
Chamfering
Grinding
Handling

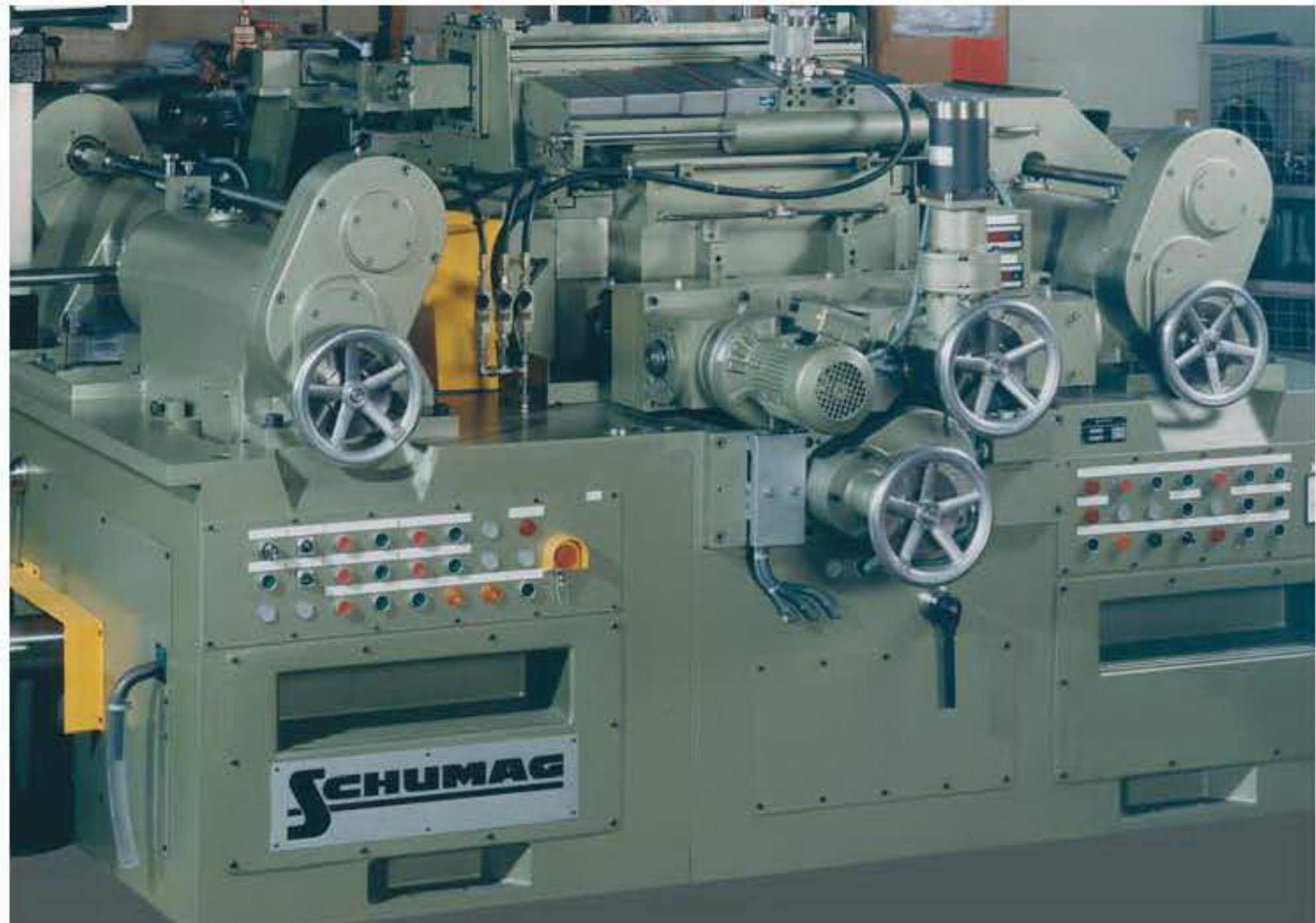
Grinding and polishing machine

■ Grinding ■



SCHUMAG

The Schleipo machines make it possible to produce ground and polished round bars with optimum accuracy and a high performance in one run. The grinding wheels are adjusted using the patented and successful principle of slides which are interconnected via threaded spindles. This configuration ensures optimum absorption of the grinding forces and high machine rigidity in combination with optimum dynamic behaviour, even when subjected to extreme loads.



Grinding and polishing machine size II

Grinding

Grinding and polishing machine Type Schleipo

This type of machine is used in sizes I to III for centerless grinding of turned or drawn round steel bars up to a ground bar diameter (depending on the type size) of 120 mm.

The feed and rotation movement of the bars is carried out by two transport and polisher wheels located upstream and downstream of the grinding wheels.

Grinding is carried out by two grinding wheels which remove the material. Both grinding wheels are adjusted centrally and simultaneously. The machine centre point is also the centre point for grinding for all dimensions. The different abrasion rates of the two grinding wheels are compensated by adjusting an intermediate slide.

The distinguishing characteristics of the Schleipo are:

- optimum grinding performance
- polished surfaces
- minimal diameter tolerance
- minimal ovality

Regulating wheel grinding machine Type RSM

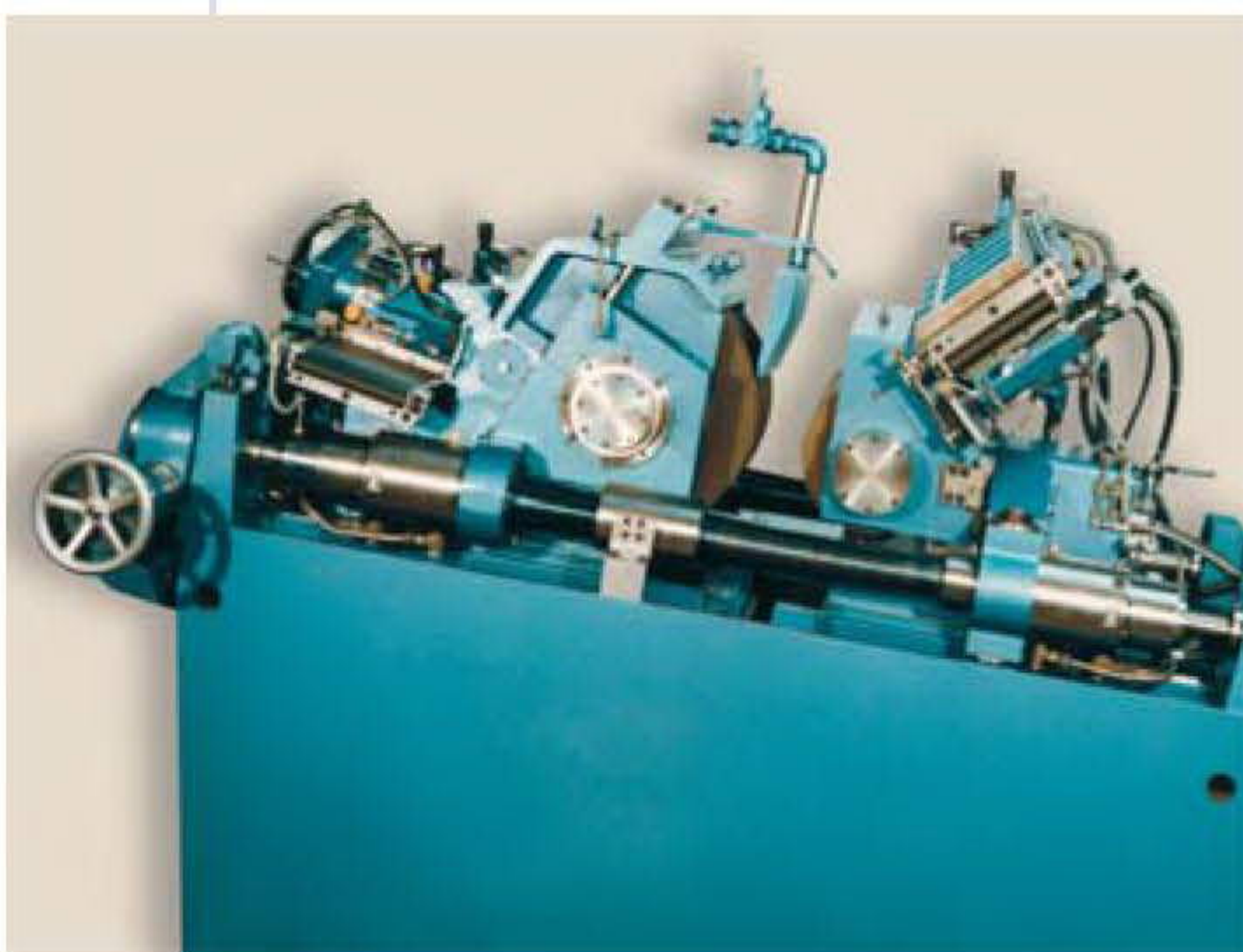
The RSM machine is suited to rough-grinding and finish-grinding round bars and short lengths from steel and non-ferrous metals. The opening range between the grinding and regulating wheels can be varied from 2 to 200 mm.

The high rigidity of this machine is the result of both the proven principle of wheel adjustment using drawing spindles and the double-sided spindle suspension.

The excellent dynamic behavior is specifically due to the compact dimensions of the grinding and regulating wheel slide and the fact that the main drive motor is isolated from the machine board. The distinguishing characteristics of the RSM are:

- high grinding performance
- minimal diameter tolerance
- good roundness
- grinding also possible for short bar lengths

RSM 60

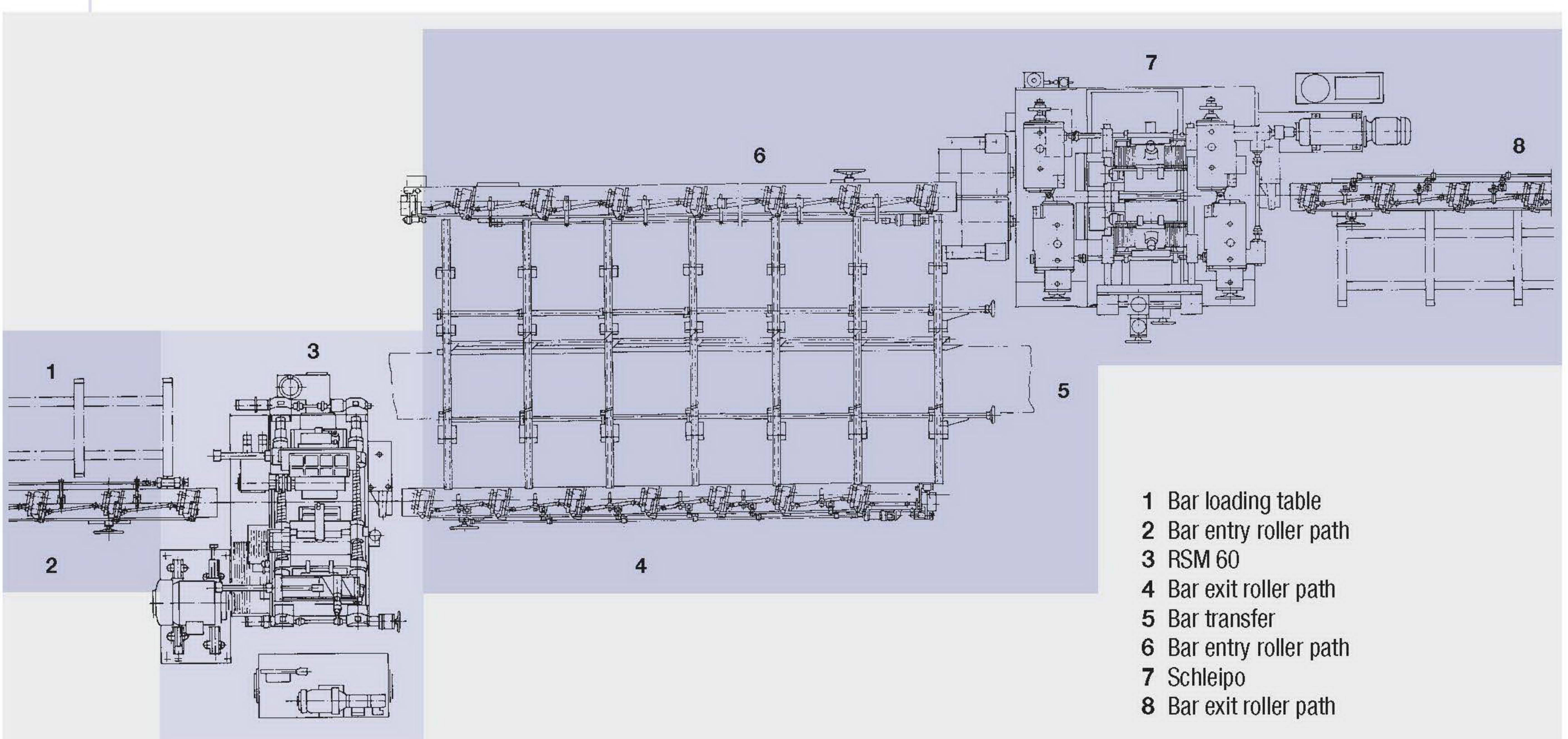


SCHLEIPO I

SCHLEIPO II

SCHLEIPO III

RSM



Technical data

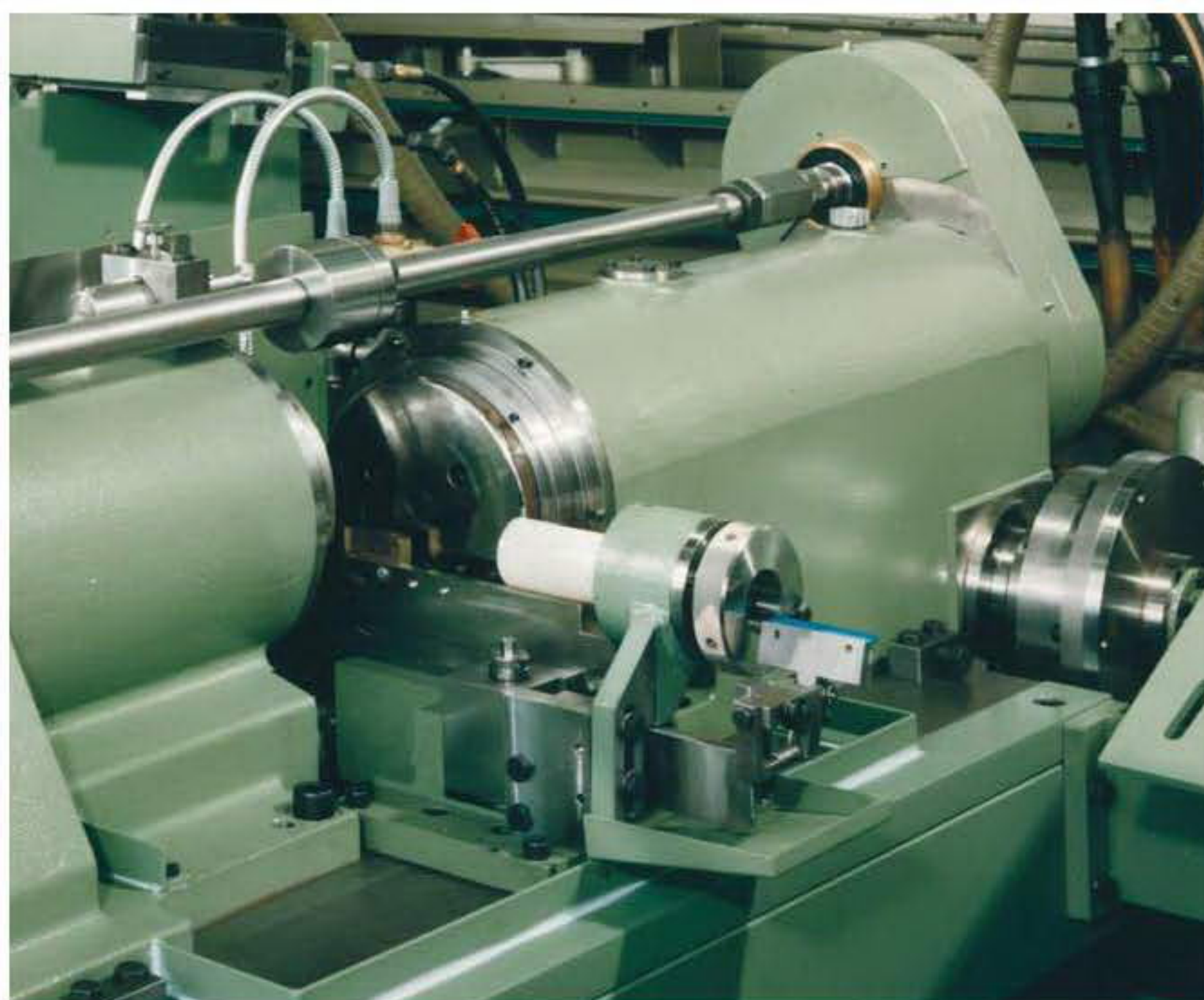
Centerless grinding and polishing machine Schleipo				
		Size I	Size II	Size III
Working range	Ø mm	1* – 25	8 – 35	15 – 120
Minimum bar length	mm	1300	1800	1940
Maximum bar length	mm	as requested	as requested	as requested
Grinding wheels	number	2	2	2
Peripheral velocity	sec/m	35/45/60	35/45/60	35/45/60
Driving power per grinding wheel	kW	22 (30)	37 (45)	75
Dimensions, max.: Outer diameter	mm	400	500	600
Width	mm	200	300	300
Bore	mm	203.2	254	305
Transport and polisher unit				
Feed speed (depends on the diameter)	m/min	2 – 30	1 – 30	0.5 – 25
Max. polishing force	N	10,000	30,000	30,000
Housing length	cm	218	310	310
Housing width	cm	250	210	320
Weight	t approx.	6.9	11.0	16.5

* < 2 mm with special equipment

Centerless grinding machine RSM 60		
Opening between new wheels	mm	2 – 200
Minimum bar length	mm	depends on feed
Maximum bar length	mm	depends on feed
Grinding wheel		
Peripheral velocity	sec/m	35/45/60
Grinding wheel driving power	kW	50 – 110
Dimensions		
max.: Outer diameter	mm	600
Width	mm	400
Bore	mm	254
Adjustment range without quick-action opener	mm	200
Quick-action opener	mm	60
Regulating wheel		
Max. diameter	mm	350
Speed	rpm	15 – 300
Inclination	degrees	+2/–10
Swivel range	mm	±1
Adjustment range without quick-action opener	mm	150
Quick-action opener	mm	0 – 60
Axial adjustment range	mm	+25/–10
Height adjustment of the support rail	mm	160
Housing length	cm	229
Housing width	cm	110
Weight	t approx.	9.0

Performance and quality specifications are not binding characteristics and strongly depend on the type, quality and dimensions of the raw materials used, the state of maintenance of the equipment etc. All specifications are in accordance with the technical state of the art at the time when they were submitted for printing. Technical modifications and errors are reserved.

Schleipo II polisher



Details/options

- Customized unscrambling and transport units for bars
- Motorized slide adjustment for centre compensation (only Schleipo)
- Automatic grinding process monitoring and control by size control
- Motorized adjustment of the dressing diamonds
- Controlled grinding wheel drive motors for constant peripheral velocity
- Coolant cleaning system and refrigerators
- Regulating wheel drive by controlled electric motor
- Automatic grinding wheel spindle balancing (only on RSM)



Unscrambler for 1 mm and up
Schleipo I



Infeed chute Schleipo II



Roller path for bars of diameter up to
150 mm

SCHLEIPO

The two grinding wheels are mounted in separate slides and adjusted centrally by means of two threaded spindles. To compensate the different grinding wheel abrasion rates, the grinding wheels are mounted on an adjustable intermediate slide.

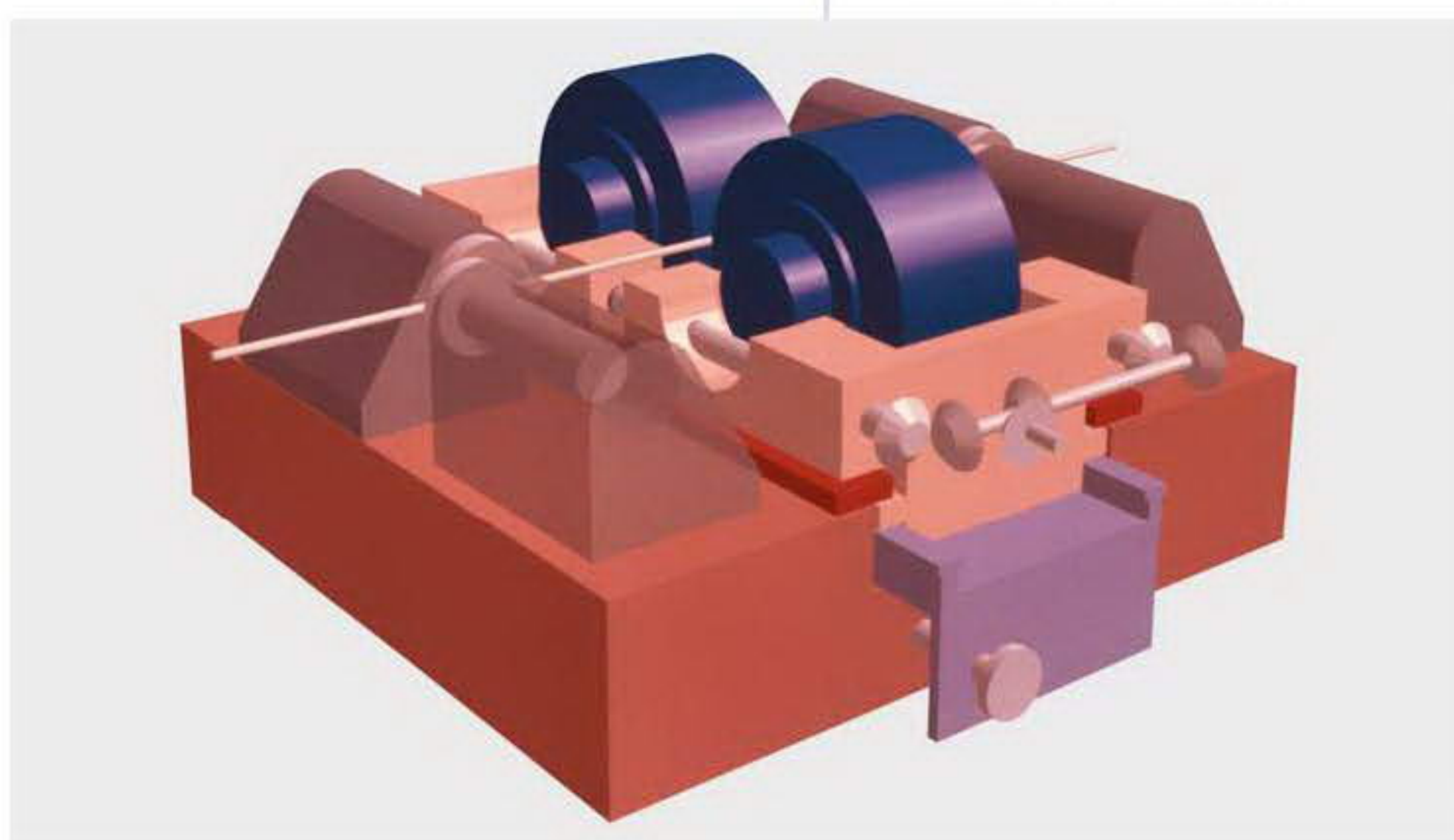
RSM

The grinding and regulating wheel slides are interconnected by means of two individual threaded spindles each. The grinding and regulating wheels are adjusted by means of the two corresponding threaded spindles.

In both machine types, the holders for the grinding work guides are attached directly to the machine body, so that the grinding process is not affected by vibrations of the work guides.

Parts of the configuration listed are optional.

Computer graphic with a representation of the drawing spindles to absorb the grinding forces and adjust the carriages.





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