

精準校正 提高效率

Precision and productivity in production



Cutting Edge Solution

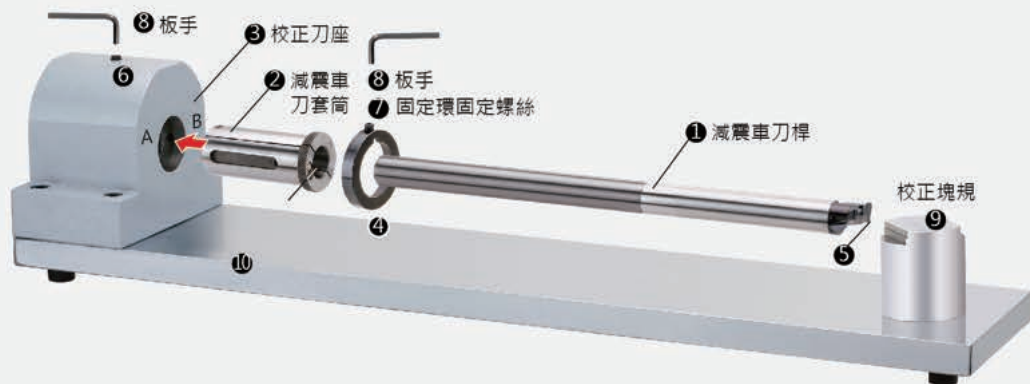
減震車刀中心校正台

Tool Setter for STABLELINE Damped Turning Tool

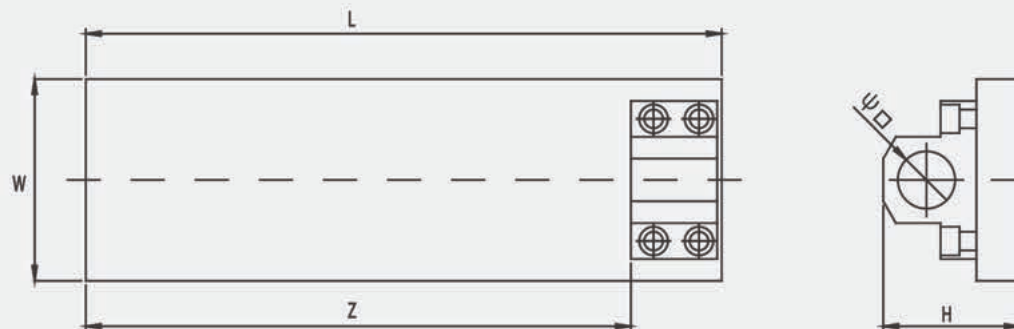


減震車刀中心校正台

Tool Setter for STABLELINE Damped Turning Tool



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|-----------------------------|----------------------------------|
| ① 減震車刀桿 | ① Damped turning tool |
| ② 減震車刀套筒 | ② Damped turning tool sleeve |
| ③ 校正刀座 (Ø32, Ø40, Ø50, Ø60) | ③ Tool holding seat |
| ④ 固定環 | ④ Retaining ring |
| ⑤ BM車刀頭刀尖 | ⑤ Tool tip of LT turning head |
| ⑥ 校正刀座固定螺絲 | ⑥ Setscrew for tool holding seat |
| ⑦ 固定環固定螺絲 | ⑦ Setscrew for retaining ring |
| ⑧ 六角板手 | ⑧ Hex wrench |
| ⑨ 校正塊規 | ⑨ Block gauge |
| ⑩ 中心校正台本體 | ⑩ Tool setter table |



規格 Spec	有效 校正長 Z	全長 L	寬 W	高 H	重量 Weight (KGS)	搭配減徑 專用套筒
CRT-C32	600	700	150	150	26	RSC32-ψ□
CRT-C40						RSC40-ψ□
CRT-C50						RSC50-ψ□
CRT-C60						RSC60-ψ□

- ▲ □: 車刀柄徑
- ▲ 所有規格均含有附件:校正塊規×1PCS、固定環×1PCS、4mm六角板手×1PCS
- ▲ □: Car knife shank diameter
- ▲ All specifications contain accessories: correction block gauge x 1PCS, fixed ring x 1PCS, 4mm hexagonal plate hand x 1PCS

減震車刀中心校正台專為快速校正減震內孔車刀而設計。

The shock absorber knife center correction station is designed for quick correction of shock-absorbing inner hole car cutters.

減震車刀中心校正台需搭配減震內孔車刀套筒使用。

The center correction table of the shock-absorbing vehicle knife should be used with the shock-absorbing inner hole car knife sleeve.

可依不同內孔車刀的伸出長度與車刀桿直徑的比值L/D，而選擇不同的中心高。

Depending on the extended length of the car knife and the diameter ratio of the car blade L/D, the different center height can be selected.

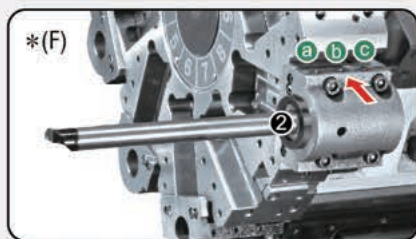
使用說明

OPERATION INSTRUCTIONS

1. 配合減震車刀套筒選擇適合的校正刀座，內孔有 $\varnothing 32$ 、 $\varnothing 40$ 、 $\varnothing 50$ 、 $\varnothing 60$
2. DPH或DPC減震車刀桿鎖上欲使用的BM車刀頭，再將對應的車刀片鎖上BM車刀頭。
3. (A)將固定環④套入減震車刀套筒②上，再將DPH或DPC減震車刀桿①裝入相同尺寸的減震車刀套筒②內。
(B)將上述整組放入校正刀座③內
(C)確認減震車刀套筒②的出水孔位置，同BM車刀頭刀尖⑤方向，朝向校正刀座A位置(左手車刀對應B位置)，使用板手⑧輕鎖校正刀座③上方固定螺絲⑥，以固定減震車刀套筒角度，鎖緊力不可過大，減震車刀桿需在減震車刀套筒②內可以自由伸縮。
*(D)減震車刀桿①拉伸至應用長度，將刀尖輕靠在校正塊規⑨的小凸緣上，伸出長度在8D內選用-0.1的凸緣，超過8D含以上長徑比則選用-0.2的凸緣。
(E)用板手⑧輕鎖固定環④上的固定螺絲⑦，以夾緊減震車刀套筒②和減震車刀桿①。
*(F)鬆開校正刀座③上方固定螺絲⑥，將組合好的減震車刀套筒②、固定環④、減震車刀桿①一同取出再裝入車床上的內徑車刀座內，鎖固減震車刀套筒②時，需先鎖車刀座中間的固定螺絲b，再鎖另外兩顆固定螺絲a、c。最後將固定環④上的固定螺絲⑦鬆開，取出固定環④，若無干涉也可不取出固定環④。



將刀尖輕靠在校正塊規的小凸緣上
8D內選用-0.1的凸緣，8D含以上
選用-0.2的凸緣



◀ Place the tool tip on the flange surface of the block gauge.
-0.1 flange for the tools less than 8D
-0.2 flange for the tools exceed or equal to 8D

1. Select the corresponding tool setter among different sizes $\varnothing 32$, $\varnothing 40$, $\varnothing 50$, $\varnothing 60$ according to the type of damped turning tool sleeve.
2. Fit the BM turning head to DPH or DPC damped turning tool and mount the insert.
3. (A) Position the retaining ring ④ on the damped turning tool sleeve ②, then fit the DPH or DPC damped turning tool ① into its equal sized damped turning tool sleeve ②.
(B) Position the damped tool assemblies into the tool holding seat ③.
(C) Check that the coolant nozzle position on the damped turning tool sleeve ② must be in line with the tool tip of the BM turning head ⑤, and which turn towards to the position A on the tool holding seat (on the contrary, turn towards to the position B in cases when the left-hand tool is used), Using a hex wrench ⑧, hand-tighten the setscrew ⑥ located at the top position of the tool holding seat ③ so that the angle of the damped turning tool sleeve can be positioned. Slight tightness of the setscrew is necessary to assure the damped turning tool can move back-and-forth freely in the sleeve ②.
*(D) Slide and adjust the damped turning tool ① to the applicable length, place the tool tip on the flange surface of the block gauge ⑨. Tool tip to be placed on flange surface at which marked -0.1 for length and diameter ratios less than 8D; tool tip to be placed on flange surface at which marked -0.2 for length and diameter ratios exceed or equal to 8D.
(E) Slightly tighten the setscrew for retaining ring ⑦ with hex wrench ⑧ until the damped turning tool sleeve ② and the damped turning tool ① is properly clamped.
*(F) Loosen the setscrew for tool holding seat ⑥, remove the damped turning tool assemblies ①②④ from the tool holding seat ③, Mount the damped turning tool assemblies ①②④ on the ID turning tool holder on a lathe. While fasten the damped turning tool sleeve ②, firstly tighten the setscrew b, located at the middle of the tool holder, following with the setscrew a, and c.
In case of interference, the retaining ring ④ can be removed by loosen the setscrew for retaining ring ⑦.



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