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Tongtai

Wheel Machine

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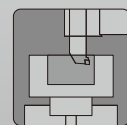


2018.09.11



20 million wheels per year
are produced with Tongtai machines

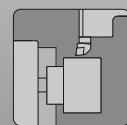
Complete Line for Wheel Machining (Suitable for casting & forging wheels)



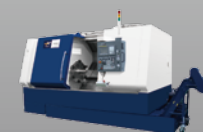
Vertical Wheel CNC Lathe



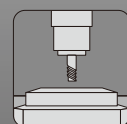
TVW-22T · TVW-22DT
TVW-26T · TVW-26DT
TVW-28T · TVW-28DT



Horizontal Wheel CNC Lathe



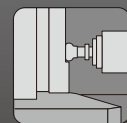
HS-36WIIG
HS-40WG



Vertical Wheel Machining Center



TMV-850W · TMV-1050W
TMV-1100W



Horizontal Wheel Machining Center

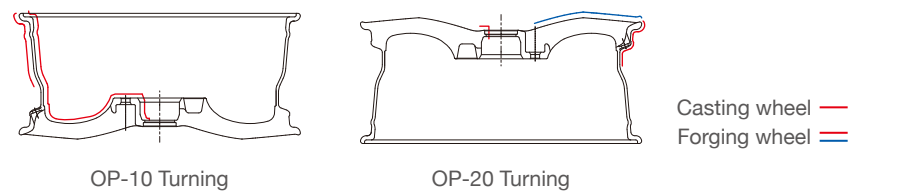


MA-200



Vertical Wheel CNC Lathe

TVW-22(D)T · TVW-26(D)T · TVW-28(D)T

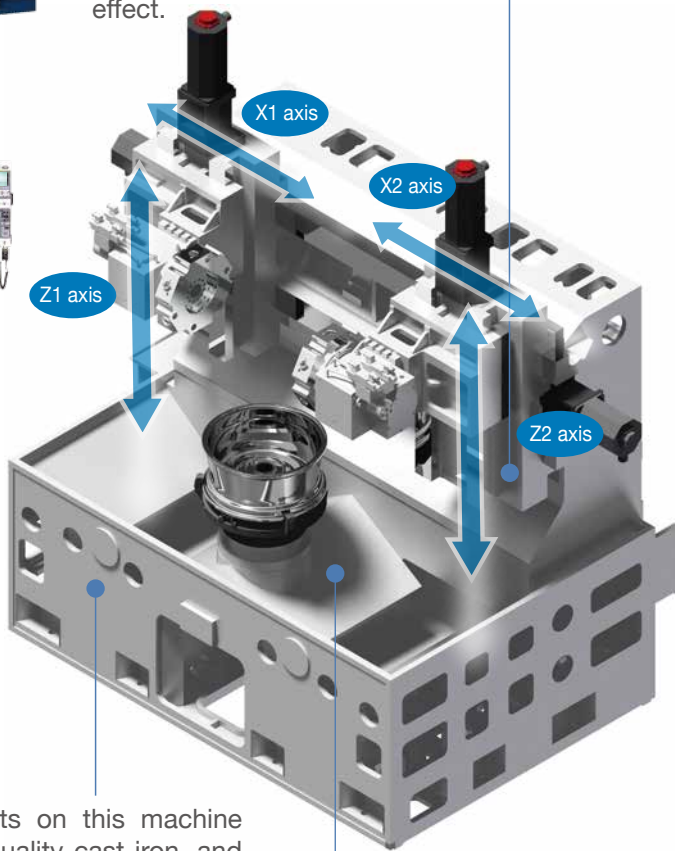


Specification						
Model	TVW-22DT	TVW-22T	TVW-26DT	TVW-26T	TVW-28DT	TVW-28T
Wheel size	14" ~ 22"		14"~24"		14"~28"	
Spindle nose	A2-11					
Spindle speed	2500 rpm		2000 rpm			
Spindle bearing dia.	Ø160 mm					
Tool capacity	6+6	6	6+6	6	6+6	6
X/Z axis stroke	450/450 mm		500/525 mm		540/750 mm	
X/Z axis rapid traverse	20/20 m/min					
Spindle motor	45/55 kW	37/45 kW	45/55 kW	37/45 kW	60/75 kW	37/45 kW



Both X and Z axes are designed with box-way structure. With proper heat treatment and grinding process, the high precision feeding units provide the high rigidity for heavy duty or intermittent cutting.

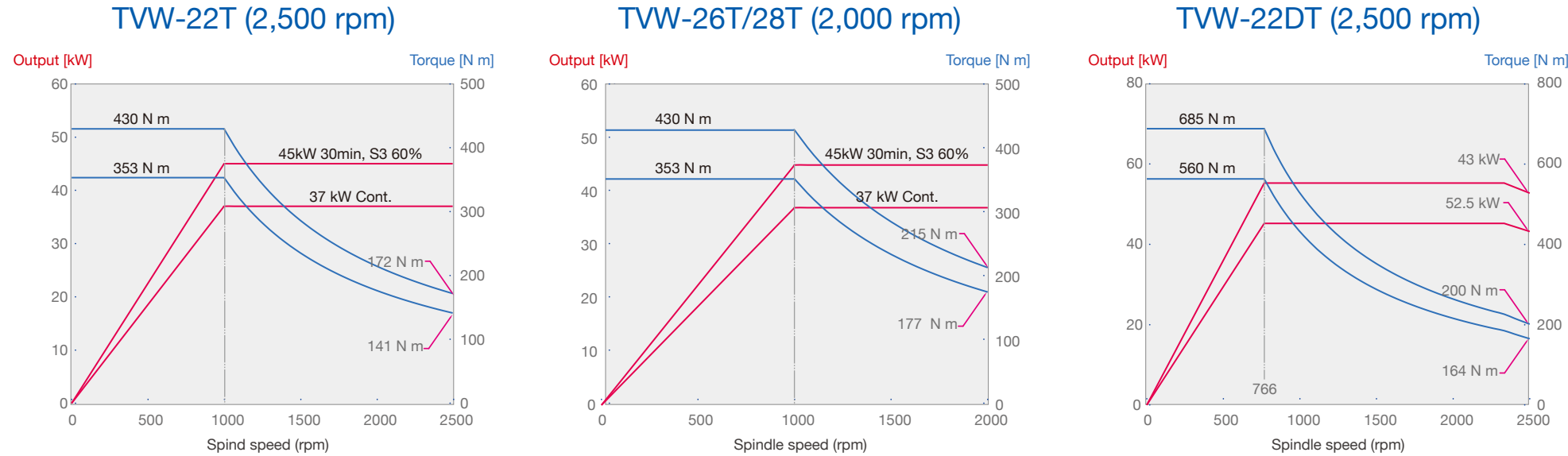
Turcite-B and precise scraping is applied on slide surface of box-way to ensure the best lubrication effect.



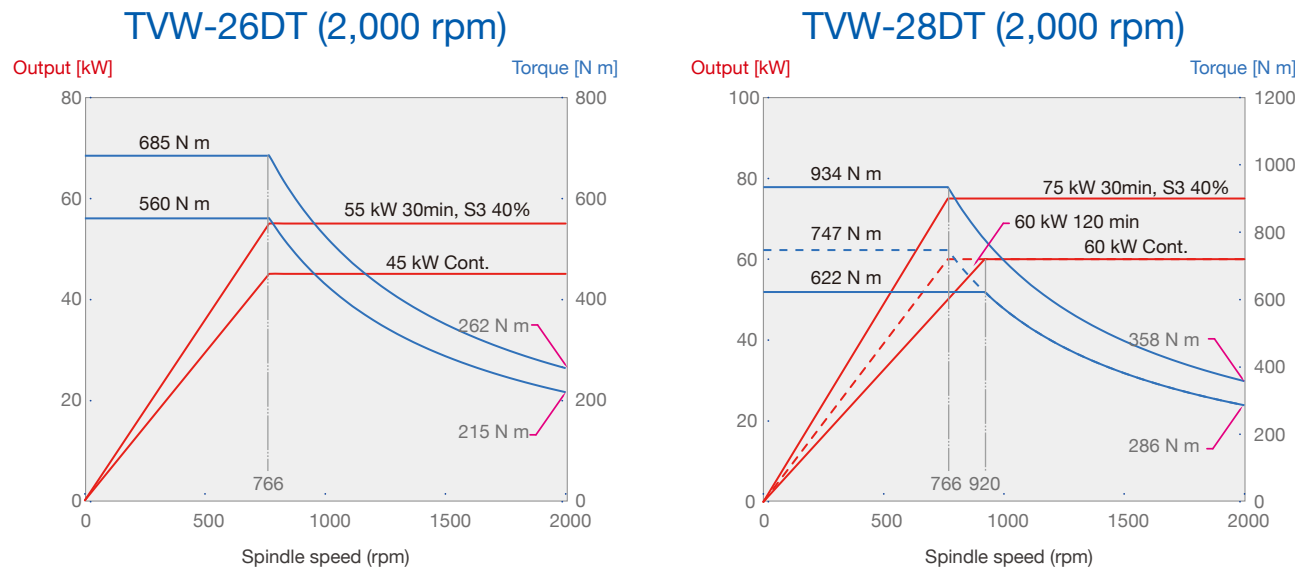
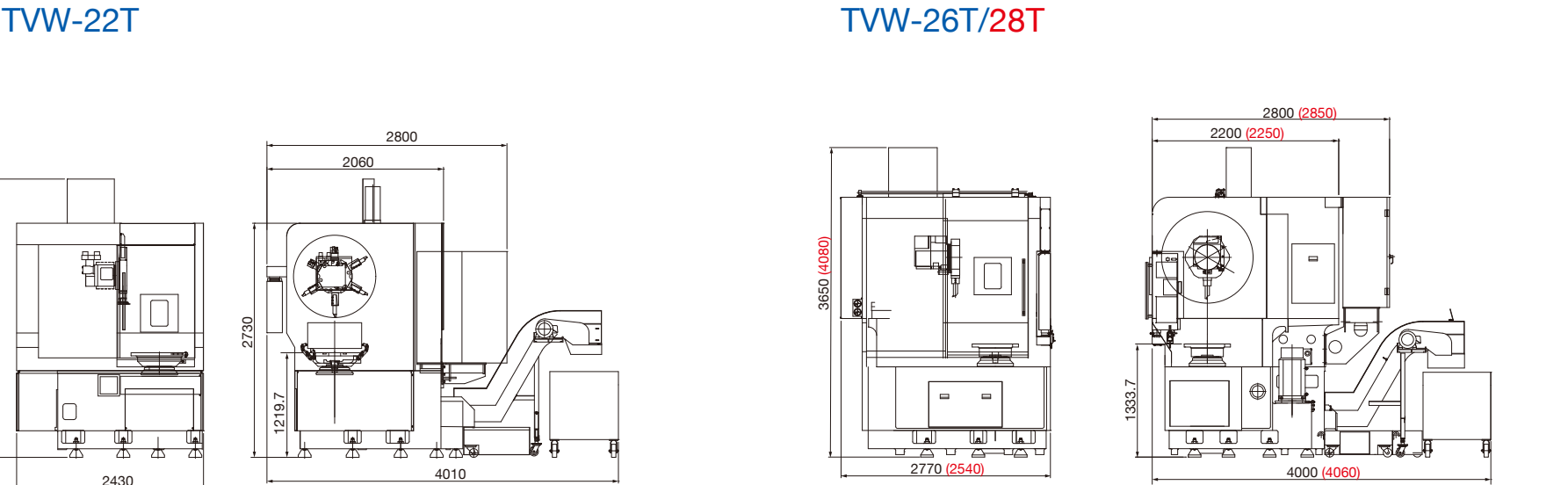
Casting components on this machine are made of high quality cast iron, and the static and dynamic rigidity is ensured by finite element analysis (FEA).

Excellent structure design benefits chip flow for wheel roughing.

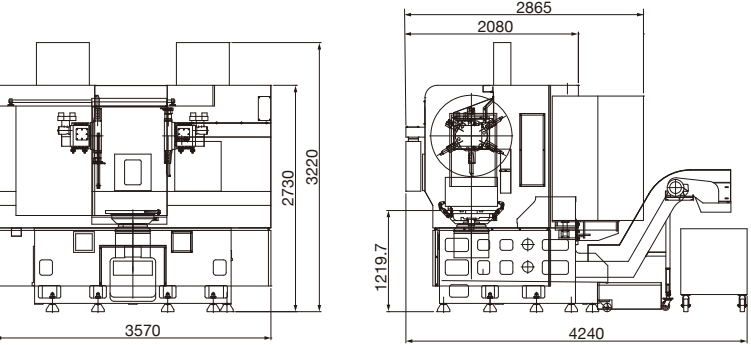
Spindle output and torque chart



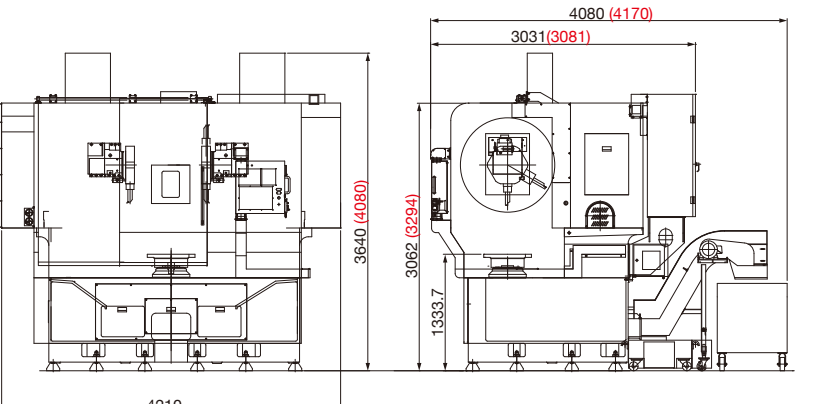
Machine dimension



TVW-22DT



TVW-26DT/TVW-28DT

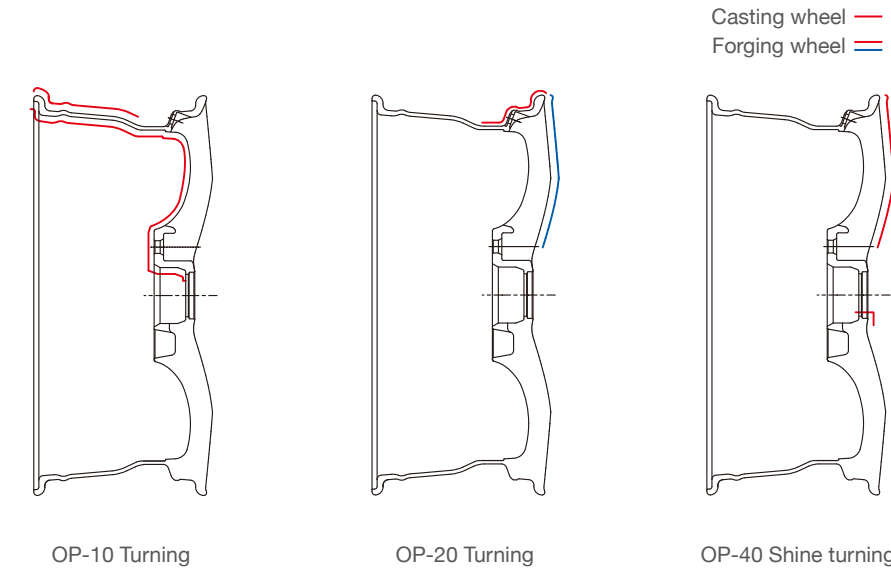


Unit : mm



Horizontal Wheel CNC Lathe

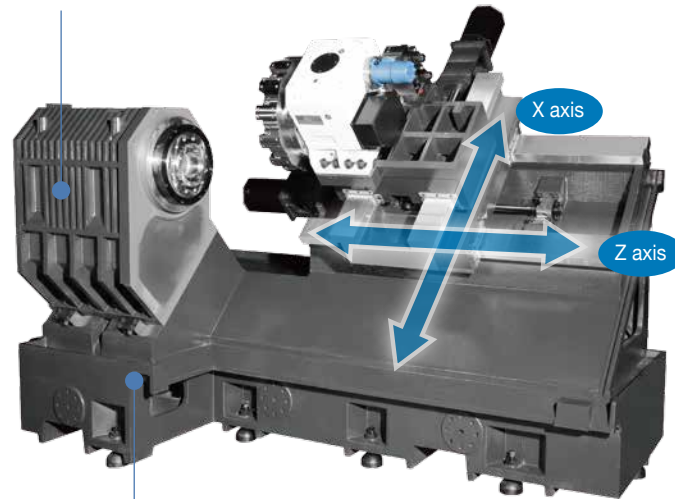
HS-36WIIG · HS-40WG



Specification		
Model	HS-36WIIG	HS-40WG
Wheel size	13" ~22"	14" ~24"
Spindle nose	A2-11	A2-11
Spindle speed	2,000 rpm	
Spindle bearing dia.	Ø160	
Tool capacity	10	8
X/Z axis stroke	350/740 mm	385/750 mm
X/Z axis rapid traverse	20/20 m/min	16/20 m/min
Spindle motor	45/37 kW	



High precesion built-in spindle with Ø160 mm bearing is available, it improves transmission efficiency and vibration occured by belt transmission mechanism at high speed. It's advantageous for shine facing that needs high machining accuracy.

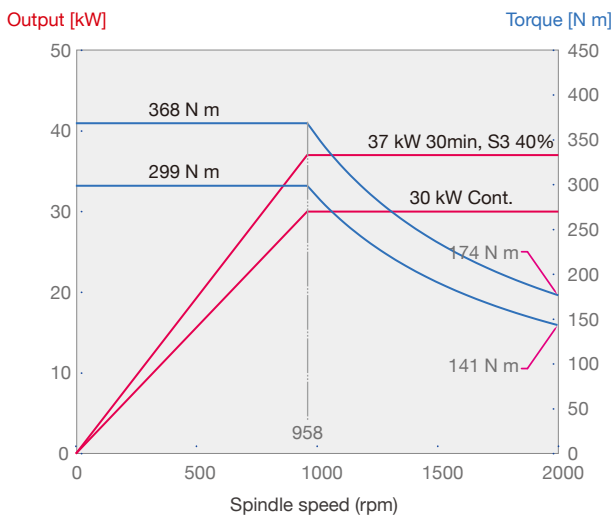


The 45 degree one-piece slant bed offers the best support for heavy duty cutting and stable machining accuracy.

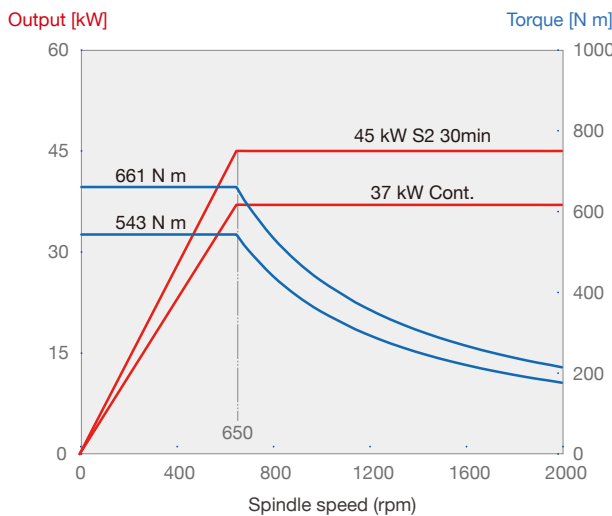


Spindle output and torque chart · Machine dimension

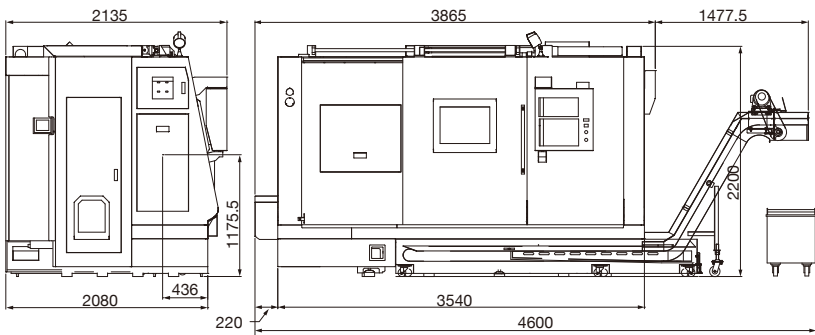
HS-36WII (2,000 rpm)



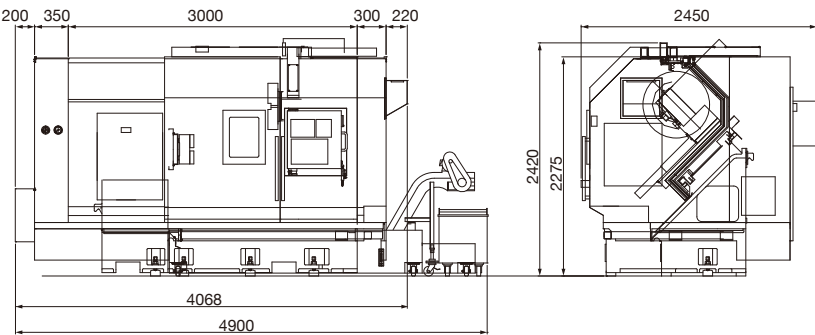
HS-40WG (2,000 rpm)



HS-36WIIG



HS-40WG

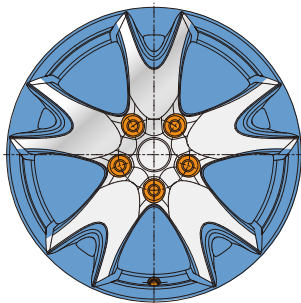


Unit : mm



Vertical Wheel Machining Center

TMV-850W • TMV-1050W • TMV-1100W



Casting wheel
Forging wheel



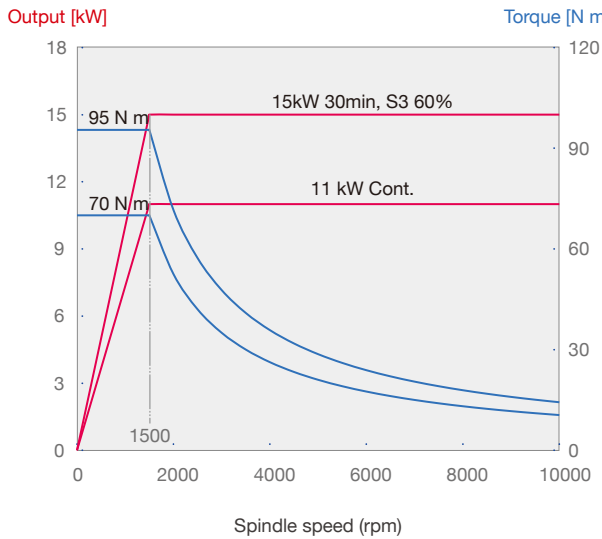
Specification			
Model	TMV-850W	TMV-1050W	TMV-1100W
Wheel size	14"~22"		14"~26"
Spindle nose	Taper 7/24 No.40		
Spindle speed	10,000 (15,000) rpm		
Tool capacity	24		
X/Y/Z axis travel	850/650/610 mm	1,050/650/610 mm	1,100/762/710 mm
X/Y/Z axis rapid traverse	48/48/48 m/min		30/30/20 m/min
Spindle motor	15/11 (11/7.5) kW		



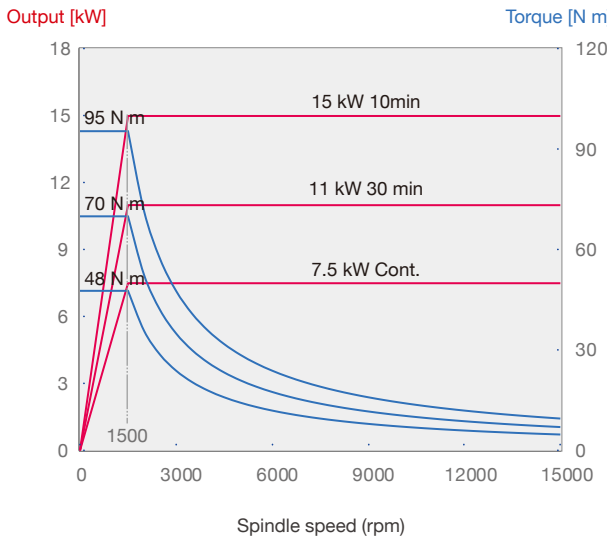
- Standard four chip augers or optional four coolant flushing outlet can remove any mount of chip efficiently.
- 4th axis is available to satisfy a variety of machining processes, including profile contouring, bolt hole drilling, air valve hole drilling and TPMS (Tire Pressure Monitoring System) hole drilling.

Spindle output and torque chart

10,000 rpm without CTS (Std.)

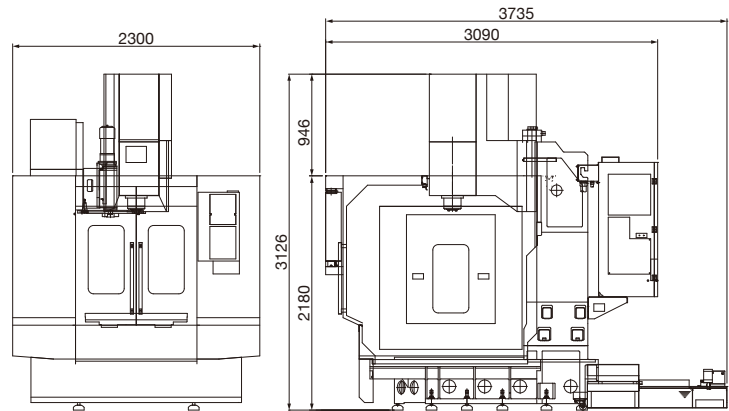


15,000 rpm with CTS (Opt.)

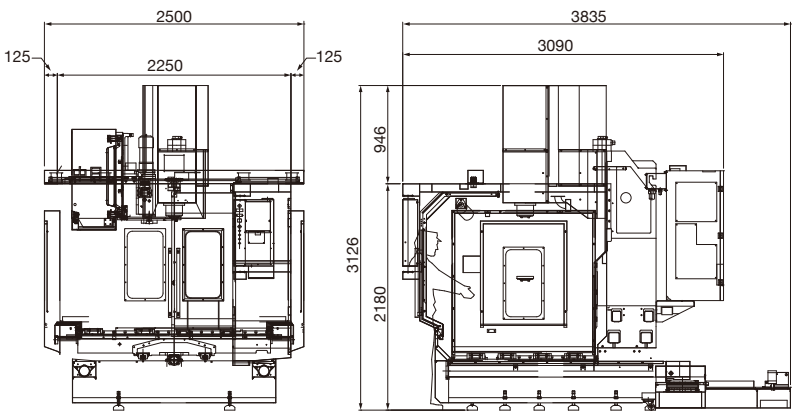


Machine dimension

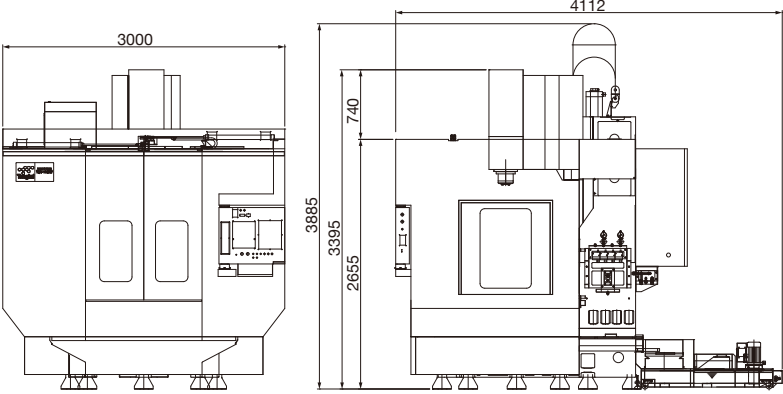
TMV-850W

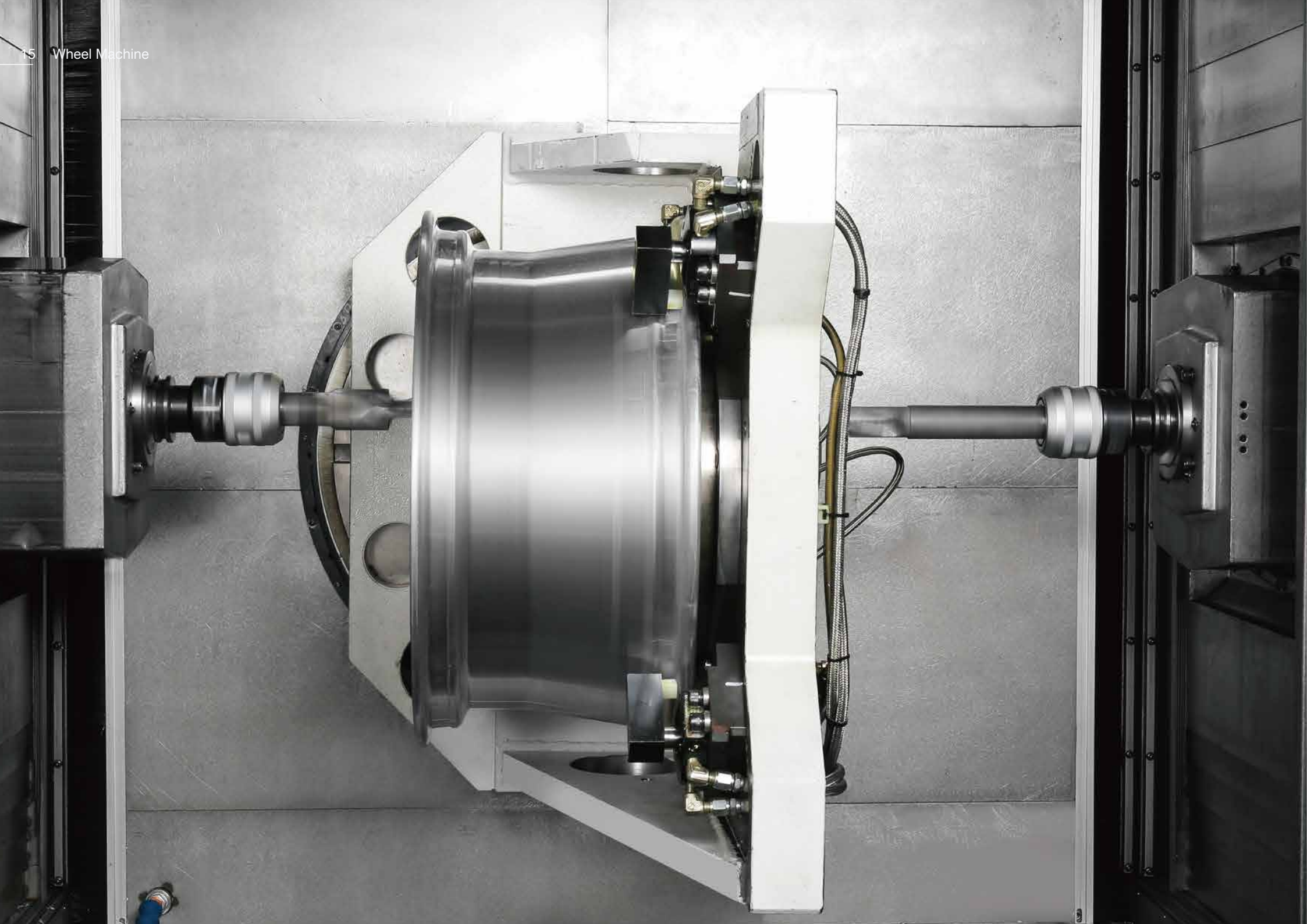


TMV-1050W



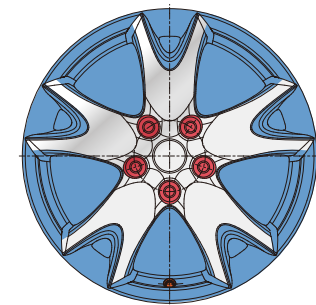
TMV-1100W





Horizontal Wheel Machining Center

MA-200

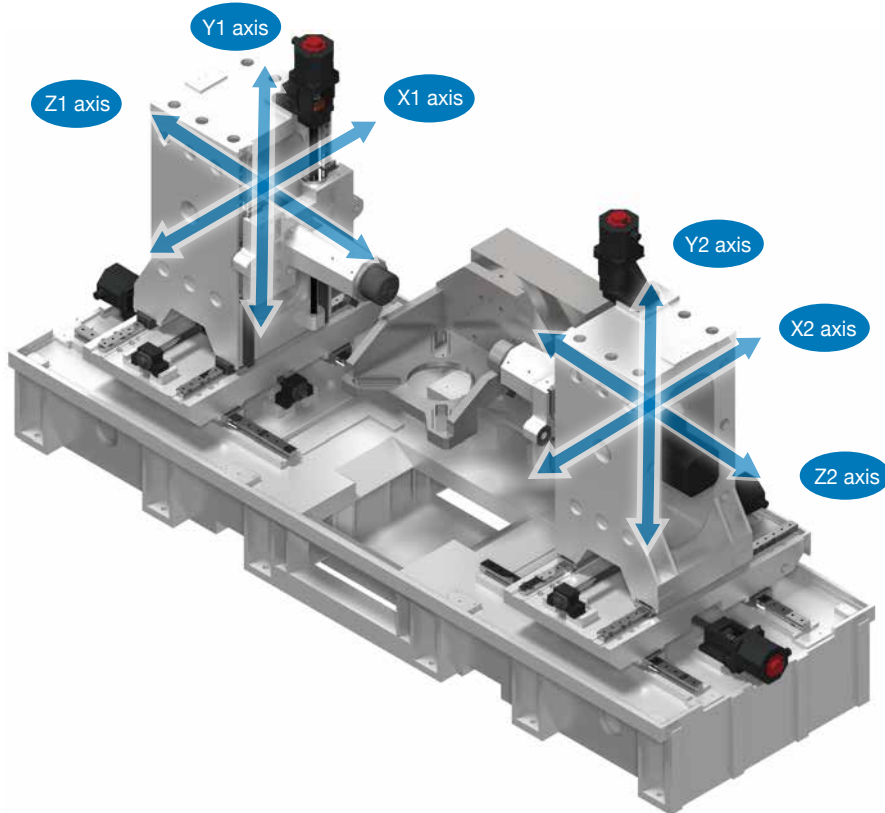


Casting wheel
Forging wheel



Specification

Model	MA-200
Wheel size	15" ~22"
Spindle nose	Taper 7/24 No.40
Spindle speed	10,000 rpm
Tool capacity	7
X/Y/Z axis stroke	200/530/410 mm
X/Y/Z axis rapid traverse	48/48/48 m/min
Spindle motor	Left: 15/18.5 kW Right: 11/15 kW

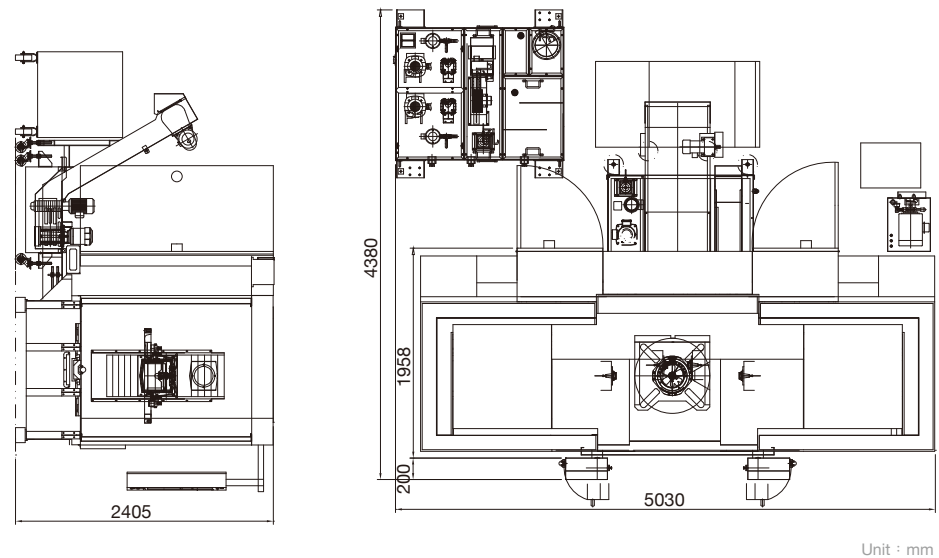
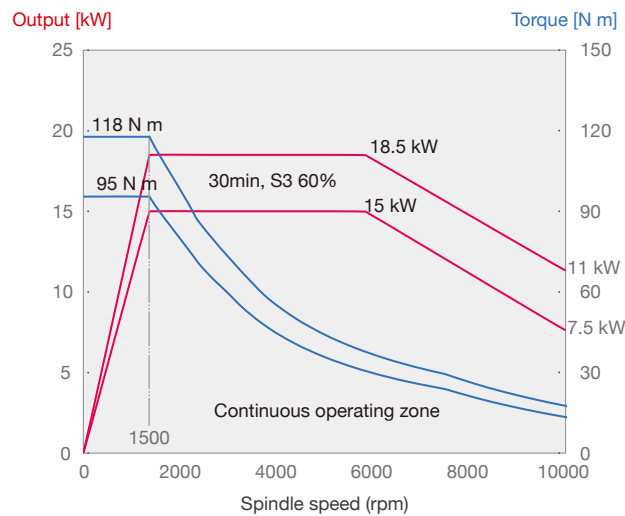


- Twin spindle can process cutting simultaneously to reduce cycle time.
- Substitute for two vertical machining centers, one MA-200 can cover all the duty done in two machining centers, including machining the front and back side of the wheel rim in one set-up. It's can decrease non-productive time. Moreover, the compact design minimizes floor space and improves investment return.
- 4th axis is available to satisfy a variety of machining processes, including profile contouring, bolt hole drilling, air valve hole drilling and TPMS (Tire Pressure Monitoring System) hole drilling.



Spindle output and torque chart · Machine dimension

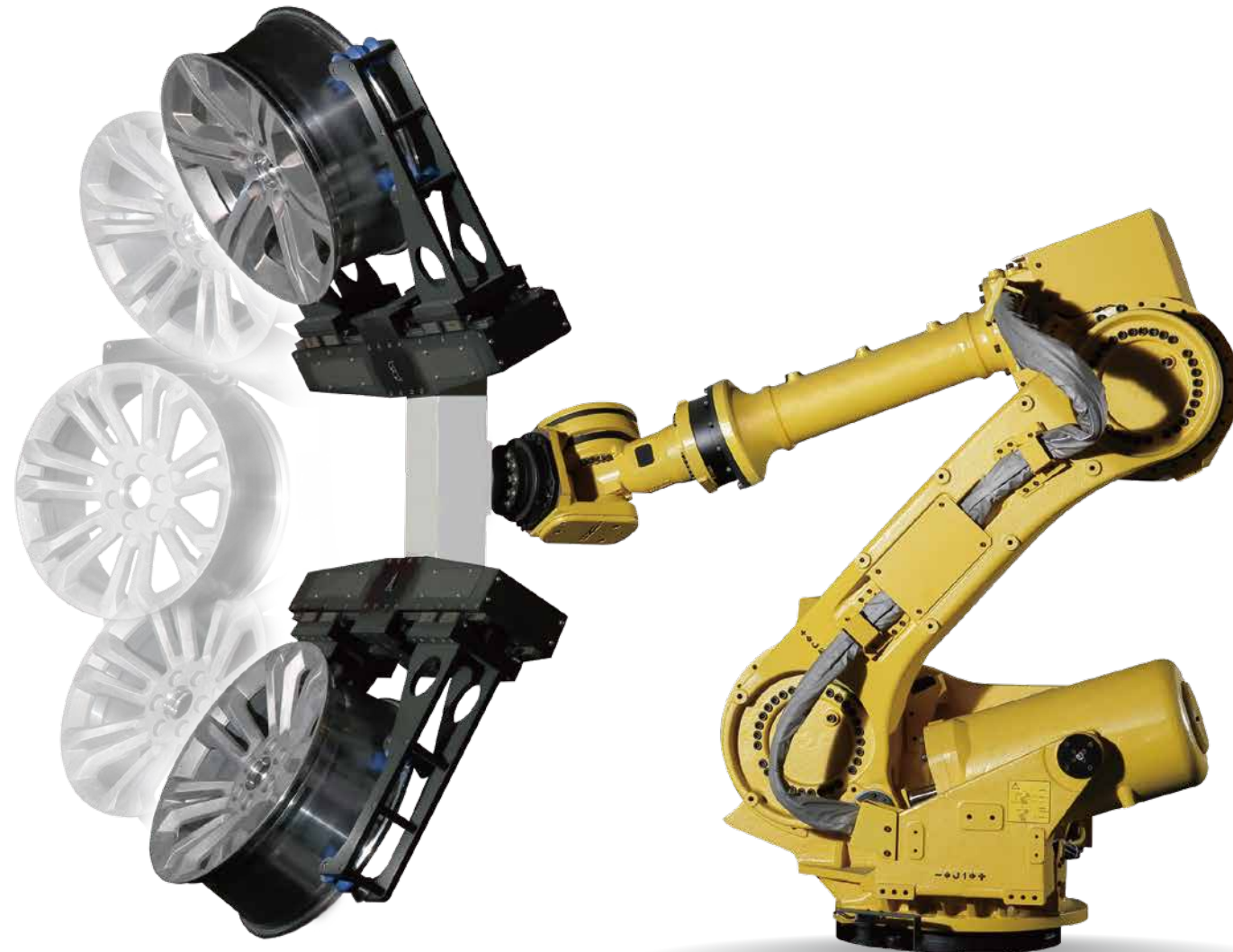
Left/Right spindle 10,000 rpm with CTS



Automatic wheel machining line

Automatic technology has made a spurt of progress for past years. Automatic production system was introduced into many corporations continually, that not only improved competency and presonnel costs, also improved production capacity and yield rate. Automatic production brings economic profit and thchnology development, it has become the key of corporation value creation and industry competency improvement.

Automatic production is very suitable for wheel machining line. It can save labor power in transit. In addition, avoid the accidents that may occur because of huge workpiece like wheel machining in high speed. To integrate Tongtai's abundant customized experience and technology with complete wheel machining line, it can offer customer the best beneficially automatic solution from material preparation, machining, inspection, stock to production management.



- 1 OP-10 TWV-22DT
- 2 OP-20 TWV-22DT
- 3 OP-30 TMV-1050W
- 4 Robot controller
- 5 Robot
- 6 Row material conveyor
- 7 Finished part conveyor
- 8 Workpiece reverse station
- 9 Washing station

Specification

item	Specification	Unit	TVW-22DT	TVW-22T	TVW-26DT	TVW-26T	TVW-28DT	TVW-28T
Wheel size	Aluminum wheel O.D.	inch	14"~22"		14"~24"		14"~28"	
	Aluminum wheel height	inch	12"		6"~12"		6"~18.5"	
Spindle	Spindle nose		A2-11		A2-11		A2-11	
	Spindle speed	rpm	2,500		2,000		2,000	
	Spindle bearing diameter	mm	Ø160		Ø160		Ø160	
Turret	Tool capacity	pc	6+6	6	6+6	6	6+6	6
	O.D. tool	mm	32x32		32x32		32x32	
	I.D. tool	mm	Ø50		Ø50		Ø50	
ATC	Tool capacity	pc	-		-		-	
	Max. tool diameter	mm	-		-		-	
	Max. tool length	mm	-		-		-	
Travel	X axis travel (Left/Right)	mm	450/450	450	500/500	500	540/540	540
	Y axis travel	mm	-		-		-	
	Z axis travel (Left/Right)	mm	450/450	450	525/525	525	750/750	750
Feed	X/Z axis rapid traverse	m/min	20/20		20/20		20/20	
	X/Z axis cutting feedrate	mm/rev	0.001-5,000		0.001-5,000		0.001-5,000	
Hydraulic unit	Hydraulic tank capacity	L	80		80		80	
	Hydraulic motor	kW	3.75		3.75		3.75	
Coolant unit	Coolant tank capacity	L	650	450	750	600	750	600
	Coolant pump motor	kW	2.2x1 + 1.1x1	2.2x1	2.2x1 + 1.1x1	2.2x1	2.2x1 + 1.1x1	2.2x1
Motor	Spindle motor	kW	55/45	45/37	55/45	45/37	75/60	45/37
	X/Z axis servo motor	kW	4.0/-7.0		4.0/-7.0		4.0/-7.0	
Machine size	Width×depth×height	mm	3,570x4,240x3,220	2,430x4,010x3,175	4,210x4,080x3,640	2,770x4,000x3,650	4,210x4,170x4,080	2,540x4,060x4,080
	Weight	kg	15,500	10,000	19,800	12,850	23,000	15,000
Controller			Fanuc 0i-TF		Fanuc 0i-TF		Fanuc 0i-TF	

Specification

item	Specification	Unit	HS-36WII	HS-40WG	TMV-850W	TMV-1050W	TMV-1100W	MA-200
Wheel size	Aluminum wheel O.D.	inch	13"~22"	14"~24"	14"~22"		14"~26"	15"~22"
	Aluminum wheel height	inch	-		4"~10.5"		4"~12.5"	10"
Spindle	Spindle nose		A2-11		7/24 Taper No. 40			7/24 Taper No.40
	Spindle speed	rpm	2,000		10,000 (15,000)			10,000
	Spindle bearing diameter	mm	Ø160		Ø70			Ø70
Turret	Tool capacity	pc	10	8	-			-
	O.D. tool	mm	32x32		-			-
	I.D. tool	mm	Ø50		-			-
ATC	Tool capacity	pc	-		24			7
	Max. tool diameter	mm	-		Ø89			Ø89
	Max. tool length	mm	-		300			343
Travel	X axis travel (Left/Right)	mm	350	385	850	1,050	1,100	200
	Y axis travel	mm	-		650		762	530
	Z axis travel (Left/Right)	mm	740	750	610		710	410
Feed	X/Z axis rapid traverse	m/min	20/-/20	16/-/20	48/48/48		30/30/20	48/48/48
	X/Z axis cutting feedrate	mm/rev	0.001-5,000		1-10,000			1-10,000
Hydraulic unit	Hydraulic tank capacity	L	40		30			40
	Hydraulic motor	kW	2.25		1.5			2.25
Coolant unit	Coolant tank capacity	L	420	475	550			615
	Coolant pump motor	kW	2.2x1		0.55			1.1×3
Motor	Spindle motor	kW	45/37		15/11 (11/7.5)			Left : 18.5/15 Right : 15/11
	X/Z axis servo motor	kW	4.0/-7.0		4.0/4.0/7.0			6.0/7.0/4.0
Machine size	Width×depth×height	mm	4,600x2,080x2,200	4,900x2,450x2,420	2,300x3,735x3,126	2,500x3,835x3,126	3,000x4,112x3,395	5,030×4,380×2,405
	Weight	kg	7,000	10,000	6,500	7,300	9,800	12,000
Controller			Fanuc 0i-TF		Fanuc 0i-MF			Fanuc 0i-TF