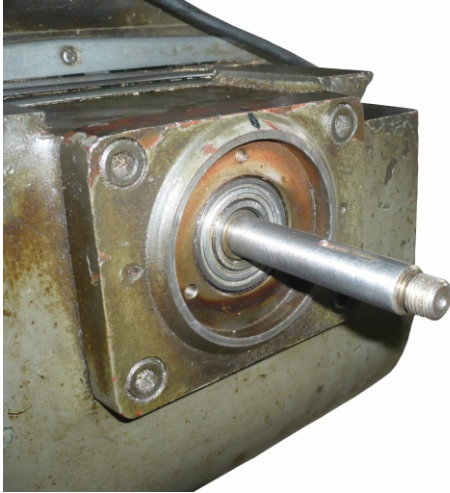


進給器 安裝說明 (Y軸-前後向適用)



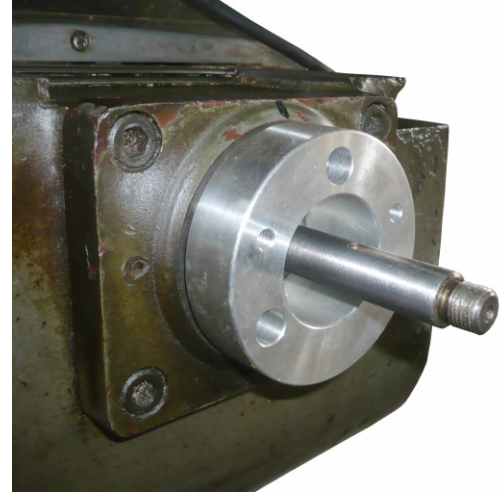
步驟 1

1. 將Y軸車臂移到最內側。
2. 從銑床上拆下把手固定螺帽，把手(轉輪)、平行埋頭鍵及尺標刻度盤。
3. 鬆開原有固定座之固定螺絲(M6×P1.0 - 3 pcs)，取下原有固定座。

Step 1

1. Move cross table to the column end.
2. Disassembly handle fix nut, handle (hand wheel), parallel socket key and dial from milling machine.
3. Loosen fix screws (M6×P1.0 - 3 pcs) from fix stand. Take out fix stand from axis screw.

POWER TABLE FEED INSTALLATION MANUAL (AVAILABLE FOR CROSS TRAVEL)



步驟 2

安裝Y軸固定座，以剛才拆下之固定螺絲(M6×P1.0-3 pcs)鎖緊。

Step 2

Install Y-axis fix stand, tighten up with fix screws (M6×P1.0 - 3 purchase).

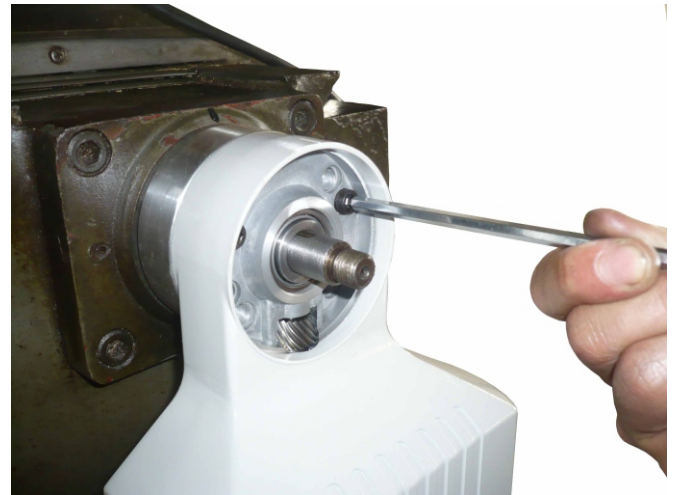


步驟 3

將Y軸內圈套上螺桿，推到最內處。

Step 3

To set Y-axis bushing onto axis screw and push bushing back.



步驟 4

將進給器機體套上Y軸內圈，安裝基準面貼合Y軸固定座以所附螺絲(M6×P1.0×25-2 pcs)鎖緊。

Step 4

To set power table feed at the right position and align with spring spin, set Y-axis bushing & gently knock in. Surface attach to Y-axis fix stand. Then tighten up with inner hex socket screw (M6×P1.0×25 - 2 pcs)



步驟 5
將延長軸與螺桿鎖緊，對正延長桿鍵槽之延伸方向在螺紋鎖合處鑽孔 $\Phi 4.0$ 貫穿並以彈簧銷($\Phi 4 \times 14$)插入固定，(必要時請自行切削延長軸之長度)。

Step 5
Tighten up extension shaft with axis screw.
To align with the direction of key way of extension shaft, drill a through hole $\Phi 4.0$ at the screw, then set into spring pin ($\Phi 4 \times 14$)
(If necessary, can cut the length of extension shaft)



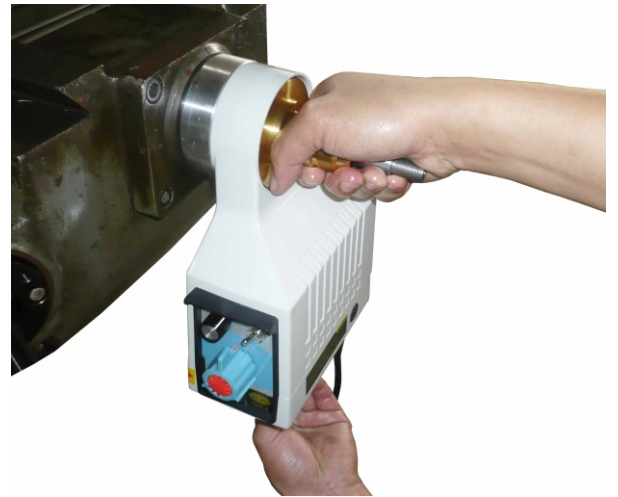
步驟 6
取下齒輪蓋

Step 6
Take out the gear housing.



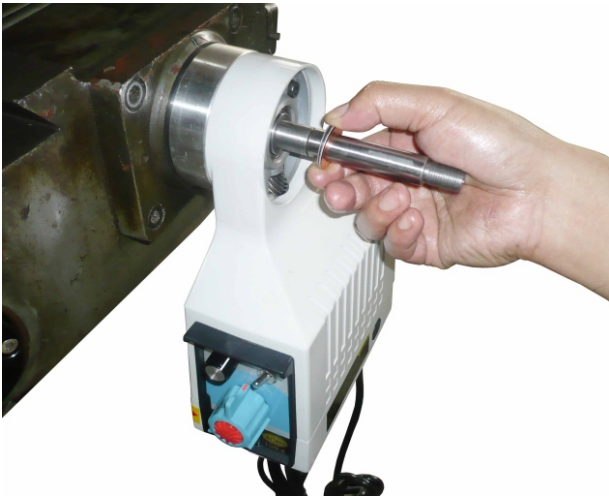
步驟 7
注意!左手必須緊緊握住中心傳動軸。

Step 7
NOTE!
Left hand must hold the center transmission shaft.



步驟 8
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間隙是否在 $0.1 \sim 0.2\text{mm}$ 之間。

Step 8
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 $0.1 \sim 0.2\text{mm}$.



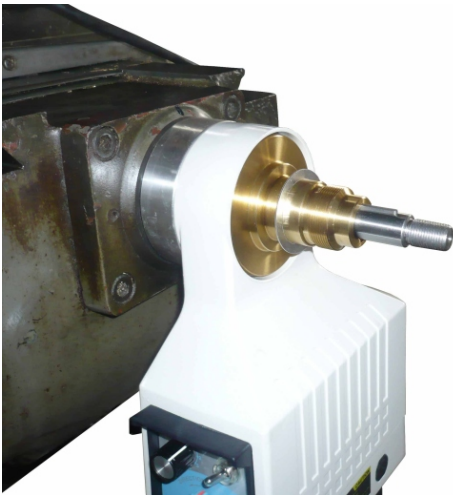
步驟 9
若齒輪間隙太小，則取適當厚度(1.0t,0.25t,0.1t)之間隙墊圈套入，然後再重復步驟8，直到間隙達到要求為止。

Step 9
If the backlash is too small, to add shims(1.0t,0.25t,0.1t). Then ,repeat the step 8 until the backlash is satisfied.



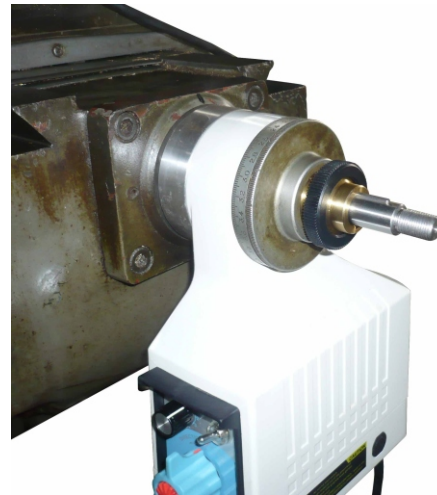
步驟 10
在延長軸之鍵槽中放入平行埋頭鍵，對準鍵槽再套入銅質傘齒輪(72齒)。

Step 10
To set parallel key into the key way of extension shaft, align with the key way, to set the bevel gear (72T).



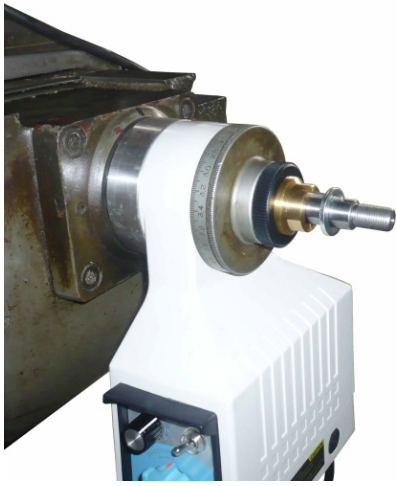
步驟 11
套上大間隙墊圈($\Phi 43.4 \times \Phi 33.4$)建議先使用 0.25t 2片，然後裝上尺標刻度盤。

Step 11
To set the shim ($\Phi 43.4 \times \Phi 33.4$). It is suggested to use 0.25t - 2 pcs, then to set the dial.



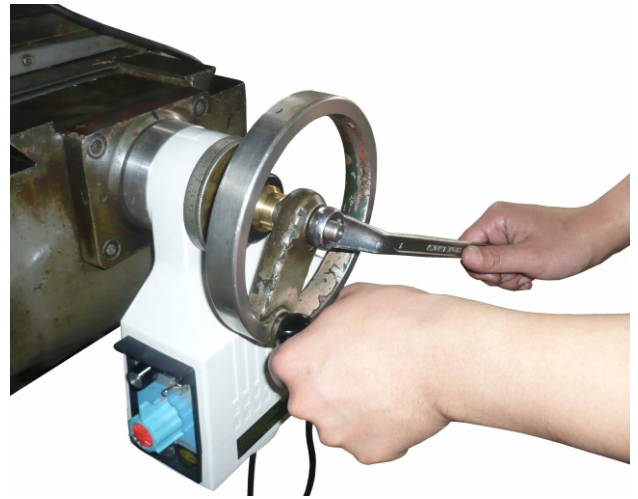
步驟 12
1. 檢查尺標刻度盤與機體端面之間隙尺寸 (0.5 ~ 0.75mm) ，若不在此範圍內請重覆步驟 11，直到間隙尺寸正確為止。
2. 鎖上固定環，將尺標刻度盤固定。

Step 12
1.To check backlash (0.5 ~ 0.75mm) between dial and surface of power table feed. If it's not in the range, please repeat the procedures step 11 until proper backlash is obtained.
2.To lock fix ring and dial.



步驟 13
裝上把手墊圈(可視實際需要自行決定要或不要)

Step 13
To set handle washer < If necessary >



步驟 14
1. 裝上把手(或轉輪)，鎖上固定螺帽。
2. 轉動把手幾圈檢查是否會碰觸到進給器機體，並感覺齒輪轉動時是否平順，若有明顯之齒間咬合聲即表示步驟4之間隙不正確，須重複8~12步驟，直到平順為止。

Step 14
1. To set handle (or hand wheel), tighten fix nut.
2. Rotate the handle few times, to check whether it is interfere with power table feed. Also check whether the gear rotate smoothly. If any noise from gear mash, it shows the backlash checked in step 4 is not correct. Please repeat the procedures from step 8 to step 12 until gear rotating is smoothly.



步驟 15
最後再套上齒輪蓋，並固定極限開關

Step 15
Finally, to set the gear housing and limit switch.