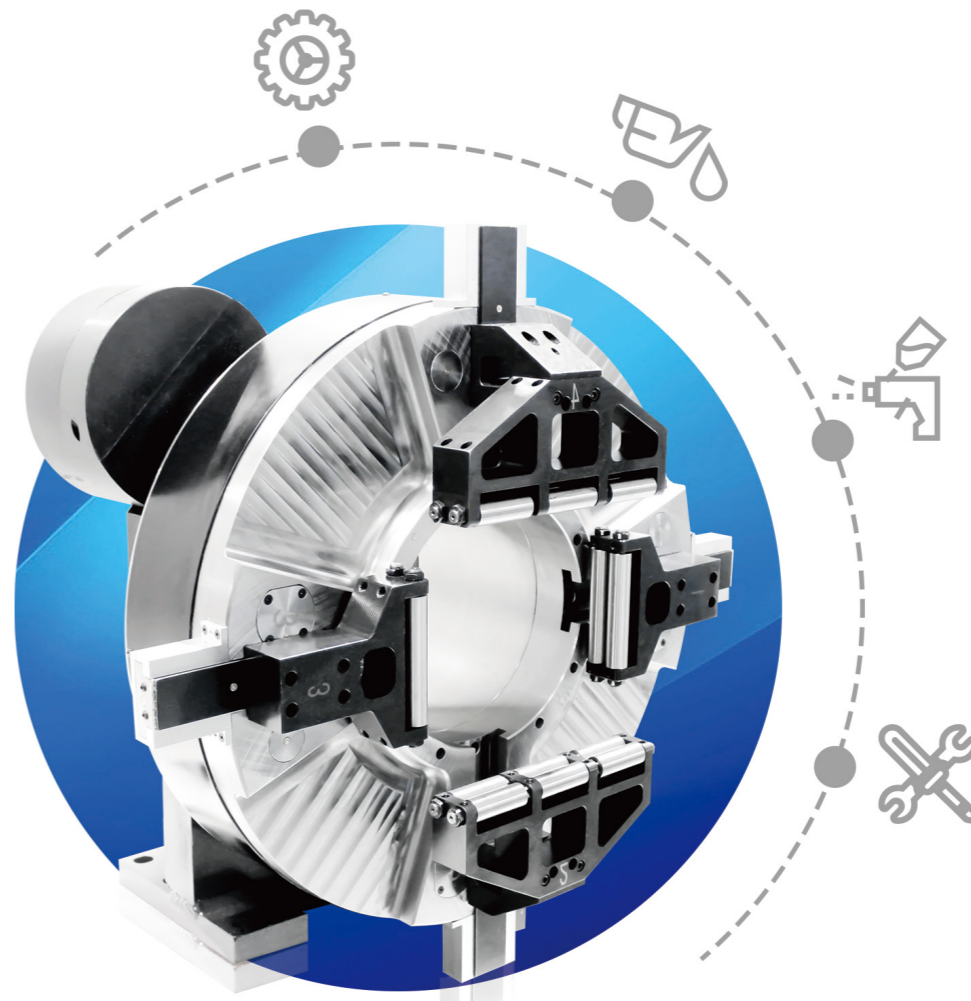




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激光卡盘保养手册

LASER CHUCK MAINTENANCE MANUAL

常州比优特机械科技有限公司
CHANGZHOU BEUT MECHANICAL TECHNOLOGY CO., LTD.

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前卡保养明细

卡盘保养图例	保养周期及说明	保养工具
  	<p>保养说明:</p> <p>1. 清洗滑块、导杆、滚轮等（先用毛刷对铁屑、灰尘进行初步清理，再用清洗剂局部重点清洗）</p> <p>2. 对加油嘴进行加油（32号机油）</p>	 <p>气 枪</p>  <p>清洗剂</p>
	<p>保养周期:</p> <p>每班一次</p>	 <p>油 枪</p>

卡盘大保养图例	保养周期及说明	保养工具
<p>● 全行程前卡</p>  <p>图 1</p>  <p>图 2</p>	<p>保养说明:</p> <p>1. 用内六角扳手将图1方框内三处螺丝拆掉，便可把风琴罩、滚轮架取下，取下前先做好标识，方便后续安装。</p> <p>2. 拆下后如图2所示，把4个动力楔块用毛刷、清洗剂清洗干净，务必注意不要把灰尘、铁屑等杂物吹进卡盘内部。</p> <p>3. 清洗完成后对滑动零部件及加油嘴进行加油润滑，请加注32号或更高级别的干净机油，不要使用脂类油，防止粘结杂物和低温冻结，造成事故。</p> <p>4. 按标识把拆下的零部件装配复原，并通气观察动作是否正常。</p>	 <p>内六角扳手</p>  <p>气 枪</p>  <p>清洗剂</p>
	<p>保养周期:</p> <p>每两个月一次</p>	 <p>油 枪</p>

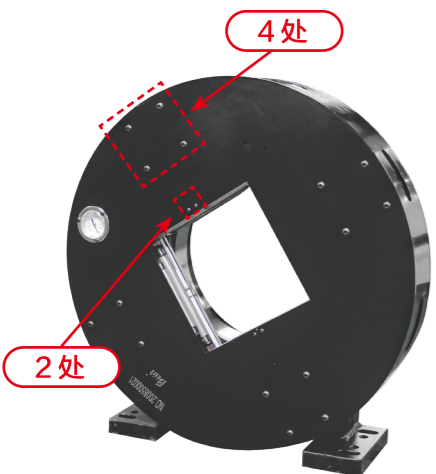

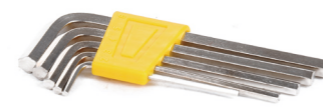
卡盘大保养图例	保养周期及说明	保养工具
<p>●管板一体机简易气动卡盘</p>  <p>图 3</p>  <p>图 4</p>	<p>保养说明:</p> <ol style="list-style-type: none"> 1. 用内六角扳手将图 3 所标识的螺丝拆掉, 便可把防尘罩取下, 取下前先做好标识, 方便后续安装。 2. 拆下后如图 4 所示, 把链轮、链条、滑块、导杆、滚轮等用气枪、清洗剂清洗干净。 3. 通气观察动作否正常。 4. 动作正常后按标识把防尘罩装好即可。 <p>保养周期:</p> <p>每月一次</p>	 <p>内六角扳手</p>  <p>气 枪</p>  <p>清洗剂</p>  <p>油 枪</p>

前卡保养明细		
卡盘保养图例	保养周期及说明	保养工具
 <p>图 5</p>  <p>图 6</p>	<p>保养说明:</p> <ol style="list-style-type: none"> 1. 清洗卡爪 (先用毛刷对铁屑、灰尘进行初步清理, 再用清洗剂局部重点清洗) 2. 对加油嘴进行加油 (32 号机油) <p>保养周期:</p> <p>每班一次</p>	 <p>内六角扳手</p>  <p>气 枪</p>  <p>清洗剂</p>
 <p>图 7</p>  <p>图 8</p>	<p>保养说明:</p> <ol style="list-style-type: none"> 1. 用内六角扳手把图 7 所示 4 处螺丝拆掉, 此时便可把 4 片防尘盖拆下 (拆下前先做好标识)。 2. 拆下后如图 8 所示, 用气枪、清洗剂把内部清洗干净。 3. 对活动部位及加油嘴进行加油 (32 号机油)。通气观察动作是否正常, 正常后把防尘盖按标识装好即可。 <p>保养周期:</p> <p>每两个月一次</p>	 <p>清洗剂</p>  <p>油 枪</p>

保养注意事项:

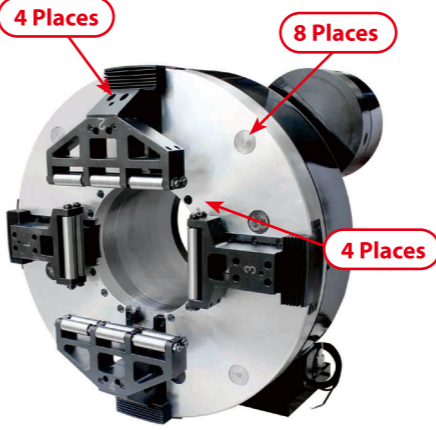
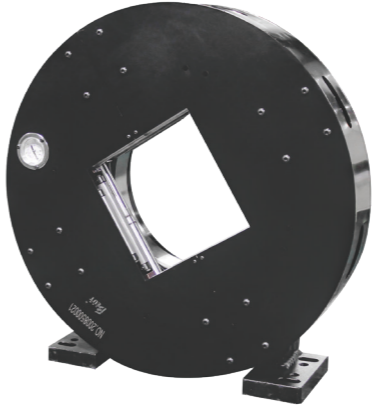




1. 保养前先停机，断电断气，禁止开动卡盘，防止造成安全事故。
2. 未注明加油点按照加油点处的提示进行加油保养。
3. 定期在三联件的油罐内加油，并控制滴油速度。

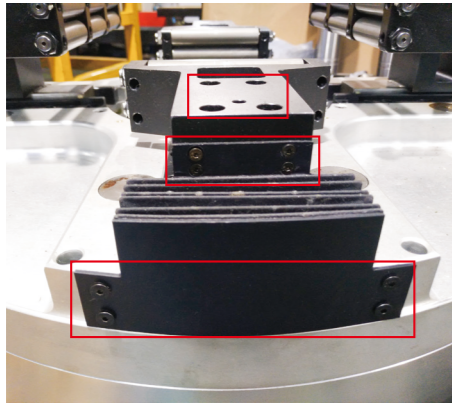
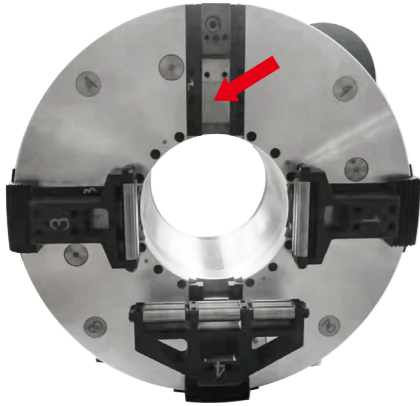




易损件更换说明


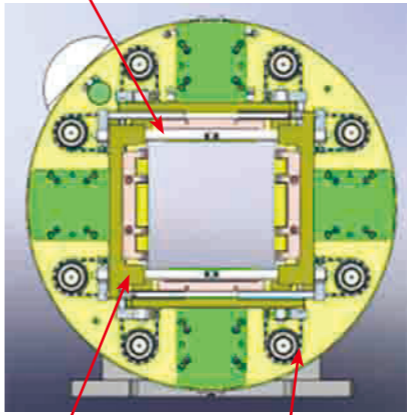




易损件更换图例	更换说明	更换工具
<p>●管板一体机简易气动卡盘滚轮架拆卸</p>  <p>图 9</p>  <p>图 10</p>	<ol style="list-style-type: none"> 1. 先通气把卡盘开到夹紧状态，按图 9 所示用内六角扳手把螺丝拆除，拆下防尘罩壳。 2. 按图 10 所示位置用内六角扳手把螺丝拆除即可把滚轮架拆下，共 4 个滚轮架按图示位置分别拆下。 	 <p>内六角扳手</p>

易损件更换图例	更换说明	更换工具
<p>●全行程前卡滚轮架拆卸</p>  <p>图 11</p>	<ol style="list-style-type: none"> 1. 按图 11 所示先把 A、B 处螺丝拆除，取下风琴罩。 2. 再用内六角扳手把 C 处的螺丝拆除，此时便可取下滚轮架（四个滚轮架均按此顺序取下）。 	 <p>内六角扳手</p>
<p>●滚轮更换</p>  <p>图 12</p>  <p>图 13</p>  <p>图 14</p>	<p>拆卸:</p> <ol style="list-style-type: none"> 1. 按图 12 所示先用内六角扳手把紧定螺丝松开。 2. 用卡簧钳把卡簧拆下。 3. 用铜棒从一侧轻轻的把滚轮轴敲下来，把偏心套也取下清洗干净备用。 <p>装配:</p> <ol style="list-style-type: none"> 1. 先把偏心套的最高点用白色做好标记。 2. 把装好轴承的滚轮放置在滚轮架的槽口内且与滚轮架轴孔同心的位置，此时把滚轮轴从一侧插入，用铜棒轻轻敲击滚轮轴，到滚轮轴一端超出滚轮架一侧。 3. 把偏心套装入滚轮架两侧，保证两侧偏心套的高点方向一致朝外侧。 4. 调整滚轮轴位置，把两端卡簧装好，把紧定螺钉轻微锁紧，不要锁紧，把滚轮架装在卡盘上调好精度后再锁紧。 	 <p>卡簧钳</p>  <p>铜棒</p>

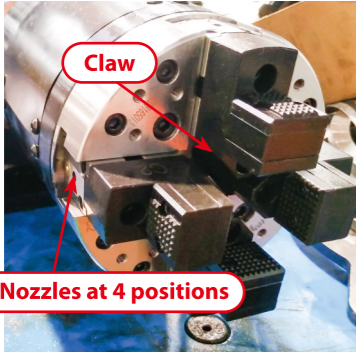


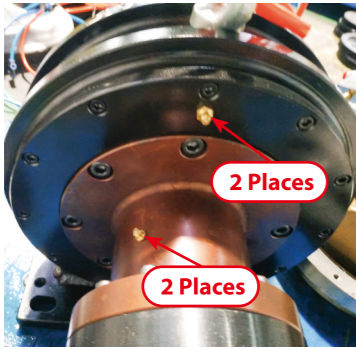



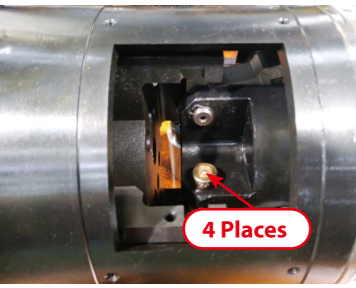
易损件更换图例	更换说明	更换工具
<p>●尾卡卡爪更换</p>  <p>图 15</p>  <p>图 16</p>	<p>1. 按图 15 所示用内六角扳手把两个螺丝拆除即可把卡爪拆下，共四个卡爪按相同的方法拆下。</p> <p>2. 换上准备好的另一付卡爪，注意键槽位置，把两个螺丝锁紧即可，卡爪精度可以通过动力楔块上的螺丝微调。。</p>	 <p>内六角扳手</p>


Front Chuck Maintenance Details		
LEGEND OF CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
  	<p>Maintenance Instruction:</p> <ol style="list-style-type: none"> 1. Clean the sliders, guide rods, rollers, etc. (use a brush to initially clean the iron filings and dust, and then use a cleaning agent to focus on local cleaning) 2. Fill the filler nozzle with oil (32# oil) <p>Maintenance Period: Once per shift</p>	 <p>Air Gun</p>  <p>Cleaning Agent</p>  <p>Oil Gun</p>

LEGEND OF MAJOR CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
<p>● Full Stroke Front Chuck</p>  <p>Figure 1</p>  <p>Figure 2</p>	<p>Maintenance Instruction:</p> <ol style="list-style-type: none"> 1. Use a wrench to remove the three screws in the box as Figure 1, and then the organ cover and the roller frame can be removed. Make a mark before removing it to facilitate subsequent installation. 2. After removal, as shown in Figure 2, clean the 4 power wedges with a brush and cleaning agent. Be careful not to blow dust, iron filings and other debris into the chuck. 3. After cleaning, lubricate the sliding parts and filler nozzles. Please add clean engine oil of No. 32 or higher. Do not use grease oil to prevent adhesion of debris and low temperature freezing, which may cause accident. 4. Assemble and restore the dismantled parts according to the mark, and ventilate to observe whether the action is normal. 	 <p>Inner Hexagon Wrench</p>  <p>Air Gun</p>  <p>Cleaning Agent</p>  <p>Oil Gun</p>
<p>Maintenance Period: Once two months</p>		

LEGEND OF MAJOR CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
<p>● Simple Pneumatic Chuck Of Tube-Sheet Integrated Machine</p>  <p>Figure 3</p>  <p>Figure 4</p>	<p>Maintenance Instruction:</p> <ol style="list-style-type: none"> 1. Use an wrench to remove the screws marked in Figure 3, and then the dust cover can be removed. Make a mark before removing it to facilitate subsequent installation. 2. After removal, as shown in Figure 4, clean the sprocket, chain, slider, guide rod, roller, etc. with air gun and cleaning agent. 3. Ventilation to observe whether the action is normal. 4. After the action is normal, install the dust cover according to the logo. 	 <p>Inner Hexagon Wrench</p>  <p>Air Gun</p>  <p>Cleaning Agent</p>  <p>Oil Gun</p>
<p>Maintenance Period: Once a month</p>		

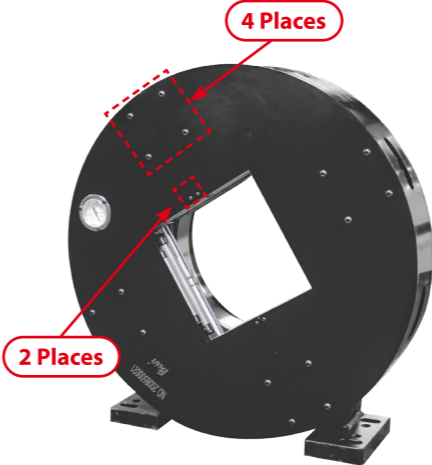


Tail Chuck Maintenance Details

LEGEND OF CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
 <p>Figure 5</p>	<p>Maintenance Instruction:</p> <ol style="list-style-type: none"> Clean the jaws (first use a brush to initially clean the iron filings and dust, and then use a cleaning agent to focus on local cleaning). Fill the filler nozzle with oil (32# oil) 	 <p>Inner Hexagon Wrench</p>  <p>Air Gun</p>
 <p>Figure 6</p>		
 <p>Figure 7</p>	<p>Maintenance Instruction:</p> <ol style="list-style-type: none"> Use an wrench to remove the 4 screws shown in Figure 7. At this time, the 4 pieces of dust cover can be removed (make a mark before removing) After dismantling, as shown in Figure 8, use an air gun and cleaning agent to clean the interior. Refuel the movable parts and the filler nozzle (No. 32 engine oil). Check the ventilation to see if the action is normal. After it is normal, install the dust cover according to the mark. 	 <p>Cleaning Agent</p>  <p>Oil Gun</p>
 <p>Figure 8</p>		
	<p>Maintenance Period: Once per shift</p>	
	<p>Maintenance Period: Once two months</p>	

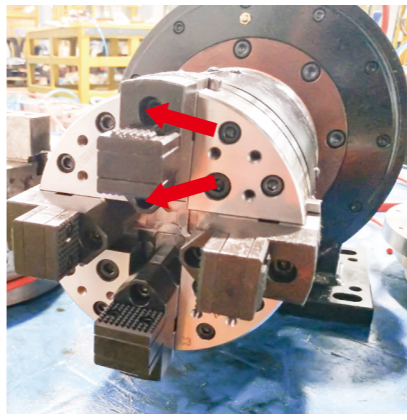
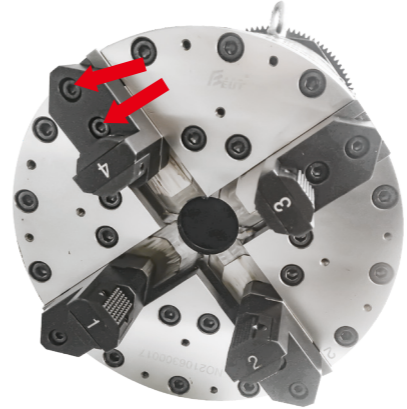

 **Maintenance Precautions:**

- Stop the machine before maintenance, cut off the power and the gas. Do not start the chuck to prevent safety accidents.
- Oil filling maintenance shall be carried out for non-filling points the according to the tips at the oil filling points.
- Regularly add the oil in the oil tank of the triple unit, and control the oil dropping speed.

Replacement Instructions For Wearing Parts

REPLACEMENT LEGEND OF WEARING PARTS	REPLACEMENT INSTRUCTIONS	REPLACEMENT TOOLS
<p>● Removal Of Simple Pneumatic Chuck Roller Rack Of Tube-Sheet Integrated Machine</p>  <p>Figure 9</p>  <p>Figure 10</p>	<ol style="list-style-type: none"> Turn the chuck to the clamped state by ventilating first, remove the screw with a wrench as shown in Figure 9, and remove the dust cover. Remove the screw with a wrench according to the position shown in Figure 10 to remove the roller frame. A total of 4 roller frames are removed according to the positions shown in the figure. 	 <p>Inner Hexagon Wrench</p>

LEGEND OF MAJOR CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
<p>●Removal Of Full Stroke Front Chuck Roller Rack</p>  <p>Figure 11</p>	<ol style="list-style-type: none"> As shown in Figure 11, first remove the screws at A and B, and take off the organ cover. Use the Allen wrench to remove the screw at C, and then the roller frame can be removed (the four roller frames are removed in this order). 	
<p>●Roller Replacement</p>  <p>Figure 12</p>  <p>Figure 13</p>  <p>Figure 14</p>	<p>Disassembly</p> <ol style="list-style-type: none"> As shown in Figure 12, first loosen the set screw with an Allen wrench. Use circlip pliers to remove the circlip. Gently knock down the roller shaft from one side with a copper rod, and also remove the eccentric sleeve and clean it for later use. <p>Assembly</p> <ol style="list-style-type: none"> First mark the highest point of the eccentric sleeve with white. Place the roller with the bearing installed in the slot of the roller frame and concentric with the shaft hole of the roller frame. At this time, insert the roller shaft from one side, and tap the roller shaft lightly with a copper rod until one end of the roller shaft exceeds the shaft. Roller frame side. Put the eccentric sleeves on both sides of the roller frame to ensure that the high points of the eccentric sleeves on both sides are in the same direction towards the outside. Adjust the position of the roller shaft, install the circlips at both ends, slightly lock the set screws, do not lock, install the roller frame on the chuck and adjust the accuracy before locking. 	 <p>Circlip Plier</p>  <p>Copper Rod</p>

LEGEND OF MAJOR CHUCK MAINTENANCE	MAINTENANCE PERIOD AND INSTRUCTIONS	MAINTENANCE TOOLS
<p>●Tail Chuck Claw Replacement</p>  <p>Figure 15</p>  <p>Figure 16</p>	<ol style="list-style-type: none"> As shown in Figure 15, use the wrench to remove the two screws to remove the jaws, and remove the four jaws in the same way. Replace the other set of jaws prepared, pay attention to the position of the keyway, and tighten the two screws. The precision of the jaws can be adjusted slightly by the screws on the power wedge. 	 <p>Inner Hexagon Wrench</p>