



MODEL 24

PRECISION PNEUMATIC LIFT FLAT LAPPING MACHINE



- The pneumatic lift version of the Model 24 is based on the open face machine, but has the pressure weights attached to the rods of three pneumatic cylinders. Self-aligning bearings accommodate any slight vertical misalignment and ensure an even pressure is applied to components inside the conditioning ring.
- The cylinders are mounted vertically on sliding rails within a fabricated hollow, known as a "spider bar". This is cantilevered over the lap plate and is mounted onto an upright column bolted to the machine frame. The primary function of the pneumatic arrangement is to permit loading and unloading to be carried out without the need to lift pressure weights manually. However, they can be used to supply additional loading to the components within the conditioning ring should this be required.
- Operator safety is a primary concern in the design. Movement of each pressure weight up or down is controlled by a two hand anti-tie down control box. This arrangement requires the use of both hands on two separate buttons to operate, and ensures that the operator cannot injure his hands or arms when lowering the weights.
- A further safety feature is that the pressure weights are mechanically latched when in the fully raised position so that, should the compressed air supply or electrical power fail, they will not fall.
- The machine is intended for use with free abrasive slurries -abrasive grit suspended in an oil-based or water based vehicle.
- Flatness of the lap plate, and consequently of the work, is controlled by adjusting the position of the three conditioning rings relative to the lap plate track.
- The pneumatic cylinders and pressure weights are also capable of the corresponding adjustment.
- This machine is also available in OpenFace version - refer to the appropriate Product Data sheet.

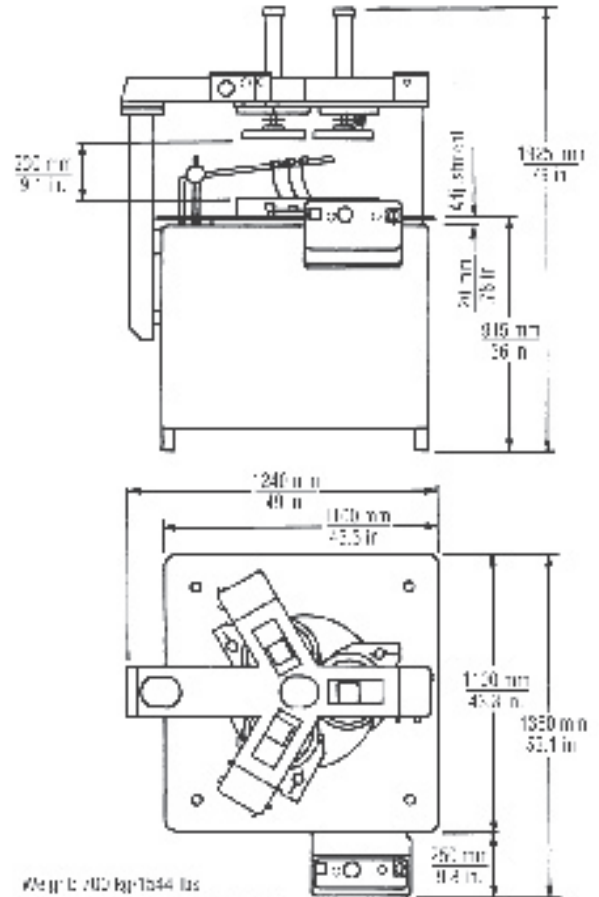


MODEL 24 STANDARD FEATURES

- Heavy duty hollow section steel floor standing base with integrally mounted-drive motor, gear reducer drive, abrasive storage, abrasive distributionsystem, complete with control panel.
- Heavy duty work table, vertically adjustable.
- Range of loads for pressure weights (machine connected to 4 bar supply.) 15kg/33lbs to 85kg/187lbs.Controls for raise/lower are of two hand anti-tie down type.
- Three conditioning rings, with adjustable roller bearing yoke assemblies to maintain lap plate flatness.
- Abrasive system complete with pump, tank and multiple point distribution.
- Electrical system wired for: 230V/460V, 60 Hz, 3 phase with operator controls at 110V complies with EN 60 204.
- Operator control panel with start and stop controls, and multiple range automatic cycle timer.
- High torque drive unit consisting of 1.5kW/2hp motor and heavy duty, sealed, maintenance - free gear reducer.Lap plate speed 70 rpm.
- Removable waste container.

STANDARD TOOLING

- High density, cast iron serrated lapping plate 610mm O.D.x 114mm I.D./ 24" O.D.X 4.5" I.D.
- Three high density cast iron serrated conditioning rings 286mm O.D.x 248mm I.D./ 11.25" O.D.x 9.75" I.D. Wear life 35mm/1.4".
- Three work holder blanks.
- Three felt pads.
- Starter sample of Lapmaster abrasive.
- Starter sample of Lapmaster vehicle.
- Lap plate lifting tool.
- Set of Allen Keys.
- Operation and maintenance manual.



Weight: 702 kg/1544 lbs
 MODEL SHOWN IN THIS MOUNTING OPTION
 1130mm x 1610mm x 2020mm
 44.5" x 63.0" x 80.0"
 Gross weight: 957 kg/2119 lbs

AVAILABLE OPTIONS

- 4 ring model.
- Variable speed lap drive 0-70 RPM (using frequency inverter).
- Water cooled lap plates..
- Non-standard voltages.
- Custom machines and tooling.
- Enlarged, moveable work table to improve multiple parts handling.



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Lapmaster has a policy of continued development and the specifications outlined above are subject to change without notice.