



Asset-Trade

Assessment & Sale of Used Assets

Ref. No.: 811-03151816

Overview and Technical Data:

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

BLANCHARD



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 waterguards 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:



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SPECIFICATIONS (Nos. 20-36, 200-36, 20K-36 Standhead Grinders)

WORK CLEARANCE
 Grinding clearance is 38 in. dia. inside the worktable. Vertical height through 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
 BIPOLAR magnetic chuck, 36 in. dia. with 3/8 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 transformer when ordered. Maximum weight of work load is 3,000 pounds.

WHEEL HOLDERS
 CYLINDRICAL wheel holder for 20 in. X 5 in. X 1 1/2 in. cylinder wheel or 20 in. Cast-iron type segment chuck (when ordered) which holds four CD-18L segments.

WHEEL SPEEDS
 750 rpm (at 60 cps)
 750 rpm (at 50 cps)

CHUCK SPEED
 2, 3, 12, 18, 25 and 33 rpm driven (at 60 cps) by a 2 hp, 1200 rpm motor.

AUXILIARY MOTORS
 20 hp, 11,700 rpm (at 60 cps) torque motor for table traverse and for raising and lowering the wheel head.

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. The hand feed is automatic downward stop in 100 increments. Maximum downward to the stop is 0.098 in. It is available on 20-36 and 200-36 machines. 20K-36 machines have 24" Vertical Height as standard.

FLOOR SPACE AND HEIGHT
 20-36 height 7 ft. 11 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.

COOLANT SUPPLY
 Built-in capacity of 20-36 and 20K-36 models is 120 gallons. A flange mounted, motor driven coolant pump with 1-1/4 in. discharge delivers 60 gallons per minute. The 200-36 model discharges coolant from its base at 15 in. height above floor level. Two 1/2 hp, 800 rpm, constant type coolant pumps are supplied with 20K-36 models for mounting by customer.

STANDARD EQUIPMENT
 Standard 36 in. dia., one-piece steel, magnetic chuck; Woreguard; 1/2 hp coolant pump (1 and coolant piping); 20 in. cylinder wheel holder; ring push button for table rotation; Work light over table; Quick acting coolant valve and work 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 hp, ft. torque motors; one for table traverse and one for raising and lowering the wheel head; Industrial voltage push button controls; Steel control panel cabinet or rear of machine containing reduced voltage starters for wheel motor (One 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; Hand-dressed steel base ways with automatic lubrication. The 20K-36 model has a storage conveyor in its base, and a sludge take box. A set of wrenches and an operation manual is included.

20-36 Machines have 24" Vertical Height as standard.
 20-36 Machines supply chuck speeds are 2, 3, 12, 18, 25 and 33 rpm. using a

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