

VDI 刀盤精度異常

Poor accuracy on tool disc



1. 檢查油壓是否 50KG

Confirm if hydraulic pressure is 50KG.



2. 利用測試棒檢查刀盤精度 X 軸向精度是否正常？如不良，放鬆刀盤螺絲來調

整 1 號刀 X 軸向精度至 0.01mm 內，調整完後務必確認動力刀座耦合正常

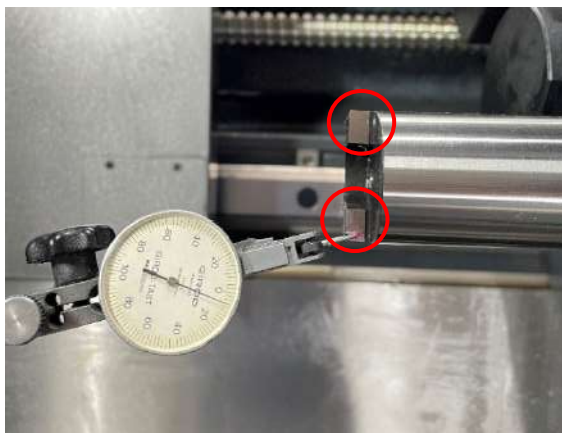
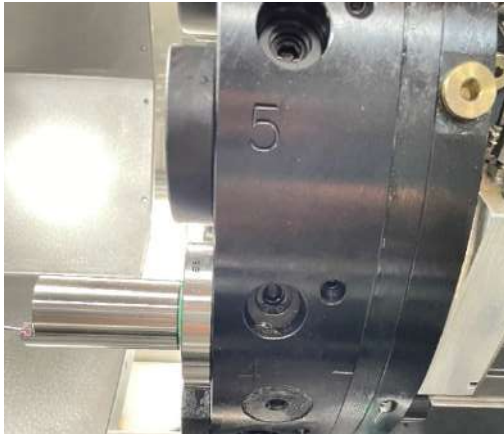
Use a testing mandrel to confirm the accuracy of X-axis of tool disc. If

of poor accuracy, please loosen tool disc screws and adjust X-axis

precision of T1 to be within 0.01mm. After the adjustment, please



make sure the coupling of live tool holder works normally.



3. 檢查刀盤 T 型塊/螺絲是否損壞，無法上足扭力

Check whether T-slots /screws were damaged and unable to lock by required torque ? .

M8: 40Nm、M10 : 80Nm、M12: 135Nm



4. 千分錶座磁在吸刀塔本體，量測刀盤任何一個位置，檢查刀塔夾緊時精度是否
在 0.01mm 內.

Put a dial indicator on the turret housing and measure any position of the
tool disc. Confirm the accuracy is within 0.01mm when turret is at
clamping status.

