VDI 軸向刀盤精度調整

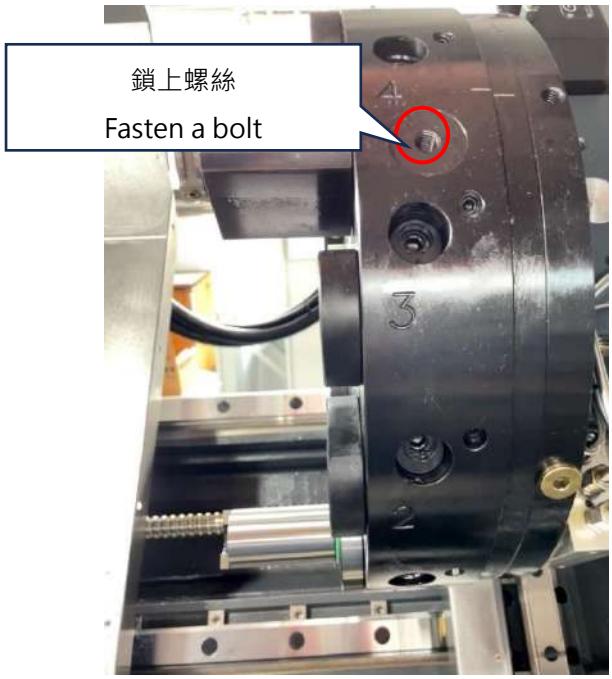
Precision adjustment on VDI axial tool disc

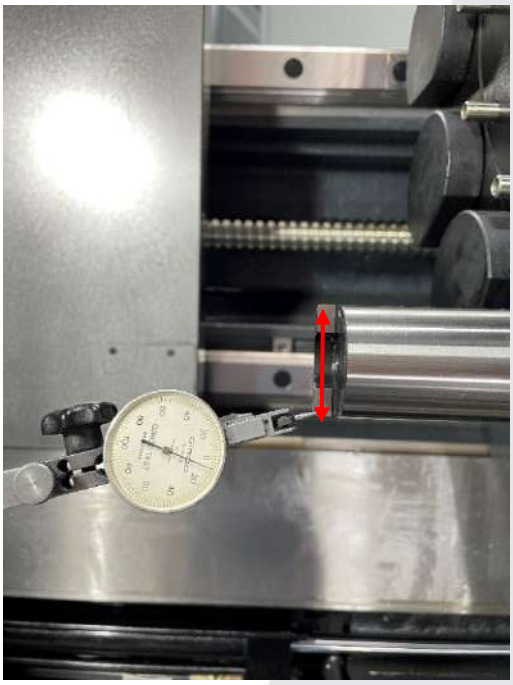
1. 檢查油壓 50 公斤,刀盤在記號線上,並確認刀塔 S8 訊號夾緊時為 1; 放鬆時為 0; S11 耦合齒訊號耦合時為 0, 脫離為 1.

Confirm hydraulic pressure is 50 kg, and tool disc aligns with the mark line (see below pic). Confirm S8 signal is 1 when clamped, and 0 while unclamped. S11 signal is 0 when clamped, and 1 while unclamped.

2. 先在一號刀 架上測試棒,確認刀盤平行度 X 軸偏移多少後，使用板手將刀盤固定螺絲放鬆 1~2 牙後，在刀盤側邊鎖上螺絲(參下圖) 當作敲擊點, 爾後用膠槌去敲擊刀盤，後量測刀盤 x 軸平行度，調整至 0.01mm 內即可.

Place a testing mandrel on T1 station. Measure how much deviation is on X axis. Loosen bolts on tool disc by 1~2threads, and fasten a bolt on tool disc (see below pic) and use it as a hitting point; and then use a plastic hammer to pound the tool disc till X axis precision to be within 0.01mm.





M8 螺絲扭力為 41Nm\M8 bolt torque is 41Nm

M10 螺絲扭力為 83Nm\M10 bolt torque is 83Nm

M12 螺絲扭力為 135Nm\M12 bolt torque is 135Nm

3. 調整完後務必確認動力刀座手動耦合是否順暢

After adjustment, ensure to confirm manually if the coupling of live tool holder rotates smoothly.