

## VDI 刀盤拆解作業 Tool disc disassembly procedure

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, ensure to firstly follow the procedures to remove VDI gearhead. Do not switch on the hydraulic pressure without gearhead being installed. Tool disc accuracy can only be adjusted after installation of the gearhead.



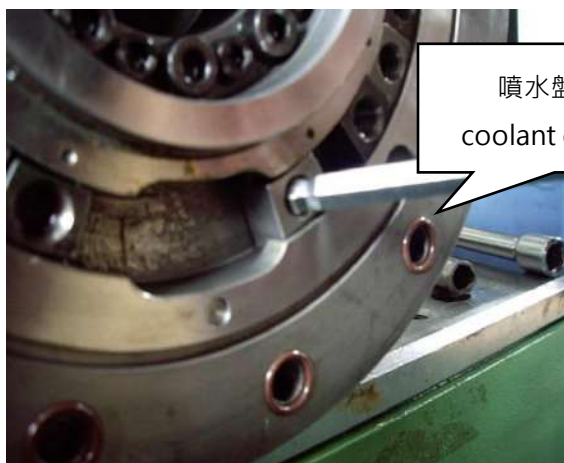
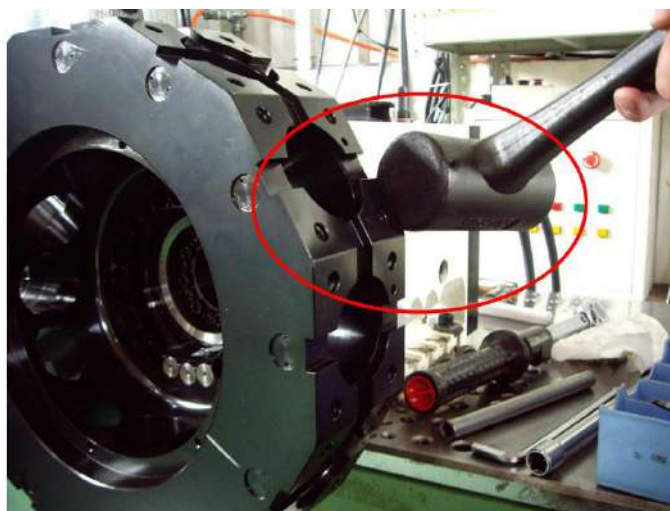
齒輪頭拆除後，請在一號刀位將刀盤固定螺絲取下，使用膠槌敲擊刀盤背面取刀盤，(拆卸刀盤請使用吊具固定刀盤，以免人員受傷)，移除刀盤時注意油壓芯軸不要撞擊到。

After removing the gearhead, unfasten the fixing screws of the tool disc at T1 station. Use a plastic hammer to tap the rear side of the tool disc to take it out. Use hooks on top of the tool disc and lift it up with a crane to avoid any danger. When disassembling 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



噴水盤 O-ring  
coolant disc O-ring



裝回刀盤需注意刀盤跟三片齒結合的孔有一條 O-RING, 當裝回刀盤時, 務必定要平均鎖回, 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 couples with the 3-pieces couplings. Mount the tool disc evenly and avoid damaging this O-ring. After installation of the tool disc, fasten all screws with required torque.



注意 O-ring  
Attention to the O-ring

