

VDI25 耦合齒組更換作業

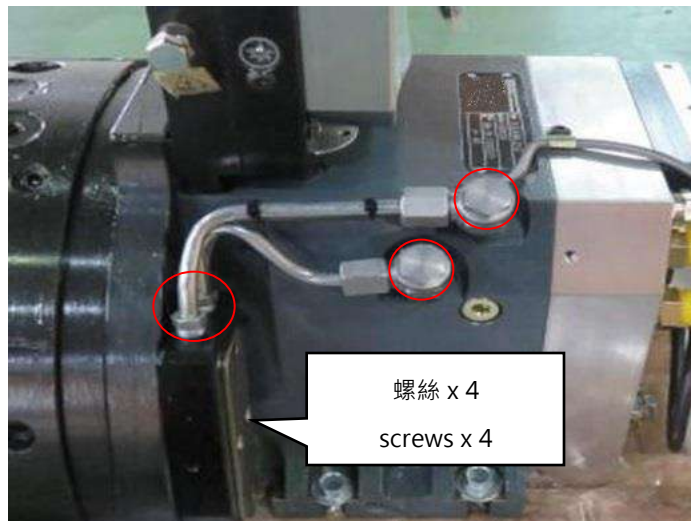
VDI 25 coupling gear set replacement procedure

更換前請先切斷油壓

Switch off hydraulic pressure before replacement.

1. 拆下 AB 油管接頭及保護蓋螺絲

Remove AB oil pipe connector and protective cover screws.



2. 拆下耦合齒座組螺絲，將耦合齒座組取出

Remove all screws, and take out the coupling gear base assembly.



3. 拆下油壓缸兩支螺絲，將油壓缸連動耦合齒取出

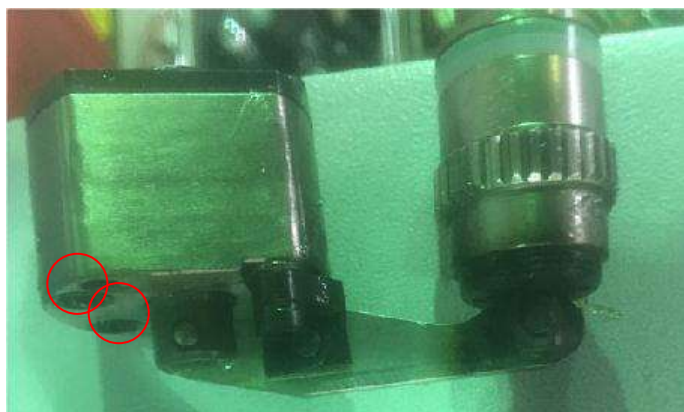
Remove 2 screws of hydraulic cylinder, and then take out the coupling of the hydraulic cylinder.



4. 注意 O-ring 不可遺失，更換此組零件，反向裝回新品

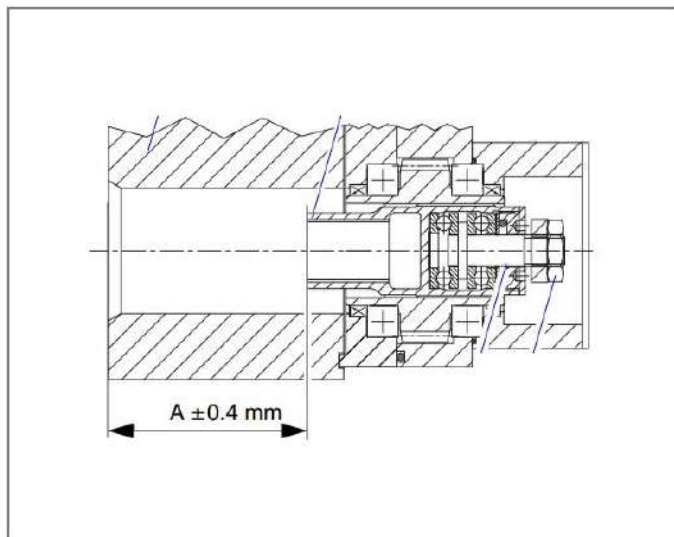
Be careful not to lose O- rings.

Reinstall back after replacement.



5.刀塔鎖緊時,量測耦合齒距離是否正確 ?

Measuring coupling distance is correct when turret is at clamping position.



Coupling profile	耦合齒距離	clearance A ± 0.4 [mm]	
11×0.8	DIN 5480	41	
14×0.8	DIN 5480	49.5	VDI25
16×0.8	DIN 5480	58.5	VDI30
20×0.8	DIN 5480	65	VDI40
24×1.25	DIN 5480	83	VDI50
30×1.25	DIN 5480	95	VDI60



6. 設定 C 軸定位角度需將齒輪記號設定在三點鐘方向

Set gear mark at 3 o'clock position when doing C axis setting.

