宝鸡机床集团有限公司
BAOJI MACHINE TOOL GROUP CO.,LTD
宝鸡忠诚机床股份有限公司
BAOJI ZHONGCHENG MACHINE TOOL CO.,LTD

CK50-H/HY车削中心

Turning Center

匠 心 智 造 中 国 好 机 床



地址:中国陕西省宝鸡市高新十四路
Add: Gaoxin 14 Road,Baoji,Shaanxi,China
邮编Postcode:721013
企业邮箱Email:gsbgs@bjmtw.com
官方网址Http://www.bjmtw.com

国内贸易Domestic Trade
电话Tel:0917-3566908 3566909
传真Fax:0917-3566966
邮箱Email:xsgs@bjmtw.com

国际贸易International Trade
电话Tel:+86-917-3566893 3566897
传真Fax:0917-3566900
邮箱Email:sales@bjmtw.com

全国客户服务热线Hot Line:400-119-9196

本样册内所印各种说明及图片如有变动，恕不另行通知（202503版）
Design and specifications given herein are subject to change without prior（Version 202503）

www.bjmtw.com

CK50-H/HY



01 产品概况 Product Overview

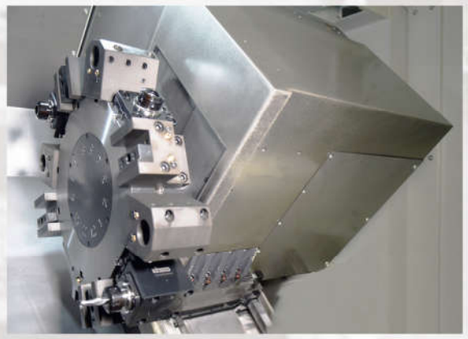
CK50-HY是一款高性能、多功能车削中心。机床具有C轴和铣削功能，可在一次安装下完成复杂零件的大部分或全部加工，特别适合于形状复杂零件的加工。机床采用广数系统，配备Y轴动力刀塔，精度高、刚性好、选刀时间短。机床采用符合安全标准的全封闭防护，既防止冷却液飞溅、又保证操作安全、外观宜人。

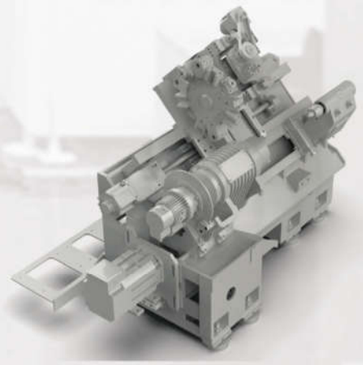
The CK50-HY is a high-performance, multi-functional turning center. With C-axis and milling functions, the machine can complete most or all of the machining of complex parts in a single setup, which is especially suitable for the machining of parts with complex shapes. The machine is equipped with a GSK CNC system and a Y-axis power turret, which provides high precision, good rigidity and short tool selection time. The machine is fully enclosed in accordance with safety standards, which not only prevents the splashing of coolant, but also ensures safe operation and pleasant appearance.

02 性能优势 Performance advantages

- 高强度铸铁整体平床身，有良好的稳定性和抗震性能；
- 导轨采用宽矩形淬硬导轨及贴塑、刮研工艺，使摩擦阻力小，精度保持性长久；
- 主轴采用精密轴承组合排列，热变形小等，运行平稳、精度稳定；
- 具有Y轴和纵横向铣削功能，可一次装夹完成对工件外圆、端面的车、铣、钻、攻的复合加工；
- 刀架采用卧式动力刀架，精度高、刚性好、选刀时间短；
- 机床C轴配高分辨率编码器，确保C轴定位精度和高可靠性，并可连续分度；
- 液压卡盘夹紧、松开和液压尾座套筒伸缩除程序控制外，均可脚踏开关控制，方便快捷；液压压力调整均采用面板式旋扭操作，表盘显示，调整安全、方便；
- 配备冷却泵及水箱，保证加工过程充分冷却；
- 机床采用符合安全标准的全封闭防护，既防止冷却液飞溅、又保证操作安全、外观宜人。

- The machine adopts high-strength cast iron integral flat bed, which has good stability and anti-vibration performance;
- The guideway is treated with hardening and grinding, also uses turcite and precision hand scraping processeswhich can achieve small friction resistance and keep the precision for a long time;
- The spindle adopts the combination arrangement of precision bearings, which can achieve small thermal deformation, smooth operation and stable precision;
- The machine has Y-axis and longitudinal and transverse milling functions, which can complete the compound machining of turning, milling, drilling and tapping on the outer circle and end face of the workpiece in one clamping;
- The turret adopts horizontal power turret with high precision, good rigidity and short selection time;
- The C-axis of the machine is equipped with a high-resolution encoder, which ensures the positioning accuracy and high reliability of the C-axis and allows continuous indexing;
- Hydraulic chuck clamping and unclamping, hydraulic tailstock sleeve expansion and contraction can be controlled by foot switches in addition to program control, which is convenient and quick; hydraulic pressure adjustments are operated by panel-type rotary torque and dial display, which makes adjustments safe and convenient;
- Equipped with cooling pump and water tank to ensure adequate cooling during machining;
- The machine tool adopts fully enclosed protection in line with safety standards, which not only prevents the coolant from splashing, but also ensures safe operation and pleasant appearance.





03 机床数据 Machine data

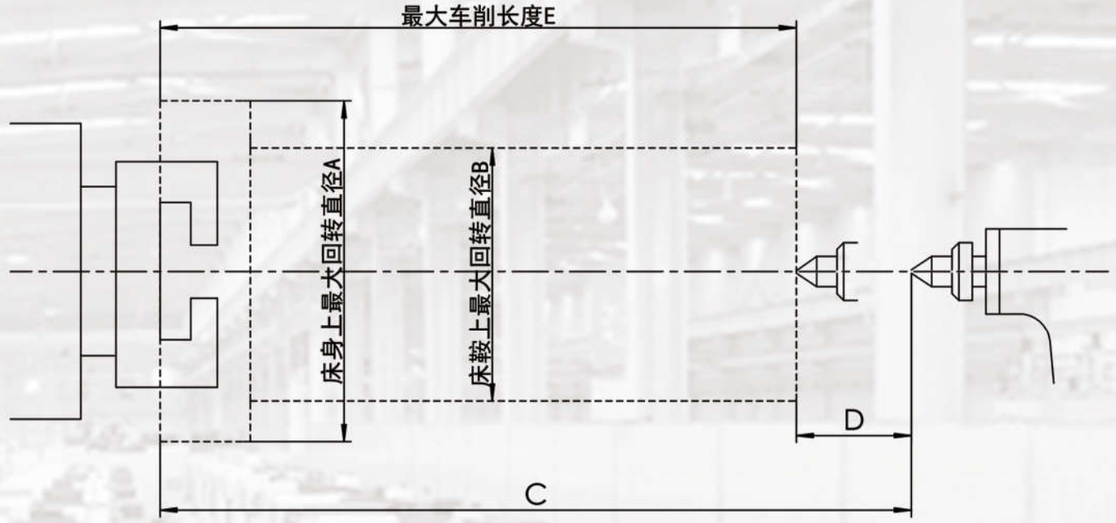
项目 Item			单位 Unit	CK50-H	CK50-H.1000	CK50-H.1500	CK50-HY	CK50-HY.1000	CK50-HY.1500
加工范围 Capacity	床身最大回转直径 Max. swing diameter over bed		mm	Φ650			Φ650		
	最大车削长度 Max. turning length		mm	500	1000	1450	500	1000	1450
	最大车削直径 Max. turning diameter		mm	Φ340			Φ340		
	床鞍上最大回转直径 Max. swing diameter over slide		mm	Φ500			Φ500		
	液压卡盘直径 Hydraulic chuck diameter		in	8″			8″		
主轴 Spindle	主轴头型式 Spindle nose type		GB5900.1	A2-8			A2-8		
	主轴锥孔规格 Spindle bore			1:20			1:20		
	主轴通孔直径 Spindle bore diameter		mm	Φ62			Φ62		
	主轴轴承直径(前/后) Spindle bearing diameter(Front/Back)		mm	Φ100/Φ90			Φ100/Φ90		
	主轴转速 Spindle speed		r/min	60～2250			60～2250		
	主电机功率(连续/30分钟) Spindle motor power(Cont./30min)		kW	11/15			11/15		
尾座 Tailstock	尾座行程 tailstock travel		mm	100			100		
	顶尖锥度 center taper		MTNo.	5/4#			5/4#		
床鞍 Saddle	倾斜角度 Slant degree		DEG	45°			45°		
	移动距离 X/Z/Y Travel X/Z/Y		mm	210/550	210/1010	210/1550	210/550/±50	210/1010/±50	210/1550/±50
	快速移动速度 X/Z/Y Rapid speed X/Z/Y		m/min	12/16			12/16		
	滚珠丝杠直径 X/Z/Y Ball screw diameter X/Z/Y		mm	Φ32/Φ40		Φ32/Φ50	Φ32/Φ40/Φ40		Φ32/Φ50/Φ40
刀架 Turret	刀位数 Tool number			12			12		
	刀具尺寸(车削/镗孔) Tool size(Turning/Boring)		mm	25×25/Φ40			25×25/Φ40		
	回转刀具速度 Living tool speed		r/min	40-4000			4500		
	最大端铣直径/攻丝尺寸 Max. end milling diameter/tapping size		mm	Φ20/M16			Φ20/M16		
其它 Other	电源 Power		kVA	35			45		
	体积长×宽×高(不含排屑器) Dimension(L*W*H) without chip conveyor		mm	2920×1830×2230	3790×1850×2230	4600×1850×2230	2977×1830×2020	3777×1850×2050	4587×1850×2050
	总重量 Total weight		kg	4500	5000	6700	4700	5000	7000
精度 accuracy	定位精度 Position accuracy	X/Z/Y	mm	0.01/0.01/-			0.01/0.018/0.008		
		C		≤50″			≤50″		
	重复定位精度 Repeat position accuracy	X/Z/Y	mm	0.005/0.005/-			0.005/0.007/0.005		
		C		≤20″			≤20″		
圆度 roundness			mm	≤0.003			≤0.003		

03 机床数据 Machine data

机床配置表 ●标配 ○选配 -没有

主要配置 Main Specification	品牌厂家 Brand manufacturers		CK50-H	CK50-HY
控制系统 control system	广数988T GSK:988T		●	●
	新代22TB Syntec: 22TB		○	○
	FANUC 0i-TF(5)		○	○
卡盘 chuck	中空 hollow	8寸 8 inch	●	●
		10寸 10 inch	○	○
	中实 solid	8寸 8 inch	○	○
		10寸 10 inch	○	○
刀架 Turret	12工位带Y轴动力刀架 12-station power turret with Y-axis		-	●
	12工位动力刀架 12-station power turret		○	-
	12工位动力刀架 12-station power turret		●	-
尾座 Tailstock	液压尾座 hydraulic tailstock	莫氏5号活顶尖结构 MT No.5 living center structure	●	●
		莫氏4号死顶尖结构 MT No.4 dead center structure	○	○
排屑装置 chip conveyor	侧排 side-type chain chip conveyor	切屑箱 chip container	-	-
		排屑器 chip conveyor	●	●
液压单元 hydraulic unit			●	●
润滑单元 lubrication unit			●	●
检测装置 detection device			○	○
自动化 automatization			○	○

04 机床图释 Machine tool illustration



尺寸 size / 规格 type	A/mm	B/mm	C/mm	D/mm	E/mm
CK50-H	650	500	670	100	500
CK50-H.1000	650	500	1130	100	1000
CK50-H.1500	650	500	1670	100	1500
CK50-HY	650	500	670	100	500
CK50-HY.1000	650	500	1130	100	1000
CK50-HY.1500	650	500	1670	100	1500