

H376

高精度复合磨削中心

High-Precision Compound Grinding Center

用途与特征

- 高精度复合磨削中心是典型的工序复合机床。采用先进的柔性复合加工技术,以多种砂轮的组合型式形成系列。一次装夹完成工件外圆、内圆、端面、锥面、非圆、曲面等部位的磨削加工,完全改变了多台机床分序加工的传统加工方式。本机床所采用的内外圆复合磨削技术在国内属于行业前沿,同时上海机床厂的设计制造水平在国内均处于领先地位,具有加工精度高、加工效率高及加工柔性高的特点。在工作精度上,外圆磨削圆度为0.0004mm,纵截面内直径一致性0.003mm;内圆磨削圆度为0.0005mm,纵截面内直径一致性0.004mm,比肩国际同类型机床,适用于军工、航空、刀具、量具、机床、汽车等行业的精密机械加工领域。



Main Application and Features

- High precision compound grinding center is a typical process compound machine tool. With advanced flexible composite processing technology, a series of grinding wheel combinations are formed. The grinding of workpiece's outer circle, inner circle, end surface, cone surface, non-circle, surface and other parts is completed by one clamping, which completely changes the traditional processing mode of multi-machine sequential processing. The internal and external composite grinding technology adopted by this machine tool belongs to the forefront of the industry in China. At the same time, the design and manufacturing level of Shanghai Machine Tool Works Ltd. play a leading role in China. It has the characteristics of high processing accuracy, high processing efficiency and high processing flexibility. In terms of working accuracy, the roundness of cylindrical grinding is 0.0004 mm, and the diameter of longitudinal section is 0.003 mm; the roundness of internal grinding is 0.0005 mm, and the diameter of longitudinal section is 0.004 mm, which is comparable to the same type of machine tools in the world. It is suitable for precision machining in military, aviation, cutting tools, measuring tools, machine tools, automobile and other industries.

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规格及主要技术参数

Main specifications

最大外圆磨削直径	Max, external grinding diameter	320mm
最大外圆磨削长度	Max, external grinding length	1000mm
最大内圆磨削直径	Max. internal grinding diameter	125mm
最大内圆磨削长度	Max. internal grinding length	125mm
最小外圆磨削直径	Min, external grinding diameter	15mm
工件最大重量	Max. workpiece weight	150kg
中心高	Center height	200mm
外圆砂轮规格	External grinding wheel size	Φ500x80x203mm
外圆砂轮线速度	External grinding wheel speed	45m/s
外圆主轴电机功率	External spindle power	15kw
内圆主轴最高转速	Max.speed of internal spindle	42000rpm

工作精度 Working Accuracy

外圆 External grinding	Φ60 x 200标准试件
圆度 Roundness	0.0004 mm
纵截面内直径一致性 the diameter of longitudinal section	0.003mm

内圆 External grinding	Φ60 x 50标准试件
圆度 Roundness	0.0005 mm
纵截面内直径一致性 the diameter of longitudinal section	0.004mm

机床选购件 Special Accessories

马波斯自动测量仪 Marposs automatic measuring device
砂轮手动、自动平衡仪 Wheel balance device (by automatic or by hand)

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内销 Domestic Section

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