

VDI 軸向刀塔無法換刀或定位

VDI axial mount turret is unable to index or position

1. 檢查刀塔放鬆夾緊是否正常，油壓是否 50KG

Check if hydraulic pressure is at 50kgs, and whether turret operates normally while doing clamp and unclamp.



2. 檢查刀塔驅動器是否有異警碼

Check if there is any error code shown on drive unit display.



3. 檢查是否油壓電磁閥、繼電器燒毀或接觸不良、節流閥流量是否過小

Check if hydraulic pressure solenoid valve and relay are well connected

and no burn out. Also check if throttle flow is too small ?



4. 檢查刀塔端各動力、編碼器、近接開關接頭線路是否鬆脫或進水

Check whether all cable lines of tool drive motor, encoder, and proximity

switch connectors are well connected and no water ingress.



5. 檢查刀塔 S8 訊號夾緊為 1 放鬆為 0，S11 耦合齒訊號耦合時為 0 脫離為 1

Check S8 signal -clamped :1 and unclamped: 0, and S11 coupling signal-
coupled: 0 , and disengaged : 1.



6. CN1、CN2、近接開關線路有無受損或更換線路測試

Check whether CN1, CN2 and proximity switch cables are intact without damages.

7. 更換馬達或驅動器

Replace motor or drive unit.

8. 檢查動力刀座及刀塔耦合齒是否損壞，無法耦合

Check whether couplings on turret and the driven tool holder are intact without damages.



9. 動力刀座安裝前需先手動定位，定位時確認刀座無法轉動

Driven tool holder needs to be manually positioned before installation.



11. 刀塔夾緊放鬆, 檢查耦合齒油壓缸前後作動是否正常

Clamp and unclamp the turret to check whether the moves of coupling gear hydraulic cylinder is normal.



12. 檢查刀塔耦合齒記號是否在 3 點鐘位置

Check whether the turret coupling mark is at 3 o'clock position.



13. 刀塔撞車後造成刀盤與耦合齒中心位置
偏移

Center of tool disc and coupling might
be off-position after a crash happened.



14. 動力機構進水生鏽卡死，內部軸承或齒輪損壞，關掉動力馬達電源，手動
旋轉耦合齒確認有無卡死

Transmission mechanism might be rusty and stuck if there is water
ingress. Internal bearings or gear wheels might be damaged.

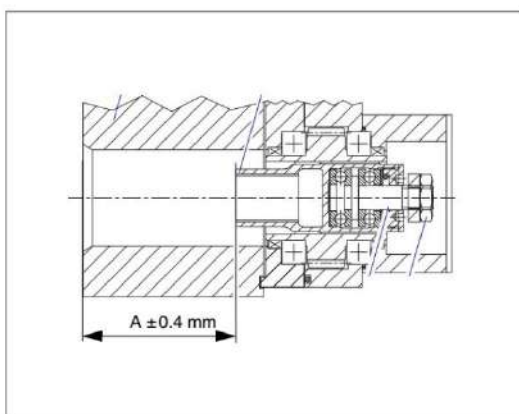
Switch off tool drive motor power and rotate coupling manually to check
if it is stuck.



15. 量測刀塔夾緊時耦合齒的距離是否在標準內

Visually check if the distance of coupling is within standard when turret is

at clamping status.



Coupling profile	耦合齒距離	clearance A ±0.4 [mm]	
11×0.8	DIN 5480	41	
14×0.8	DIN 5480	49.5	VDI25
16×0.8	DIN 5480	58.5	VDI30
20×0.8	DIN 5480	65	VDI40
24×1.25	DIN 5480	83	VDI50
30×1.25	DIN 5480	95	VDI60

