

# H377A

## 高精度复合磨削中心

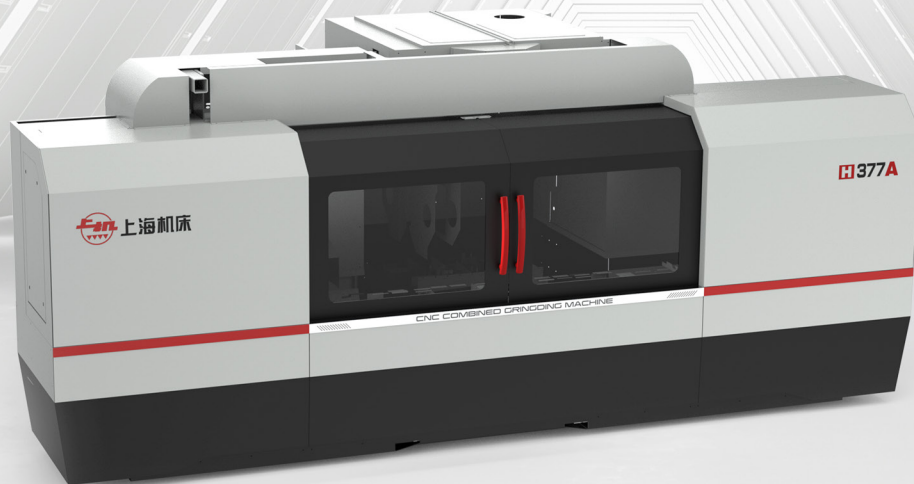
High-Precision Compound Grinding Center

### 用途与特征

H377A高精度复合磨削中心是上海机床厂有限公司全面升级的新一代工序复合机床，具有更大的机床规格：中心高300mm、最大磨削长度1600mm、承重能力300kg；更高的机床精度：工件头架回转精度0.0004mm、砂轮转塔回转重复定位精度1"、1200mm标棒纵向直线度0.002mm。新一代工件头架具备锥度调节功能，更好的保证了卡盘及顶尖磨削的工件锥度；工作台新增第二导轨，可搭载多种功能配件如各类型修整器，满足多样化的磨削工艺需求。机床全新搭载基于动力学特性的磨床在线性能评估系统，实现了磨床加工状态和性能监控评估，随时确保机床健康工作。加工精度上：标准试件外圆圆度0.0004mm；内圆圆度0.0005mm。H377A高精度复合磨削中心是我国先进工业母机的典型代表，助力军工、航空、机床、汽车、量具等行业加工能力更上一层楼。

### Application and Features

H377A high-precision compound grinding center is a new generation of compound grinding machine, which has been comprehensively upgraded by Shanghai Machine Tool Works Ltd. It owns larger specifications: center height of 300mm, maximum grinding length of 1600mm, and maximum loading capacity of 300kg; higher accuracy: workpiece headstock rotation accuracy of 0.0004mm, wheelhead rotation repetitive positioning accuracy of 1", and longitudinal straightness of 0.002mm for the standard workpiece of 1200mm. The new generation of workpiece headstock has taper adjustment function, which better guarantees the taper of workpieces during grinding with chucks and centers; the worktable adds a second guide rail, which can carry various functional accessories such as all types of dressers to meet diverse grinding process requirements. The machine is equipped with a new grinding online performance evaluation system based on dynamic characteristics, which realizes monitoring and evaluation of grinding machine processing status and performance, ensuring the healthy operation of the machine tool at any time. For processing accuracy: the roundness of the standard test piece is 0.0004mm for external grinding and 0.0005mm for internal grinding. H377A high-precision compound grinding center is a typical representative of advanced industrial mother machines in China, boosting the processing capabilities of industries such as military, aerospace, machine tools, automobiles, and measuring instruments to a higher level.



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## 规格及主要技术参数 | SPECIFICATIONS AND MAIN TECHNICAL PARAMETERS

最大外圆磨削直径	Max. cylindrical diameter to be ground	500 mm
最大外圆磨削长度	Max. cylindrical length to be ground	1600 mm
最大内圆磨削直径	Max. internal diameter to be ground	200 mm
最大内圆磨削长度	Max. internal length to be ground	200 mm
最小外圆磨削直径	Min. cylindrical diameter to be ground	8 mm
工件最大重量	Max. workpiece weight	300 kg
中心高	Center height	300 mm
砂轮规格	Wheel size	Φ500×80×203mm
砂轮线速度	Wheel peripheral speed	45m/s
工件转速	Workpiece rotation speed	5~500r/min

## 工作精度 | WORKING ACCURACY (ACCORDING TO T/CAM 151-2023)

长外圆	Long cylindrical	Φ63×630 standard test workpiece
圆度	Roundness	0.001 mm
纵截面内直径一致性	Diameter uniformity in the longitudinal section	0.003 mm
短外圆	Short cylindrical	Φ63×200 standard test workpiece
圆度	Roundness	0.0004 mm
内圆	Internal circle	Φ60×70 standard test workpiece
圆度	Short cylindrical	0.0005 mm
纵截面内直径一致性	Diameter uniformity in the longitudinal section	0.004 mm

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Considering continuous development of technology, above information is for reference only.