

VDI 徑向刀塔無法換刀或定位

VDI Radial 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 · S10 耦合齒訊號耦合時為 1;脫離為 0

Check S8 signal -clamped :1 and unclamped: 0, and S10 coupling signal-
coupled: 1 , and disengaged : 0.



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 with a new 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.



10.

動力

9. 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.





10. 把加工刀位的刀座移除後，檢查刀塔夾緊放鬆,檢查耦合齒油壓缸前後作動是否正常。

Remove the tool holder on the working position. Clamp and unclamp the turret to confirm it works normally. Check if the moves of coupling hydraulic cylinder is normal.



11. 檢查刀塔耦合齒原點是否在 3 點鐘位置

Check if turret coupling origin is at 3 o' clock.



12. 刀塔撞車後造成刀盤或耦合齒中心位置偏移。

Centers of the tool disc and coupling might be off-position when a crash happened.



13. 動力 U 型皮帶式，請檢查皮帶是否斷裂

For tool drive motor with U connection: check if the belt is intact without breakage.





14.齒輪頭內部零件損壞卡死無法運轉。

Internal parts of the gearhead are damaged and stuck and cannot operate

