

434/BMT- T 型塊安裝

434/BMT- Installation of T-slot

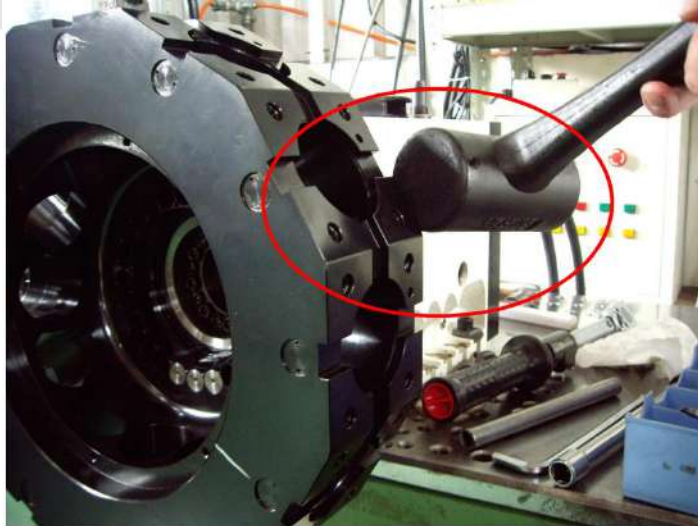
434/BMT 更換 T 型塊需移除齒輪頭，請先依齒輪頭拆卸步驟再做以下動作。

For 434/BMT type, it is required to remove the gearhead first before replacement of T-slots. Please follow the procedures of disassembly of gearhead before you do the following steps.

1. 齒輪頭拆除後，請在一號刀位將刀盤 21 顆固定螺絲取下，使用膠槌敲擊刀盤背面取下刀盤。(拆卸刀盤請使用吊具固定刀盤，以免人員受傷)

After removing the gearhead, please remove fixing screws * 21pcs on the too disc at T1 station. Use a plastic hammer to tap the rear side of the too disc to remove it. (When disassembling the tool disc, please use hooks and lift it up with a crane to prevent any injury).



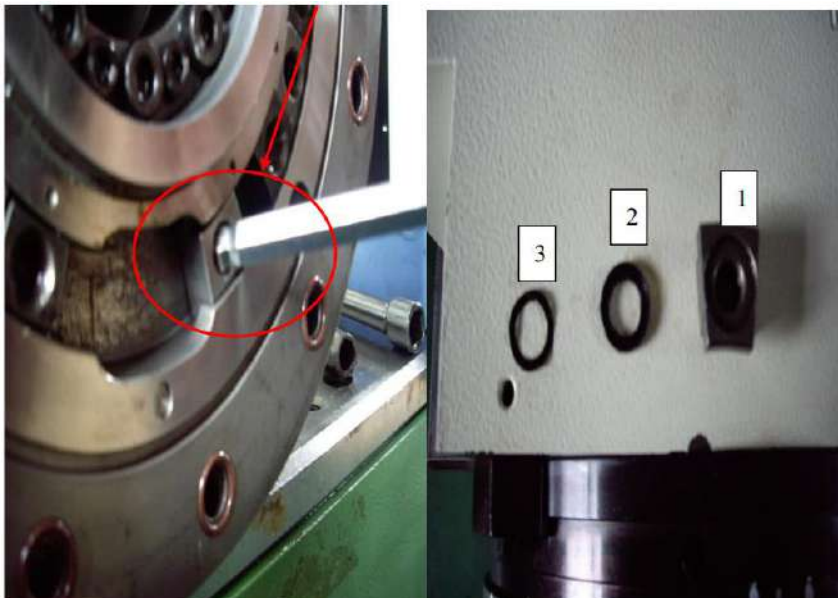


2. 434/BMT 款的 T 型塊不是鎖定位珠固定，是用 T 型塊(圖 1)加隔環(圖 2)

跟波形墊片(圖 3)，故如需拆下檢查，請使用一根六角板手頂住 T 型塊螺絲孔後往下壓即可取出檢查。

T-slots are not fixed by the positioning bead for 434/BMT type turret.

T-slots are fastened by T-slot (see below pic 1) + a spacer ring (see below pic 2) and a wavy spacer (see below pic 3), so if you need to remove T-slots for inspection, please use a hex wrench to press down the screw hole of T-slot, then T-slot may be taken out for inspection



3. 裝回刀盤需注意，刀盤跟三片齒結合的孔，有一條 O-RING,故裝回刀盤必定要平均鎖回，否則此條 O-RING 很容易斷裂損毀，裝好刀盤後將 21 顆螺絲鎖回並上妥扭力。

Please pay attention to the replacement of the tool disc. There is an O-RING in the hole where the tool disc is coupled with the 3-pieces couplings. Therefore, the tool disc must be mounted evenly, otherwise, this O-RING is easy to break and damage. After installing the tool disc, fasten and tighten all 21 screws.



螺絲 screw	M8	M10	M12
扭力 torque	39Nm	77Nm	135Nm
數量 quantity	15	21	19

