

VDI 齒輪頭調整 Gearhead adjustment

調整前確認刀塔油壓 50kg 並移除動力刀座，刀塔在 1 號刀記號線夾緊狀態並有 S8 訊號

Before adjustment, confirm hydraulic pressure is 50kg. Remove all live tool holders, and confirm turret is clamped at T1 station (as per pic shown) and S8 has signal.



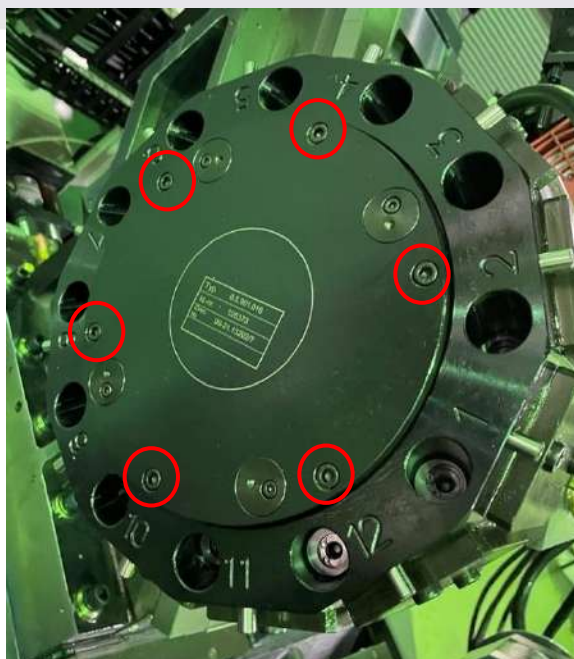
1. 確認刀盤上方與本體平行的面 X 軸向精度是否正常約 0.01mm 內

Confirm x-axis precision is within 0.01mm.



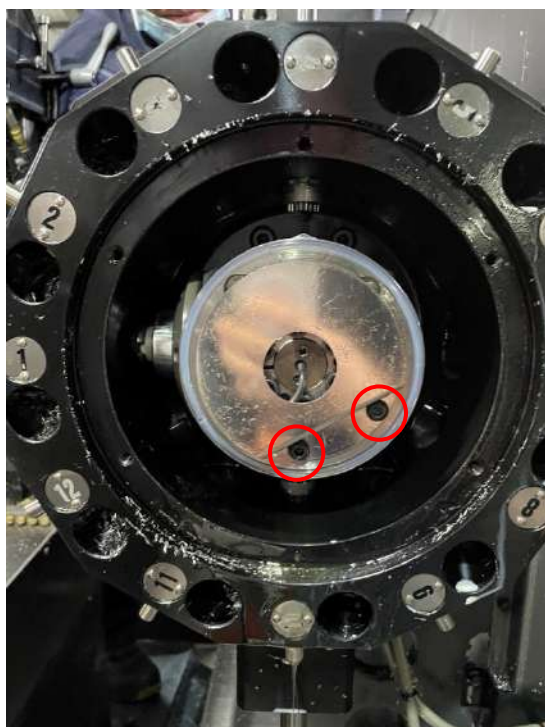
2. 拆解前蓋上 6 顆螺絲

Remove 6 screws on front cover of turret.



3. 移除螺絲拆解齒輪頭蓋板

Remove screws, and then disassemble the gearhead cover.



4. 放鬆齒輪頭迫緊螺絲 6 顆

Loosen 6 tightening screws on the gearhead.





齒輪頭螺絲
Gearhead screw

5. 利用旁邊螺絲孔鎖上螺絲放鬆迫緊環

Install a screw on the next-by screw hole to loosen the tightening ring



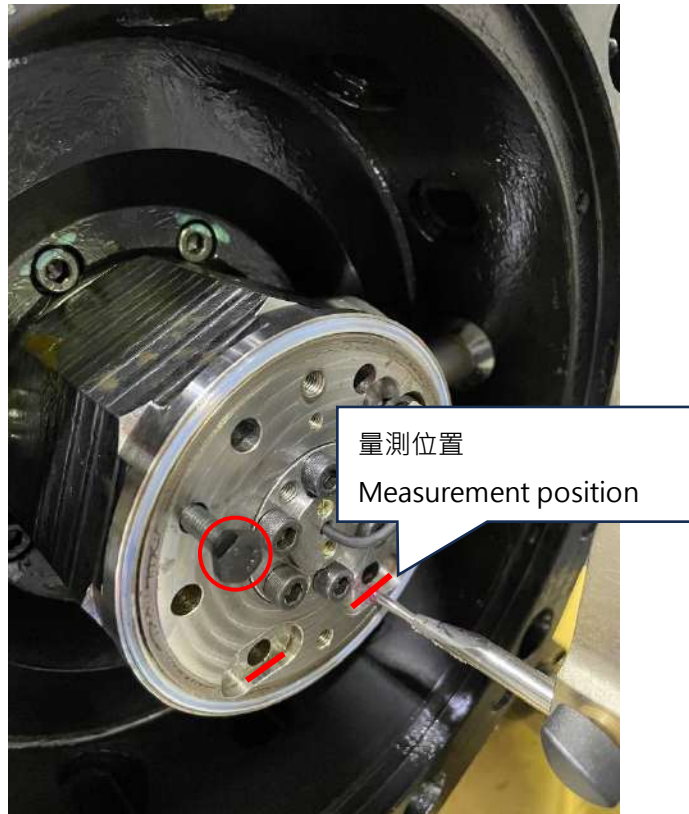
利用螺絲放鬆迫緊環
Loosen the tightening ring with a screw

齒輪頭調整有兩種方式:

There are two ways to adjust the gearhead:

6. 方法 A. 齒輪頭放鬆後鎖上螺絲輕敲，調整齒輪頭水平 X 軸向約 0.01mm 內，鎖緊迫緊環螺絲。

Method A. After loosening the gearhead, fasten a screw, and tap lightly to adjust the gearhead x-axis to be within 0.01mm, and then fasten a tightening screw.

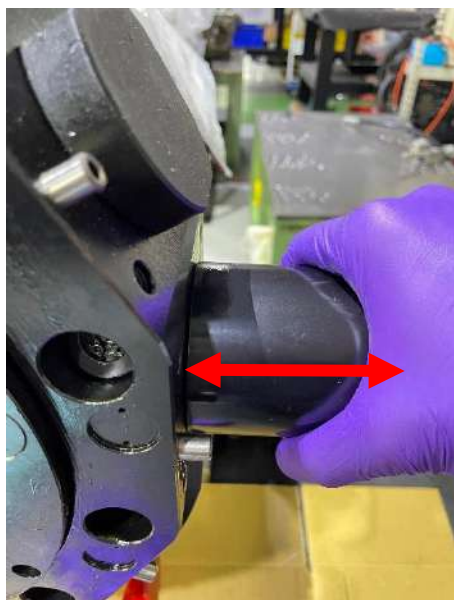
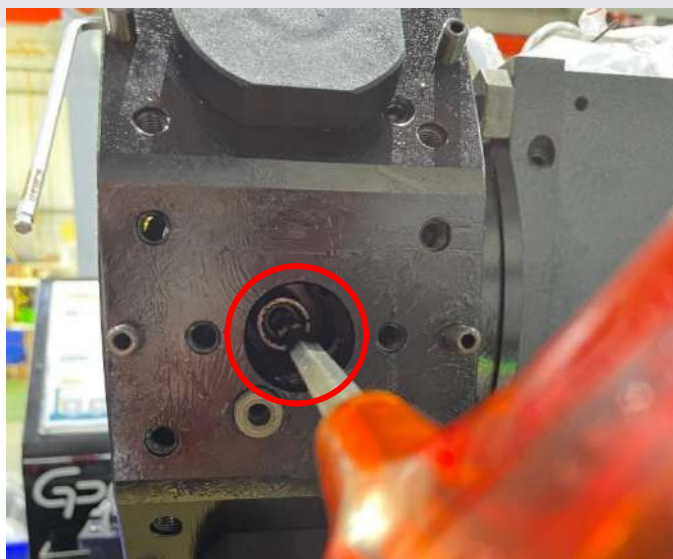


方法 B. 先目測刀盤與齒輪頭的中心後鎖上前蓋，耦合齒調整至 3 點鐘方向並利用 T 型扳手上下調整耦合齒中心位置，放鬆刀盤迫緊塊使動力刀座可以手動耦合順暢

Method B.

Visually check the center of tool disc and gearhead, then install the front cover.

Adjust the coupling to 3 o'clock and use a T-shape wrench to adjust the center of coupling up and down. Loosen tool disc pressing block so the live tool holder can be coupled smoothly by hand.



動力刀座確認耦合順暢後，利用動力刀座的耦合齒固定齒輪頭

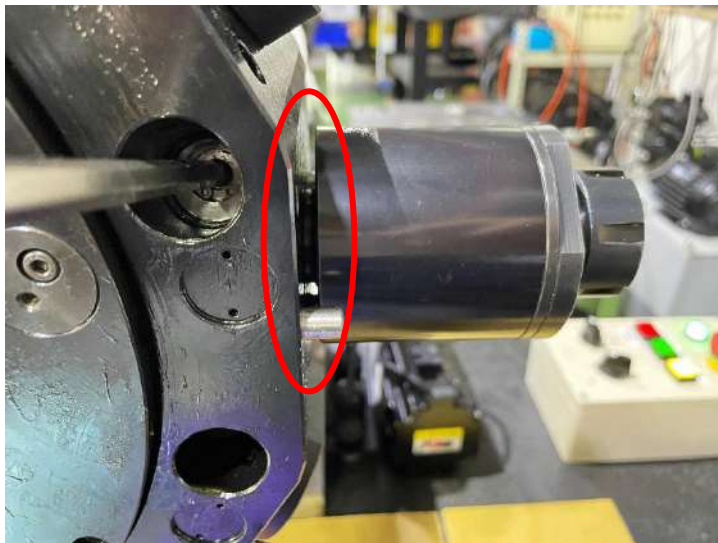
After confirming smooth coupling of live tool holder, use a live tool holder
coupling to fix the gearhead.





動力刀座必須以不能轉動的距離鎖上刀盤，刀盤迫緊塊輕微鎖緊避免傷到齒排，此時動力刀座的耦合齒已固定住齒輪頭的位置

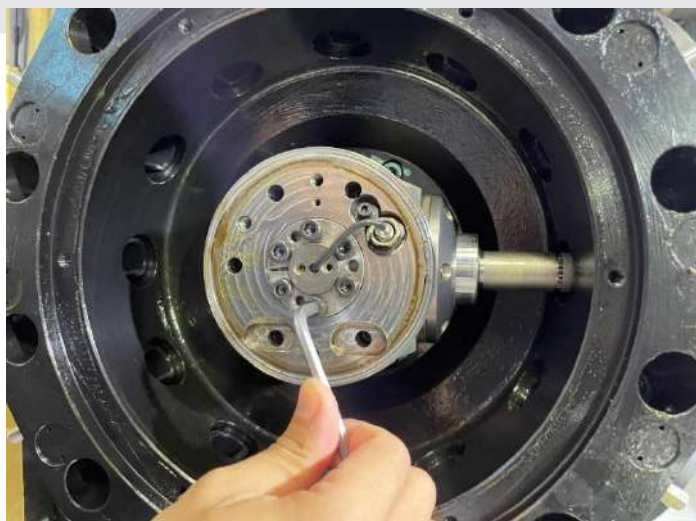
Mount the driven tool holder to the tool disc, fastening the tool disc clamping block gently and not to damage the serration of the live tool holder. At this moment, the driven tool holder coupling is coupled to the gearhead.



拆下前蓋，鎖緊迫緊環螺絲後移除固定齒輪頭的刀座

Remove the front cover, tighten the tightening ring screw and remove the tool holder that fixes the gearhead.





7. 齒輪頭調整完鎖上前蓋，確認動力軸原點位置及手動耦合必須順暢

After adjusting the gearhead, install and fasten the front cover. Confirm the origin position of the transmission shaft and ensure coupling by hand must be smooth.

