

35-85-J2 ASSEMBLY PROCEDURES

H, PREPARE FOR TURRET ADJUSTMENT ON MACHINE

- 1, CLEAN ALL RELATED PARTS & INSTALL TURRET ASSEMBLY ON SADDLE.
- 2, HOOK UP ALL CONNECTION LINES.
- 3, INSTALL A BORING BAR HOLDER TO TURRET AS SHOWN.

I, ADJUSTMENT FOR TURRET DISK ANGULAR POSITION.

- 1, INSTALL A DIAL INDICATOR WITH THE LEVER POINTED TO OD CUTTER SLOT AS SHOWN.

- 2, MOVE THE TURRET UP AND DOWN ALONG X AXIS. WATCH THE READING AND MAKE SURE THE READING BEING WITHIN 0.01mm.

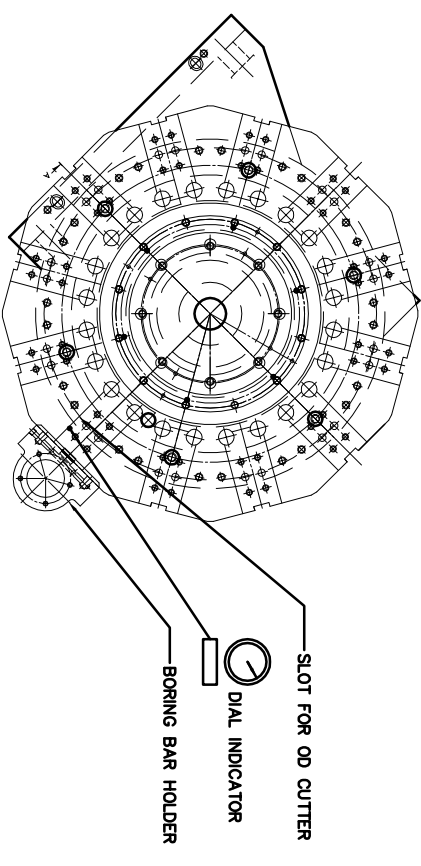
NOTE:

USE A RUBBER MALLET TO STRIKE TO ROTATE THE TURRET DISK TO ADJUST THE READING.

- 3, IF THE READING WITHIN SPECIFICATION, REMOVE THE TURRET DISK, FULLY TIGHTEN ALL THE SCREWS ON #69 CLUTCH, THEN PUT IT BACK TO TURRET BODY. DOUBLE CHECK THE PARALLELISM BETWEEN X AXIS AND OD TOOL SLOT.

IF THE READING STILL WITHIN SPECIFICATION, REMOVE THE TURRET DISK AGAIN AND PLANT THE TAPER PIN ON CLUTCH #69.

NOTE: IF THE PARALLELISM READING WITHIN 0.01 STILL CAN NOT DEVELOPED, IT IS NECESSARY TO ADJUST BODY SIDE PORTION OF CLUTCH #69.1



符號	種類	符號	種類	符號	除另行指定外一般加工公差為A級					熱處理	材質	核准	校對	設計	製圖	表面處理	數量	第三角法	比例	單位	圖名	機種	
					尺寸	區分	A級	B級	C級														
▽▽▽▽	平行度	//	真直度	—	1~4	±0.05	±0.10	±0.30															
▽▽▽	垂直度	⊥	真圓度	○	4~16	±0.07	±0.20	±0.50															
▽▽	傾斜度	∠	真圓度	○	16~63	±0.10	±0.30	±0.70															
▽	位置度	⊕	圓錐度	∅	63~250	±0.20	±0.50	±1.20															
▽	同軸度	⊙	線之圓錐度	∅	250~1000	±0.30	±0.80	±2.00															
▽	對稱度	↔	面之圓錐度	∆																			
▽	面之圓錐度	∆	基準線面																				