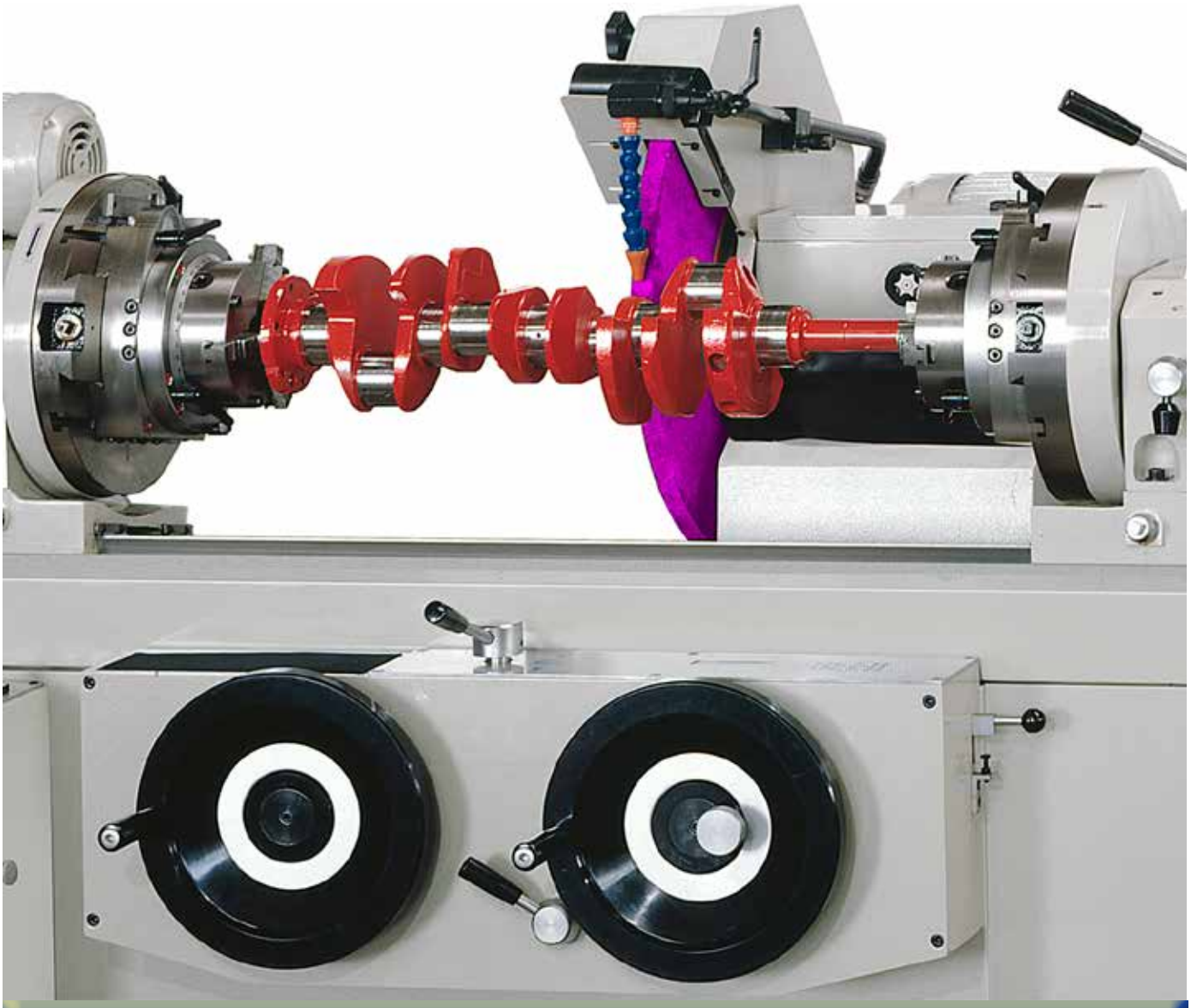


REX

HYDRAULIC CRANKSHAFT GRINDERS

PRECISION SINCE 1936

ROBBI

MADE IN ITALY

Robbi Group srl
Via dell'Industria 7
37040 Veronella - VR
Italia
39 0442 47700
39 0442 47966
robbi@robbigroup.com
https://rettificatrici-robbi.com

MEMBER COMPANY UCIMU

REX: HYDRAULIC CRANKSHAFT GRINDERS

REX Crankshaft Grinders use work heads with 4-way cross slides with an advanced locking system which permits quick centering of the crankshaft.
Heavy duty one piece cast iron construction assures you a lifetime of superior accuracy and dependability.

WHEEL HEAD

Sideways are coated with antifriction material to obtain free movement and a minimun of wear
Hardened steel spindle, turns in oil bathed fully adjustble precision sleeve bearings

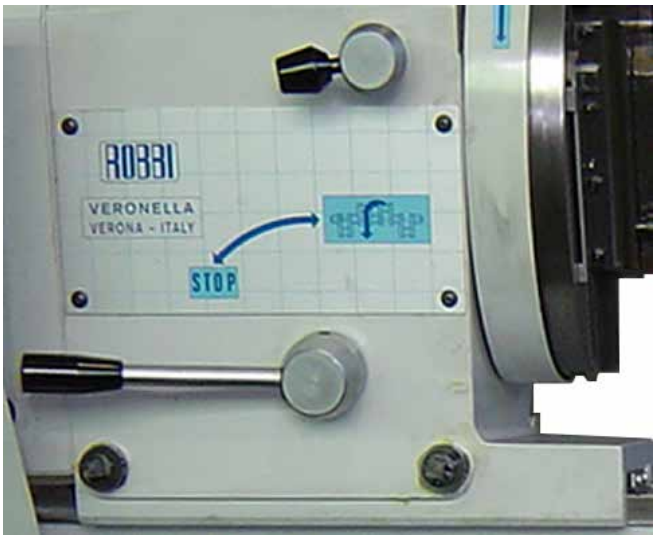
HYDRAULIC CONTROLS

Rapid hydraulic wheelhead traverse and hydraulic table movement increase speed during set-up and grinding
Fine feed controls for both movements assure accuracy

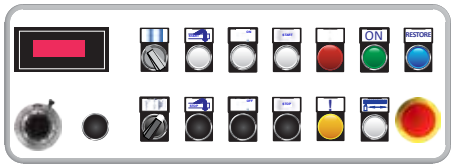
WORK HEADS

4 way cross slides with advanced locking system permit quick centering of crankshaft. Shiftring is found by a centesimal dial indicator
"O" setting is obtained by shifting the heads against the central stop, which maybe released for possible corrections
Indexed chucks rotate 360 °
Micrometric chuck rotation
Easy change from chucks to centers
Only two keys for all shifting, centering and clamping operations

REX 1200 - 1500



REX 1800 - 3100



REX 1200 - REX 1200 K

STANDARD EQUIPMENT

Electric installation 24 V
Hydraulic installation
Cooling installation with tank
Two self centering chucks
Pair of additional counter weights
Grinding wheel with pair of wheel hubs
Narrow steady rest
Wheel periphery and side truing attachment with diamond
Eccentricity control device with dial gauge
Truing fixture for checking concentricity with dial gauge
V-square for centering of crankpins with dial gauge
Wheel balancing mandrel
Motor drive pulley for reduced wheel diameter
Grinding wheel stripper
Set of steel splash guards
Service spanners
Operating manual

TECHNICAL SPECIFICATIONS

Distance between centers		1320	mm
Distance between chucks		1300	mm
Height of centers over table		220	mm
Swing over table	Max	440	mm
Offset of centers	Max	80	mm
Grinding diameter	Max	180	mm
Fast hydraulic wheelhead traverse		80	mm
Hand micrometric wheelhead feed		150	mm
Hand micrometric wheelhead feed graduation		0,005	mm
Whellhead feed per reverse		1	mm
Hand micrometric worktable traverse per reverse		11	mm
Fast hydraulic worktable traverse		3	m/min
Grinding wheel speeds	Min	1000	rpm
Grinding wheel speeds	Max	1150	
Grinding wheel diameter	Max	610	mm
Width of grinding wheel	Min	19	mm
Width of grinding wheel	Max	40	mm
Diameter of chucks		160	mm
Chucks holding diameter		200	mm
Rest capacity		30-100	mm
Workhead spindle speeds		35-70	rpm
Weight on centers	Max	120	Kg
Weight on rests	Max	300	Kg
Wheel-head motor		4	kW
Workhead spindle motor		0,33-05	kW
Hydraulic power motor		0,5	kW
Cooling pump		0,12	kW
Length		3300	mm
Width		1350	mm
Height		1550	mm
Approximate net weight		2800	Kg

REX 1500 NM

STANDARD EQUIPMENT

- Electric installation 24 V
- Hydraulic installation
- Cooling installation with tank
- Two self centering chucks
- Pair of additional counter weights
- Grinding wheel with pair of wheel hubs
- Narrow steady rest
- Wheel periphery and side truing attachment with diamond
- Eccentricity control device with dial gauge
- Truing fixture for checking concentricity with dial gauge
- V-square for centering of crankpins with dial gauge
- Wheel balancing mandrel
- Motor drive pulley for reduced wheel diameter
- Grinding wheel stripper
- Set of steel splash guards
- Service spanners
- Operating manual

TECHNICAL SPECIFICATIONS

Distance between centers		1550	mm
Distance between chucks		1540	mm
Height of centers over table		250	mm
Swing over table	Max	500	mm
Offset of centers	Max	100	mm
Grinding diameter	Max	180	mm
Fast hydraulic wheelhead traverse		110	mm
Hand micrometric wheelhead feed		150	mm
Hand micrometric wheelhead feed graduation		0,005	mm
Whellhead feed per reverse		1	mm
Hand micrometric worktable traverse per reverse		11	mm
Fast hydraulic worktable traverse		3	m/min
Grinding wheel speeds	Min	900	rpm
Grinding wheel speeds	Max	1000	
Grinding wheel diameter	Max	710	mm
Width of grinding wheel	Min	19	mm
Width of grinding wheel	Max	50	mm
Diameter of chucks		180	mm
Chucks holding diameter		220	mm
Rest capacity		30-100	mm
Workhead spindle speeds		20-30-40-60	rpm
Weight on centers	Max	200	Kg
Weight on rests	Max	500	Kg
Wheel-head motor		5,5	kW
Workhead spindle motor		0,5-0,75	kW
Hydraulic power motor		0,75	kW
Cooling pump		0,12	kW
Length		3900	mm
Width		1500	mm
Height		1700	mm
Approximate net weight		3300	Kg

REX 1800

STANDARD EQUIPMENT

Electric installation 24 V	Eccentricity control device with dial gauge
Hydraulic installation	Truing fixture for checking concentricity with dial gauge
Cooling installation with tank	V-square for centering of crankpins with dial gauge
Two self centering chucks	Wheel balancing mandrel
Pair of additional counter weights	Motor drive pulley for reduced wheel diameter
Grinding wheel with pair of wheel hubs	Grinding wheel stripper
Narrow steady rest	Set of steel splash guards
Normal steady rest	Service spanners
Wheel periphery and side truing attachment with diamond	Operating manual

TECHNICAL SPECIFICATIONS

Distance between centers		1800	mm
Distance between chucks		1750	mm
Height of centers over table		300	mm
Swing over table	Max	600	mm
Offset of centers	Max	125	mm
Grinding diameter	Max	180	mm
Fast hydraulic wheelhead traverse		130	mm
Hand micrometric wheelhead feed		170	mm
Hand micrometric wheelhead feed graduation		0,005	mm
Whellhead feed per reverse		1	mm
Hand micrometric worktable traverse per reverse		8	mm
Fast hydraulic worktable traverse		3	m/min
Grinding wheel speeds	Min	850	rpm
Grinding wheel speeds	Max	940	
Grinding wheel diameter	Max	760	mm
Width of grinding wheel	Min	19	mm
Width of grinding wheel	Max	50	mm
Diameter of chucks		200	mm
Chucks holding diameter		250	mm
Rest capacity		30-120	mm
Workhead spindle speeds		0÷60	rpm
Weight on centers	Max	350	Kg
Weight on rests	Max	800	Kg
Wheel-head motor		5,5	kW
Workhead spindle motor		2,2	kW
Hydraulic power motor		1,25	kW
Cooling pump		0,12	kW
Length		4500	mm
Width		1650	mm
Height		1700	mm
Approximate net weight		4600	Kg

REX 2200 L - REX 2200 RM

STANDARD EQUIPMENT

- Electric installation 24 V
- Hydraulic installation
- Cooling installation with tank
- Two self centering chucks
- Pair of additional counter weights
- Grinding wheel with pair of wheel hubs
- Narrow steady rest
- Normal steady rest
- Wheel periphery and side truing attachment with diamond
- Eccentricity control device with dial gauge
- Truing fixture for checking concentricity with dial gauge
- V-square for centering of crankpins with dial gauge
- Wheel balancing mandrel
- Motor drive pulley for reduced wheel diameter
- Grinding wheel stripper
- Set of steel splash guards
- Service spanners
- Operating manual

TECHNICAL SPECIFICATIONS

		L	RM	
Distance between centers		2300		mm
Distance between chucks		2220		mm
Height of centers over table		300	350	mm
Swing over table	Max	600	700	mm
Offset of centers	Max	130	150	mm
Grinding diameter	Max	180	200	mm
Fast hydraulic wheelhead traverse		130	170	mm
Hand micrometric wheelhead feed		180	200	mm
Hand micrometric wheelhead feed graduation		0,005		mm
Whellhead feed per reverse		1		mm
Hand micrometric worktable traverse per reverse		8		mm
Fast hydraulic worktable traverse		3		m/min
Grinding wheel speeds	Min	850	770	rpm
Grinding wheel speeds	Max	940	900	
Grinding wheel diameter	Max	760	815	mm
Width of grinding wheel	Min	19		mm
Width of grinding wheel	Max	50	60	mm
Diameter of chucks		200	230	mm
Chucks holding diameter		250	290	mm
Rest capacity		30-120	30-160	mm
Workhead spindle speeds		0÷60		rpm
Weight on centers	Max	350	600	Kg
Weight on rests	Max	800	1500	Kg
Wheel-head motor		7,5	10	kW
Workhead spindle motor		2,2		kW
Hydraulic power motor		1,25	1,25	kW
Cooling pump		0,12	0,12	kW
Length		5000		mm
Width		1750		mm
Height		1750	1800	mm
Approximate net weight		5000	5400	Kg

REX 2700 RM - REX 2700 M

STANDARD EQUIPMENT

- Electric installation 24 V
- Hydraulic installation
- Cooling installation with tank
- Two self centering chucks
- Pair of additional counter weights
- Grinding wheel with pair of wheel hubs
- Narrow steady rest
- Normal steady rest
- Wheel periphery and side truing attachment with diamond
- Eccentricity control device with dial gauge
- Truing fixture for checking concentricity with dial gauge
- V-square for centering of crankpins with dial gauge
- Wheel balancing mandrel
- Motor drive pulley for reduced wheel diameter
- Grinding wheel stripper
- Set of steel splash guards
- Service spanners
- Operating manual

TECHNICAL SPECIFICATIONS

		RM	M	
Distance between centers		2800		mm
Distance between chucks		2700		mm
Height of centers over table		350	400	mm
Swing over table	Max	700	800	mm
Offset of centers	Max	150	200	mm
Grinding diameter	Max	200	230	mm
Fast hydraulic wheelhead traverse		170	190	mm
Hand micrometric wheelhead feed		200	220	mm
Hand micrometric wheelhead feed graduation		0,005		mm
Whellhead feed per reverse		1		mm
Hand micrometric worktable traverse per reverse		8		mm
Fast hydraulic worktable traverse		3		m/min
Grinding wheel speeds	Min	770	680	rpm
Grinding wheel speeds	Max	900	800	
Grinding wheel diameter	Max	815	915	mm
Width of grinding wheel	Min	19	25	mm
Width of grinding wheel	Max	60	70	mm
Diameter of chucks		230	250	mm
Chucks holding diameter		290	310	mm
Rest capacity		30-160	30-200	mm
Workhead spindle speeds		0÷60		rpm
Weight on centers	Max	600	950	Kg
Weight on rests	Max	1.500	2200	Kg
Wheel-head motor		7,5	12,5	kW
Workhead spindle motor		2,2		kW
Hydraulic power motor		1,25		kW
Cooling pump		0,12		kW
Length		5500	6000	mm
Width		1850	2100	mm
Height		1800	2000	mm
Approximate net weight		6400	7400	Kg

REX 3100 M

STANDARD EQUIPMENT

- Electric installation 24 V
- Hydraulic installation
- Cooling installation with tank
- Two self centering chucks
- Pair of additional counter weights
- Grinding wheel with pair of wheel hubs
- Narrow steady rest
- Normal steady rest
- Wheel periphery and side truing attachment with diamond
- Eccentricity control device with dial gauge
- Truing fixture for checking concentricity with dial gauge
- V-square for centering of crankpins with dial gauge
- Wheel balancing mandrel
- Motor drive pulley for reduced wheel diameter
- Grinding wheel stripper
- Set of steel splash guards
- Service spanners
- Operating manual

TECHNICAL SPECIFICATIONS

Distance between centers		3200	mm
Distance between chucks		3100	mm
Height of centers over table		400	mm
Swing over table	Max	800	mm
Offset of centers	Max	200	mm
Grinding diameter	Max	230	mm
Fast hydraulic wheelhead traverse		190	mm
Hand micrometric wheelhead feed		200	mm
Hand micrometric wheelhead feed graduation		0,005	mm
Whellhead feed per reverse		1	mm
Hand micrometric worktable traverse per reverse		8	mm
Fast hydraulic worktable traverse		3	m/min
Grinding wheel speeds	Min	680	rpm
Grinding wheel speeds	Max	800	
Grinding wheel diameter	Max	915	mm
Width of grinding wheel	Min	25	mm
Width of grinding wheel	Max	70	mm
Diameter of chucks		250	mm
Chucks holding diameter		310	mm
Rest capacity		30-200	mm
Workhead spindle speeds		0÷60	rpm
Weight on centers	Max	950	Kg
Weight on rests	Max	2.200	Kg
Wheel-head motor		7,5	kW
Workhead spindle motor		2,2	kW
Hydraulic power motor		1,5	kW
Cooling pump		0,25	kW
Length		5500	mm
Width		1850	mm
Height		1800	mm
Approximate net weight		8400	Kg

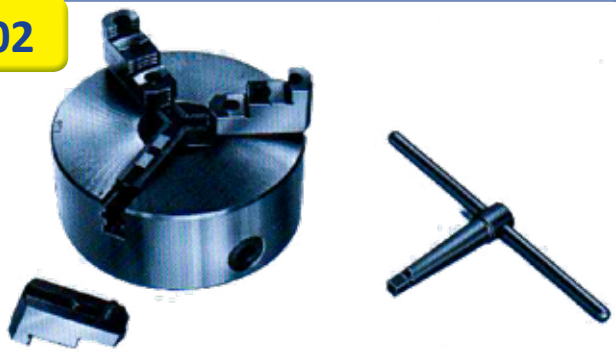
Standard Equipment

01 Cooling installation with tank
02 Two self centering chucks
03 Pair of additional counter weights
04 Grinding wheel with pair of wheel hubs
05 Narrow steady rest
06 Normal steady rest (excluding Rex 1200 and Rex 1500)
07 Wheel periphery and side truing attachment with diamond
08 Eccentricity control device with dial gauge
09 Truing fixture for checking concentricity with dial gauge
10 V-square for centering of crankpins with dial gauge
11 Wheel balancing mandrel
12 Motor drive pulley for reduced wheel diameter
13 Grinding wheel stripper
14 Set of steel splash guards
15 Service spanners
16 Operating manual

01

Hydraulic Crankshaft Grinders

02



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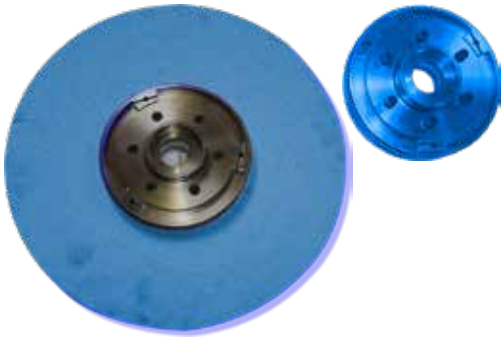

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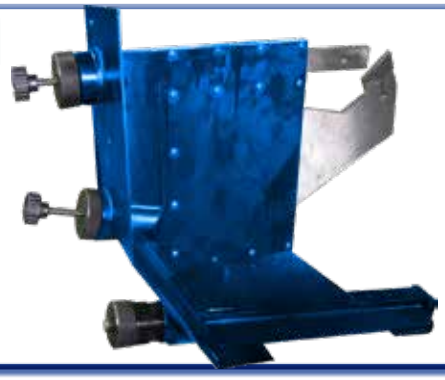

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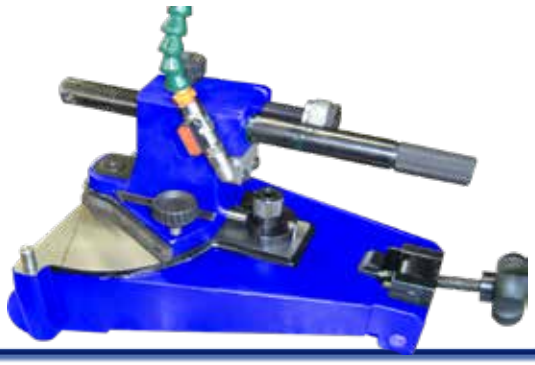

10

08

09

11

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17

DOTAZIONI EXTRA

13.00	Hydraulic truing attachment for wheelhead periphery, without diamond
030R	Infinitely variable hydraulic table traverse speed from 0 to 3000 mm/min with automatic reversing and variable dwell, for cylindrical grinding
031R	Infinitely variable hydraulic table traverse speed from 0 to 3000 mm/min with autonatic reversing and variable dwell and centesimal wheel feed adjustable from 0,01 to 0,04 mm for cylindrical grinding
AG	System for gauging while working capavity from ø 30 ÷ 130 mm
AG.240	Equipment for AG capacity ø 130 ÷ 240 mm
019M	Dial indicator ø 100 mm cwith reduction for application on AG
021M	Electronic equipment for continuos gauging during grinding work operation with one screen complete with transducer head application on AG
1001	Electronic equipment for continuos gauging during grinding work operations with two screens complete with transducer head applicable on AG
020R	Balancing stand for grinding wheels and other rotating parts, disc type
021R	Balancing stand for grinding wheels and other rotating parts, blade type
14.00	Centre grinding attachment
033R	Portable belt super finisher
033.20	Abrasive belt 1450x20 mm for 033R
033.28	Abrasive belt 1450x28 mm for 033R
028R	Diamond tool for wheel dressing
024R	Coolant magnet cleaner
025R	Coolant paper cleaner
034R	Grinding wheel recessing attachment
16.00	Narrow steady rest
035R	Pair of additionals counterweights
036R	Divers for diameters 90 ÷150x35mm

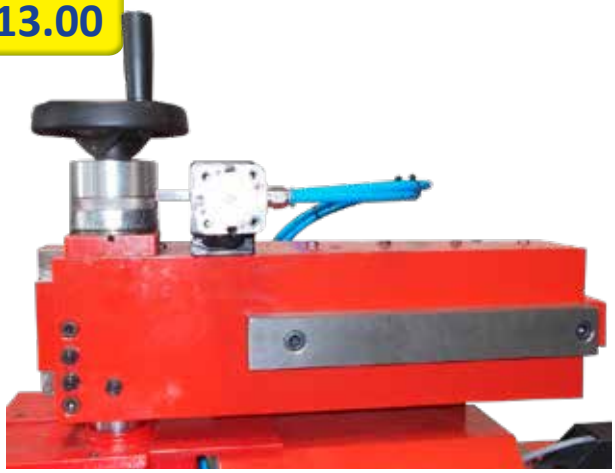
021R

033R

AG

AG

13.00



021M

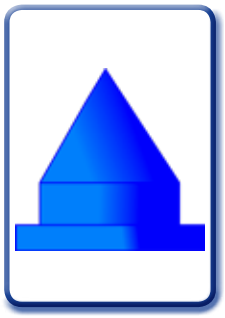
		mm	1200	1500 MN	1800	2200	3100M
Perno gira brida con vite		35			35.23.00.B	37.23.00.B	38.23.00.B
		50			35.23.00.C	37.23.00.C	38.23.00.C
		40	33.23.00.B	34.23.00.B			
		55	33.23.00.C	34.23.00.C			
Brida	ø	25-65	33.23.00.D				
		20-90		34.23.00.E	35.23.00.E		
		60-100			35.23.00.F	37.23.00.E	38.23.00.E
		90-150				37.23.00.F	38.23.00.F
Piastra menabrida			33.23.01	34.23.01	35.23.01	37.23.01	38.23.01
Punta conica	ø	40	33.23.08	34.23.08	35.23.08		
		45				37.23.08	38.23.08
Punta tronco-conica	ø	55	33.23.09	34.23.09	35.23.09		
		75			35.23.10		
		70				37.23.09	38.23.09
		93				37.23.10	38.23.10

Brida

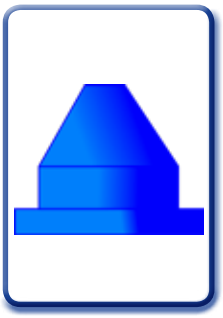
Brida

Piastra Mena Brida

Punta Conica Cuspide in Widia



Punta Conica in HSS



Punta Tronco conica in HSS

Semi-Automatic Crankshaft Grinders

Crankshaft grinding machines:
- Rex 2700
- Rex 3100

can be made also in semi-automatic version

Operator Panel

- SIEMENS TP 700 touch screen operator panel that allows a simple and intuitive working cyles programming
- Plunge and pass rectification cycles parametrically programmed
- Grinding with automatic stop at the programmed quote
- Grinding wheel dressing with automatic compensation
- Direct reading system of the work quota during the cycle (optional)
- Progress to the quota controlled by a measuring device in processl
- Electronic handwheels

The 'touch-screen' panel displays:
- machine status and alarm messages
- all the parameters set for the automatic cycle being processed
- any corrections to the set parameters made during the automatic cycle being processed

At Your Service Since 1936

Robbi has operated in the machine tool market since 1936 and specialise in the manufacture of machines tailored to meet the more demanding needs of the customer's complexed and more specialised demands.

Whilst maintaining competitive prices, Robbi have ensured their machines have stability and precision.

Robbi grinding machines, use the best technology and the most robust and reliable components available on the market in their build programme.

Robbi have a commitment to assist and help, proactively, its customers to ensure they maximise the efficiency of the machine.

Robbi, in fact, offers various service solutions, including the:

- *development of manufacturing processes;*
- *replacement parts spare part programme,*
- *making parts available for older models,*
- *tailored operational training programs*
- *and maintenance training to maximise the features of grinding machines and maintain the Robbi Grinders longevity.*

Understanding the needs of our customers we are offer the best solutions and services that increase their return on productivity thus improving our customers return on his investment.

Ideas that may improve our business are always appreciated from customers.

If there's anything we can do to improve your experience with Robbi, please let us know.

Robbi have a commitment to ensure all customers are completely satisfied.

Choose Robbi precision for increased productivity and a faster return on your investment.

Call us today,we've have a solution for your grinding application.

PRECISION SINCE 1936
ROBBI
MADE IN ITALY

Robbi Group srl
Via dell'Industria 7
37040 Veronella - VR
Italia
39 0442 47700
39 0442 47966
robbi@robbigroup.com
https://rettificatrici-robbi.com

MEMBER COMPANY
UCIMU