



# 減震車刀中心校正台

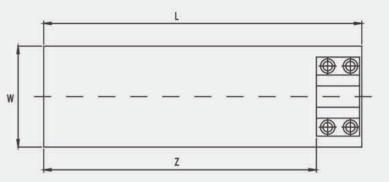
Cutting Edge Solution

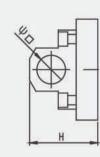
**Tool Setter for STABLELINE Damped Turning Tool** 



- ① 減震車刀桿
- 2 減震車刀套筒
- 6 校正刀座 (Ø32, Ø40, Ø50, Ø60)
- 4 固定環
- 6 BM車刀頭刀尖
- 6 校正刀座固定螺絲
- 固定環固定螺絲
- 8 六角板手
- 9 校正塊規
- 中心校正台本體

- Damped turning tool
- 2 Damped turning tool sleeve
- Tool holding seat
- A Retaining ring
- 6 Tool tip of LT turning head
- **6** Setscrew for tool holding seat
- Setscrew for retaining ring
- 8 Hex wrench
- Block gauge
- 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Ø32、Ø40、Ø50、Ø60
- 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®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 Ø32, Ø40, Ø50, Ø60 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 ring④ can be removed by loosen the setscrew for retaining ring⑦.



### 正河源機械配件有限公司

CHAIN HEADWAY MACHINE TOOLS CO..LTO.

JTEL:+886-4-26265252

FAX: +886-4-26267941

● 地址:台灣台中市清水區五權路232號

No. 232, Wuquan Rd., Qingshui Dist., Taichung City 436, Taiwan







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