

進給器 安裝說明 (X軸-左右向適用)

POWER TABLE FEED INSTALLATION MANUAL (AVAILABLE FOR CROSS TRAVEL)



步驟 1
將固定座，固定在工作固定台上，取軸承內圈套入螺桿上，再將進刀器固定在固定座上。取下齒輪蓋。

Step 1
To set the fix stand on work table, take bearing bushing and set it on the axis screw, then set the power table feed on the fix stand, take out the gear housing.



步驟 2
注意!左手必須緊緊握住中心傳動軸。

Step 2
NOTE!
Left hand must hold the center transmission shaft.



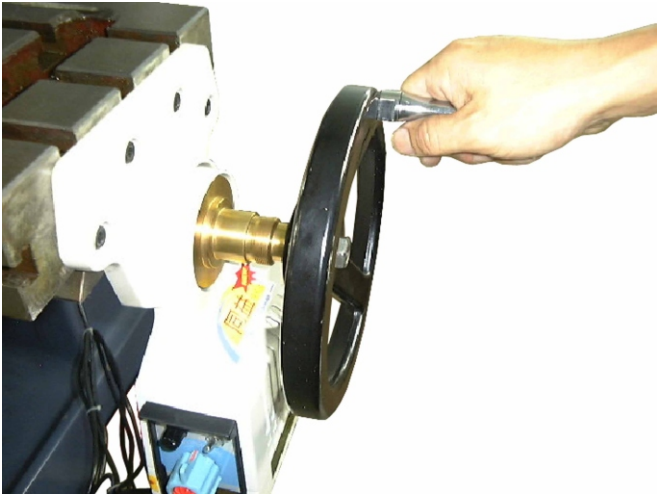
步驟 3
將左手按住中心傳動軸，右手將銅傘齒輪套入螺桿上，並左、右晃動感覺齒輪間之問隙是否在0.1~0.2mm之間。

Step 3
By using left hand to hold the center transmission shaft. By using right hand to set the bevel gear on axis screw. Then, check the backlash between gears is in the range 0.1~0.2mm.



步驟 4
若齒輪間隙太小，則取適當厚度(1.0t, 0.25t, 0.1t)之間隙墊圈套入，然後再重復步驟3，直到間隙達到要求為止。

Step 4
If the backlash is too small, to add shims(1.0t,0.25t,0.1t). Then ,repeat the step 3 until the backlash is satisfied.



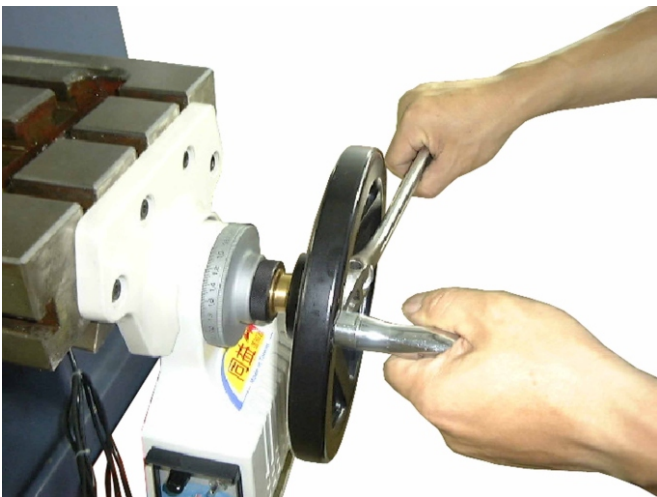
步驟 5
放入埋頭平行鍵及銅傘齒輪，鎖緊把手。
輕輕轉動把手，感覺齒輪之間是否有干涉(即間隙太小之故)，若有干涉則必須重覆步驟3及步驟4，再增加適當之間隙墊圈，若否，則進行下一步驟。

Step 5
To set socket parallel key and bevel gear, tighten the handle.
Slightly rotate the handle, to feel if any interfere in between (backlash).
If interfere, please repeat the procedure step 3 & step 4, to add few more shims.
If not, go to next step.



步驟 6
取出把手，放入適當之大間隙墊圈(Φ43×Φ33)以調整刻度盤與傘齒輪之間隙，並鎖上固定環。

Step 6
Take out the handle, add proper shim(Φ43×Φ33), to adjust the backlash between dial & bevel gear, lock with fix ring.



步驟 7
放入把手並鎖緊之，此時輕輕搖動把手，應無干涉音，且非常輕盈輕鬆。

Step 7
To set the handle and tighten, slightly rotate the handle, there should be smoothly without any interfere.



步驟 8
最後再套上齒輪蓋，並固定極限開關

Step 8
Finally, to set the gear housing and limit switch.