

**PALMARY**

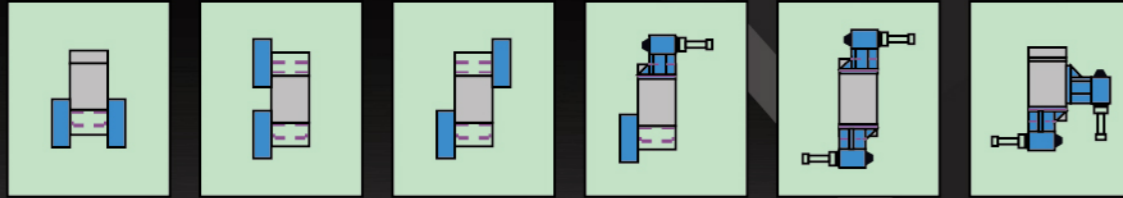
**CNC**

**CYLINDRICAL GRINDER  
MULTI-SPINDLE WHEELHEADS TYPE**

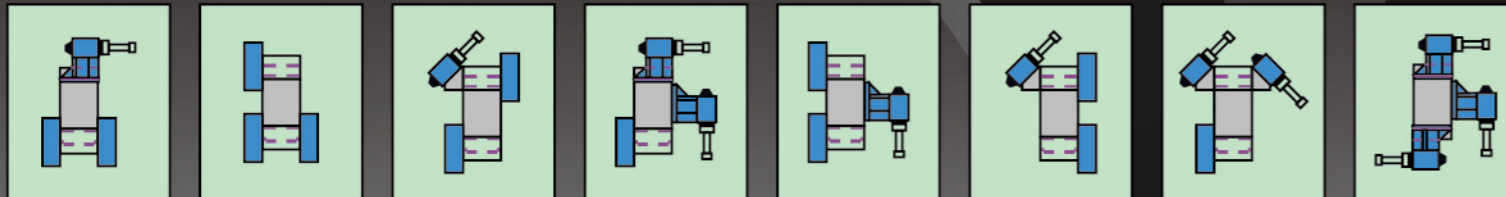
**OCD-M2 / M3 series**

**Grinding wheel Versions**

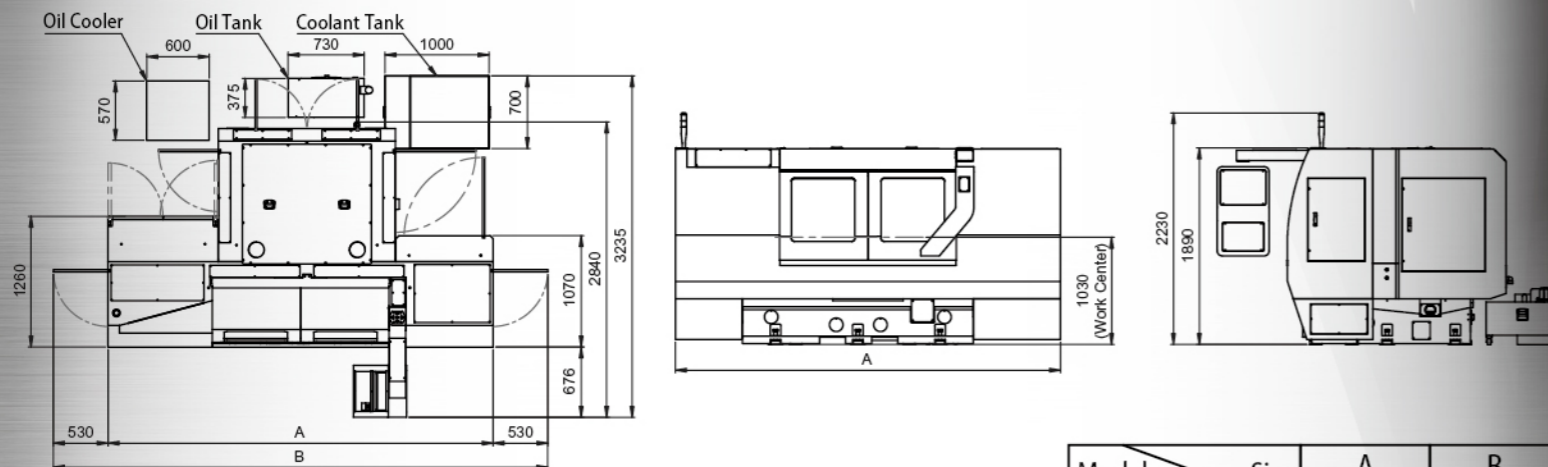
**OCD-M2 series**



**OCD-M3 series**



• Dimensions (unit: mm)



Model	Size	A	B
OCD-3235M		3100	4180
OCD-3265M		3700	4780
OCD-3295M		4300	5380



**Outstanding Features:**

- CNC Cylindrical Grinder Multi-spindle Wheelheads type provide for various size workpiece grinding application. To grind the inner dia., outer dia. & end face at one time clamping, not only could save the cycle time but also for better grinding accuracy.
- The machine distance between centers has 350, 650, and 950 mm on choice. The swivel over table is 320mm and max. workpiece load held by between centers is 150kg.
- The swivel wheelhead (B-axis) was driven automatically and has the min. setting angle 0.0003 degrees which allows the prompt position and superior grinding accuracy results.
- The wheelhead swivel position accuracy could be less than 1" (the angle unit: 1 second) for the customer's high accuracy requirements.
- Machine could equip with 2 no. grinding wheels (OCD-M2 series) or 3 no. grinding wheels (OCD-M3 series) for kinds of different industry need.



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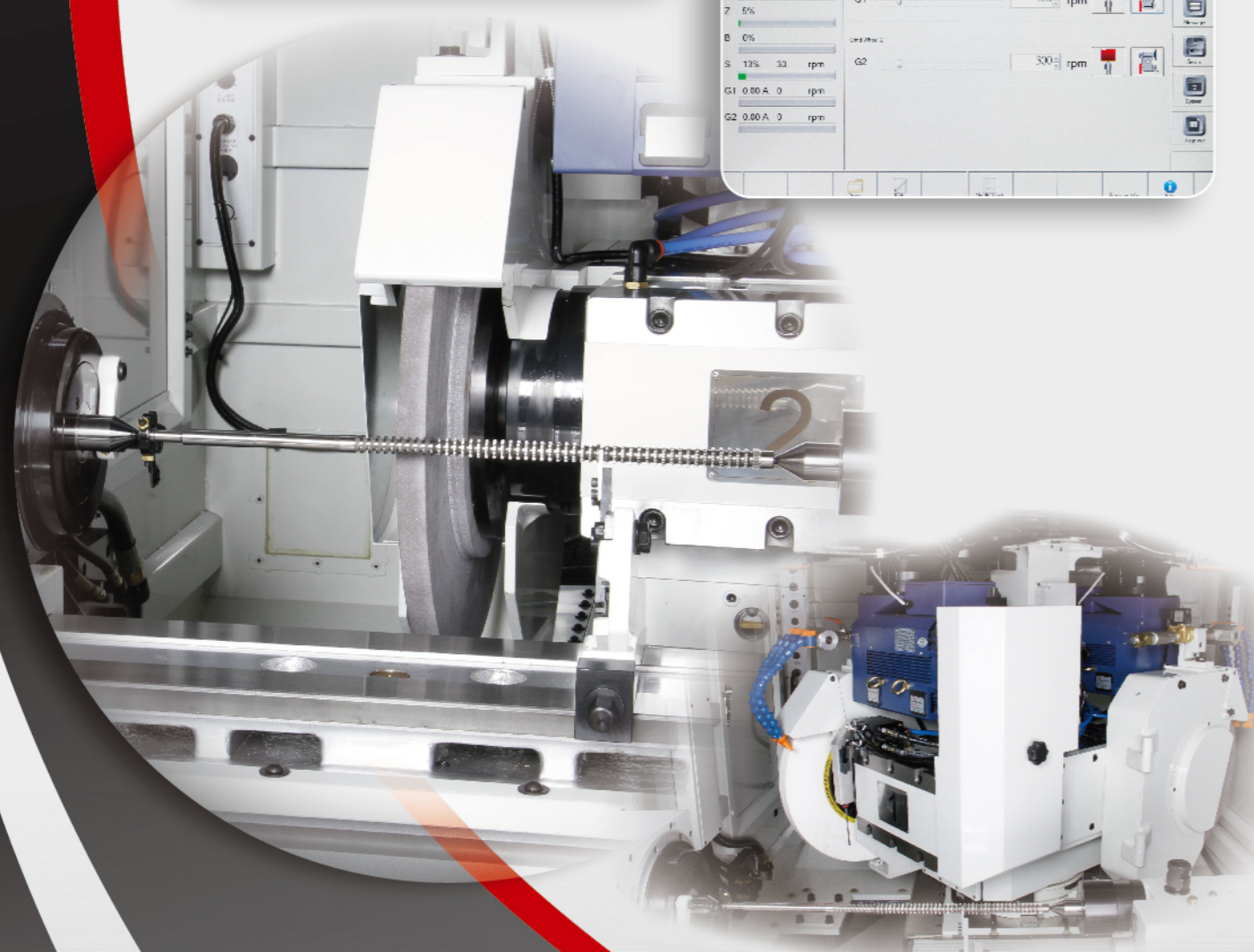
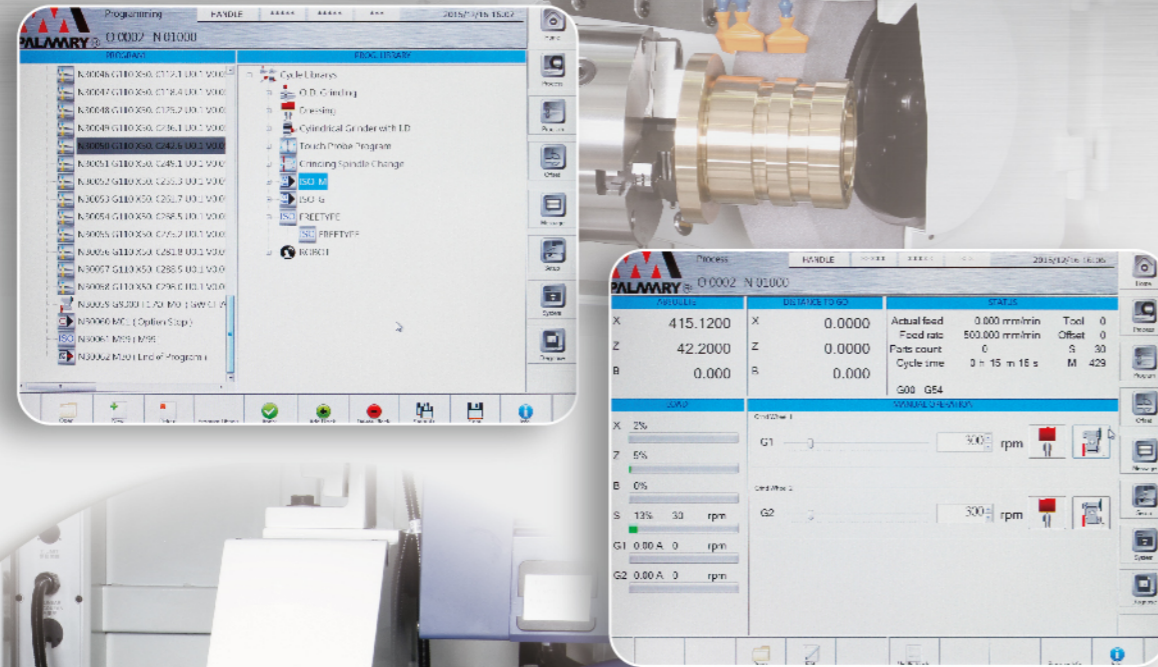


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# PALMARRY

# CNC CYLINDRICAL GRINDER MULTI-SPINDLE WHEELHEADS TYPE

## OCD-M2/M3 series



### Specification

	OCD-3235M	OCD-3265M	OCD-3295M
Swing Over Table		Max. Ø320 mm	
Distance Between Centers	350 mm	650 mm	950mm
Max. Grinding Diameter		Max. Ø300 mm	
Max. Load Held Between Centers		150 kg	
OD. Wheel (Straight Type)	OD. x W x ID. Linear Velocity Speed	Ø510 x 50 x Ø203.2 mm 2,000 m/min. ( 33 m/s ) 1,248 rpm	
OD. Wheel (Angular Type)	OD x W x ID Linear Velocity Speed	Ø510 x 75 x Ø203.2 mm 2,000 m/min. ( 33 m/s ) 1,248 rpm	
ID. Wheel Spindle	G.W. Diameter G.W. Max. Linears Velocity Swivel Angle	14,000~30,000 rpm Ø43~Ø60 mm 2700 m/min -40° ~ +220°	
B-Axis Wheelhead Swivel Base	Repeatability Accuracy Swivel Time 0°~180° Min. Setting Angle	< 1" (1 sec. - Angle Unit) < 3s 0.0003°	
X-Axis Wheelhead	Rapid Moving Min. Setting Value	6 m/min. 0.001 (Opt. 0.0001) mm	
Z-Axis Table	Rapid Moving Min. Setting Value	6 m/min. 0.001 (Opt. 0.0001) mm	
Workhead	Centers Taper Spindle Speed Swivel Angle	MT. 4 10 ~ 300 rpm -30° ~ +90°	
Tailstock	Centers Taper Moving Distance	MT. 4 35 mm	
Controller		FANUC	
Motor	G.W. Spindle	5.5 kw 4P (7.5 hp)	
	ID. Spindle (Build-In Type)	15	
	B-Axis Wheelhead Swivel Base (Servo Motor)	0.75 kw (1.0 hp) Tc : 2.0 Nm	
	X-Axis Wheelhead (Servo Motor)	1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Z-Axis Table (Servo Motor)	1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Workhead Spindle (Servo Motor)	1.6 kw (2.1 hp) Tc : 8.0 Nm	
	Hydraulic Lubrication Pump	0.75 kw 4P (1.0 hp)	
Capacity	Hydraulic System	0.18 kw 4P (0.24 hp)	
	Coolant Pump	60L	
	Hydraulic Tank	42L	
Power Supply	Build-in Type Spindle Coolant Tank	15L	
		34.2KVA	
Machine	Dimensions	3,100 x 3,995 x 2,227mm	3,700 x 3,995 x 2,227mm
	Net Weight	8,500Kg(Estimated)	10,000Kg(Estimated)
			12,000Kg(Estimated)

• OCD-M2 choose 2 no. grinding wheels. OCD-M3 choose 3 no. grinding wheels.