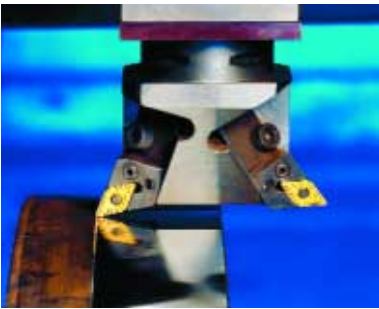


Portal Wheel Lathe

Type DRR 1250 N-2-D



Possible machining operations:

- Reprofiting of locomotive and car wheel sets of all types
- Profiling of newly tyred wheel sets with correct axially symmetrical gauge and distance dimension (C dimension)
- Rim turning with preliminary measurement and final measurement
- Brake disk turning

Proven portal design with flange friction roller drive for maximum productivity, economics and machining quality

- Substantially improved machining accuracy
- Rapid automatic loading and unloading, independent of wheel set diameter or bearing housing confirmation
- Automatic measuring systems for all important data with wear measurement for minimum possible metal removal
- Sound-proofing and chip protection with optimum view and protection for the operator

Main Dimensions and operating Data

Subject to technical changes

Max. tread diameter	1,250	mm
Min. tread diameter	600	mm
Min. turning diameter for facing operations	540	mm
Gauge	1,435	mm
Max. axle length to be accommodated	2,600	mm
Min. axle length to be accommodated	1,900	mm
Centre angles (combined)	60/90	deg.
Max. weight of work piece	4,500	kg

Accuracies at turning

True-running error in the tread plane	≤ 0.1	mm
Axial run-out	≤ 0.2	mm
Shape error or profile	≤ 0.1	mm
Max. difference in diameter of both wheels	≤ 0.1	mm
Deviation from gauge (per side)	± 0.3	mm
Deviation from selected diameter i.e. diametrical deviation	≤ 0.05 ≤ 0.5/1,000	% mm
Surface finish profiling	Rz ≤ 60	µm
Surface finish machining rims	Rz ≤ 10	µm
Surface finish machining brake discs	Rz ≤ 16	µm

Machine data

Max. chip cross section for profiling	18	mm ²
Adjustable setting force per friction roller	10–60	kN
Max. main drive capacity (S6, 60%).	112	kW
Cutting speed when profiling:		
1st gear step	max. 100	m/min
Circumferential speed of wheel set tread for special machining operation		
2nd gear step	max. 400	m/min
Rapid traverse of saddle in longitudinal and transverse directions	3,000mm/min	
Feed range, infinitely variable from	0.1–4.0	mm/rev
Max. noise level of the machine	≤ 80	dB (A)
Machine weight	approx. 53	t
Floor area required (without switch cabinet, hydraulic unit, chip conveying system, etc.)	approx. 7 x 3.5	m

Hegenscheidt  **MFD**

HegenscheidtMFD GmbH & Co. KG
P.O. Box 1652 · D-41806 Erkelenz
Bernhard-Schondorff-Platz · D-41812 Erkelenz
Phone 0 24 31/86-0
Fax 0 24 31/86-4 66
E-mail: hegenscheidt.mfd@hme.vossloh.de
www.hegenscheidt-mfd.de

Hegenscheidt Australia Pty Ltd
Suite 2, 115 Main Street
Blacktown NSW 2148/Australien
Phone + 61 2 9676 58 00
Fax + 61 2 9676 54 00
e-mail: hegenscheidt@ozemail.com.au

Hegenscheidt MFD Corporation
6255 Center Drive
Sterling Heights, MI 48312-2667/USA
Phone + 1 5 86 2 74 49 00
Fax + 1 5 86 2 74 49 16
e-mail: hegen_mfd@hegenscheidtmfd.com