

2019

CAMPORA SRL / **usati**



Rettificatrice

JONES e SHIPMAN

mod.1074

USATA

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COSTRUZIONE e COMMERCIO

MACCHINE UTENSILI

SCHEMA TECNICA

Rettificatrice JONES e SHIPMAN mod.1074**Caratteristiche tecniche**

Specification

Imperial dimensions marked with an asterisk are approximate

Dimensions	1074		1076		1078	
Grinding length between centres	457mm	18"	686mm	27"	1016mm	40"
Maximum diameter ground with new wheel	254mm	10"	254mm	10"	254mm	10"
Height from table top to centre	127mm	5"	127mm	5"	127mm	5"
Table swivel, included angle clockwise	19°	19°	16°	16°	12°	12°
Table swivel, included angle anti-clockwise	20°	20°	18°	18°	16°	16°
Net weight approx.	2040kg	4500lb	2310kg	5100lb	2630kg	5800lb
Gross weight approx.	2580kg	5700lb	3000kg	6600lb	3630kg	8000lb
Shipping dimensions approx.	6.3m ³	220cu.ft.	8.2m ³	290cu.ft.	8.5m ³	300cu.ft.

Common to all machines

Workhead	Workhead speeds r.p.m. (6)	40, 60, 90, 140, 210, 320.
	Traverse speeds, per minute	76mm to 4572mm
	Shortest traverse max. speed	1mm
	Hand traverse, handwheel per rev.	12.7mm
	Fine hand traverse knob graduations	0.01mm
Wheelhead	Traverse on screw	178mm
	Retraction	32mm
	Max. reset (reduction in dia.)	1mm
	Infeed handwheel graduations (reduction in dia.)	0.005mm
	Fine feed knob graduations (reduction in dia.)	0.001mm
	Intermittent feed infinitely variable (reduction in dia.)	0.00005mm to 0.05mm
	Continuous feed infinitely variable (reduction in dia.) per min.	0.001mm to 25mm
	Swivel of wheelhead (ES & EIU wheelheads only)	360°
	Top slide adjustment (ES & EIU wheelheads only)	105mm
Wheel	Standard size (E Type)	400 × 40 × 127mm
	Wheel speeds (two) r.p.m.	1550 & 1990
	Standard size (ES & EIU Types)	300 × 25 × 127mm
	Wheel speeds (two) r.p.m.	2000 & 2650
Internal Spindle	Internal grinding spindle capacity, No. 1660 R.H.	19 to 50mm dia.
	Internal grinding spindle speed r.p.m. (Type EIU wheelhead only)	16500
Power	Wheelhead (All Types)	4kW
	Workhead	0.55kW
	Hydraulic pump	0.75kW
	Coolant pump	0.12kW
Workpiece Weight	Maximum between centres	100kg

The Models 1076 and 1078 can also be supplied with raised centres 178mm (7") and workhead speeds of 25, 38, 63, 116, 193, 293 r.p.m. This enables shafts having narrow flanges up to 356mm (14") diameter to be ground, subject to the condition that the maximum capacity is governed by the weight of material which can be carried by the workhead and tailstock centres.

Model 1077 — 356mm (14") Swing × 686mm (27"). Specification otherwise as Model 1076.

Model 1079 — 356mm (14") Swing × 1016mm (40") Specification otherwise as Model 1078.

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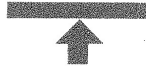
SCHEDA TECNICA

1074 series

Performance on standard machines

Wheelhead Feed

Repetitive accuracy to dead stop measured with an electronic probe. 0-001mm (0-00004"). Manual adjustment of wheelhead position in increments of 0-0005mm (0-000025").



Although these machines will swing 254mm (10") or 356mm (14") diameter and admit 457,686 and 1016mm (18", 27" and 40") between centres the maximum capacity is governed by the weight of material which can be carried by the workhead and tailstock centres.

Roundness

Dead Centres 0-00025mm (0-00001") M.Z.C.*
Live Spindle 0-0006mm (0-000025") M.Z.C.*
*Radial departure from a true circle. (Using standard wheel and hardened test piece).



Parallelism

Parallel to convex only.
Model 1074-0-005mm (0-0002") 457x76mm dia (18"x3" dia) test bar.
Model 1076-0-0076mm (0-0003") 686x102mm dia (27"x4" dia) test bar.
Model 1078-0-01mm (0-0004") 1000x100mm dia. (40"x4" dia.) test bar. (Without the use of steadies.)



Surface Finish

0-05 micron (2 micro-inch Ra)*
(Improved Ra values can be obtained by using selected grades of grinding wheels applicable to the material being ground).
*Using standard wheel and hardened test piece.



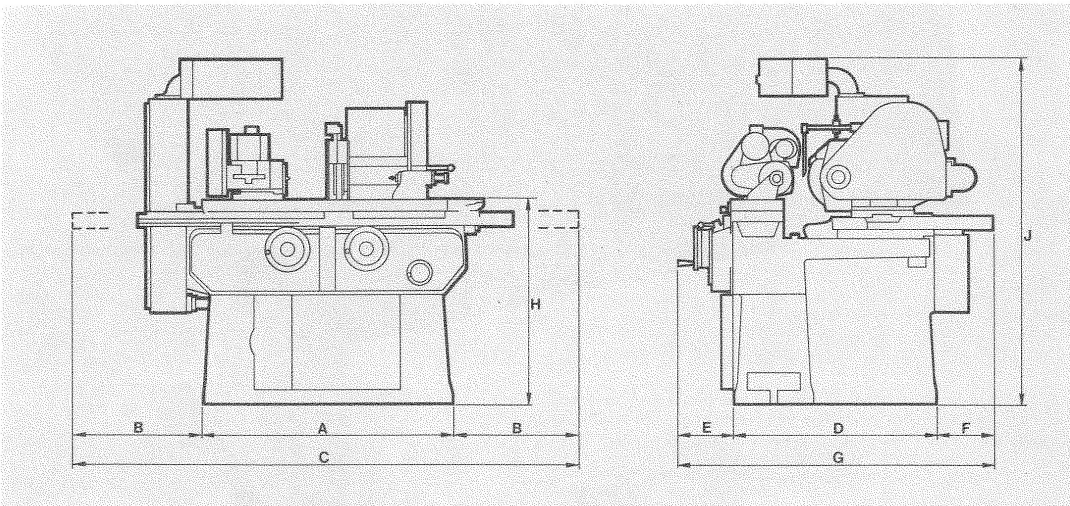
Table Reverse Accuracy

0-025mm (0-001") T.I.R. at any set speed.
0-05mm (0-002") T.I.R. variation between maximum and minimum speed



Machine dimensions

	1074	1076	1078	ALL MODELS
A	1182mm (46½")	1638mm (64½")	2196mm (86½")	D 950mm (37-7/8")
B	545mm (21½")	785mm (30¾")	1121mm (44½")	E 254mm (10")
C	2272mm (89½")	3208mm (126¼")	4438mm (174¾")	F 281mm (11-1/8")
				G 1485mm (58½")
				H 962mm (37¾")
				J 1626mm (64")



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