

VDI 刀盤拆解作業

VDI tool disc disassembly procedure



注意事項 Attentions :

1. 請將刀塔維持在夾緊狀態下進行更換動作，以免造成三片齒移動導致刀盤與刀塔刀位不符。

Please make sure the turret in at clamping status while performing this replacement procedure to avoid 3-piece couplings from off-position.

2. 更換過程中，刀盤請用天車或任何其它能吊住刀盤之吊具固定，以免刀盤鬆脫掉落地面，造成人員安全問題。

Please hang up the tool disc by crane carefully and to avoid it from falling down to prevent any casualty.



3. 有標註需上扭力之螺絲，請務必上妥該扭力，以免造成刀盤不貼面導致精度不佳及切削液外漏。

Follow required torque to fasten all screws; Fail to follow the instruction will cause tool disc not mounted correctly and lead to poor precision and coolant leakage.

4. 請務必在刀塔原點即 1 號刀位置進行更換刀盤作業以免刀號不對。

Tool disc replacement procedure can only be performed when turret origin is at T1 position. Fail to follow will cause incorrect tool stations.

5. 調整刀盤精度，請務必讓刀塔在夾緊狀態下進行。

Only adjust tool disc precision when turret is at clamping status.

步驟 1. 請務必讓刀塔在夾緊狀態下進行。請將刀盤鎖上吊環，並用吊具固定刀盤以免更換過程刀盤掉落

Step 1. Please ensure the turret is at clamping status. Hook the tool disc and lift it up with crane carefully and to prevent it from falling down.

步驟 2. 拆除刀盤前方螺絲

Step 2. Remove all screws located in front cover of the tool disc.



M8 螺絲扭力為 41Nm \ M8 screw torque is 41Nm

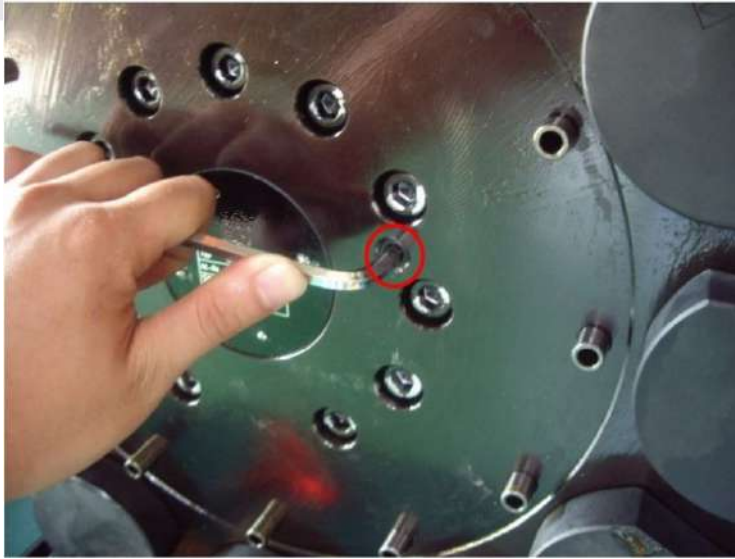
M10 螺絲扭力為 83Nm \ M10 screw torque is 83Nm

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

步驟 3. 將塞頭螺絲拆下

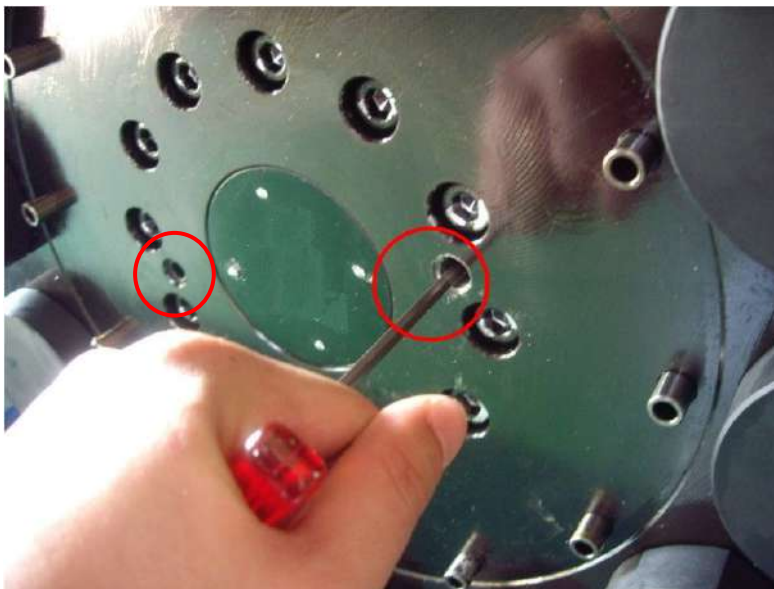
Step3. Remove the plug.





步驟 4. 使用六角 T 型板手將迫緊螺絲往內鎖進(紅圈處)，使刀盤向外推開，拆下刀盤。

Step 4. Use Hexagonal T-shape wrench to make locking screw inward (the red circled part) and allow the tool disc to be disassembled.



步驟 5. 安裝刀盤

Step 5. Assemble the tool disc

請檢查迫緊螺絲必需退回刀盤內，避免安裝不上刀盤，刀盤貼合面與刀塔接合

面，擦拭乾淨後，塗抹潤滑油或防鏽油膏。

Ensure the locking screws must be returned back to the tool disc,
otherwise the tool disc will not be able to mount in place. After cleaning,
apply a layer of lubricant or anti-rust grease on tool disc joint surface. (see
below)

