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Ref. No.:  
811-03151816

### Overview and Technical Data:

## **BLANCHARD - No. 20K-36 Rotary Surface Grinder**

**BLANCHARD**



**BLANC**

Year of Build:  
Jan 1979

### **Description:**

## **Used Blanchard No. 20K-36 Rotary Surface Grinder**

The Blanchard 20 series is ideally suited for medium size work pieces, which must be ground to close size, flatness and parallelism tolerances, as well as to fine surface finish requirements. It has a 36" diameter magnetic chuck and swings 48" inside the water guards, with a vertical range of 24".

### **Technical Data**

- Axial Travel: 610mm
- Wheel Diameter: 508mm
- Table Diameter: 914mm
- Grinding wheel diameter 20"
- Magnetic chuck diameter 36"
- Swing diameter inside warterguards 48" Vertical range 24"
- Maximum load on chuck 3000 lbs
- Grinding wheel horsepower 50 HP / 90 Kva
- Type of feed system Servo Down feed rates IPM .0001 - .100
- Chuck rotation speeds RPM 6 - 24
- Coolant capacity 250 gal
- Height\* (Approximate) 105" Length (Approximate) 140" Width (Approximate) 69" Weight (Approximate Net) 18000 lbs

### **Technical Data:**

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Control:

NC

### **Dimensions and Weight:**

Height:  
17.526 mm  
Length:  
2.667 mm  
Width:  
3.556 mm  
Weight:  
8.200 kg

### **Buyer Information:**

Condition:  
Normal wear  
Available:

Immediately

Sold as:

EXW (Ex Works - Incoterm)

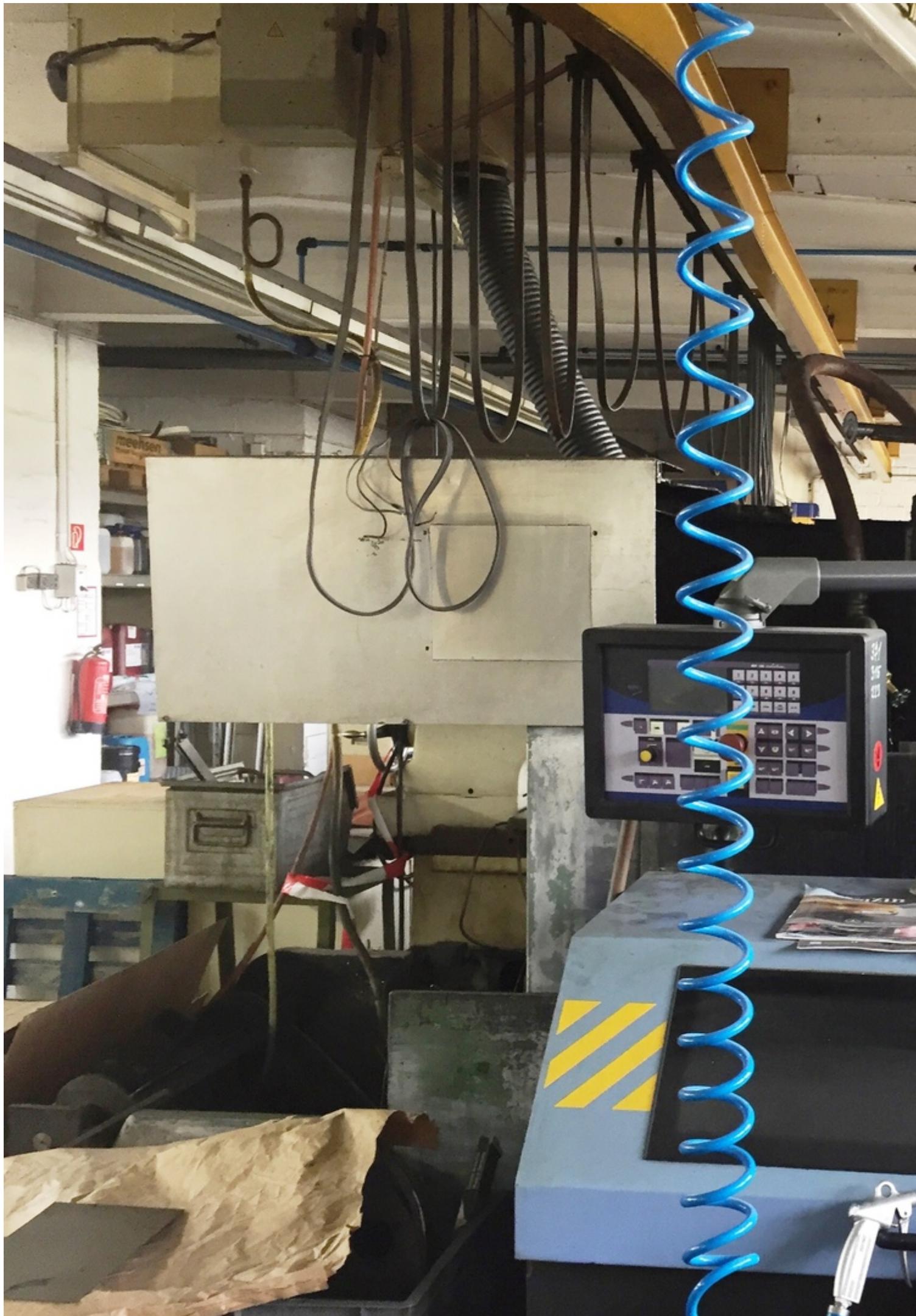
VAT:

19 %

Location:

Germany

**Images:**













## SPECIFICATIONS (Nos. 20-36, 20D-36, 20K-36 Blanchard Grinders)

### WORK CLEARANCE

Swing clearance is 38 in. dia. inside the waterguards. Vertical height\* (range) is 12 in. (18 or 24 when ordered) between the top surface of the 36 in. dia. chuck and the grinding surface of a new grinding wheel in its raised position.

### POWER REQUIREMENTS FOR COMPLETE MACHINE

30 hp wheel motor: 55 Kva  
40 hp wheel motor: 65 Kva  
50 hp wheel motor: 90 Kva

### WORK TABLE

Blanchard magnetic chuck, 36 in. dia. with 5/8 in. radial spacing between concentric poles. Chuck has a 2 in. dia. center hole. Chuck uses direct current; Voltages 115 or 230 (230 preferred), and requires 792 watts supplied by a Neutrofier when ordered. Maximum weight of work load is 3,000 pounds.

### WHEEL HOLDER

Cylinder wheel holder for 20 in. X 5 in. X 16-1/2 in. cylinder wheel; or 20 in. Cortland type segment chuck (when ordered) which holds four CD-18L segments.

### WHEEL SPEEDS

720 Rpm (at 60 cps)  
750 Rpm (at 50 cps)

### CHUCK SPEED. \*\*

6, 9, 12, 18, 25 and 33 Rpm; driven (at 60 cps) by a 2 hp, 1200 Rpm motor.

### AUXILIARY MOTORS

20 lb. ft., 900 Rpm (at 60 cps) torque motors for table traverse and for raising and lowering the wheel head.

### FEED

Vertical downfeed of the wheel is either by hand or by power. The power feed is variable between 0.004 and 0.080 in. per minute. An accurate, automatic downfeed stop is provided. Maximum downfeed to the stop is 0.098 in. 0.298 in. is available on

special order on American Built Machines. 0.298 is standard on British Built Machines. The wheel head can be rapidly raised and lowered by power.

### COOLANT SUPPLY

"Wet" Base capacity of 20-36 and 20K-36 models is 125 gallons. A flange mounted, motor driven coolant pump with 1-1/4 in. discharge delivers 60 gallons per minute. The 20D-36 model discharges coolant from its base at 15 in. height above floor level. Two 1/2 hp, 1800 Rpm, immersion type coolant pumps are supplied with 20D-36 models for mounting by customer.

### STANDARD EQUIPMENT

Blanchard 36 in. dia., one-piece steel, magnetic chuck; Waterguards; 1/2 hp coolant pump(s) and coolant piping; 20 in. cylinder wheel holder; Jog push button for table rotation; Work light over table; Quick acting coolant valves and wash hose; Outside chuck ring; Wheel dresser unit built into head. A 30 hp wheel motor built into the head; A 2 hp chuck rotation motor; Two 20 lb. ft. torque motors, one for table traverse and one for raising and lowering the wheel head. Reduced voltage push button controls. Steel control panel cabinet at rear of machine containing reduced voltage starters for wheel motor (Star connected for starting and plugging, Delta connected for running), line starters for small motors, thermal overload protection for all motors. Ammeter wired into wheel motor circuit; Pilot lamp for chuck. Hardened steel base ways with automatic lubrication. The 20K-36 model has a sludge conveyor in its base, and a sludge tote box. A set of wrenches and an operators manual is included.

### FLOOR SPACE AND HEIGHT

20-36--Length 11 ft. 5 in., width 5 ft. 7 in., including control cabinet; minimum height 7 ft. 11 in., maximum height (12" vertical range) 8 ft. 4 in. Height of chuck surface from the floor is 36 in.

\* British Built Machines have 24" Vertical Height as standard.

\*\* For 50 cycles supply chuck speeds are 5, 7, 10, 15, 20 and 27 rpm. using a 4 hp motor.



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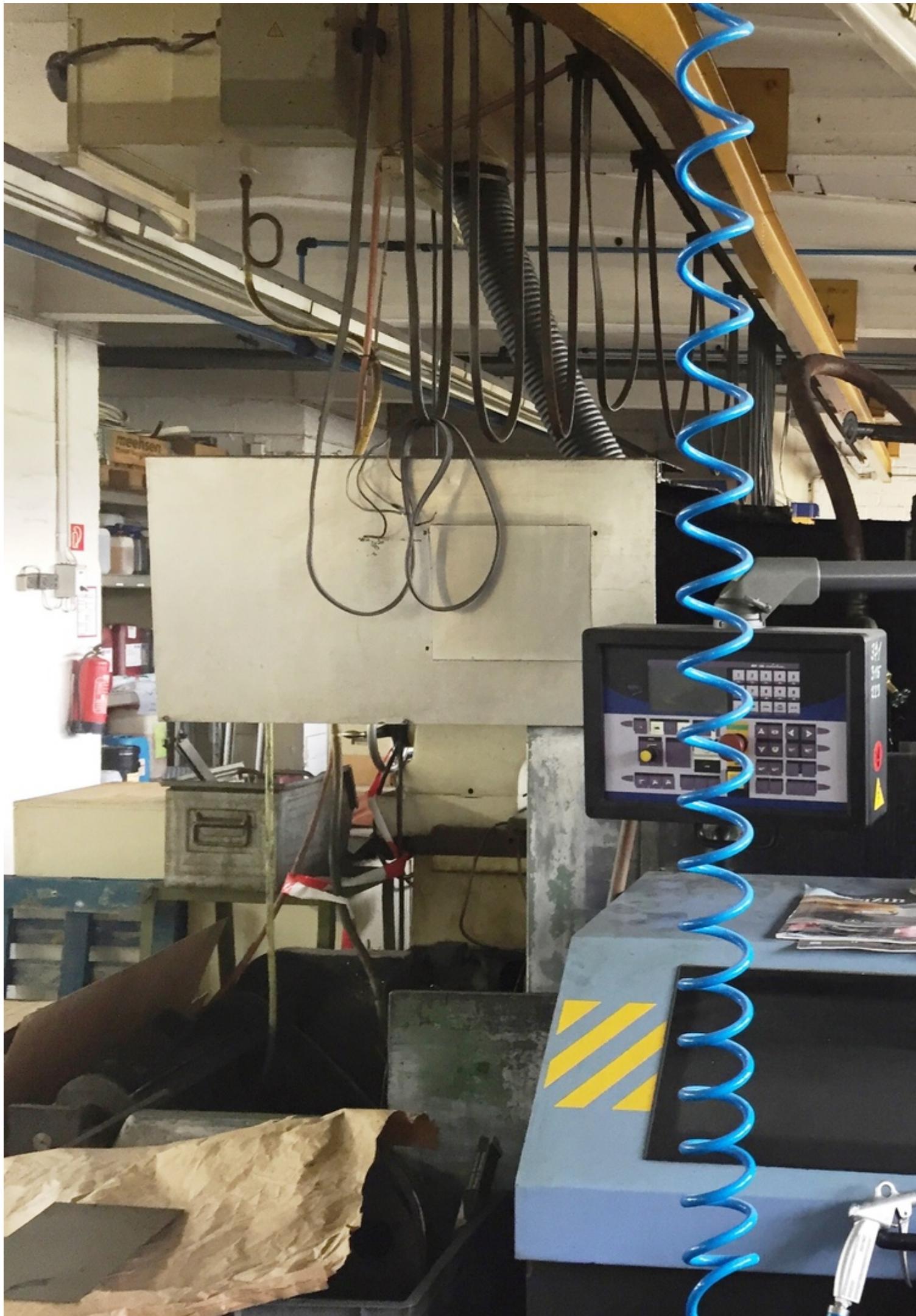
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