

TF-9DHD

Centerless Thrufeed/Infeed Grinder



The TF-9DHD is an automatic thrufeed/infeed centerless grinder with great capabilities within a small footprint. Utilizing up to an 8-5/8" (219mm) wide work wheel and a 15HP main spindle motor, it is able to remove more material faster, and with better surface finishes, than similar machines. The hard chrome plated, cast iron slides are dovetail ground to provide superior rigidity when positioning the regulating wheel. Both top and bottom slides can be positioned independently, reducing setup times dramatically.

This automated machine includes precision bearings on the work head assembly as well as 0.1 μ m glass scale feedback for closed loop position control. A simple, customizable touch screen can be tailored to address your process. Another time-saving feature is the work rest blade height adjustment. Operating at an independently controlled axis relative to the work wheel, the work rest blade height can be adjusted with a built-in ramp, simply using one screw.

As a thrufeed grinder, the machine can be fitted with entrance and exit tracks to grind bar stock. It is common to find this machine setup to fine grind wire to +/-0.0001" over 12 feet of wire. It is not unusual to install several different grit wheel segments over the 8.25 inch span, ranging from rough segments to finer segments for the exit side. This allows us to remove more material in a single pass while still maintaining a superior surface finish on the exit side.

Infeed grinding can be performed on this machine to process pins and shouldered parts where a plunge is required. The infeed cycle can be simply defined on the touch screen control to insure fluid motion as the

grinding wheels contact. This eliminates chatter and has the ability to control the ground diameter to tight tolerances.

Medical Catheter Grinding

The TF-9DHD has the ability to spread the grind out over 8 inches (200 mm), providing superior surface finish when grinding catheters. By using a multi-grit wheel, the machine can both rough and finish the same part in one thrufeed operation, therefore enabling it to process mixed durometer plastic tubing in one pass. An optional work wheel pressure washing system eliminates the potential for scratching, and can also be used to clean the wheel between dressings.

Medical Guidewire grinding

The TF-9DHD can be configured two ways to grind guidewires from diameters of 0.023" down to 0.002". In a traditional method, a wide wheel dressed with a single taper can be set up. The product thrufeeds into the machine to a set sensor position on a track, and the result is a wire with one taper and a barrel. Optimized vacuum feeding systems can produce short stylets as fast as 5 seconds piece-to-piece, unattended, using this method. In the profiling configuration, a narrow 1.5" or 3" grinding wheel is dressed with a short funnel form. Sensors initiate the retraction of the regulating wheel slide, producing the desired taper. Multiple tapered grinds in one pass are possible using this unique method, and up to six tapers or complex curves can be produced. Built-in paddle grinding cycles can produce heads on wires, sometimes without the use of a mechanical paddle stop.

THE GLEBAR ADVANTAGE

The TF-9DHD was built with the operator in mind, with reduced setups and a fully customizable interface geared to enhance productivity through the use of automation. Independent top and bottom slide controls, simple work rest blade adjustment, and a motor up to 15HP driving a precision twin grip spindle, offer high productivity and precision in a small package.



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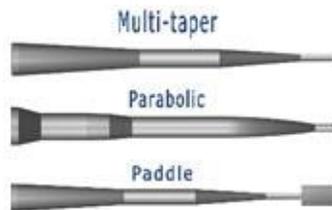
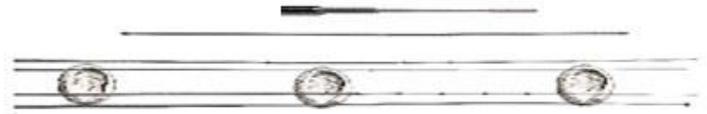
KEY FEATURES

- Industrial touch screen workstation, NEMA 4 rated
- Closed loop control via linear scale on the movable slide
- Operator-friendly control
- Interface to measurement instruments
- Automatic size compensation capability
- Automatic infeed for forming small shaped parts
- Super precision regulating housing
- Available stationary and removable wheel dressers
- Built-in infeed and thrufeed cycles with programmable inputs and positioning



SPECIFICATIONS

- Diameter accuracy: 0.00005" (1.3µm)
- Roundness: 0.00005" (1.3µm)
- Grinding diameter: Min 0.002" (0.05mm), Max 2.5" (63.5mm)
- Grinding length: Infeed 8" (200mm), Thrufeed - no limit
- Work wheel spindle power: 7.5HP (5.6kW), 10HP (7.5kW), or 15HP (11kW)
- Work wheel diameter: 9" (229mm)
- Work wheel length: 8-5/8" (219mm)
- Work wheel RPM: 2400
- Regulating wheel diameter: 4" (100mm)
- Regulating wheel RPM: 10 - 400



ACCESSORIES

- Hydraulic template-tracing work wheel dresser
- Hydraulic template-tracing regulating wheel dresser
- Straight line regulating wheel dresser
- Three stage recirculating coolant system
- Programmable side feeder
- Wire feeder
- Wheel balancing system
- Roller Outboard support
- Bowl feeder



GRINDS

- Carbide
- Ceramic
- Composite
- Glass
- Plastic
- Metal
- Rubber
- Wood



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