

T 型塊安裝

Installation of T-slot

1. 刀塔回到 1 號刀位置並在鎖緊狀態

Turret is T1 position and is at clamping status.



2. 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，拆除刀盤前方
螺絲

Put hooks on tool disc and hang it up by crane to prevent it from falling
down during replacement. Remove all screws located in from cover of the
tool disc.





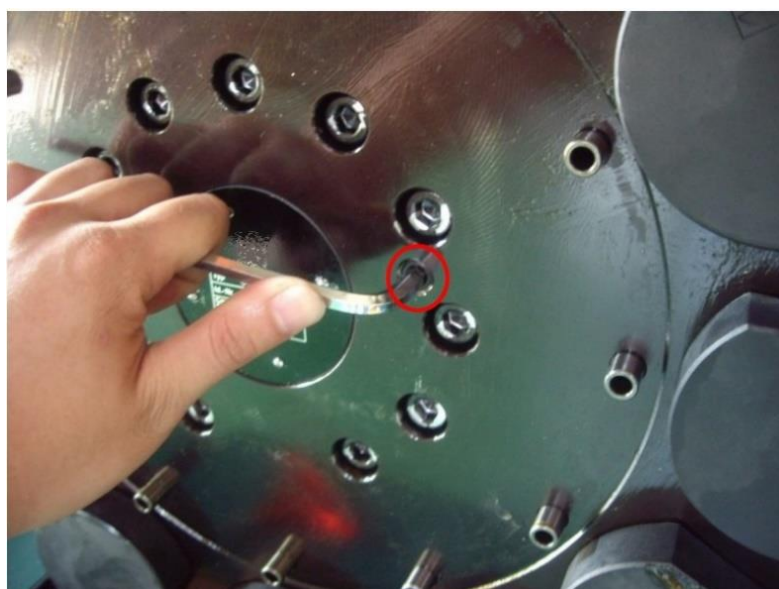
M8 螺絲扭力為 41Nm \ M8 screw torque is 41Nm

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

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

3.將塞頭螺絲拆下

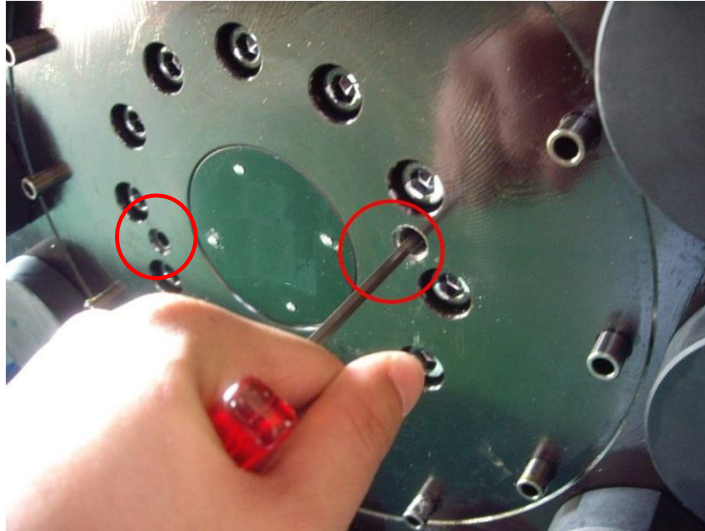
Remove the plug.



4.使用六角 T 型扳手將破緊螺絲往內鎖進(紅圈處) , 使刀盤向外推開拆下刀盤

Use Hexagonal T-shape wrench to fasten the locking screw (red circled)

inward to let the tool disc to be disassembled.



5.移除刀盤後即可看到 T 型塊

After taking off the tool disc, you may see a circle of T-slots.



6. 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，不需鎖死，保持可些微左右移動的狀態

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.

