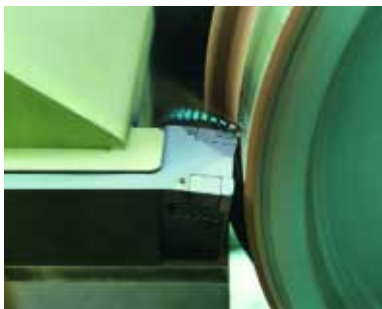


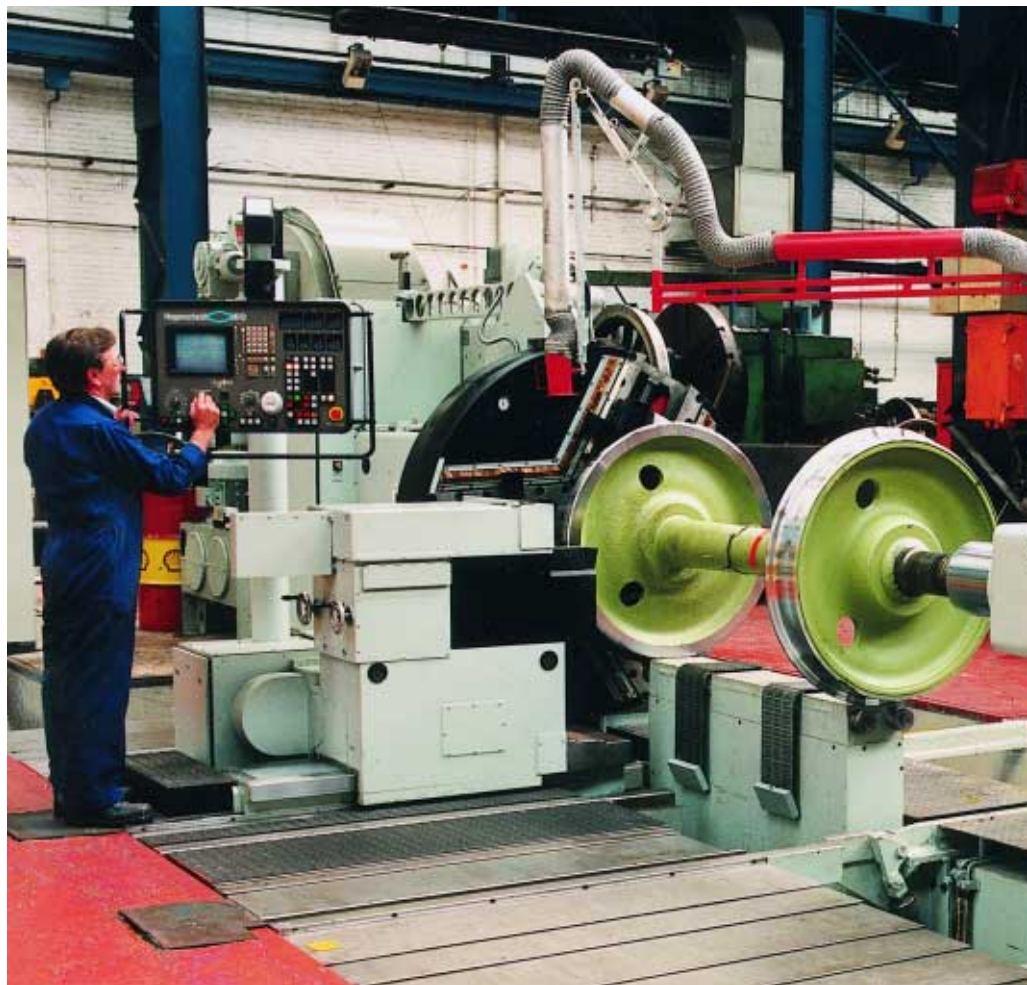
# Universal Wheel Lathe

Type DRH 1250/1000



## Machining possibilities

- Overturning of the treads and flanges in one process as well as facing the inner and outer wheel tyre faces,
- Turning of installed wheel and shaft brake discs
- Hub machining
- General turning, such as machining inner or outer bearing seats, commutator machining, turning of a minimum groove and wheel hub inside machining,
- Roller finishing of internal and external bearing seats,
- Profiling of newly tyred wheel sets with correct axially symmetrical gauge and distance dimension (C dimension)



## The applied modern technologies ensure perfect metal removal efficiency as well as high machining accuracy

- Universal application for every machining task at the wheel set
- Highest possible automation of the machining processes for relieving the operators
- Convinces as a contribution for systematic cost reduction of the wheel set maintenance

# Main Dimensions and Operating Data

Subject to technical change without notice.

Machine type	DRH 1250	DRH 1000
Max. tread diameter	1,260 mm	1,020 mm
Min. tread diameter	580 mm	540 mm
Track gauge	1,435 mm	1,000 mm
Max. axle length between the tips	2,600 mm	1,800 mm
Min. axle length between the tips	1,340 mm	1,200 mm
Centre angles of the centre points	60/90 °	60/90 °
Max. weight of workpiece	2,700 kg	2,000 kg

## Machining accuracies

Round true deviation at the wheel set	≤ 0.2 mm	≤ 0.2 mm
Axial run-out at the wheel set	≤ 0.2 mm	≤ 0.2 mm
Deviation of the profile shape	≤ 0.2 mm	≤ 0.2 mm
Max. diameter difference between both wheels	≤ 0.2 mm	≤ 0.2 mm
Peak-to-valley height Rz in profile machining, depending on feed	≤ 80 µm	≤ 80 µm
Peak-to-valley height Ra in hub machining	≤ 5 µm	≤ 5 µm
Peak-to-valley height Ra in bearing seat machining turning	≤ 5 µm	≤ 5 µm
Peak-to-valley height Ra in bearing seat machining roller Finishing	≤ 1 µm	≤ 1 µm

## Machine data

Connected load	110 kVA	110 kVA
Rated voltage	400 V	400 V
Frequency	50 Hz	50 Hz
Control voltage	24 V/230 V	24 V/230 V
	50 Hz	50 Hz
Max. main drive rating	40 kW	40 kW
Face plate speed range:		
1st stage	5-23-92 1/min	5-23-92 1/min
2nd stage;	23-92-370 1/min	23-92-370 1/min
Chip cross section (face plate side)	max. 16 mm <sup>2</sup>	16 mm <sup>2</sup>
Chip cross section (tailstock side)	max. 12 mm <sup>2</sup>	12 mm <sup>2</sup>
Tool post rapid motion, longitudinally and flatly	4,000 mm/min	4,000 mm/min
Programmable feed per revolution	0.1–4.0 mm/r	0.1–4.0 mm/r
Max. noise level of the machine	≤ 90 dB (A)	≤ 90 dB (A)
Machine weight	approx. 33 t	28 t
Required space for machine installation (without switch cabinet, hydraulic unit, chip conveyor, etc.) approx.	8.40 x 3.00 m	7.40x3.00 m

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