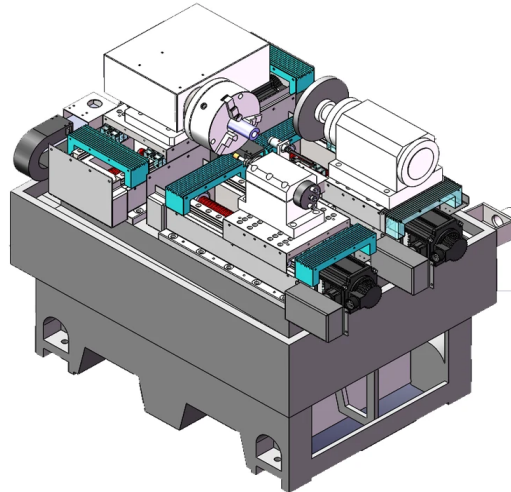


WK22 High Precision Internal and External CNC Punch Grinder

Model WK22 | Punch Grinder | WUK Machinery, Shenzhen China



Overview

The WK22 is a CNC punch grinder for internal and external grinding of punch pins and small precision components. It clamps from 1 mm to 150 mm diameter, swivels the workhead plus or minus 45 degrees and carries an internal spindle running between 10000 and 20000 rpm on ER11 collets. External wheel speed is variable from 0 to 8000 rpm.

Who It Is For

Stamping and progressive die shops, press tool makers, connector and terminal manufacturers, and maintenance teams that keep presses running on their own tooling.

Key Benefits

- **Clamping Range 1 to 150 mm** – Pilot pins, punches, die buttons and small bushes all go on the same machine, internal or external.
- **Internal Spindle to 20000 rpm** – Small bores need surface speed, not just rotation. 10000 to 20000 rpm on ER11 collets delivers it.
- **Workhead Swivel Plus Minus 45 Degrees** – Angled lands, chamfers and tapered forms are ground by setting the head rather than building a fixture.
- **25 mm Spindle Through Hole** – Long blanks feed through the spindle instead of cantilevering out of the chuck, which keeps deflection out of the ground diameter.

Technical Features

- CNC control, brand selectable from FANUC, SIEMENS, SYNTEC or GSK
- 150 mm horizontal and 150 mm longitudinal worktable travel
- Workhead rotation 0 to 1000 rpm, infinitely variable
- Internal spindle 10000 to 20000 rpm on ER11 collets
- External spindle motor 8000 to 10000 rpm with wheel speed variable 0 to 8000 rpm
- Grinding wheels from 125 to 150 mm diameter

WK22 Specifications

Figures are taken from the machine data sheet. Items not documented are marked TBC rather than estimated.

Clamping working diameter (ID and OD)	1 to 150 mm
Horizontal travel of worktable	150 mm
Longitudinal stroke of worktable	150 mm
Work head rotation speed	0 to 1000 rpm
Working head rotation angle	+/- 45 degrees
T slot of worktable	14 mm x 1
Internal spindle speed	10000 to 20000 rpm
Internal spindle collets	ER11
Grinding wheel speed (external)	0 to 8000 rpm
External spindle motor speed	8000 to 10000 rpm
Grinding wheel size	125 to 150 mm
Spindle through hole	25 mm
Machine overall dimensions (L x W x H)	1200 x 500 x 1500 mm
Machine weight	1280 kg

Applications

- Regrinding worn punches in progressive and compound dies
- Making replacement punch pins in house instead of buying them
- Grinding die buttons and bushes on the bore
- Small shaft and spindle grinding in connector and terminal tooling
- Form tool grinding where an angled land has to be held

Materials and Construction

Cast iron base and column with ground slideways, CNC controlled axes and a high frequency internal spindle. Wheel type is specified for the punch material, including diamond wheels for carbide.

Quality Control Before Shipping

- Spindle run out measured on workhead and both wheel spindles
- Axis positioning checked against the control readout
- Workhead swivel angle verified
- Ground test pins measured for diameter and roundness
- Electrical and control safety inspection before packing

Customisation Options

- CNC control brand selected from FANUC, SIEMENS, SYNTEC or GSK
- Collet and workholding sets for your punch sizes
- Diamond wheel package for carbide punches
- Coolant and mist filtration options
- Voltage and frequency configured for your supply



Certification

Certification is quoted and confirmed in writing on request. Documented certification status for this model is TBC.

Commercial Terms

- Minimum order: 1 set
- Delivery: 15 to 45 working days after deposit
- Trade terms: EXW, FOB, CFR and CIF
- Packing: plywood cases lined with plastic film
- Warranty: 12 months on the machine
- CNC control options where applicable: FANUC, SIEMENS, SYNTEC and GSK

Enquiries: WhatsApp +86 137 2585 2907 or wuk.machinery@hotmail.com. Web page: www.wuktech.com/products/wk22-cnc-internal-external-punch-grinder.html