



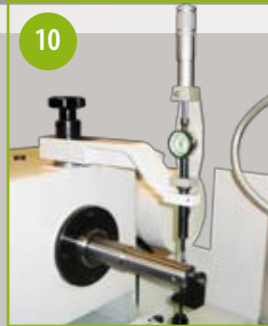
BR650-1000 | Conrod Boring and Grinding Machines

BR

BR650 - BR1000

Adjusting plate wheel for connecting rod support

- 1 Electric control panel
- 2 Grinding spindle
- 3 Handwheel for the rotation eccentricity setting of the wheel spindle
- 4 Handwheel with diamond-holder tube for the grinding wheels dressing
- 5 Handwheel with tubes for the lateral clamping of the conrod
- 6 Handwheel for the transversal placement of the conrod holder column
- 7 Lever for the inversion of the table automatic feed
- 8 Boring spindle
- 9 Handwheel for the manual rotation of the boring spindle
- 10 Boring tool setting device
- 11 Nozzle with cock for coolant
- 12 Expansible spindle for the conrod clamping
- 13 Plate for the conrod holding
- 14 Handwheel for the manual feed of the table
- 15 Motor for the vertical placement of the holding plate of the conrod



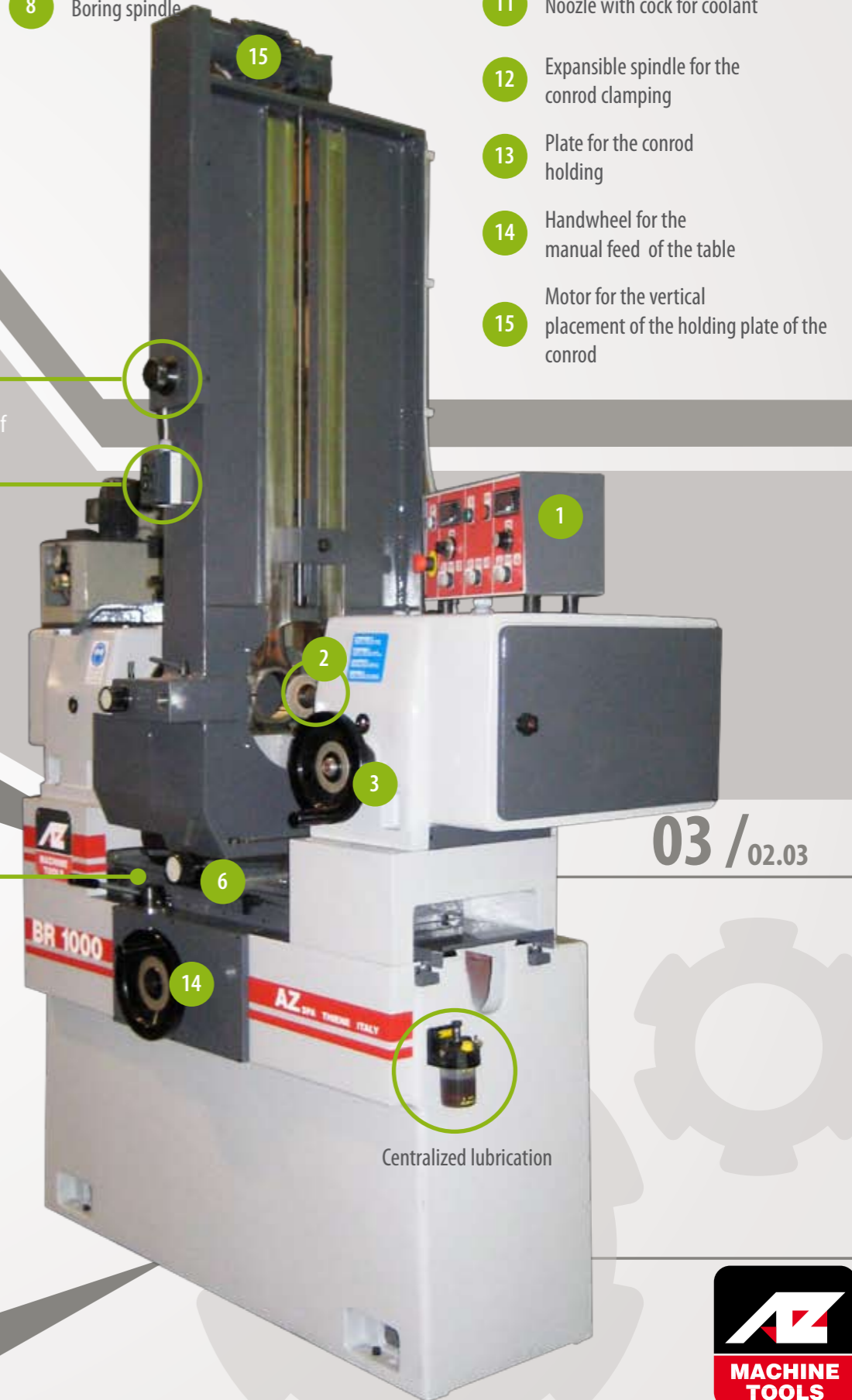
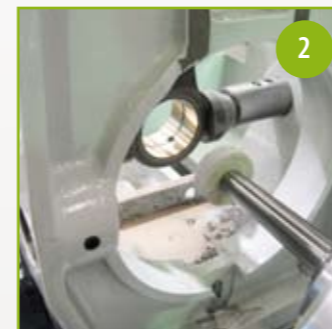
- A Table feed with variable speed motor
- B Variable speed of boring shaft

Handwheel with centesimal nonius for the vertical placement of the holding plate of the conrod

Push-button panel for plate up-down control for connecting rod support



precision bearings in oil bath



Centralized lubrication

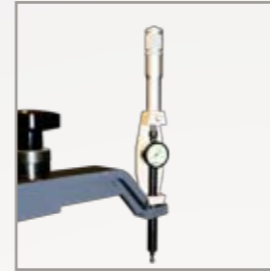
BR650 - BR1000

STANDARD EQUIPMENT

Centering device



Calibrating device



Square



Tool setting device



Grinding wheel



Tools



Grinding wheel dresser



SPINDLES



AZ741



AZ742



AZ743



AZ744

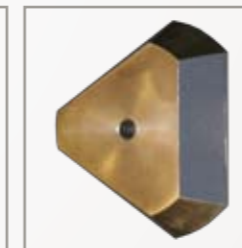
EXPANDING SPINDLES

BORING SPINDLES



GRINDING SPINDLES

CENTERING CONES



STANDARD - BR650

- Low voltage electric control 24 V
- Coolant system
- Set of no. 12 grinding wheels for cast iron and steel
- Set of no. 8 tools
- Grinding wheel dresser (diamond excluded)
- Set of centering cones (No.5)
- No. 3 expanding spindles, 23-38 mm. dia. 37-77 mm. dia. 75-160 mm. dia. (AZ741-AZ742-AZ743)
- No. 2 grinding spindles, 30-65 mm. dia. and 65-165 mm. dia.
- No. 3 boring spindles, 14-29 mm. dia, 38 mm. dia. and 58 mm. dia.
- Tool setting device
- Centering device with centesimal dial gauge
- Calibrating device for tools complete with instrument (AZ721)
- Square with mounted pin for clamping connecting rods
- 3 liters of coolant additive
- Service tools
- Operating manual

STANDARD - BR1000

- Low voltage electric control 24 V.
- Coolant system
- Set of 12 grinding wheels for steel and for cast iron
- Set of no. 8 tools
- Set of centering cones (No.5)
- Grinding wheel dresser (diamond excluded)
- Expanding spindle for con-rods clamping from 160 to 250 mm. dia. (AZ744)
- Expanding spindle for con-rods clamping from 75 to 160 mm. dia. (AZ743)
- Expanding spindle for con-rods clamping from 37 to 76 mm. dia. (AZ742)
- Expanding spindle for con-rods clamping from 23 to 37 mm. dia. (AZ741)
- Boring spindle 59 mm. dia.
- Boring spindle 38 mm. dia.
- Boring spindle from 14 to 29 mm. dia.
- Boring Head da 105 to 160 mm. dia.
- Boring Head from 160 to 210 mm. dia. and from 210 to 250 mm. dia.
- Grinding spindle from 30 to 65 mm. dia.
- Grinding spindle from 65 to 250 mm. dia.
- Tool setting device
- Centering device with dial gauge
- Calibrating device for tools complete with instrument
- 3 liters of coolant additive
- Service tools and Operating manual



BR650 - BR1000

RECOMMENDED -OPTIONAL EQUIPMENT



AZ411



AZ711-AZ714



AZ520



AZ832



AZ854

RECOMMENDED EQUIPMENT

- AZ411 Diamond and rest 0,40 kt
- AZ854 Rod alignment checking fixture

OPTIONAL EQUIPMENT

- AZ711-AZ714 Inner gauge
- AZ520 Boring head
- AZ832 Grinder for tools

SPECIFICATIONS



Two movement possibilities:
- vertical
- horizontal

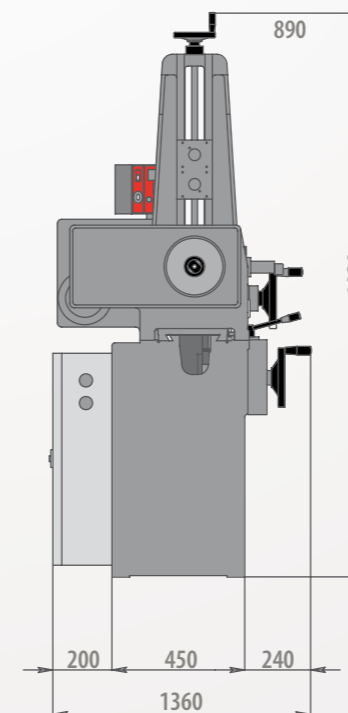
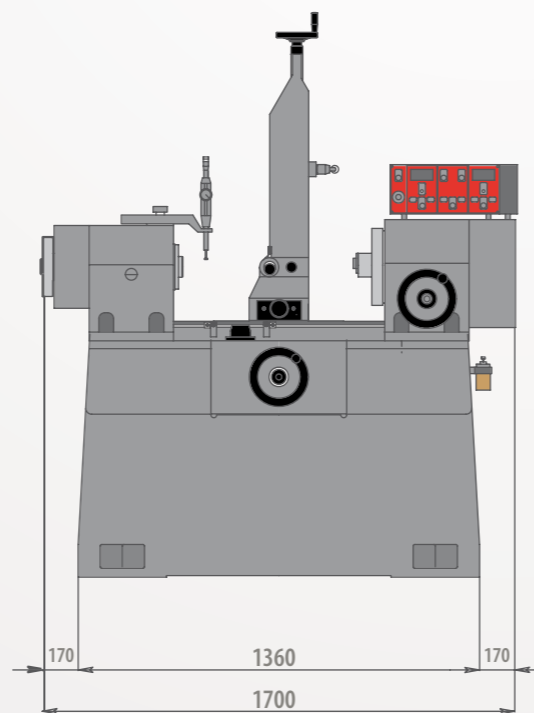
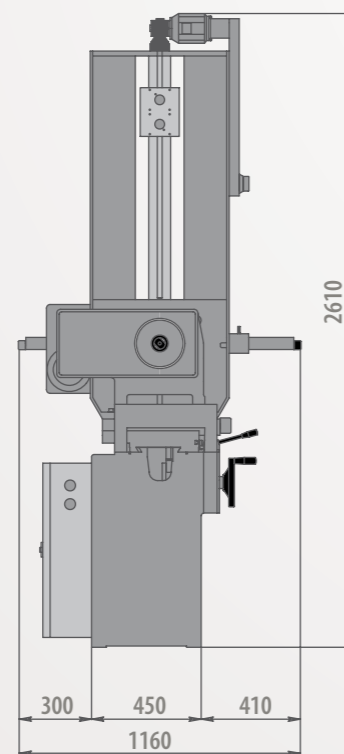
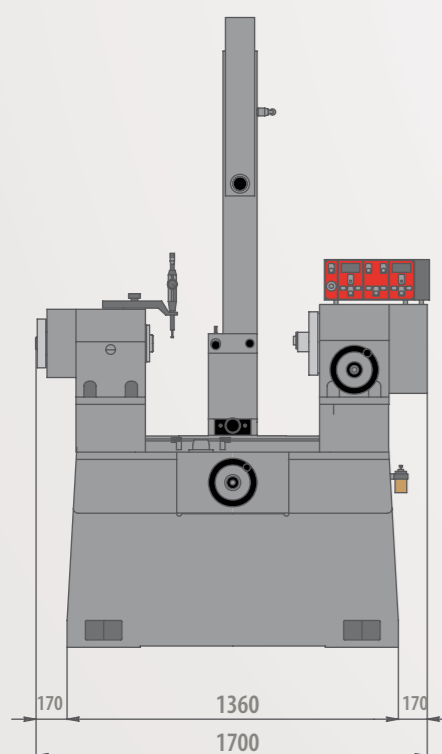
Example of conrod blocking with piston pin



AZ spa | MACHINE TOOLS

	BR650	BR1000
WORKING CAPACITY		
Boring capacity (min. and max. dia.)	15-160 mm	15-250 mm
Grinding capacity (min. and max. dia.)	30-160 mm	30-250 mm
Min. and Max. con-rod center distance	160-650 mm	160-1000 mm
Height of spindle C/L over table	150 mm	380 mm
SPEEDS AND FEEDS		
Boring spindle rotation speeds	0-1200 RPM	0-1200 RPM
Grinding spindle rotation speeds	3300 4400 5300 6300 7500 9000 RPM	3300 4400 5300 6300 7500 9000 RPM
Grinding spindle revolution speeds	80-160 RPM	80-160 RPM
Radial grinding travel (max. eccentricity of wheel C/L)	12 mm	12 mm
Max. table traverse	420 mm	420 mm
Variable automatic table speed on both sides	0-165 mm/min	0-165 mm/min
MOTOR RATINGS		
Motor, feed change	0,1 KW	0,1 KW
Motor, boring head	1,5 KW	1,5 KW
Motor, planetary movement of grinding head	0,5-1 KW	0,5-1 KW
Motor, spindle grinding head	1,1 KW	1,1 KW
Motor, cooling system	0,12 KW	0,12 KW

DIMENSIONS



AZ spa

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