

Title (en)

METHOD AND DEVICE FOR GRINDING WORKPIECES WITH CENTERS WHICH COMPRISE FORM VARIATIONS

Title (de)

VERFAHREN UND VORRICHTUNG ZUM SCHLEIFEN VON WERKSTÜCKEN MIT ZENTREN, DIE FORMABWEICHUNGEN AUFWEISEN

Title (fr)

PROCEDE ET DISPOSITIF POUR LA RECTIFICATION DE PIECES AYANT UN CENTRE PRESENTANT DES ECARTS DE FORME

Publication

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Application

EP 99963457 A 19991209

Priority

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Abstract (en)

[origin: DE19857359A1] The invention relates to a method for machining workpieces with areas which comprise form variations, whereby the workpiece (5) is fixed between the tip (13) of the tool spindle (30) of the workpiece spindle head (1) and the tip (6) of the sleeve (13) of the tailstock (3), and a backrest seat (8) is ground on the workpiece (5). The tip (6) of the sleeve (13) of the tailstock (3) sits closely in the center of the receiver of the workpiece. The method is characterized in that the tip and the tailstock sleeve are retracted from the contact area, said contact area being located in the center of the clamping of the workpiece, to an intermediate position after the backrest seat has been ground. In addition, the workpiece is positionally fixed on the side of the tailstock by a backrest (7) and by an axial force which is applied via a prestressed pressure pin (21) and which is directed against the center of the clamping of the workpiece.

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DE 19857359 A1 20000621; **DE 19857359 B4 20050915**; AU 1974700 A 20000703; BR 9916125 A 20010904; CA 2352426 A1 20000622;
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