

T 型塊安裝 Installation of T-slot

刀盤拆卸前,需先依照 VDI 齒輪頭拆卸步驟拆卸齒輪頭。在未安裝齒輪頭的情況下,請勿開啟油壓。刀盤精度必須在安裝齒輪頭後才能調整。

Before disassembling the tool disc, please ensure to firstly follow the procedures to remove the gearhead. Do not switch on hydraulic pressure without the gearhead being installed. The tool disc accuracy adjustment can only be performed after the gearhead is installed.



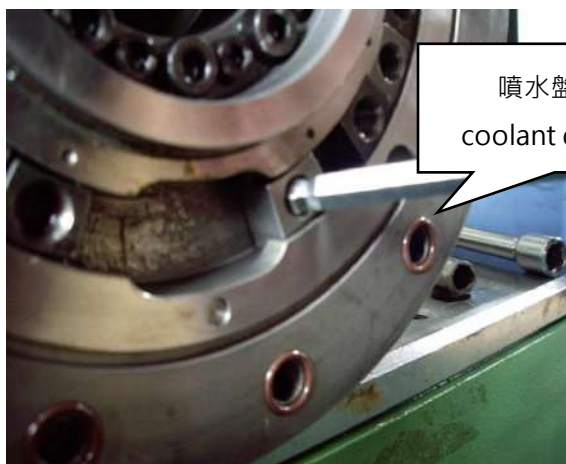
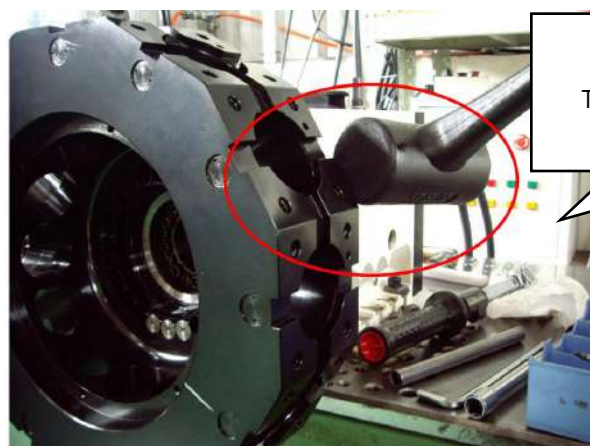
1. 齒輪頭拆除後，請在一號刀位將刀盤固定螺絲取下。使用膠槌敲擊刀盤背面取刀盤。(拆卸刀盤時，請使用吊具固定刀盤，以免人員受傷)，移除刀盤時注意油壓芯軸不要撞擊到。

After removing the gearhead, take out the fixing screws of tool disc in T1 station. Use a plastic hammer to tap the rear side of tool disc to remove it. (When disassembling the tool disc, please use hooks and lift it by crane to prevent any possible casualty). When removing the tool disc, ensure not to damage the hydraulic shaft.



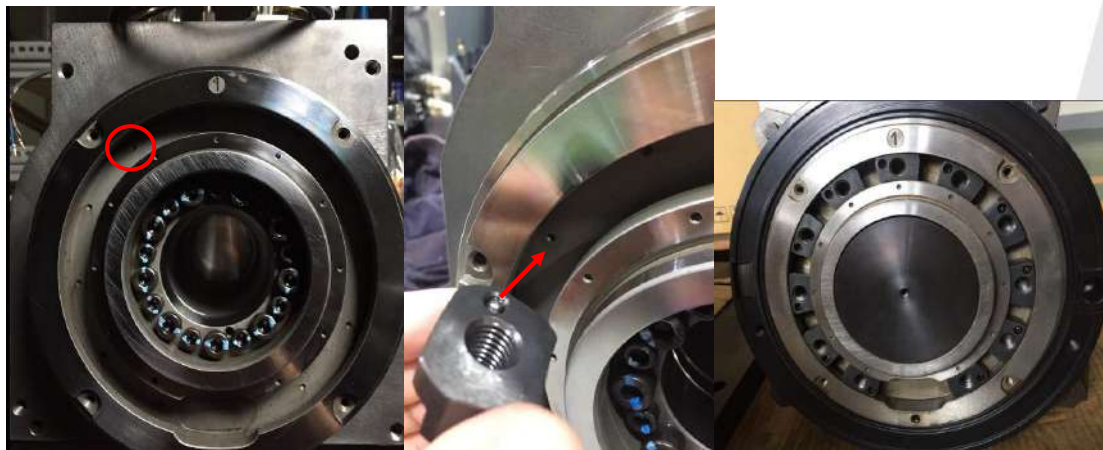
M8 螺絲扭力 39Nm \ M8 screw torque 39Nm

M10 螺絲扭力 77Nm \ M10 screw torque 77Nm



2. 拆下刀盤後可看到 T 型塊。將 T 型塊螺絲放鬆後，可將 T 型塊取下。安裝時將定位珠對到孔內，將螺絲鎖上，不需鎖緊，保持可些微左右移動的狀態。

After removing the tool disc, you may see T-slots. Unloose T-slot screws in order to take out broken T-slots. Upon installing T-slots, do not lock them too tight; leave T-slots able to move slightly right and left.



3. 裝回刀盤需注意刀盤跟三片齒結合的孔有一條 O-RING，在裝回刀盤時，務必要平均鎖回，否則此條 O-RING 很容易斷裂損毀。裝好刀盤後，將螺絲鎖回並上妥扭力。

Please pay attention to the installation of the tool disc. There is an O-ring in the hole where the tool disc is attached with the 3-pieces couplings. Ensure to install and fasten the tool disc evenly, otherwise, this O-ring might be damaged. After installing the tool disc, fasten with screws with required torque.

