

BMT, VDI 動力刀座安裝注意事項

Mounting attentions for BMT, VDI live tool holders

1.使用動力刀座時，如有異音請先移除動力刀座

Remove all tool holders when there is any abnormal sound.

2.檢查是否為動力機構本身的異音

Check if the abnormal sound comes from transmission mechanism itself?

3.動力機構耦合的中心已跟刀盤的加工位偏移

The center of transmission coupling is not aligned with the processing position of tool disc.

4.刀座長時間使用造成的零件磨損

Some tool holder parts might be worn out because of long-term use.

5.請勿在加工位置安裝動力刀座，以免導致原點偏移

Do not mount live tool holder on working position to avoid origin off-position.

6.安裝前都必須確認動力機構的原點位置是否正確

Before installation of live tool holder, ensure transmission mechanism is at origin position.

7.VDI - DIN5480 動力刀座在安裝前都必須做手動定位

Manual positioning is required for VDI-DIN5480 live tool holders upon mounting.

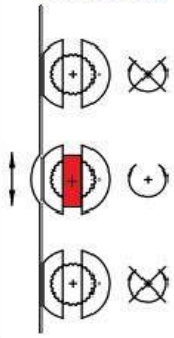


BMT - DIN1809 動力機構與刀座耦合示意

Diagram of BMT -DIN 1809 transmission mechanism and tool holder coupling

圖示(一):

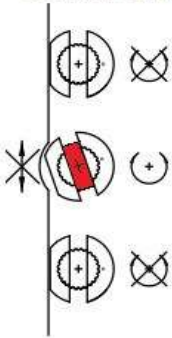
齒輪頭耦合齒在原點狀態下才可作換刀及旋轉之動作



Tool drive in zero - position.
Rotating or indexing is possible.

圖示(二):

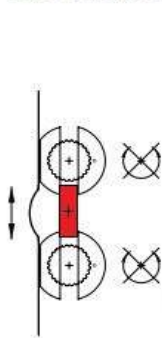
齒輪頭耦合齒沒在原點狀態下不可作換刀及旋轉之動作



Tool drive not in zero - position.
Rotating or indexing is not possible.

圖示(三):

齒輪頭耦合齒在原點狀態下，但齒輪頭位移不可作換刀及旋轉之動作



Fault case.
Turret in inter position.

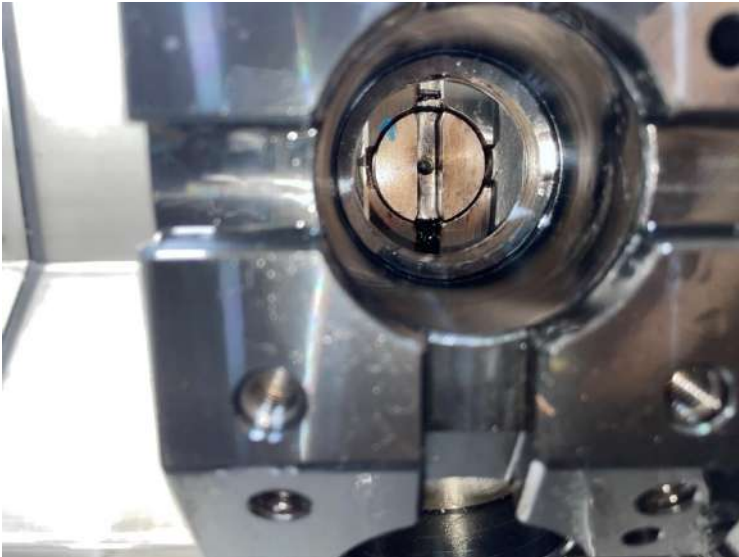


齒輪頭耦合齒必須與刀盤孔同心並和導軌成平行

刀座耦合齒示意圖

Only do indexing and rotating when gear head coupling is at zero position.

BMT 齒輪頭原點位置 BMT gear head origin position

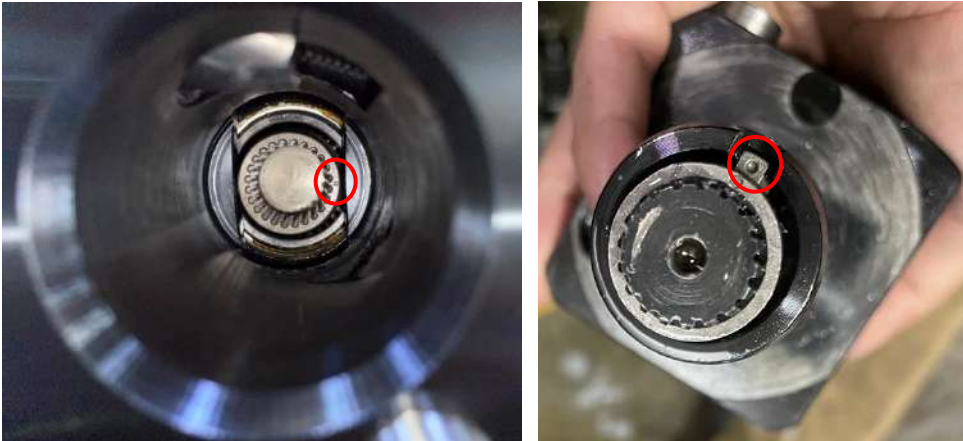


VDI -DIN5480 動力機構與刀座耦合示意

Diagram of VDI- DIN5480 transmission mechanism and tool holder coupling

軸向齒輪箱與徑向齒輪頭 3 點鐘原點位置

Axial gearbox and radial gear head 3 o'clock origin position



動力刀座要裝在刀盤前，需先手動旋轉將動力刀座之耦合定位銷卡入定位槽，若動力刀座安裝前未

先手動定位，容易導致定位不精準或卡刀等情形，而造成動力刀座及齒輪箱動力刀機構零件的損壞。

Before mounting VDI live tool holder to the tool disc, pls ensure to manually rotate the tool holder coupling and make sure the coupling positioning pin is snapped into the positioning groove. Fail to do this positioning procedure might cause inaccurate live tooling positioning or stuck and lead to damage on live tooling and tool drive unit of gear box.

