

**Specification****ROBBI IGR 600**

Maximum internal grinding diameter	250mm
Height of centres over table	180 / 230mm
Maximum cantilever weight (150mm from spindle nose	80Kg
Maximum distance between headstock & grinding spindle	1200mm
Maximum diameter of grinding spindle	120mm
Maximum table swivel	+8 deg / -4 deg
Table speed	0-4000mm/min

**CNC & Semi Automatic versions available****CNC (Siemens 840Di) & Semi Automatic (T6 PLC) versions available****ROBBI T6 PLC Version includes:**

- Control panel SIEMENS TP 700 for easy programming of grinding cycles
- Wheelhead and table position visualized on operator panel
- Programmable grinding cycles: plunge and pass
- Program up to 12 different diameters, in a single grinding cycle
- Possibility to update the operative panel, with the correction of each diameter
- Manual grinding cycle, with stop of the grinding wheel feed once the programmed diameter has been reached
- Automatic grinding wheel dressing cycle with compensation of all the grinding dimensions
- In-process measuring gauge and gap control systems (Option)

**AUTOMATIC GRINDING CYCLES, PLUNGE AND PLUNGE AND PASS WITH PARAMETERS:**

- Stock removal - rough and finish
- Automatic increments - rough and finish, for pass grinding cycles
- Automatic feeds - rough and finish, for plunge grinding cycles
- Dwell - table inversion
- Sparkout time
- Sparkout pass

**PRECISION DEGREE**

ROBBI grinding machines are built in accordance to the international precision Standards ISO 2433. The table movement linearity is guaranteed within a maximum deviation of 0,002 mm/m. Surface finish degree: 0,2 Ra  $\mu$  (\*\*). The obtainable grinding roundness is (with live spindle) 0,4  $\mu$  (\*\*)

(\*\*) For a test workpiece ground in our factory during machine testing.