



# LANDIS LT1SE-DH

Cam segment grinding machine

---

Date: 2/2023

Prepared by: Caitlin Barnhart

# LANDIS LT1SE-DH



## Cam segment grinder

- Landis system CNC control
- Hydrostatic wheelhead ways & wheel spindle
- CNC grinding wheelfeed
- CNC wheel dressing
- CNC variable speed workdrive
- Linear motor technology
- Easy access for simple, one-man wheel change
- Totally enclosed grinding area
- CBN grinding wheels
- Small footprint
- Specific design for machine stability
- Reduced number of parts
- Low center height



# LANDIS LT1SE-DH

## Features

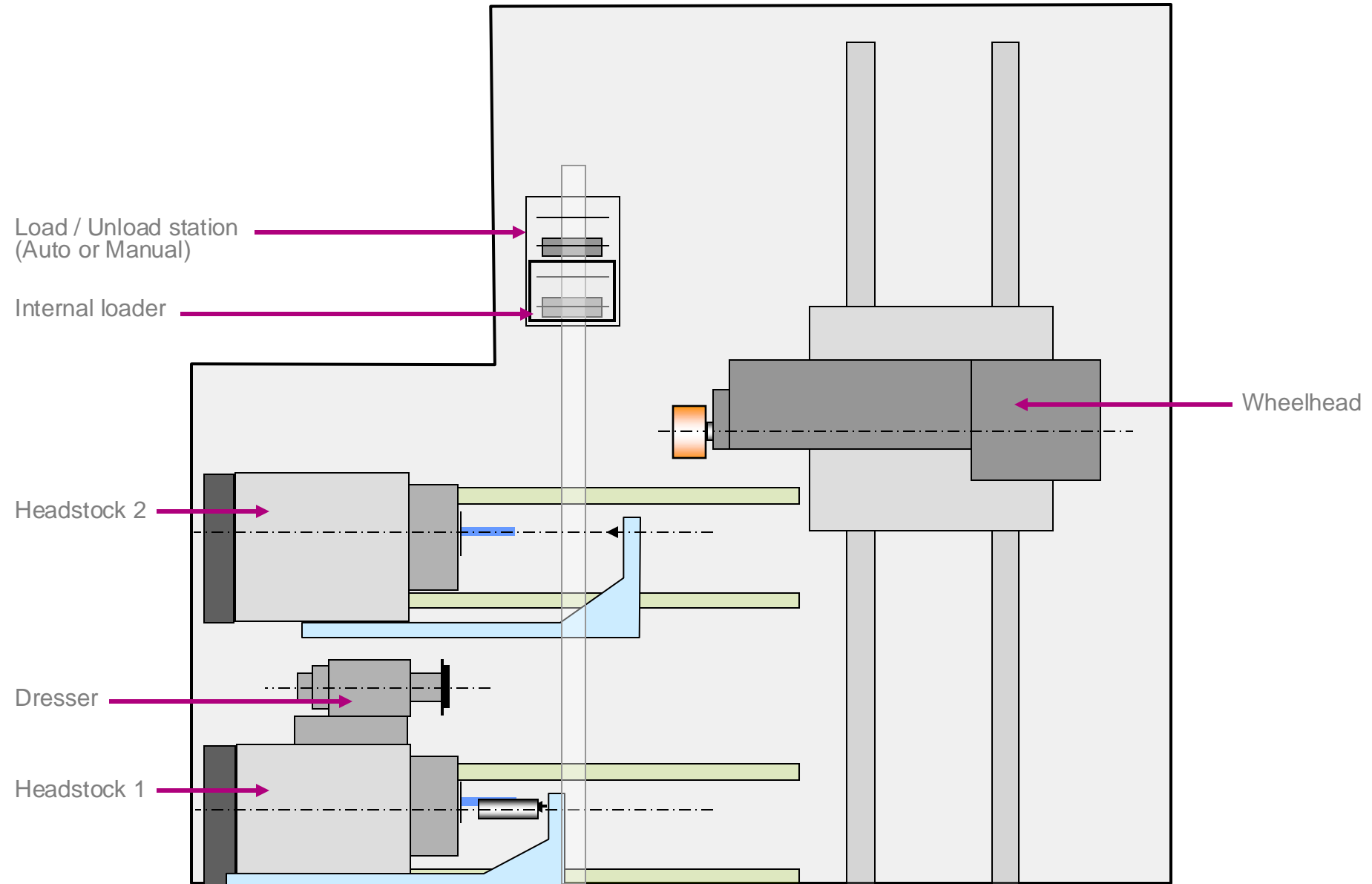
- Compact cam grinder
- Small footprint: 2300mm wide x 2800mm deep (machine only)
- High efficiency & output
- Flexible
- Technologically advanced

## Capacities

- Principally designed for all camshaft types, plus cylindrical and non-cylindrical work pieces
- Grinds lengths of up to 200mm
- Up to Ø80mm component swing
- Up to 20mm component lift



# LANDIS LT1SE-DH

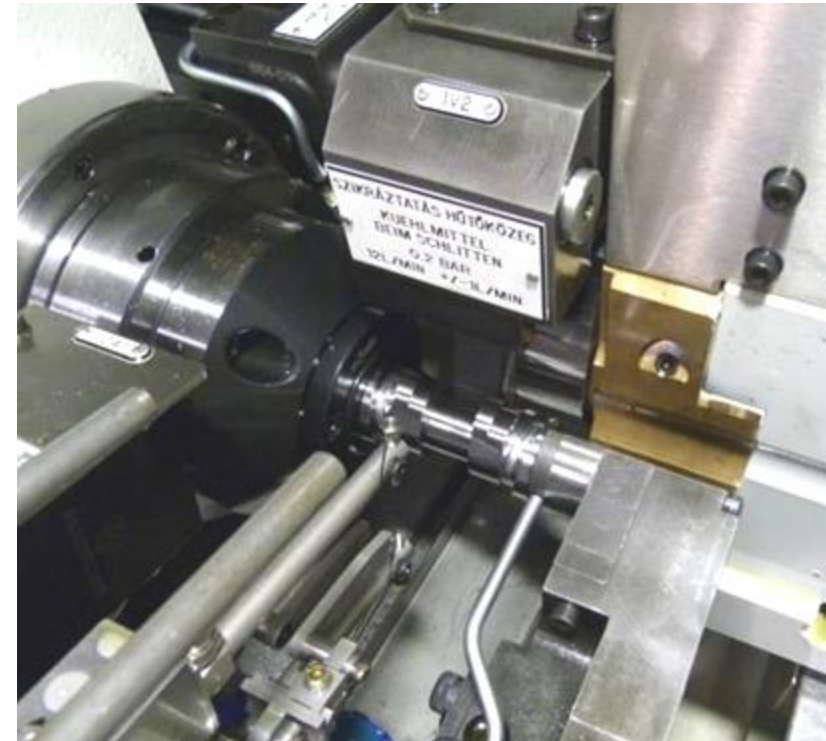


# LANDIS LT1SE-DH

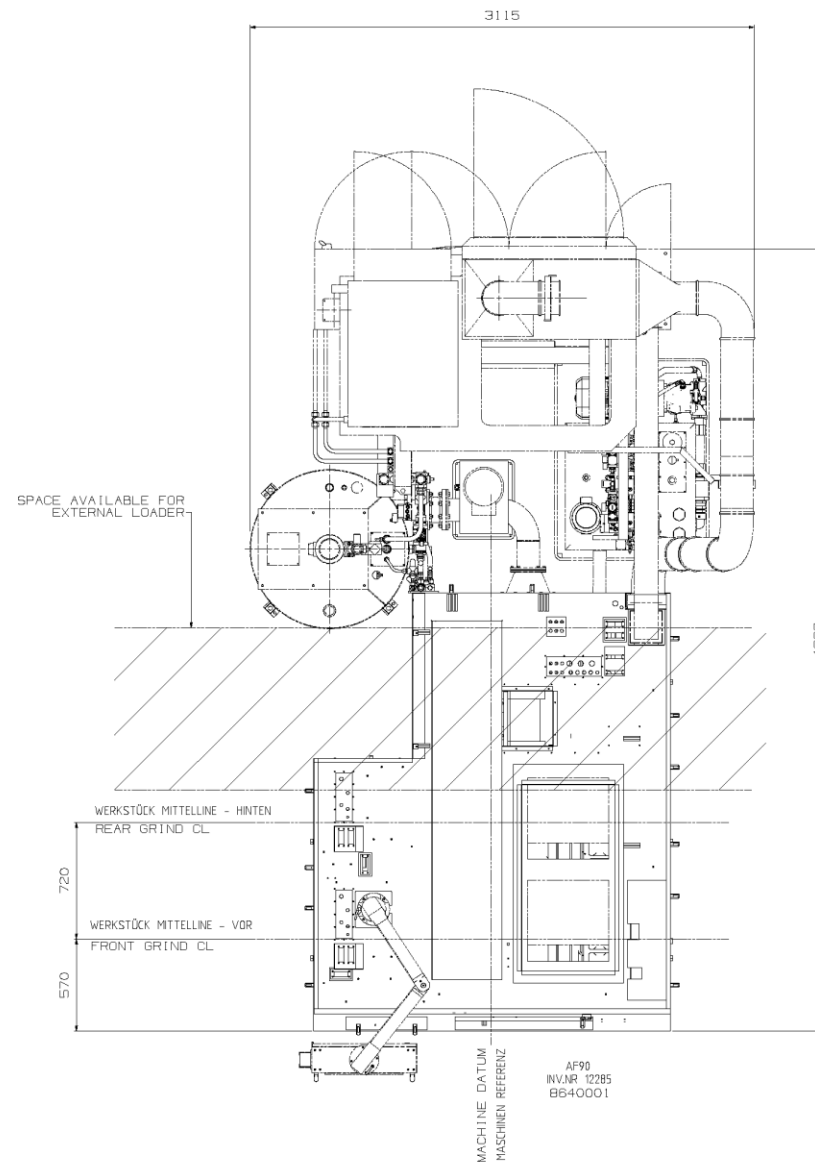
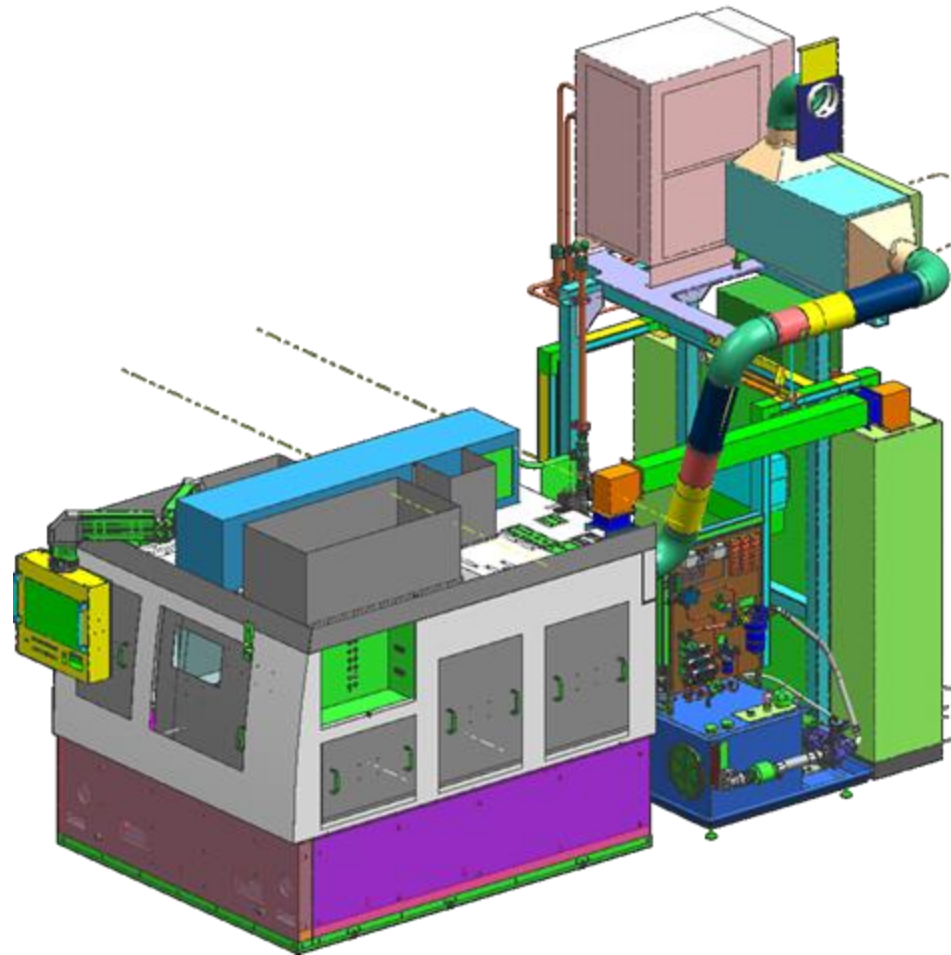
## Install Base

- 864-01 AUDI - GYOR (HUNGARY)
- 864-02 AUDI - GYOR (HUNGARY)
- 864-03 AUDI - GYOR (HUNGARY)
- 864-04 AUDI - GYOR (HUNGARY)
- 864-05 AUDI - GYOR (HUNGARY)
- 864-06 AUDI - GYOR (HUNGARY)
- 864-07 AUDI - DALIAN (CHINA)
- 864-08 AUDI - DALIAN (CHINA)
- 864-09 AUDI - DALIAN (CHINA)
- 864-10 AUDI - DALIAN (CHINA)
- 864-11 AUDI - DALIAN (CHINA)
- 864-12 AUDI - DALIAN (CHINA)

## TOTAL 12 MACHINES



# LANDIS LT1SE-DH





# LANDIS LT1SE-DH

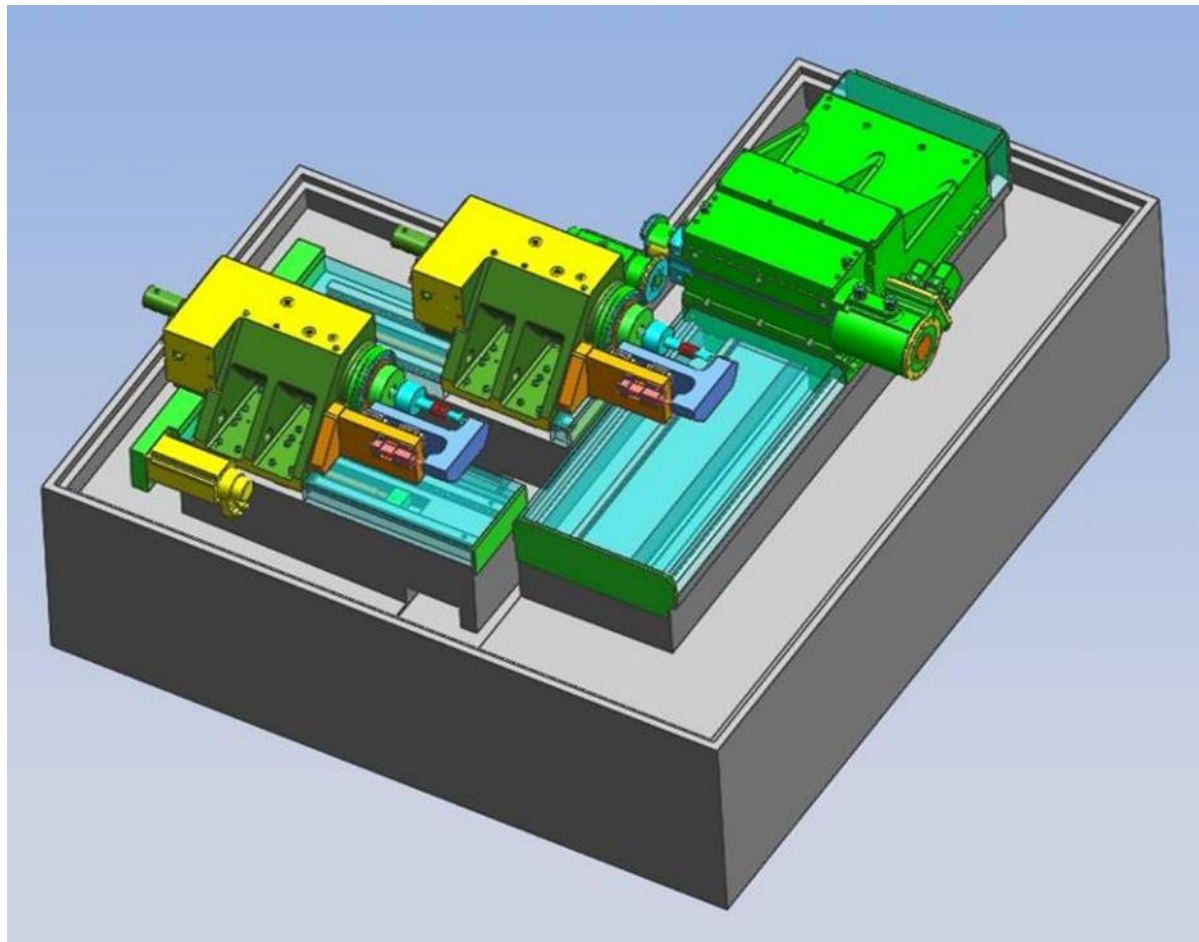
## Machine Bed

- Cast iron bed
- Designed for rigidity and thermal stability
- Seating for hydrostatic wheelhead in-feed
- Seating for workheads
- Coolant discharge through the bed
- All parts exposed to coolant are synthetically treated to prevent swarf build up
- Independent levelling blocks



# LANDIS LT1SE-DH

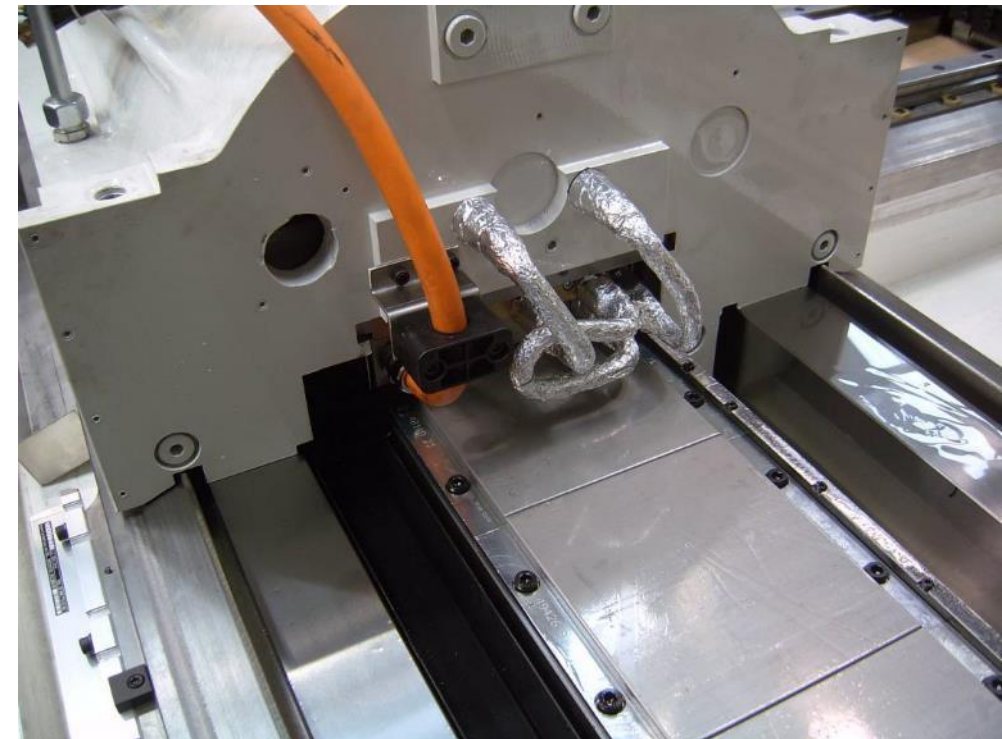
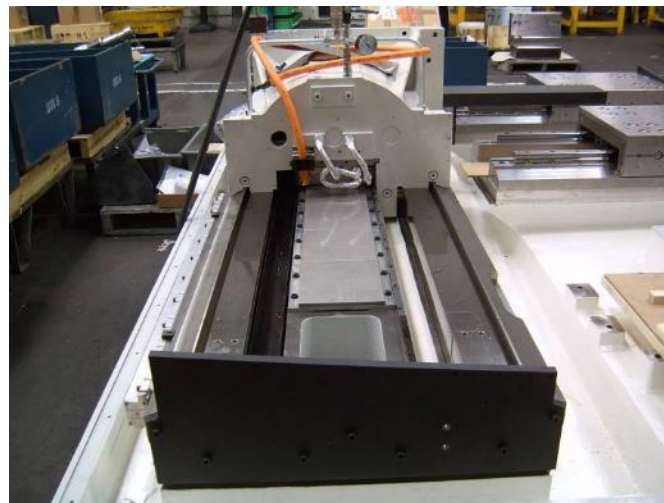
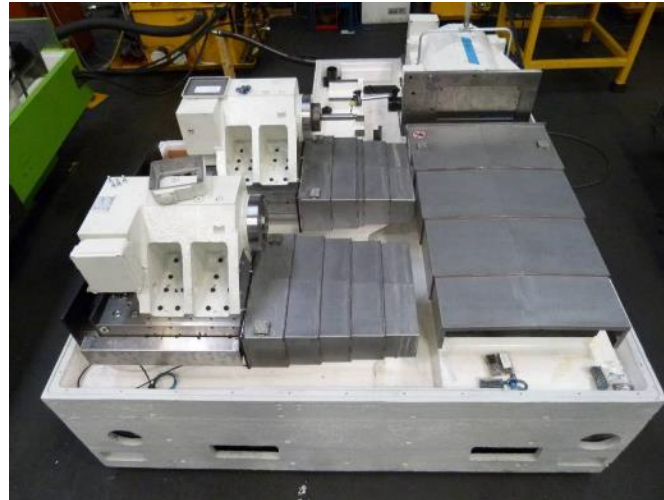
Machine Bed





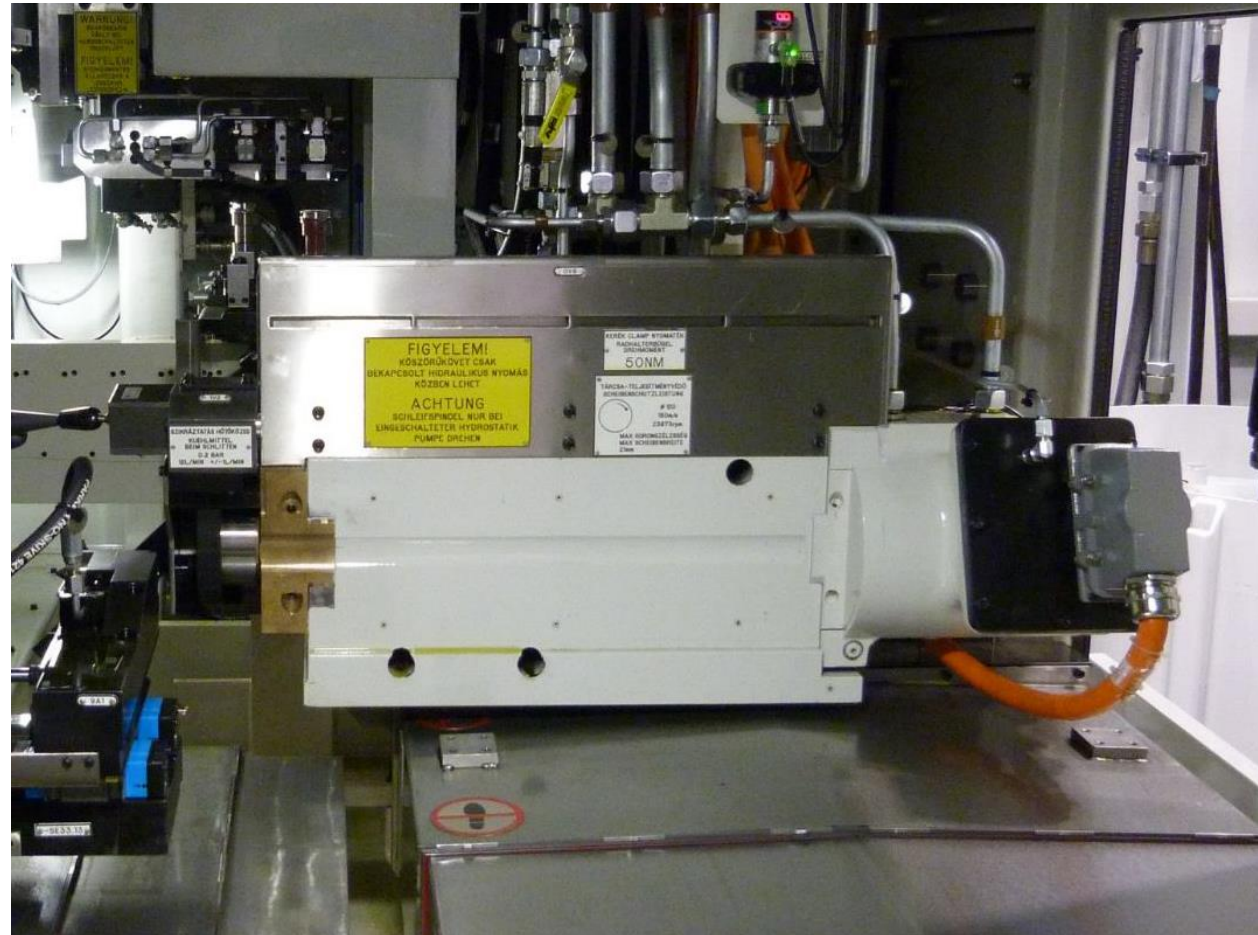
# LANDIS LT1SE-DH

Wheelhead Slide (X-Axis)



# LANDIS LT1SE-DH

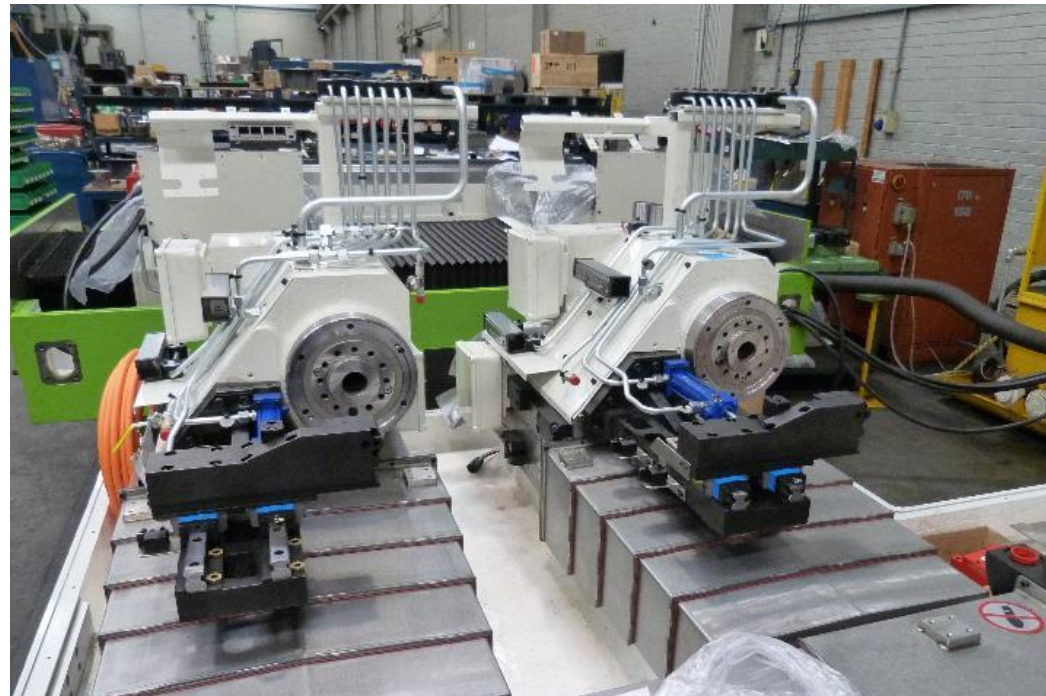
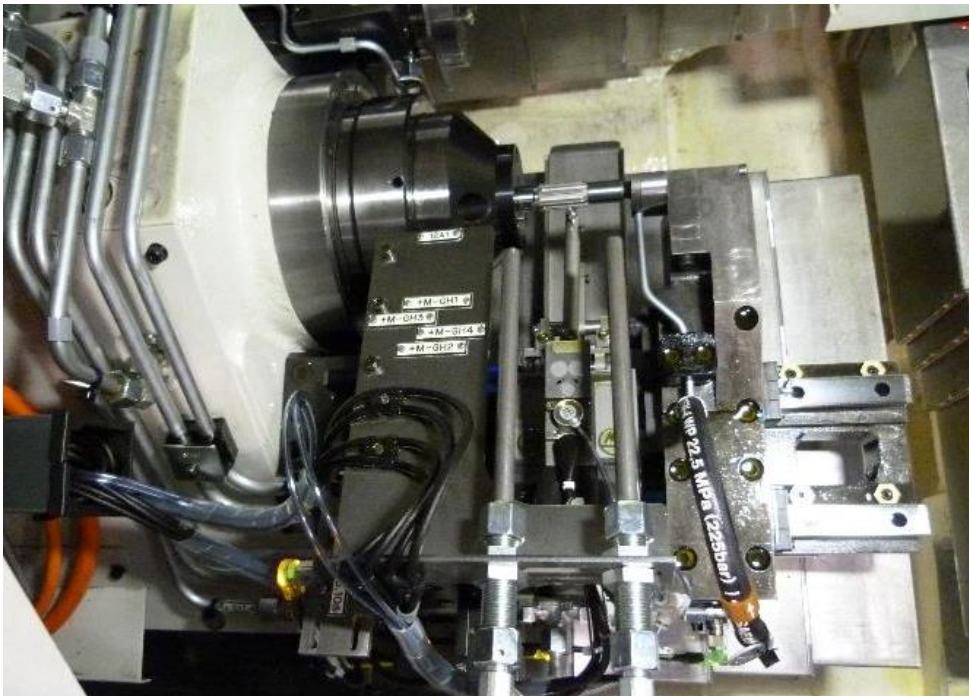
## Wheelhead





# LANDIS LT1SE-DH

## Work Station 1 – Headstock (C-Axis)

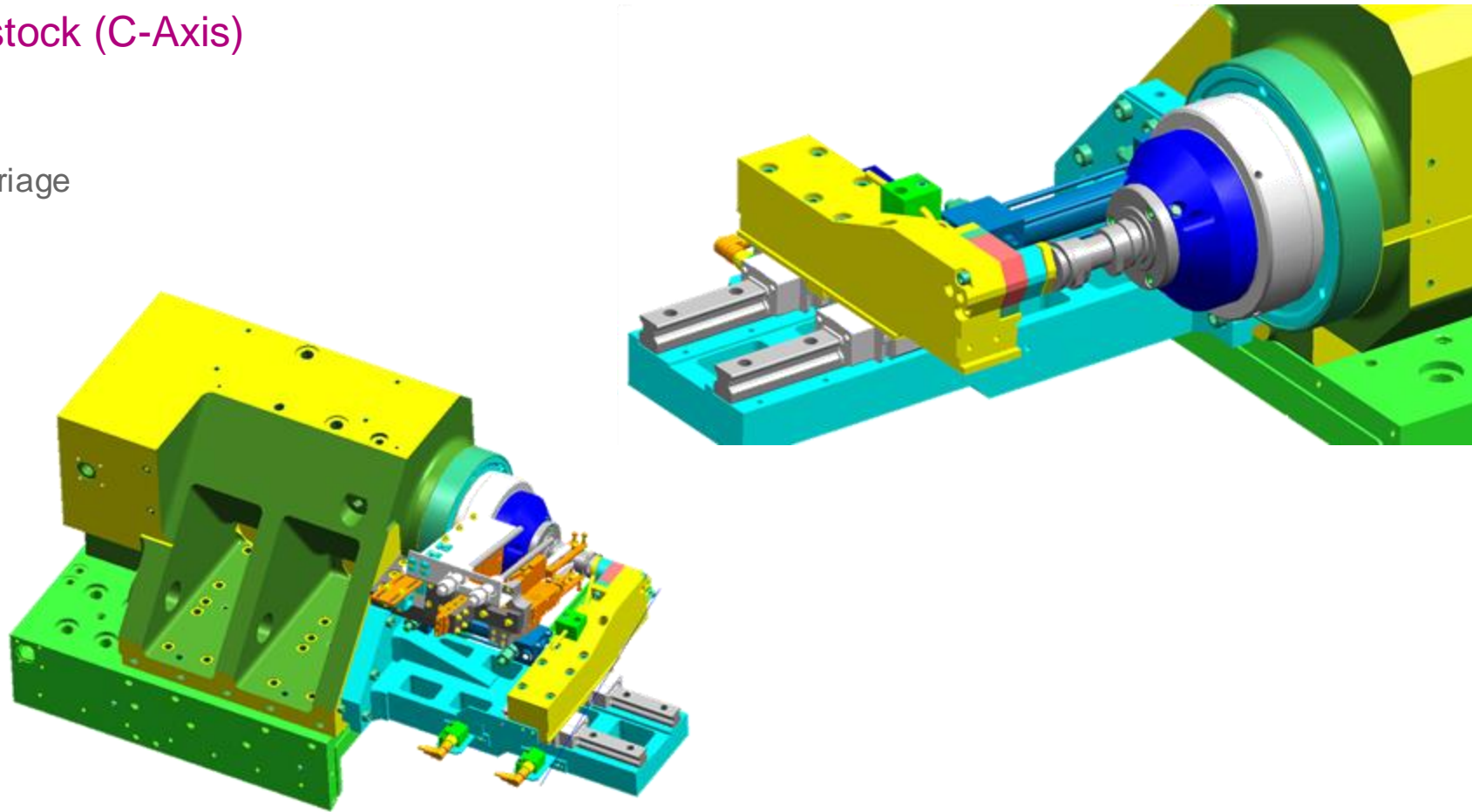


# LANDIS LT1SE-DH

## Work Station 1 – Headstock (C-Axis)

### Footstock

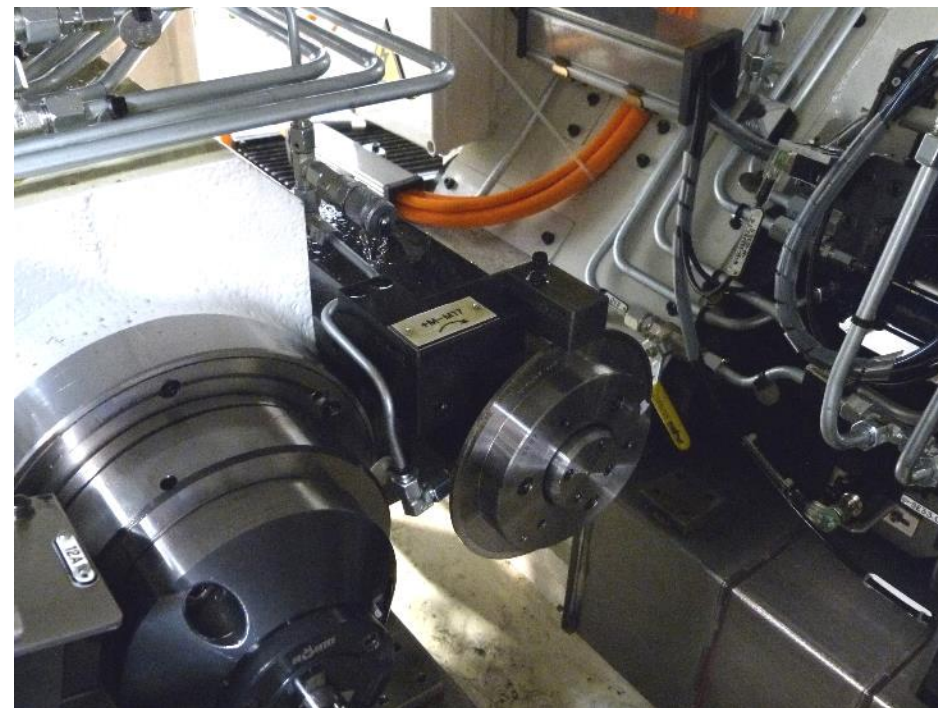
- Solid center on moving carriage
- 80mm stroke





# LANDIS LT1SE-DH

## Wheel Dressing Unit



# LANDIS LT1SE-DH

## Operator Guards



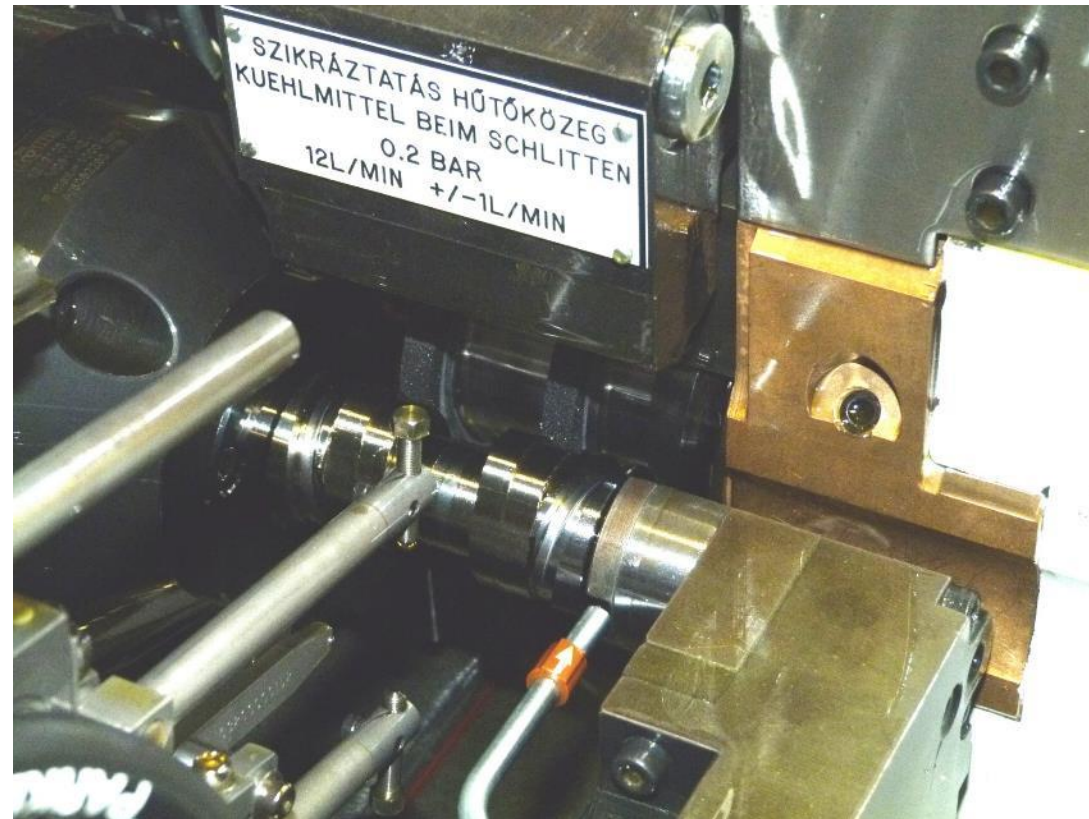
Component loading hatch





# LANDIS LT1SE-DH

## Tooling



Finish grind two pairs of split cam lobes and blend base circle

# LANDIS LT1SE-DH



## Specifications

	Landis LT1Se	Landis LT1Se-DH
<b>Grinding capacity</b>		
Max. component swing	200 mm (7.9")	75 mm (3")
Max. grinding length	250 mm (9.8")	150 mm (5.9")
Max. workpiece weight	100 kg (220.5 lb.)	30 kg (66 lb.)
<b>CBN Grinding wheel</b>		
Max. number of spindles	2	
Wheel type	CBN	
Max. wheel Ø	200 mm (7.9")	120 mm (4.7")
Max. wheel width	50 mm (2")	80 mm (3")
Wheel surface speed	120 m/sec (65 ft/sec)	120 m/s (394 ft/sec)
Spindle power	20 kW	26 kW

	Landis LT1Se	Landis LT1Se-DH
<b>Workhead &amp; footstock</b>		
Quantity	1	2
Workhead speed range	0 - 600 rpm	
Workhead drive power	5.5 kW	
Max. workhead motor torque	260 Nm	
Footstock stroke	150 mm (5.9")	
Type	Live spindle	
<b>Axes &amp; control</b>		
Guideways / bearings (X)	Precision linear ways	Hydrostatic
Guideways / bearings (Z)	Precision linear ways	Precision linear ways
Drive	Linear motor	Linear motor
Grinding spindle	Ball bearings	Hydrostatic
<b>Dimensions</b>		
Machine bed	Composite	Cast iron
Dimensions (W x D x H)	2,600 x 2,150 x 2,457 mm (8.5' x 7' x 8')	2,205 x 2,705 x 2330 mm (7.2' x 8.9' x 7.6')
Machine weight	12,500 kg (27,558 lb.)	12,000 kg (26,456 lb.)