

Ref. Nr.: 811-03151816

### Overview and Technical Data:

**BLANCHARD - No. 20K-36**  
Drehschleifmaschine

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Baujahr: Jan. 1979





## Description:

### Gebrauchte Blanchard 20AD-36 Drehschleifmaschine

Die Baureihe Blanchard 20 eignet sich hervorragend für mittelgroße Werkstücke, die zu Bodengröße, Flachheits- und Parallelitätstoleranzen sowie zu feinen Oberflächenbeschaffenheiten geschliffen werden müssen. Es hat ein 36" Durchmesser magnetisches Spannfutter und schwingt 48" innerhalb der Wasserschutz, mit einer vertikalen Strecke von 24 ".

#### Technische Daten

- Axialweg: 610mm
- Raddurchmesser: 508mm
- Tischdurchmesser: 914mm
- Schleifscheibendurchmesser 20 "
- Magnetfutterdurchmesser 36 "
- Schwenkdurchmesser innen Warterguards 48 "Vertikalbereich 24"
- Maximale Belastung des Futters 3000 lbs
- Schleifscheibenpower (HP) 50
- Art des Einspeisesystems Servo Down Vorschubgeschwindigkeiten IPM .0001 - .100
- Chuck Drehzahlen RPM 6 - 24
- Kühlmittelkapazität 250 gal
- Höhe \* (Ungefähr) 105 "Länge (Ungefähr) 140" Breite (Ungefähr) 69 "Gewicht (Ungefährtes Netz) 8200kw



## Technical Data:

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Steuerung: NC

### Dimensions and Weight:

Höhe: 17.526 mm

Länge: 2.667 mm

Breite: 3.556 mm

Gewicht: 8.200 kg

### Buyer Information:

Zustand: Normale Beanspruchung

Verfügbarkeit: Sofort

Verkauft als:

EXW (ab Werk - Incoterm)

MwSt.: 19 %

Standort: Deutschland

## Images:



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**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 wheel head 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**  
Bearing mounted magnetic chucks, 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 are 230/230 volt, 3 phase and 440/440 volt supplied by a Neutrofier when ordered. Maximum weight of work load is 3,000 pounds.

**WHEEL HOLDERS**  
Cylindrical 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-18C segments.

**WHEEL SPEEDS**  
720 rpm (at 60 cps)  
730 rpm (at 50 cps)

**CHUCK SPEEDS**  
• 10, 12, 15, 20, 25 and 33 Rpm; driven at 10 cps by a 1/2 hp, 1200 Rpm motor.

**4 WHEEL MOTORS**  
15 in. dia. 100 rpm (at 60 cps) torque ratings for table traverse and for raising and lowering the wheel heads.

**FEED**  
Vertical downward 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 downward stop is provided. Maximum downward feed rate is 0.098 in. 0.298 in. is available on

**COOLANT SYSTEM**  
Coolant tank capacity of 20-36 and 20K-36 models is 125 gallons. A flange mounted, motor driven pump, 1/2 hp, 3600 rpm, discharges at 60 gallons per minute. The 20D-36 model discharges coolant from the base at 15 in. height above the wheel. Two 1/2 in. (1800) immersion type coolers/pumps are supplied with 20D-36 models for mounting by customer.

**STANDARD EQUIPMENT**  
Blanchard 16 in., one-piece steel, magnetic chuck. Watergards: 1/2 hp cooling pump(s) and coolant piping; 20 in., cylindrical wheel holder; 20 in. (16 in.) for table rotation; Work light over table; Quick acting coolant valves and wash hoses; Outside chuck rings; 20 in. wheel motor built into the head; A 2 hp chuck rotation motor; Two 20 in. diameter magnetic chucks; table travel and one for raising and lowering the wheel head. Reduced voltage push button controls. Steel frame pedestal cabinet and all motors contain reduced voltage starters for wheel motor (Star connected for starting and reversing), Delta connection for main line starters for small motors, thermal overload protection for all motors. Ammeter wired into wheel motor circuit. All motors are mounted on hardened steel base ways with automatic lubrication. The 20K-36 model has a sludge conveyor to its base, and a sludge tank. A set of wrenches and an operators manual is included.

**FLOOR SPACE AND HEIGHT**  
20-36—Length 11 ft. 3 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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