

Gleason Pfauter P1200G Profile Grinding Machine Gleason Pfauter P1200G 成型磨研磨機

技術規格表 (Technical Specifications)

Descriptions (中文)	Descriptions (English)	Data
可研磨外徑	Max. Workpiece Outer Diameter	1,200mm
可研磨最大齒深	Max. Tooth Depth	80mm
旋轉檯面中心到砂輪中心最小/最大距離	Min./Max. Distance between Table Center and Grinding Wheel Center	100/870mm
砂輪上下最大行程 (標準)	Max. Vertical Stroke of Grinding Wheel (Standard)	700mm
砂輪上下最大行程 (選配)	Max. Vertical Stroke of Grinding Wheel (Optional)	1,000mm / 1,300mm
砂輪離檯面最低高度	Min. Height of Grinding Wheel above Table	470mm
Y軸最小/最大行程(移刀軸)	Min./Max. Stroke of Y-axis (Shift Axis)	+50/-250mm
砂輪最大外徑	Max. Grinding Wheel Outer Diameter	400mm
砂輪最小/最大寬度	Min./Max. Grinding Wheel Width	32/80mm
砂輪可修整的最小外徑	Min. Dressable Grinding Wheel Outer Diameter	175mm
砂輪主軸外徑	Grinding Spindle Diameter	80mm
砂輪刀座(A軸)旋轉範圍	Swivel Range of Grinding Wheel Head (A-axis)	+/-45°
旋轉檯面外徑	Rotary Table Outer Diameter	800mm
旋轉檯面分度渦輪外徑	Diameter of Table Indexing Worm Wheel	630mm
旋轉檯面中心孔直徑	Table Bore Diameter	180mm
旋轉檯面中心孔深度	Table Bore Depth	875mm
旋轉檯面最大載重	Max. Load on Rotary Table	10,000kg
機台淨重 (含700mm砂輪行程主樑)	Net Weight (with 700mm Stroke Column)	25,000kg
機台淨重 (含1,000mm砂輪行程主樑)	Net Weight (with 1,000mm Stroke Column)	25,500kg
機台淨重 (含1,300mm砂輪行程主樑)	Net Weight (with 1,300mm Stroke Column)	26,000kg

機台現況 (Machine status)

1. 經目視檢查，機器外觀鈑金、各工作軸向、液壓系統、線上量測系統、冷卻系統及過濾設備等，均未發現明顯破裂、變形或損壞跡象。
2. 機器可正常開機，經確認電源供應無異常；但由於各軸向參數及程式資料已流失，目前無法進一步確認各軸向及機器整體動作是否正常。
3. 開機後，螢幕上所顯示的各軸向位置、座標及加工程式等相關資料均顯示為「問號」。更換 NCU 電池及 UPS 電池後，狀況仍未改善。
4. 開機後於診斷頁面中出現大量錯誤訊息，包括 A1 軸編碼器異常、輸入電壓錯誤、控制模組異常、交叉誤差補償異常等。
5. 依客戶說明，手輪目前已損壞，需更換新品；雷射印表機亦可能存在故障，後續需進一步檢查確認。
6. 液壓油、切削油、冷卻液及潤滑油等各類油品及液體，因存放及使用時間已久，建議全部更換新品。
7. 空壓系統之風管需進一步檢查，確認是否有老化、龜裂或破損情形，必要時需進行更換。

1. Based on the visual inspection, no obvious signs of cracking, deformation, or damage were found on the machine enclosure, working axes, hydraulic system, in-process measuring system, cooling system, filtration unit, or other visible components.
2. The machine can be powered on, and the power supply has been confirmed to be normal. However, the axis parameters and program data have been lost, so it is currently not possible to verify whether the individual axes and overall machine movements are functioning properly.
3. After power-up, the axis positions, coordinates, machining programs, and other related data displayed on the screen all appear as question marks ("?"). The NCU battery and UPS battery were replaced, but the condition remained unchanged.
4. After power-up, a large number of error messages appear on the diagnostic page, including A1-axis encoder errors, input voltage errors, control module errors, cross-error compensation errors, and other related alarms.
5. According to the customer, the handwheel is damaged and needs to be replaced with a new one. The laser printer may also be defective and requires further inspection and confirmation.
6. The hydraulic oil, cutting oil, coolant, lubricating oil, and other fluids have been stored or used for an extended period and should be replaced with new fluids.
7. The pneumatic system hoses/pipes should be inspected for aging, cracks, or damage. Replacement will be required if any deterioration or leakage is found.

標準配備 Standard Equipment

Descriptions (中文)	Descriptions (English)
最新西門子CNC控制器840D (5個CNC控制軸及一個工作軸) 19寸平面操作面板 / 12.1寸液晶平面彩色螢幕	Siemens CNC Control 840D (5 CNC axes + 1 workpiece spindle) 19" Flat Operator Panel / 12.1" LCD Color Display"
軸向與編碼器 所有軸向及工作軸都由數位傳輸並含絕對式encoder(開放式之工作軸及刀軸除外)。 軸向名稱：X - 徑向軸、Y - 移刀軸、Z - 砂輪垂直軸向、A - 砂輪座旋轉角度軸、S - 刀具軸、C - 工作台。	Axis configuration and encoders Digital drives with absolute encoders for all axes and workpiece spindles (except for open workpiece spindles and tool spindles). Axis names: X - Radial axis, Y - Shift axis, Z - Vertical axis of grinding wheel, A - Swivel range axis of wheel head, S - Tool spindle, C - Rotary table.
程式語言編輯 對話式操作界面導引操作者輸入相關數據及參數管理並整合自動化應用加工,可依標準或特別要求設定加工點。	Programming and dialogue interface Dialogue-driven user interface guides the operator to input relevant data and parameter management, integrating automated applications; machining points can be set according to standard or special requirements.
緊急退裝置 (異常時自動啟動)	Emergency Retraction Device
增量式量測系統	Incremental Measuring System
電子手輪及12個標準鍵	Electronic Handwheel & 12 Standard Keys
砂輪軸頭座 可加工直齒及螺旋齒。內含無限可變頻式三向交流馬達及液體散熱流道/馬力24KW 砂輪刀軸轉速1,200~8,000 min-1 (rpm) 法蘭孔徑127mm 切線方向移刀位置由NC軸控制 自動平衡器	Grinding Wheel Head Suitable for spur and helical gears. Features an infinitely variable-frequency 3-phase AC motor with liquid cooling channels / Power: 24 kW Grinding spindle speed: 1,200 ~ 8,000 rpm Flange bore: 127 mm Tangential shifting position controlled by NC axis Automatic balancer
砂輪軸馬達負載顯示控制	Grinding spindle motor load display and control
砂輪頭座旋轉位置於工作時自動由油壓夾持固定工作位置, 夾持及非夾持之最大誤差值只有0.001mm	The swivel position of the grinding head is automatically clamped and fixed hydraulically during operation; the maximum deviation between clamped and unclamped states is only 0.001 mm.
工作台C軸 獨立式伺服馬達 單渦線雙渦桿渦輪傳動, 此項特殊設計可自動消除背隙。	Rotary Table C-axis Independent servo motor Dual-worm drive with single worm wheel; this special design automatically eliminates backlash.

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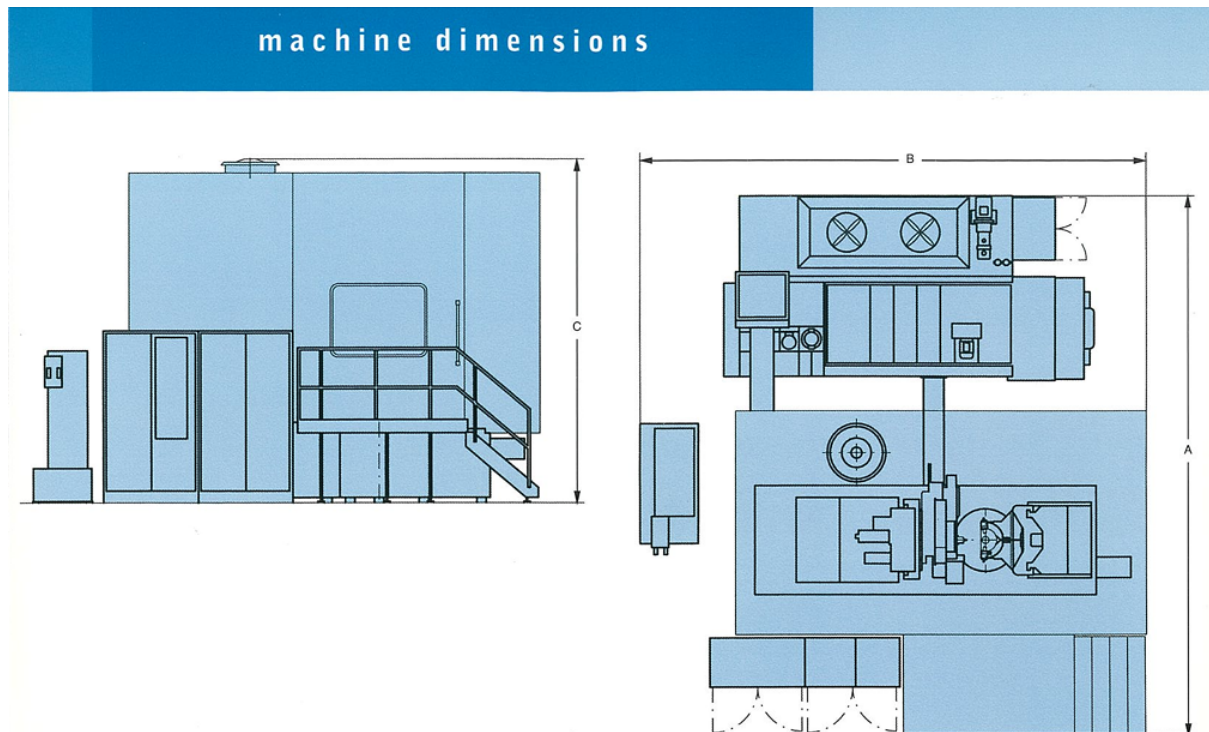
靜液壓軸承系統、重型工件加工時，液壓自動補償。 轉速10 min-1	Hydrostatic bearing system with automatic hydraulic compensation during heavy workpiece machining. Table speed: 10 rpm
滑軌 由伺服馬達驅動 研磨頭座上下移動使用高精度滾珠螺桿配合滾珠螺帽最快及瞬間移動速度6,000mm/min 徑向軸由靜液壓軸承進給。 最快及瞬間移動速度3,000mm/min	Guideways Driven by servo motors Vertical movement of the grinding head uses a high-precision ball screw with a ball nut; maximum and rapid traverse speed is 6,000 mm/min. The radial axis is fed via hydrostatic bearings. Maximum and rapid traverse speed is 3,000 mm/min.
尾座含工件支撐架由三件可調式銅導塊組成範圍為110-250mm 尾座垂直行程 900mm 尾座最低位置 780mm 尾座最高位置 1,680mm	Tailstock with workpiece steady rest consisting of three adjustable copper pads, with a range of 110–250 mm. Tailstock vertical stroke: 900 mm Minimum tailstock position: 780 mm Maximum tailstock position: 1,680 mm
全覆式工作區 內含負壓及防燃保護裝置、安全保護閘門,大口徑300mm通風管接往油煙分離器。	Fully enclosed work area Includes negative pressure and fire protection devices, safety interlocking doors, and a large 300 mm diameter ventilation duct connecting to an oil mist separator.
操作員工作台	Operator's station / console
潤滑及油壓 落地式油槽(約400公升容量)用於潤滑及油壓內含輸油幫浦供應循環式或油浸式驅動件並自動潤滑全部滑軌。免油脂潤滑主軸培林、免保養。自動偵測濾心污染開關控制器。	Lubrication and hydraulics Floor-standing hydraulic/lubrication tank (approx. 400L capacity) used for lubrication and hydraulics, including an oil pump to supply circulating or oil-submerged drives and automatically lubricate all guideways. Maintenance-free spindle bearings with grease-free lubrication. Automatic filter clogging switch controller.
冷卻切削及潤滑設備 兩組電控式離心式幫浦，衡量流量150公升/min一只，3,000公升容量油槽。內含兩組流量控制器。	Coolant and lubrication equipment Two electronically controlled centrifugal pumps, each with a rated flow rate of 150 L/min; 3,000-liter capacity oil tank. Includes two flow controllers.
切削液過濾裝置 HOFFMANN 品牌過濾器，免用濾紙，用於加工鐵料過濾使用。若欲加工鑄鐵材料，需另註明並需另付費用加裝特殊器材。	HOFFMANN brand filter, paperless, used for filtering ferrous materials during machining. If machining cast iron materials, it must be specified separately and requires an additional fee to install special equipment.

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HOFFMANN品牌冷凍機 用於循環油及潤滑油、切削油及刀軸之冷卻。	HOFFMANN chiller system Used for cooling circulating oil, lubricating oil, cutting oil, and the tool spindle.
電控設備 依據IEC 204/1+2, EN 60204 part 1/(11月 1998) 及 DIN / VDE 0113標準, 電機整合PLC控制。控制面板設於電器箱的上方,可由工作平台上直接接觸。 機台線路： 主電源 400V 三向交流電源50頻；電控電源24V直流；電磁電源 24V直流；總功率80KVA；更改電壓及電頻率需另付費。	Electrical equipment According to IEC 204/1+2, EN 60204 part 1 (November 1998), and DIN / VDE 0113 standards, electrical integration with PLC control. The control panel is located above the electrical cabinet and can be directly accessed from the work platform. Machine wiring: Main power supply 400V 3-phase AC, 50 Hz frequency; Control power supply 24V DC; Electromagnetic power supply 24V DC; Total power 80 KVA. Changing the voltage and frequency requires an additional fee.
電控室冷氣機 用於控制電器箱內溫度。	Electrical cabinet air conditioner Used to control the temperature inside the electrical cabinet.
自動分割分次研磨設定： 自動建議客戶使用者單邊或雙邊研磨量供參考（此系統用於齒型）。	Automatic indexing and multi-pass grinding settings: Automatically suggests single-sided or double-sided grinding stock to the user for reference (this system is used for gear profiles).
齒輪量測：用於內外圓柱齒輪，並含齒輪量測後之品質，由DIN或AGMA表示。量測內容：齒形、導程、節距及外徑偏擺。	Gear measurement: Used for internal and external cylindrical gears, including the gear quality grade after measurement, expressed by DIN or AGMA. Measurement content: Gear profile, Lead, Pitch and radial runout.
雷射印表機	Printer

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機台尺寸 Machine Dimensions

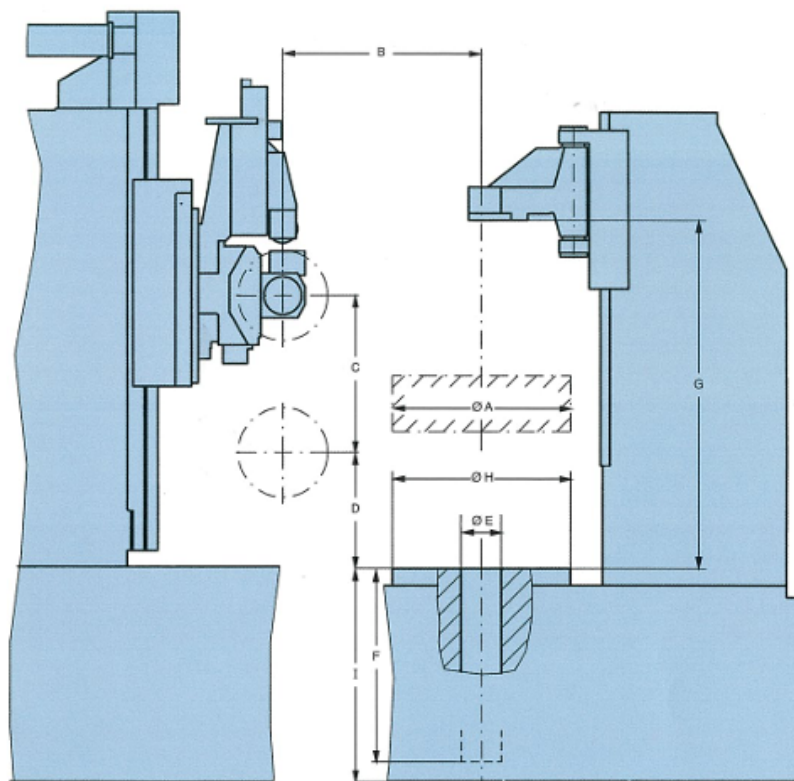


mm A: 7100
mm B: 8000
mm C: 4650

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工作區域尺寸 Work Area Dimensions

work area dimensions



Work area dimensions	P 800 G	P 1000 G	P 1200 G	P 1600 G	P 2000 G*	P 2400 G*	P 2800 G*	P 3200 G*	P 4000 G*	P 5000 G*	P 6000 G*
Nominal workpiece diameter external gear mm A	800	1000	1200 (1480)	1600	2000	2400	2800	3200	4000	5000	6000
Min./max. center distance mm B	100/700	100/800	100/900	100/1100	100/1200	300/1500	600/1700	600/1900	600/2300	600/2800	600/3300
Maximum axial slide travel:											
– Standard mm C						700					
– Optional mm C						1000					
– Optional mm C						1300					
– Optional mm C						1600					
Lowest grinding wheel position over table mm D						450					
Table bore diameter mm E	245	245	245	300	500	610	880	880	880	880	880
Depth of table bore mm F	870	870	870	870	870	870	980	980	980	980	980
Min./max tailstock arm position over table mm G	780/1680	780/1680	780/1680	780/1680	925/1825	925/1825	925/2335	925/2335	925/2335	925/2335	925/2335
Table diameter mm H	800	800	800	1200	1460	1870	2500	2500	2500	2500	2500
Table height mm I	970	970	970	970	970	970	1000	1000	1000	1000	1000

* Available as special design with special grinding head.

() Special order.

The information and specifications in this publication are subject to change without notice.

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機台照片 Machine Pictures



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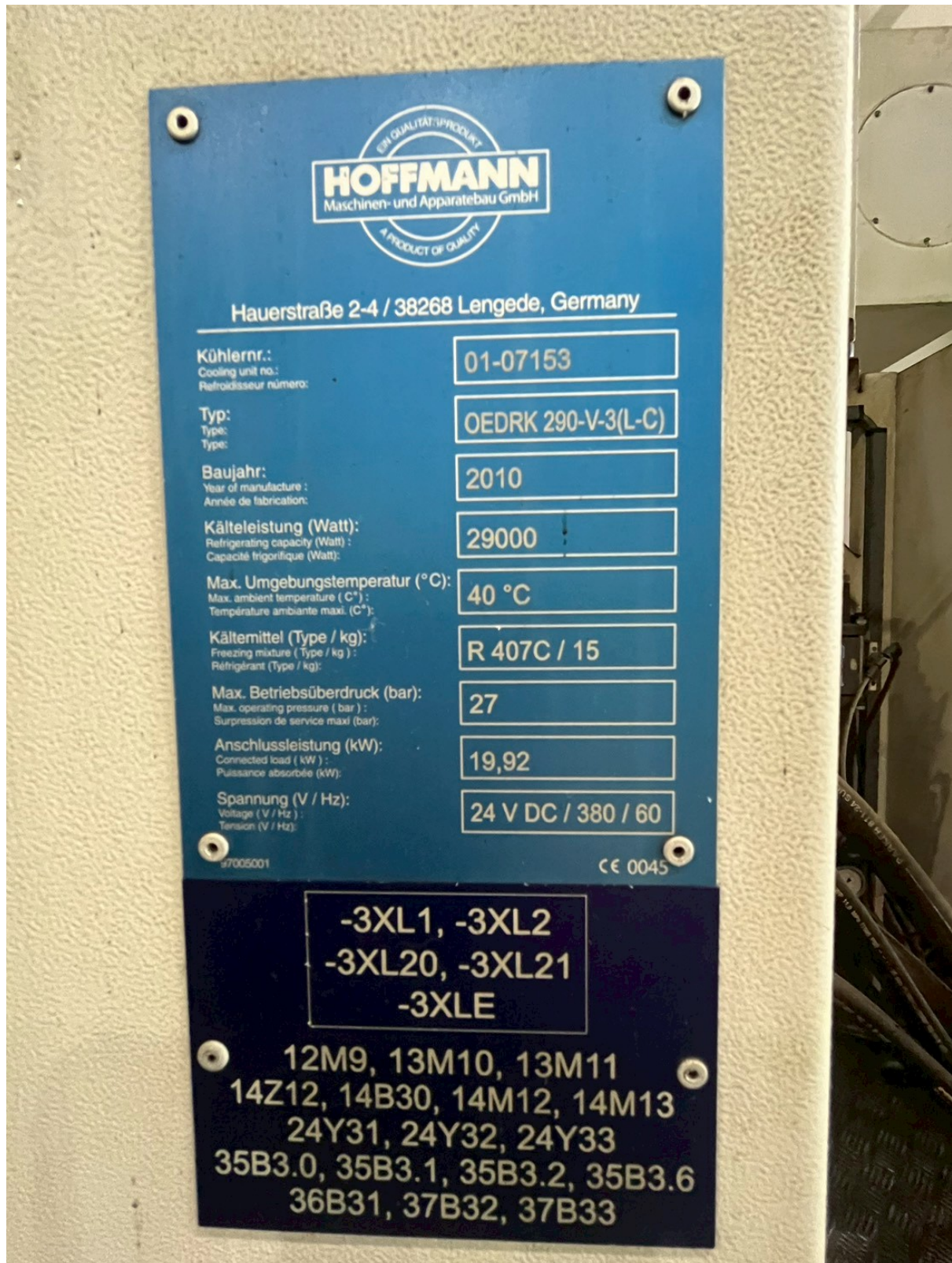
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財產編號:	1210021
財產名稱:	P1200G齒輪研磨機
取得日期:	0099/06/19



Gleason PFAUTER	
GLEASON-PFAUTER Maschinenfabrik GmbH Daimlerstrasse 14 D - 71636 Ludwigsburg	
CE	Baujahr Year of manufacture Année de fabrication
Type Type Type	Fert.-Nr. Prod.-No No de fabrication
P 1200 G	2010 30 769
Netzplan Network plan le réseau linéaire pour planification	602 8666
Inventar-Nr. Inventory number L'inventaire numéro	
Spannung Voltage Tension	3~ 380 V
Frequenz Frequency Fréquence	60 Hz
Anschlußwert Connected load Puissance connectée	80 kVA
Stromlaufplan Circuit diagram Schéma électrique	S08 30 769-0
Hydraulikplan Hydraulic diagram Schéma hydraulique	4-08-062-1329 253
Pneumatikplan Pneumatic diagram Schéma pneumatique	4-08-060-1329 254
Schmierplan Lubrication diagram Schéma de lubrification	

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