

機台上拆解齒輪箱前蓋步驟

Steps to disassemble gearbox front cover on machine

1.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。

1. Mount hooks on tool disc and lift it up by crane to avoid it from falling down. Remove all screws on front cover of the tool disc.



M8 螺絲扭力為 41Nm \ M8 torque is 41Nm

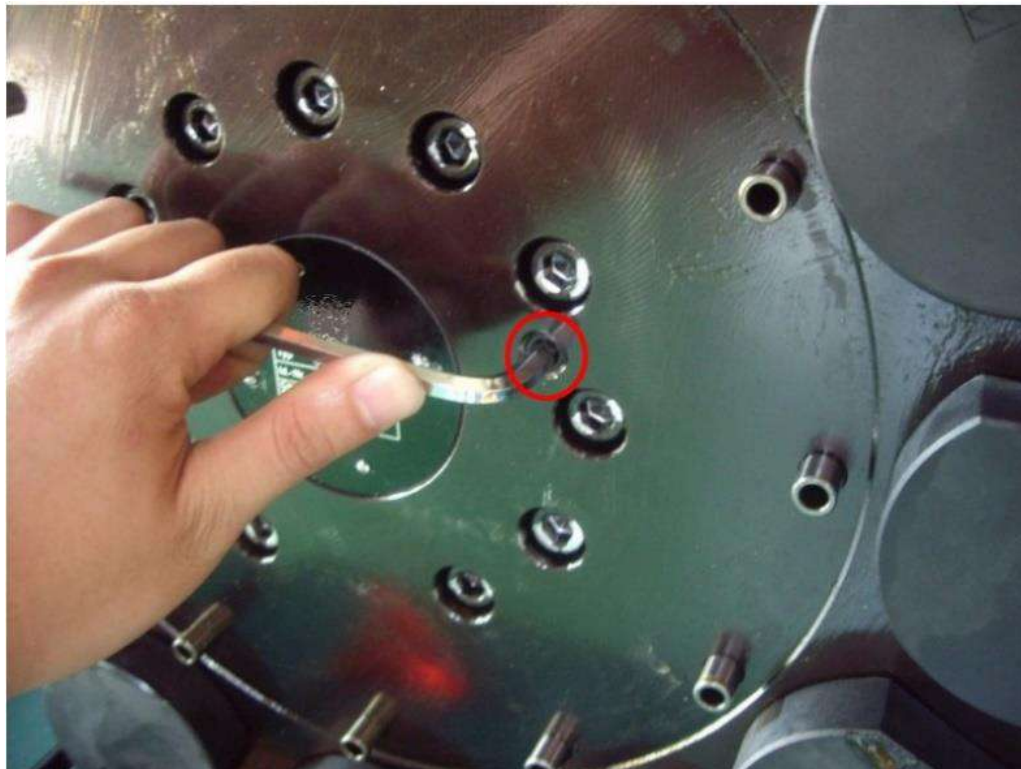
M10 螺絲扭力為 83Nm \ M10 torque is 83Nm

M12 螺絲扭力為 135Nm \ M12 torque is 135Nm



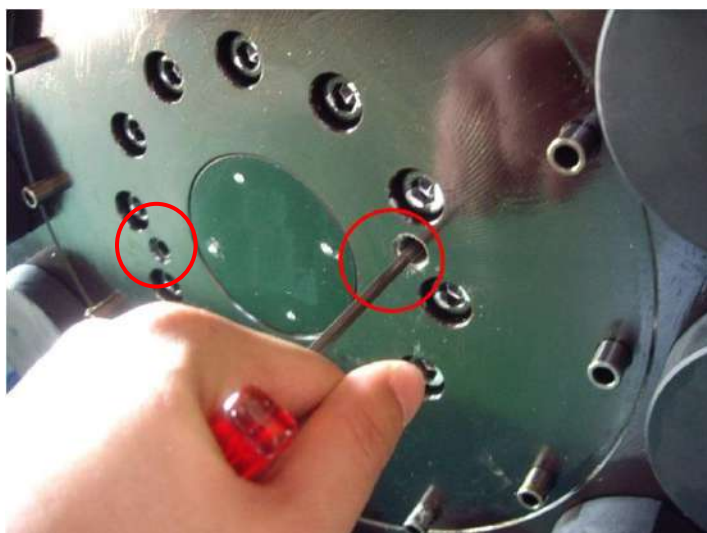
2.將塞頭螺絲拆下。

Remove screw plug.



3.使用六角 T 型板手將迫緊螺絲往內鎖進(紅圈處)，使刀盤向外推開拆下刀盤。

3.Use a Hex T-shape wrench to fastening screw inward (red circle) and
allow the tool disc to be removed.



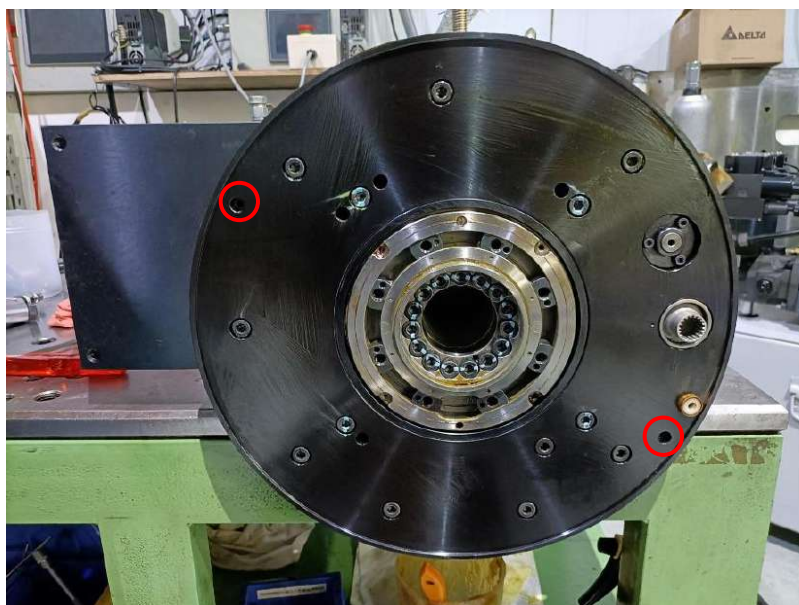
4. 移除齒輪箱後方的出水閥。

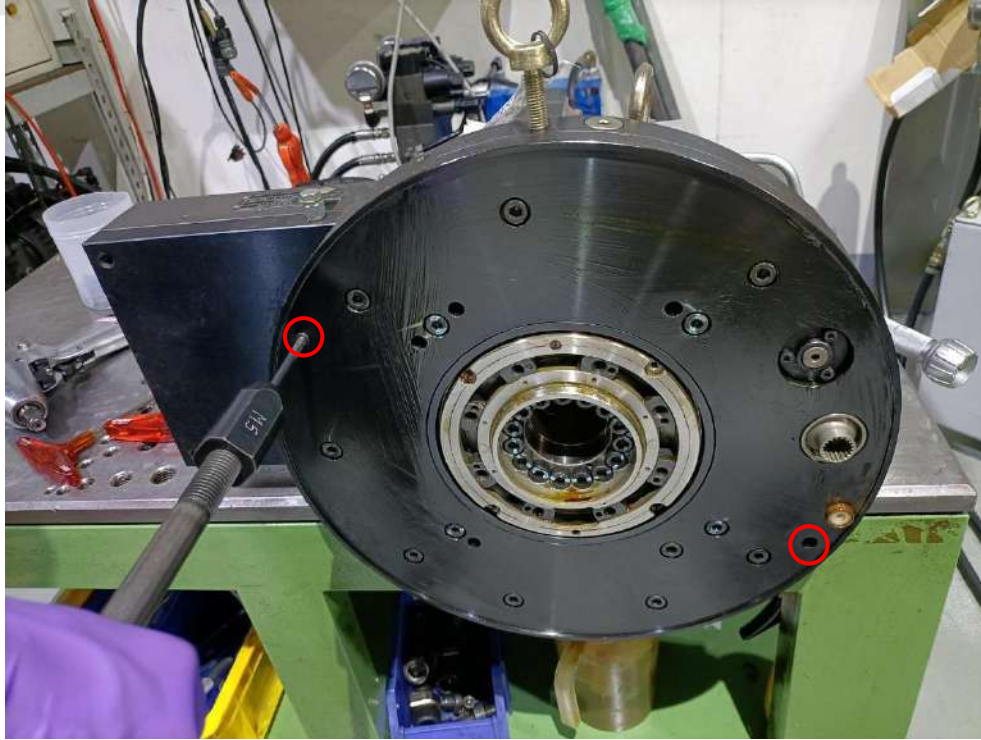
4. Remove the coolant valve behind the gearbox.



5. 移除齒輪箱上蓋及本體之間的定位銷 x2。

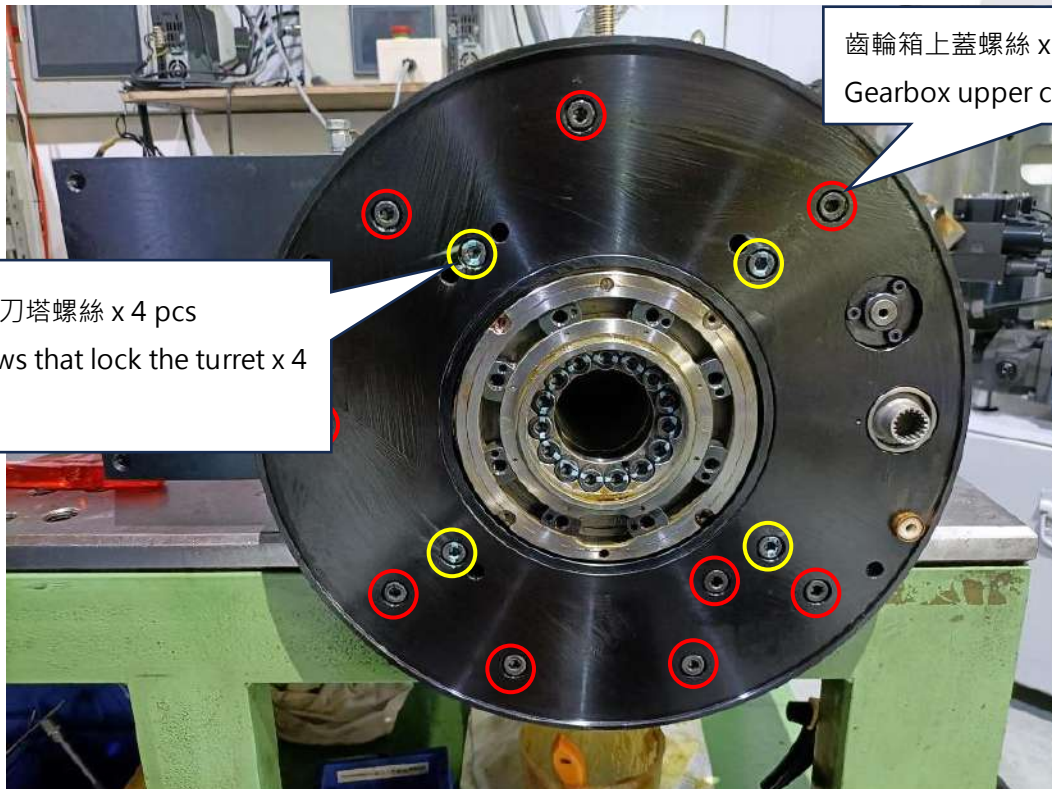
5. Remove the positioning pins x2 pcs between the upper cover of gearbox and the housing.





6. 將齒輪箱上蓋及鎖固刀塔的螺絲全部移除。

6. Remove 9 * screws located on the upper cover of the gearbox, and the 4 * screws that lock the turret.

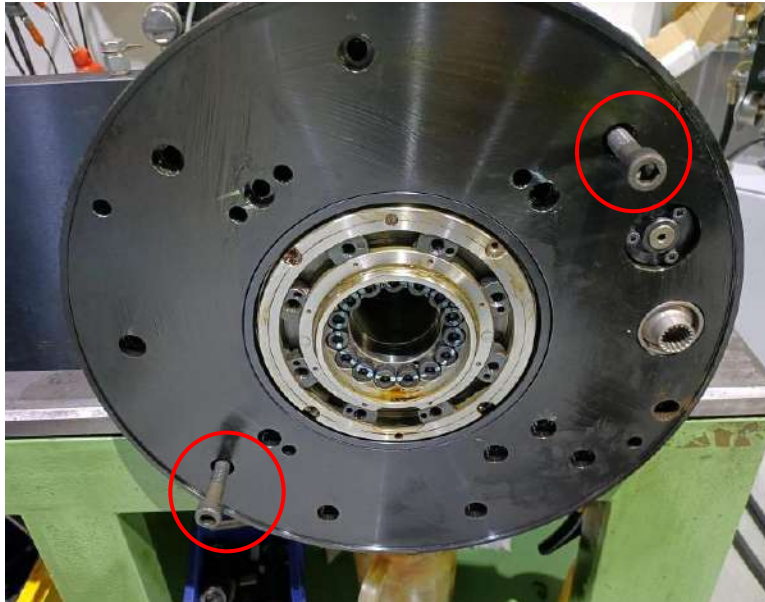


齒輪箱上蓋螺絲 x 9 pcs
Gearbox upper cover screws x 9 pcs

鎖固刀塔螺絲 x 4 pcs
screws that lock the turret x 4 pcs

7. 利用螺絲往內鎖進上蓋螺絲孔將前蓋逼出。

7. Use 2 screws to lock into the screw holes on the upper cover and force the front cover to come out.



8. 利用螺絲逼出的兩個孔位，建議更換 O 型圈。

8. It is recommended to replace with new O-rings on the 2 screw holes that are used to force the front cover out.

