

# Waldrich 10'000 grinding machine



For grinding cylindrical and cambered rollers for a wide variety of productions. The rollers are located on two-point steady rests or pedestal bearings. Drive is provided by a cardan shaft or belt. The CNC control system ensures that the machine can be deployed universally and for the highest precision. All materials can be manufactured with the optimum accessories and the wide selection of abrasives. Soft coverings can be machined dry because of the dust extraction system. The flow of coolant is monitored. Software limit switches and programs ensure safety during machining. The measuring system provides measuring data for initial and final reports on shape and radial runouts.

## Technical data

Year of the machine	Approx. 1955
Last inspection	2002 / 2009
Control unit	Sinumerik 8400 / Simodrive 6110
Biggest machining diameter	ø1800 mm
Smallest machining diameter	ø80 mm
Maximum grinding length	10,000 mm
Minimum grinding length	800 mm
Maximum load	50,000 kg
Machine weight	78,000 kg

## Speeds

Grinding-wheel spindle	i=1 5 -1400 rpm
Roller drive	GS1 i 41.5 n=0-150 rpm GS 2 i 10.2 n=0-150 rpm
Z-feed	10 m/ min
X-feed	5 m/ min
Q1-feed	2 m/ min
Q2-feed	2 m/ min

## Axis travel

Z-axis	11,019 mm
X-axis	850 mm
U-axis	-4.91 / + 4.95 = 9.86 mm
Q1-axis	755 mm
Q2-axis	755 mm

### Motor power

Roller drive (sheet 150)	51 kW / 11 8A / 487Nm /1000 rpm
Grinding spindle motor (sheet 151)	22kW/ 55A/ 210Nm / 1000 rpm
Z-axis drive (sheet 152)	27 Nm / 2000 rpm
X-axis drive (sheet 152)	27 Nm / 2000 rpm
U-axis drive (sheet 153)	1.4 Nm / 6000 rpm
Q1-axis drive (sheet 154)	1.4 Nm / 6000 rpm
Q2-axis drive (sheet 154)	1.4 Nm / 6000 rpm

### Accessories

Measuring unit	Ø 0-1 500mm
Drive belt for S-rollers	1
Replacement belt	3 pairs
Cardan shaft drive	x 2 / 630-790 mm / 1000-1180 mm
Wearing bushings	Ø50 -Ø350 mm
Locking bushings	x 5 / Ø130, Ø200, Ø250, Ø300, Ø350 mm
Clamping supports with slides	2
Clamping supports for steady rests	2
Two-point steady rests	2 pairs / 150-300 mm 290-635 mm
Insertion jaws up to 35 tonnes	Ø1 50 - Ø300mm
Insertion jaws up to 50 tonnes	Ø290 - Ø635 mm
Underlays	7 pairs / 30, 35, 40, 45, 60, 80, 207 mm
Finishing device	1 Protech BF 30-100
Band finishing devices	Various
Grinding wheel clamping flanges	x 6 / Ø305 x Ø600 x 80
Grinding wheels	Various
Dust extraction	
Machine instructions and wiring diagrams	

### Control unit

Grinding software	SIGRIND
Measuring software	SIWAME











