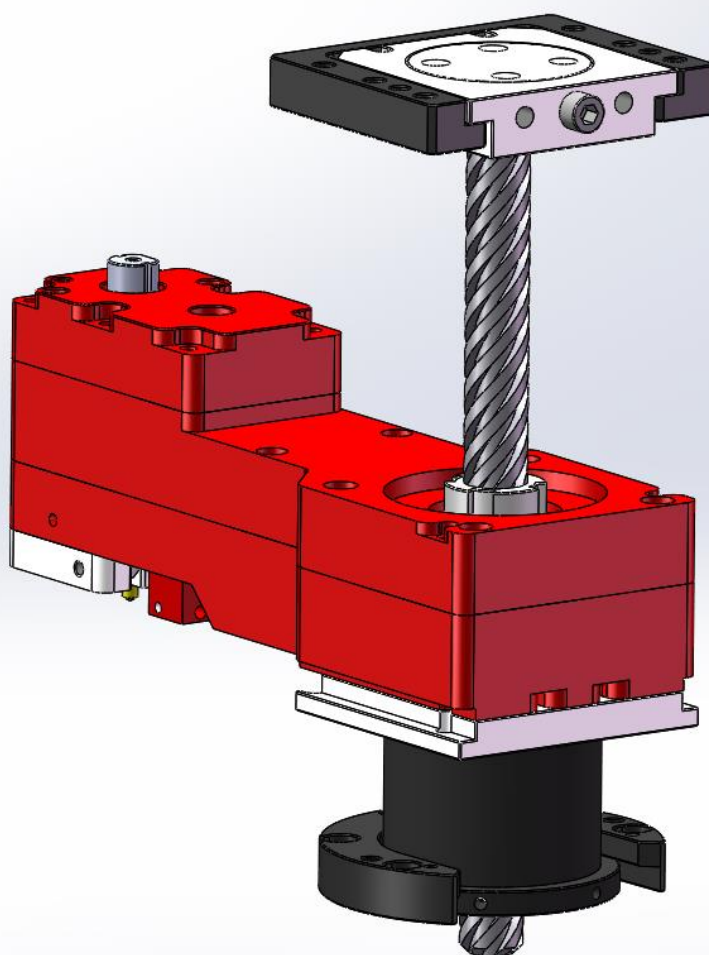




卓迪克模内攻牙
模内攻牙创新者

模内攻牙安装步骤说明书

Instructions for installation of tapping in die





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一. 模内攻牙机准备

One. Die inside tapping machine preparation

1. 确认产品螺纹规格：

Confirm the product thread specification:

丝锥规格	螺距	柄径	总长	螺纹方向	
Tap the specification	pitch	Handle the	Chief,	Thread direction	

2. 确认安装方式：

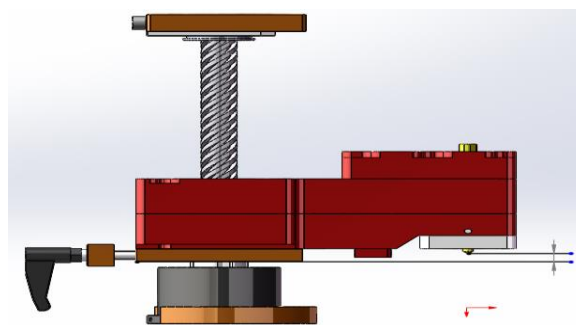
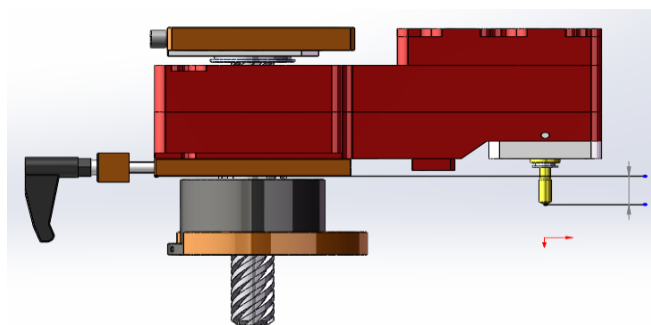
Confirm the installation method:

根据安装方式，确认驱动螺杆方向，左右旋正确与否。

According to the installation method, confirm whether the driving screw direction, right and left rotation is correct or not.

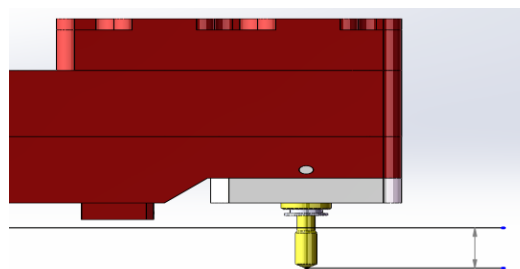
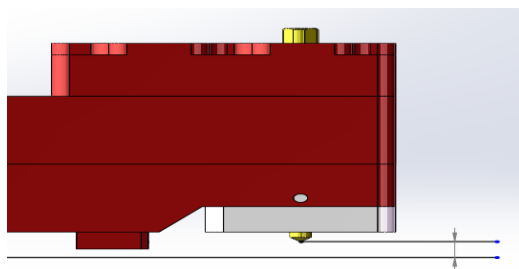
将螺杆螺母放入攻牙机箱体，根据安装方式组装方法装配，螺杆不转向压下时，丝锥出来为正确。

Put the screw nut into the tapping machine box and assemble it according to the installation method. When the screw is not turned down, the tap is correct.



3. 安装丝锥，确认攻牙可用行程是否充足

Install taps to confirm that the tapping stroke is sufficient





二. 冲床参数确认及送料方式

Punch machine parameter confirmation and feeding method

1. 确认攻牙机行程是否与冲床行程匹配

Confirm whether the stroke of the tapping machine matches the stroke of the punching machine



攻牙机行程是否与冲床行程匹配
Tapping machine stroke and punch stroke matching

技术参数	代号R	单位Unit	JW36-110
滑块公称力	Pe	KN	110
公称力行程	Sp	mm	5
滑块行程长度	s	mm	180
滑块行程次数	n	spm	35-65
最大封闭高度	H2	mm	400
装模高度 调节量	t	mm	90
立柱间距离	G	mm	1770
工作台尺寸 (前后X左右)	DxC	mm	680x1770
工作厚度	H3	mm	155
侧面开口尺寸 (前后X高度)	ExF	mm	700x350
滑块底面尺寸 (前后X左右)	bxa	mm	580x1400
工作台离地面 距离	H1	mm	900
外形尺寸 (前后X左右X高)	AxBxH	mm	2050x2670 x3100
主电机功率	KW		11
压机总重	kg		19000
压机气压			

注:

每台攻牙机根据冲床行程、送料方式、螺纹规格及要求,非标定制产品,专机专用。(行程不匹配不可使用)

Note:

Each tapping machine according to the punch stroke, feeding mode, thread specifications and requirements, non-standard customized products, special machine.(trip mismatch not available)

2. 确认送料方式是否匹配

Confirm that the feeding mode matches

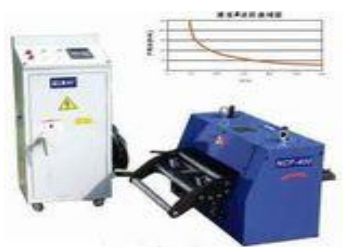
1. 拉杆滚轮送料机（送料角度 270~90）

Drawing rod roller feeder (feeding Angle 270-90)



2. NC 送料机（送料角度 330~30）

NC feeder (feeding Angle 330-30)



1. 滚轮送料机参数设置

送料角度：270~90

气缸定位角度：90~260

气缸误送检测角度：90~95

攻牙角度：95~265

1. Parameter setting of roller feeder

Feeding Angle: 270~90

Cylinder positioning Angle: 90~260

Cylinder error detection Angle: 90~95

Angle of attack: 95~265

2. NC 送料机参数设置

送料角度：330~30

气缸定位角度：40~280

气缸误送检测角度：50~55

攻牙角度：60~300

2. NC feeder parameter setting

Feeding Angle: 330~30

Cylinder positioning Angle: 40~280

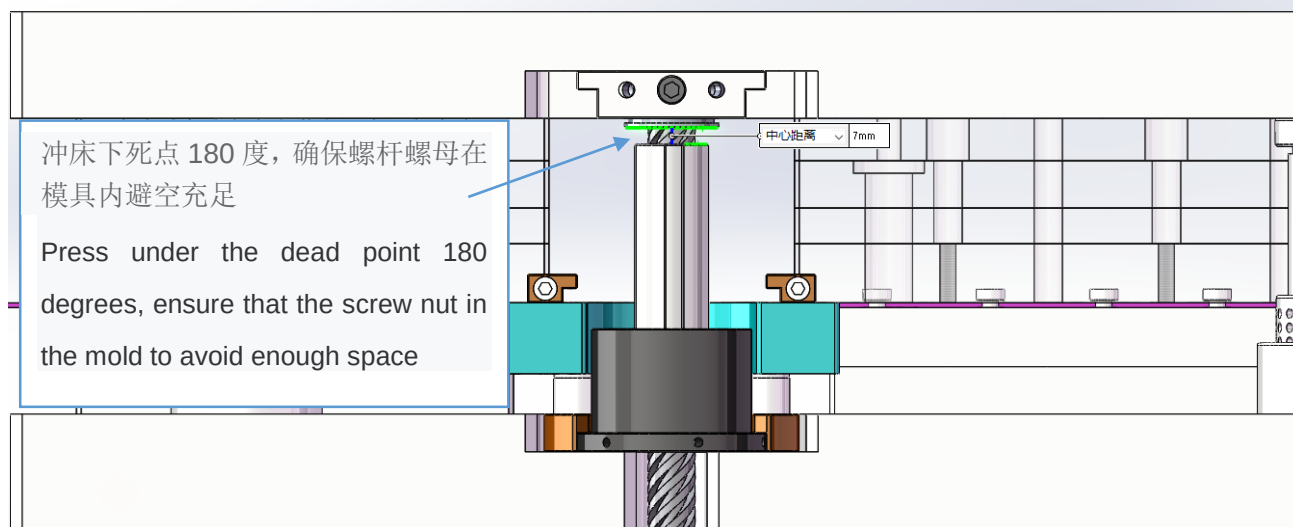
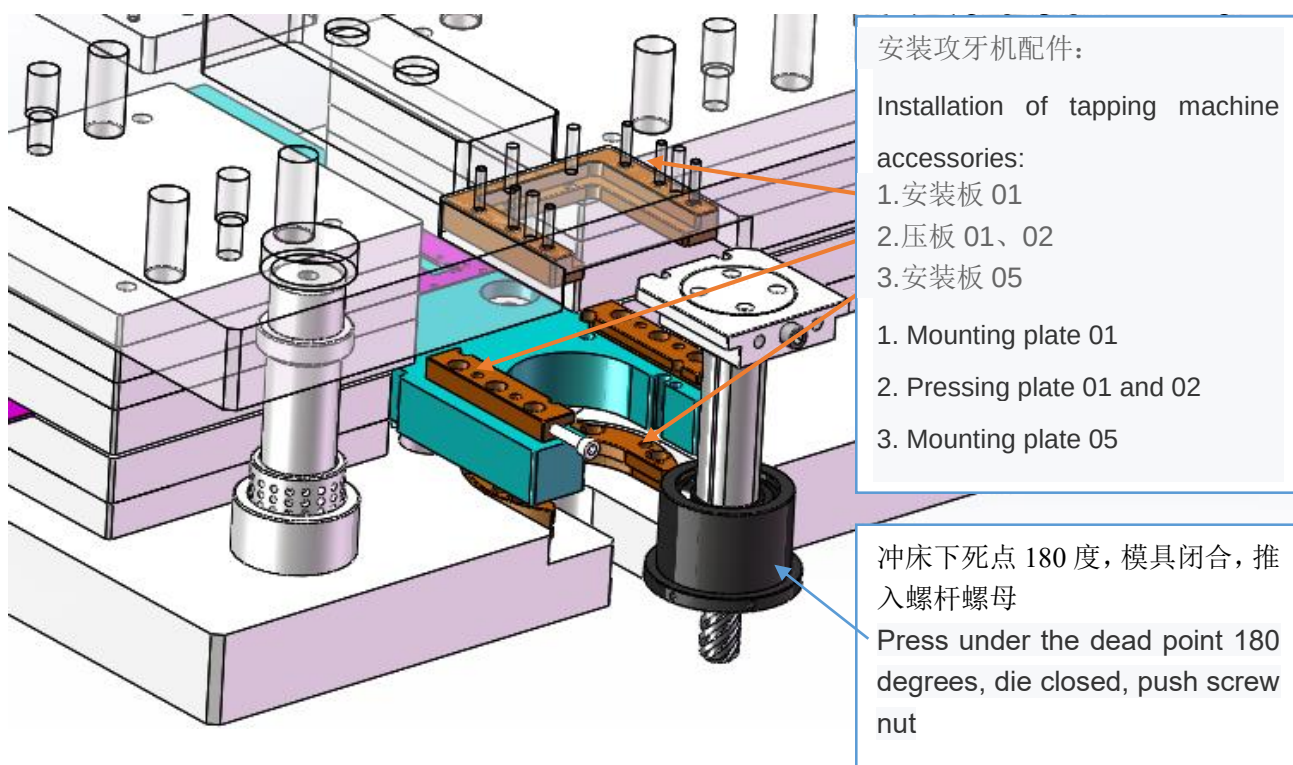
Cylinder error detection Angle: 50~55

Angle of attack: 60~300



三. 安装攻牙机配件并确认螺杆螺母避位

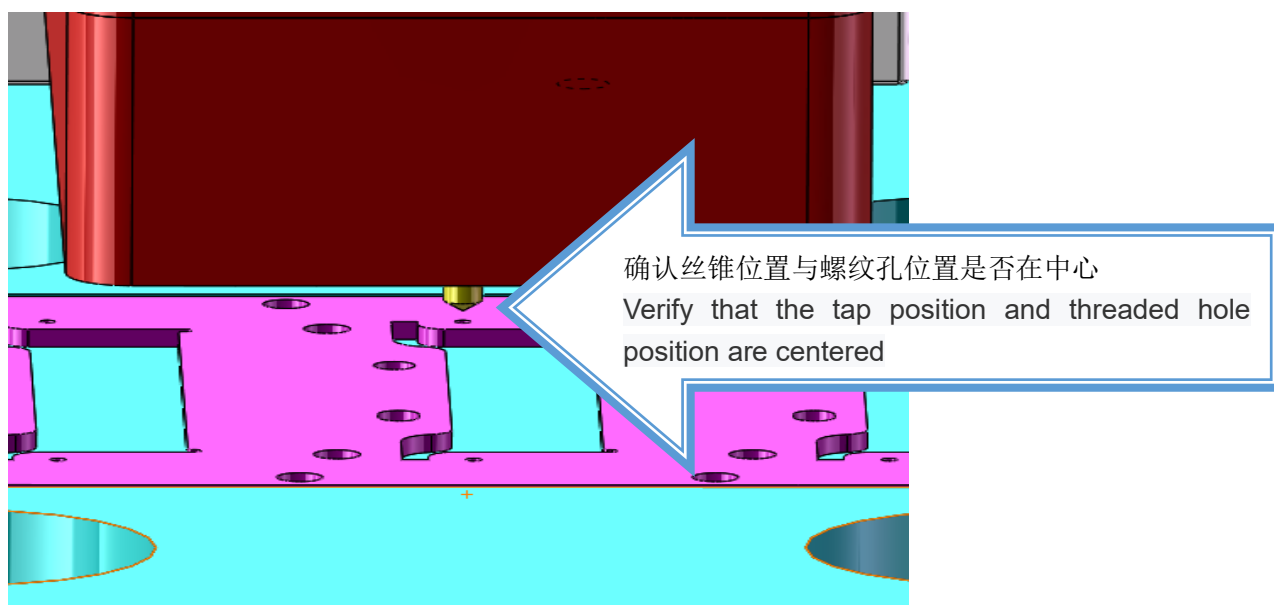
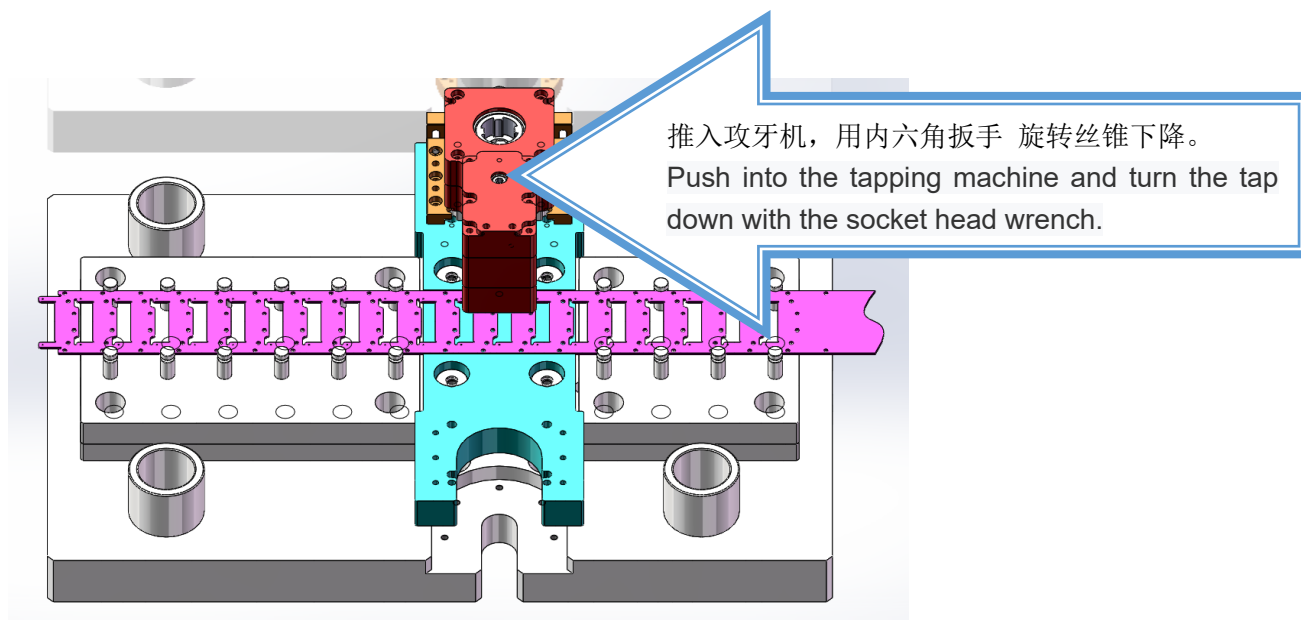
Install the tapping machine accessories and confirm the position of the screw nut





四. 确认螺丝孔与丝锥位置

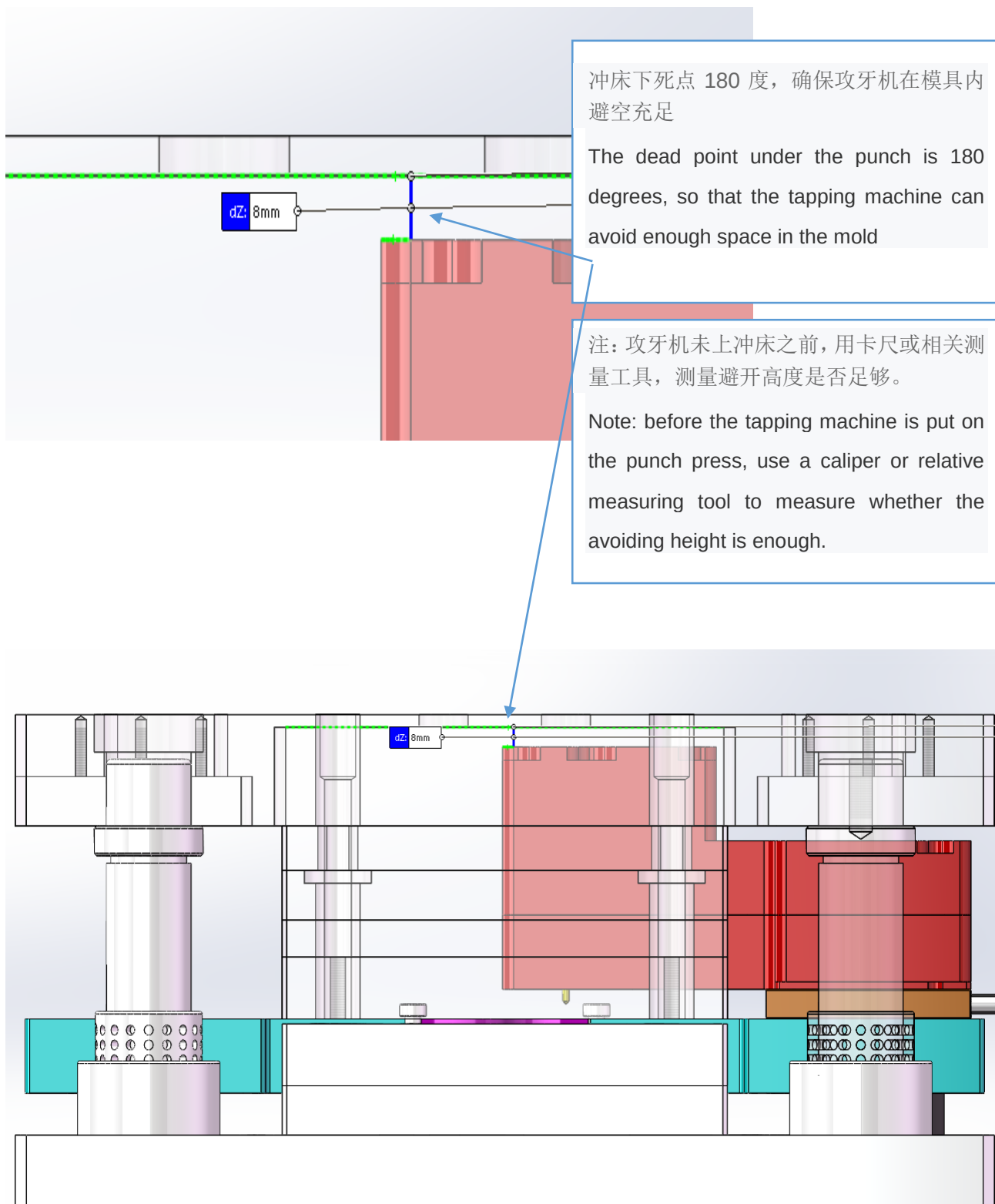
Confirm screw hole and tap position





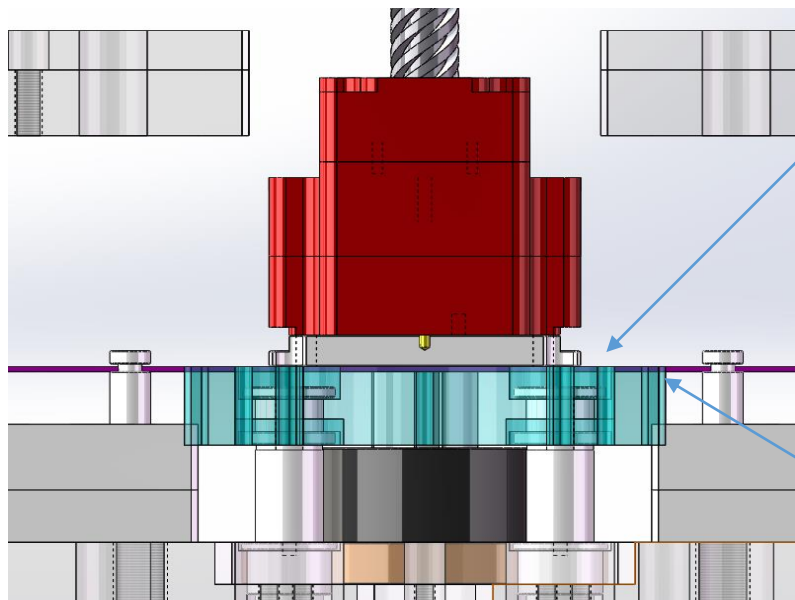
五. 确认攻牙机在模具内空间

Make sure the tapping machine is in the mold space



六. 确认料带状况及攻牙机安装顺畅

Confirm the condition of the material belt and the smooth installation of the tapping machine

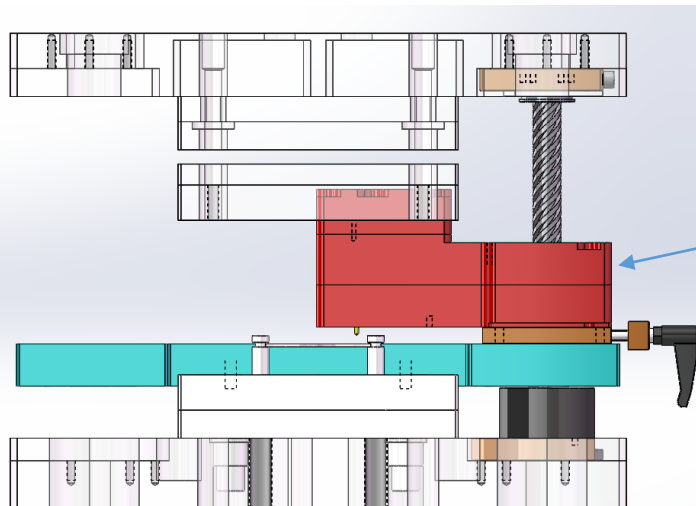


注：料带反面贴平浮升板正面送料，浮升板有料槽的贴平料槽送料。

Note: the material belt is pasted on the back side and the material is fed on the front side.

确认料带与浮升板间隙，越小越好，如果超过 1mm 一定要处理

Confirm the gap between material belt and floating plate, the smaller the better, if more than 1mm must be handled

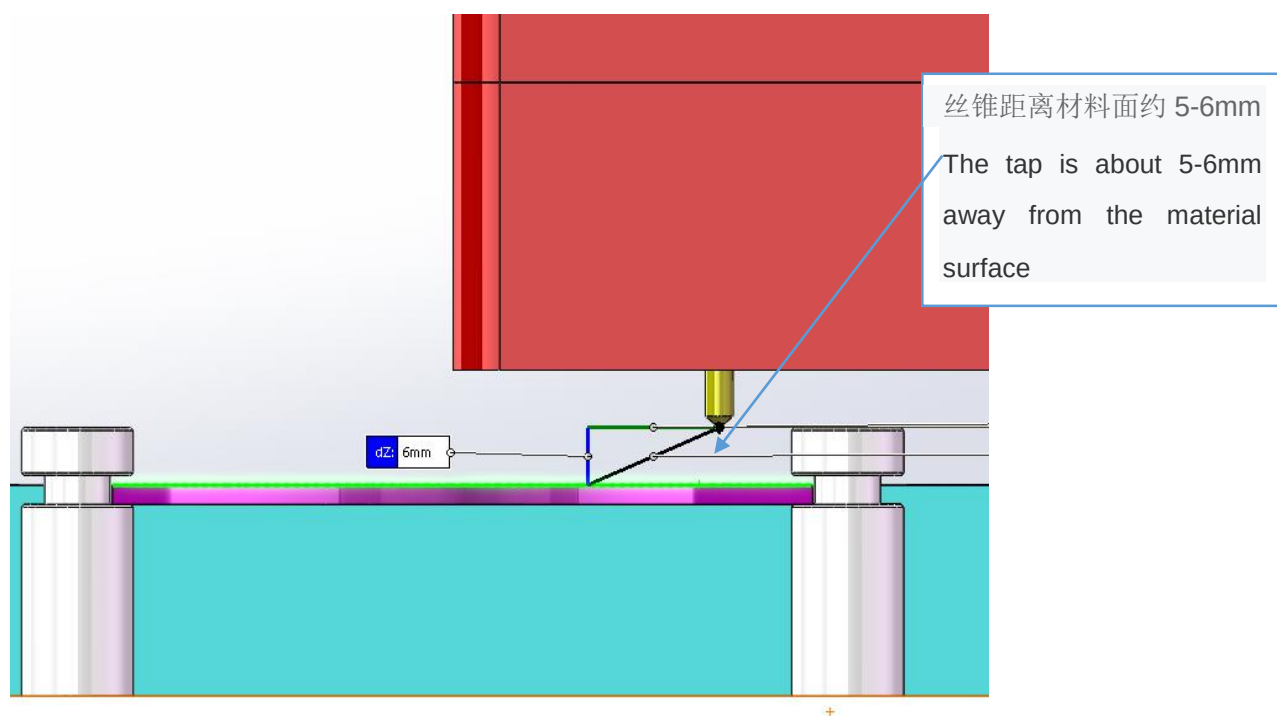
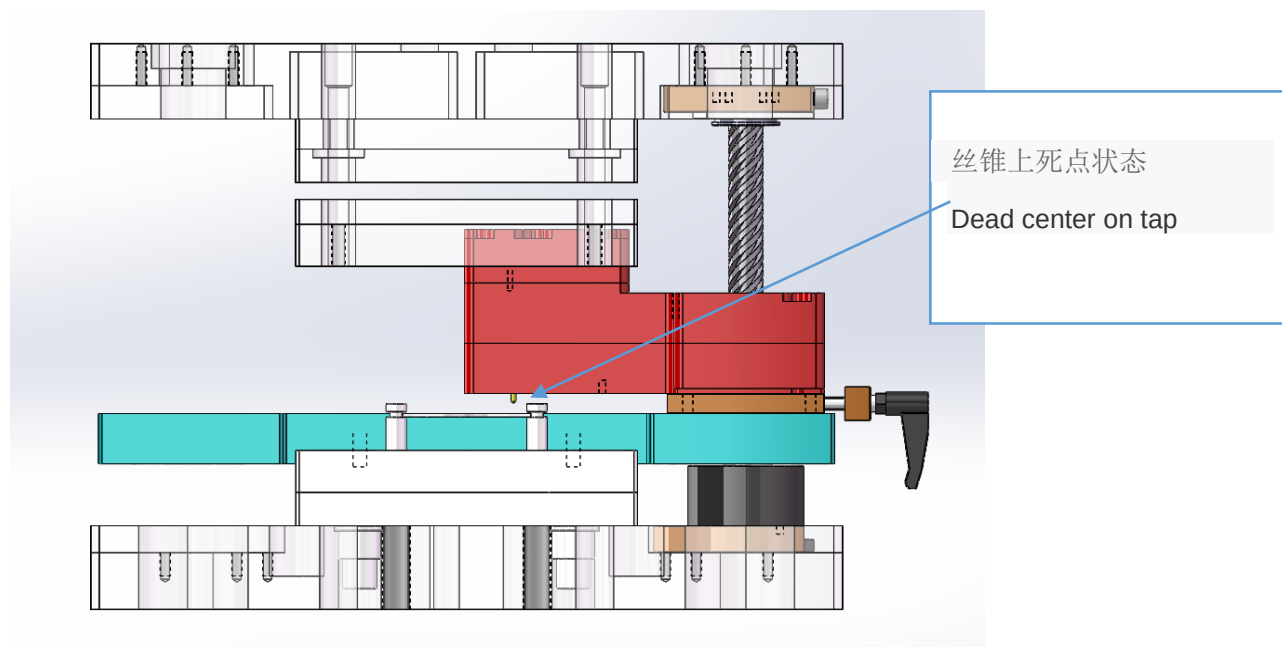


安装攻牙机 推入模具确认顺畅

Install tapping machine to push into mold to ensure smooth

七. 攻牙机上死点状态（冲床 0 度位置）

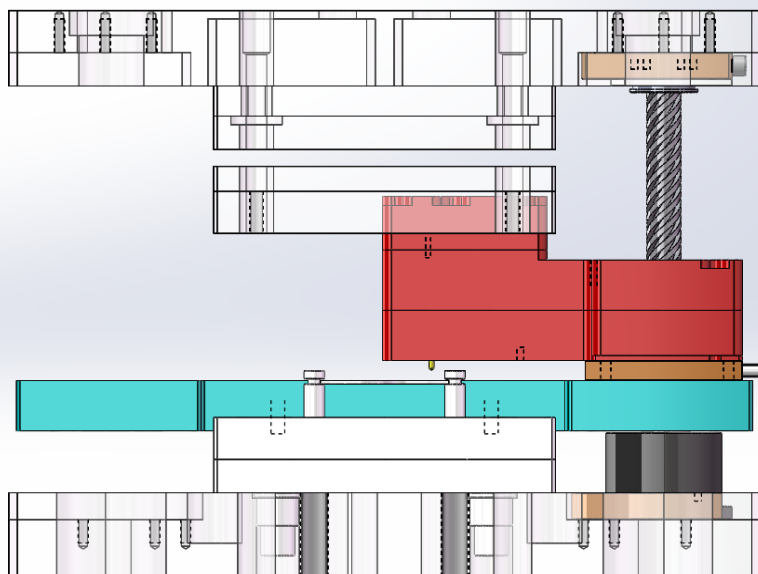
Dead point state of tapping machine (0 degree position of punching machine)





八. 调试寸动生产丝锥位置状况

Adjust position of inching production tap



安装攻牙机时冲床停在 0 度

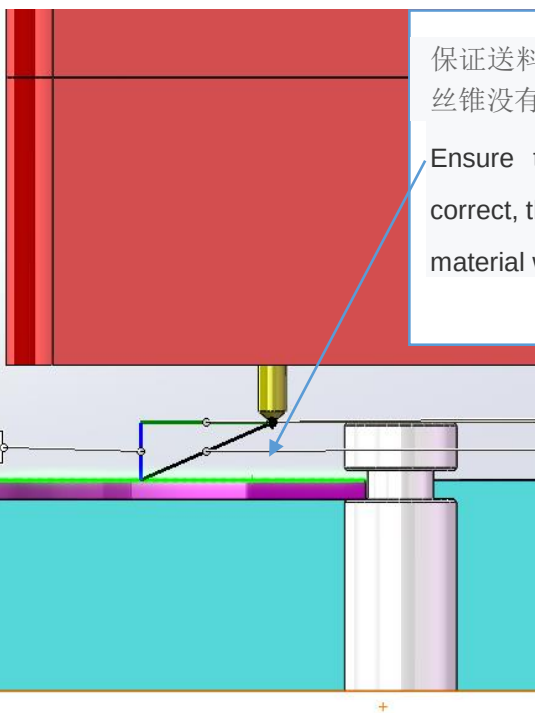
When the tapping machine is installed, the punch is stopped at 0 degrees

攻牙机旋转至上死点回转 2 圈

Tapping machine rotation top dead - point rotation 2

丝锥距离材料面约 5-6mm

The tap is about 5-6mm away from the material surface

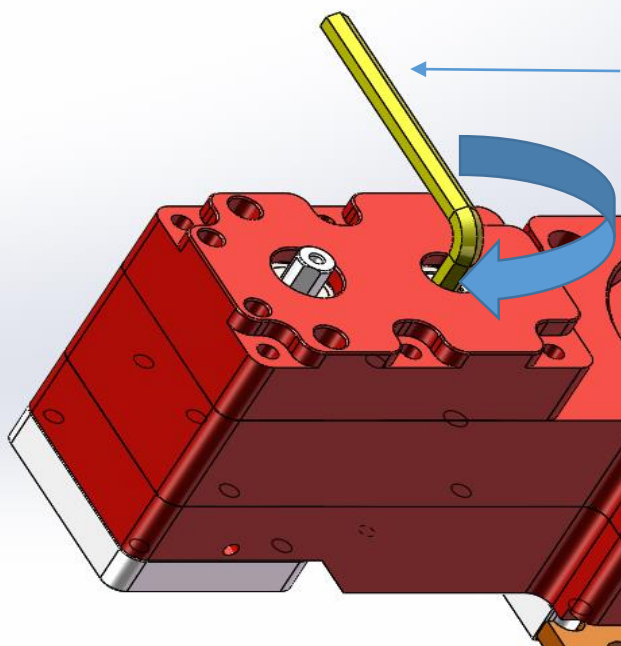


保证送料角度正确，开始送料时丝锥没有进入材料中。

Ensure that the feed Angle is correct, the tap does not enter the material when starting the feed.

九. 攻牙深度调节及丝锥更换

Tapping depth adjustment and tap replacement



上死点回转扳手可以调整丝锥高度

Upper dead center swivel spanner can adjust tap height

注: Note:

根据实际情况调整丝锥高度。

Adjust tap height according to actual situation.

(如: 上死点回转 2 圈, 产品螺纹未攻穿, 可以适当加深 1 圈。

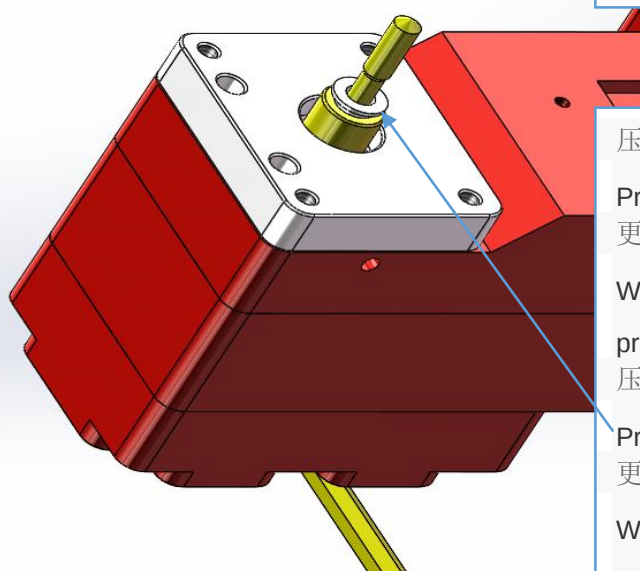
(such as: the top dead point rotation 2, the product thread is not penetrated, can be properly deepened 1 turn.

回转圈数越多攻牙深度越深。

The more the number of turns, the deeper the depth of attack.

回转圈数不能超过攻牙机极限, 即不能超过攻牙机下死点)

The number of revolutions shall not exceed the limit of the tapping machine, that is, the dead point under the tapping machine shall not be exceeded.



压下弹片, 拔出丝锥

Press down the shrapnel and pull out the tap
更换新丝锥时, 对好丝锥夹头内四方并压到

When replacing a new tap, square the tap chuck and press into it

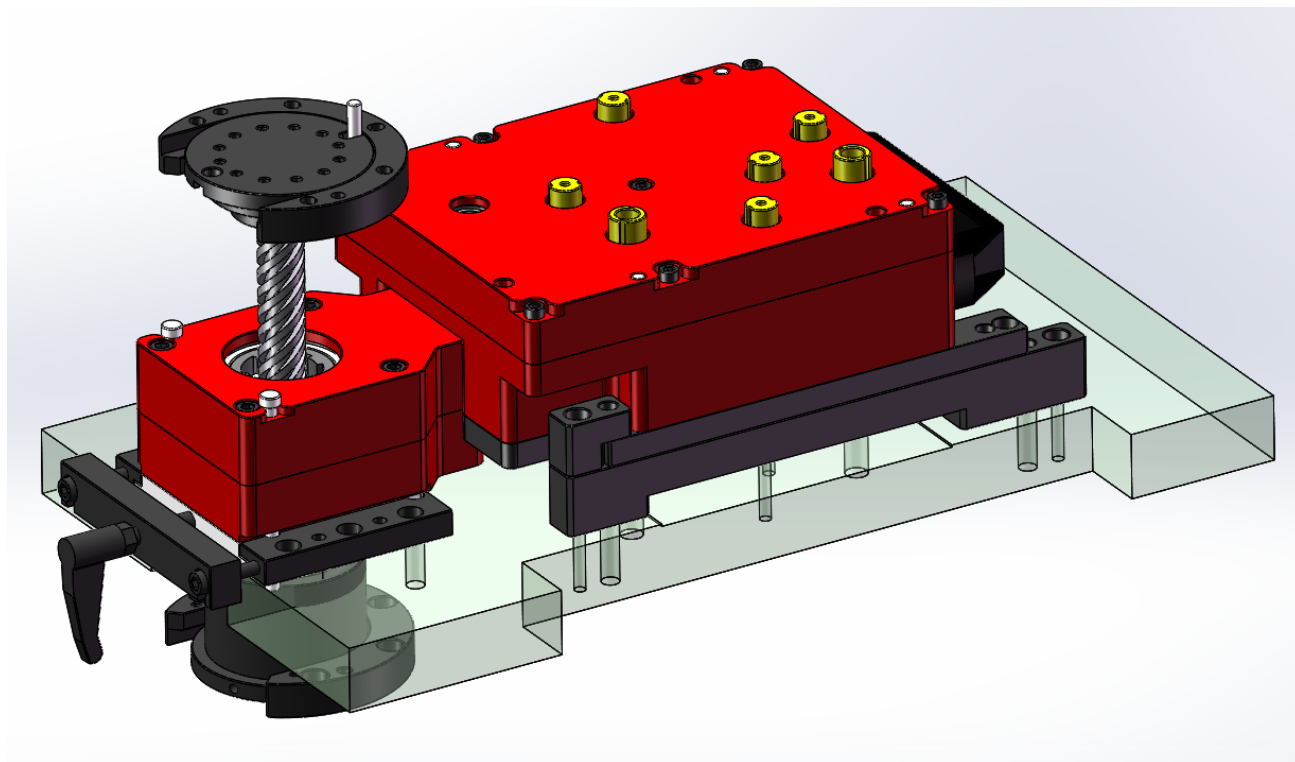
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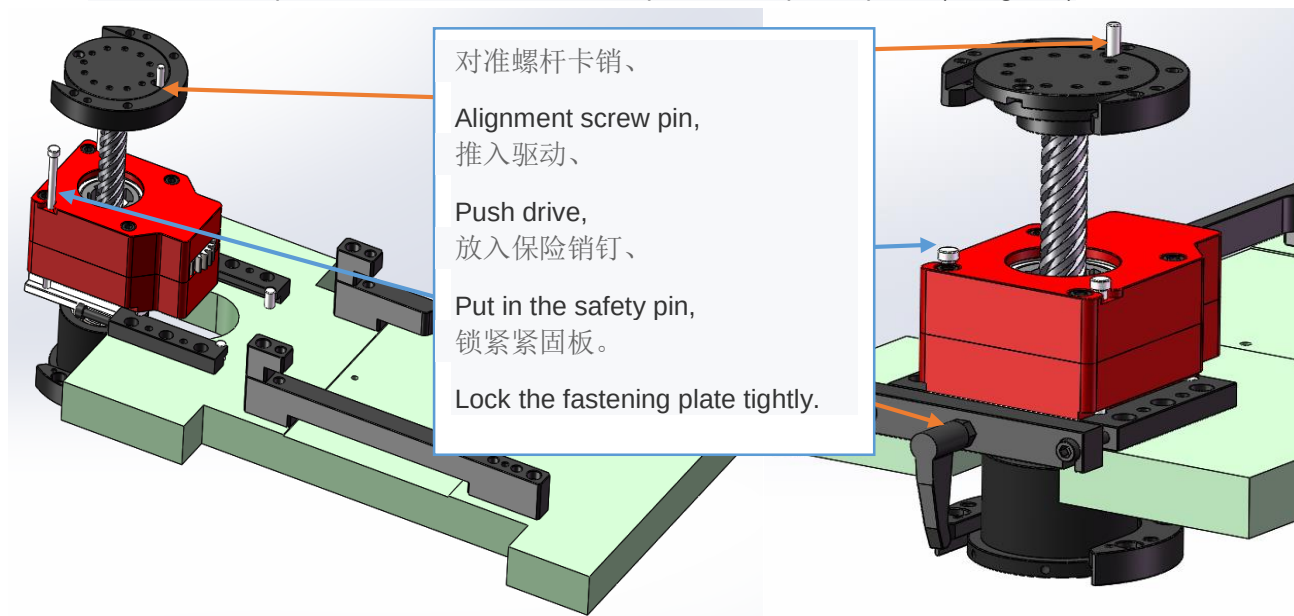
十. 分体机安装步骤

Steps for splitter installation



1. 安装驱动部分，冲床停上死点拆装（0度）

Install the drive part and disassemble the dead point of the punch press (0 degrees)



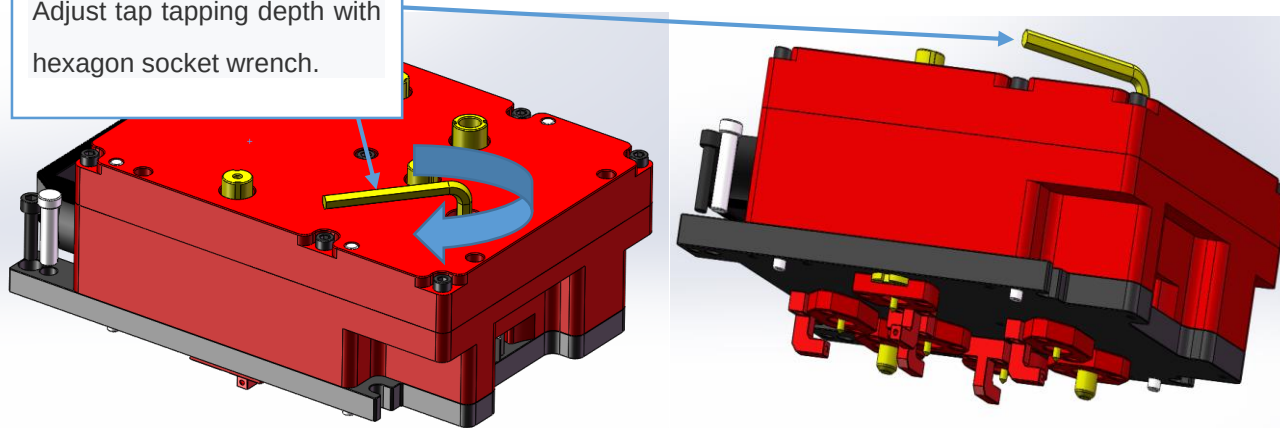


2. 安装攻牙头部分，冲床停上死点拆装（0度）

Install the tapping head part and disassemble the dead point on the punch press (0 degree)

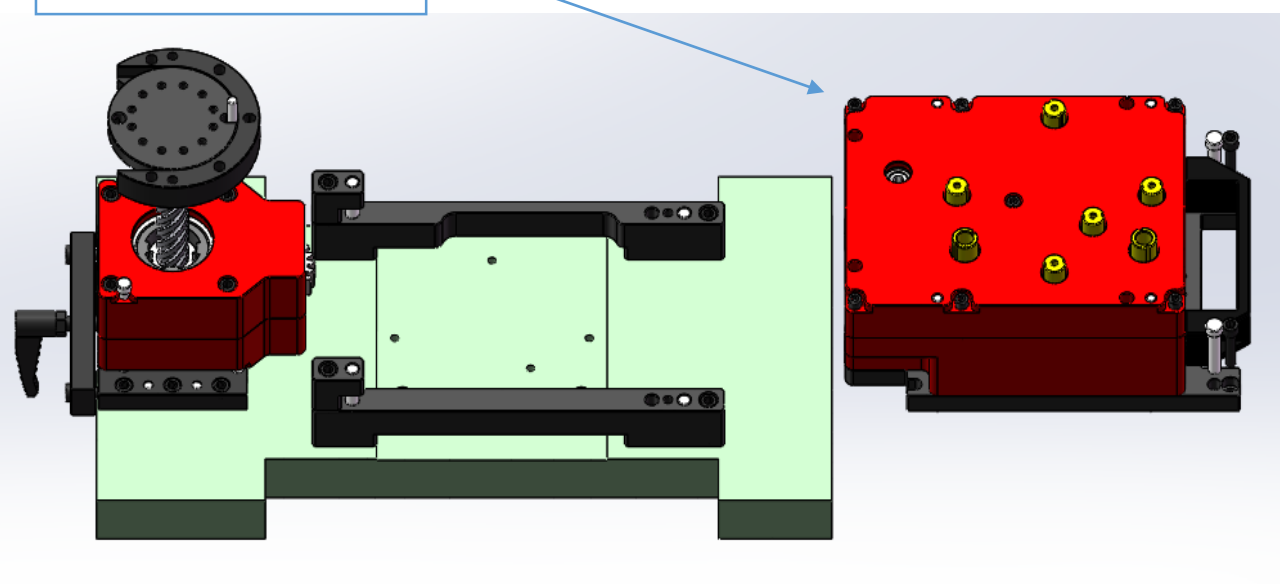
用内六角扳手调节丝锥攻牙
深浅。

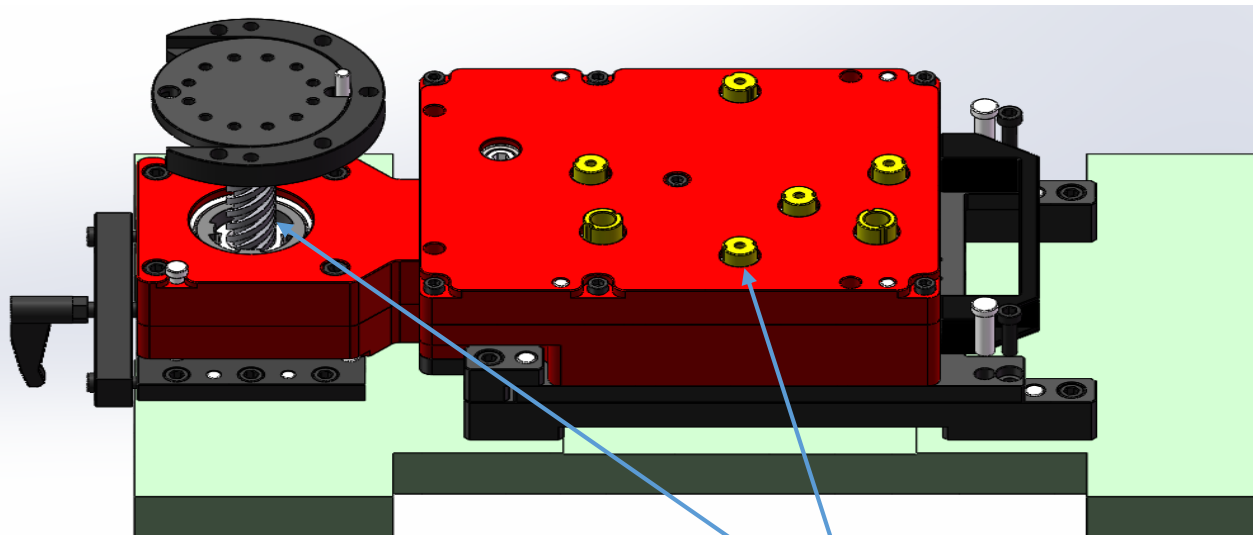
Adjust tap tapping depth with
hexagon socket wrench.



推入攻牙头

Push into the tapping head





放入销钉、螺丝锁紧

Put in the pin and screw to
lock tightly

使用前加油：

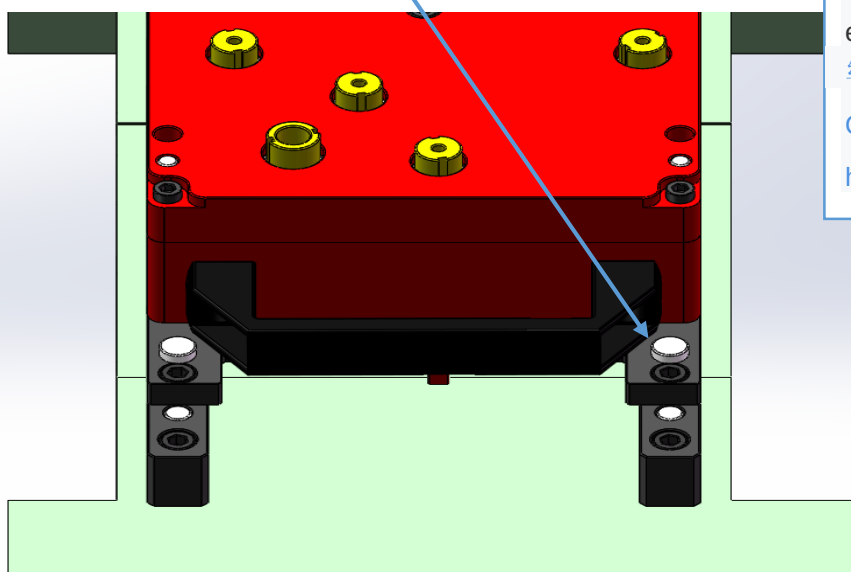
Refueling before use:

螺杆每 4 小时加一次高温黄油。

Heat the screw with butter
every 4 hours.

丝锥轴每 2 小时加一次机油。

Oil the tap shaft every 2
hours.



十一. 保养及注意事项

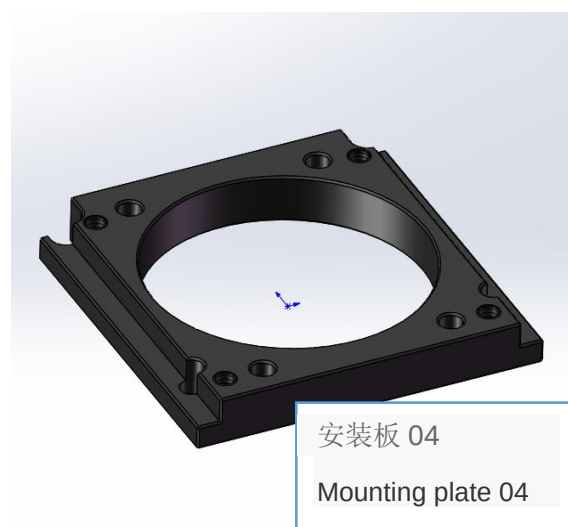
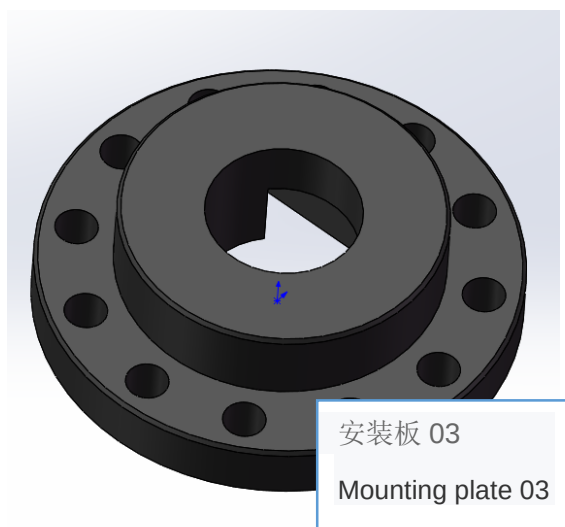
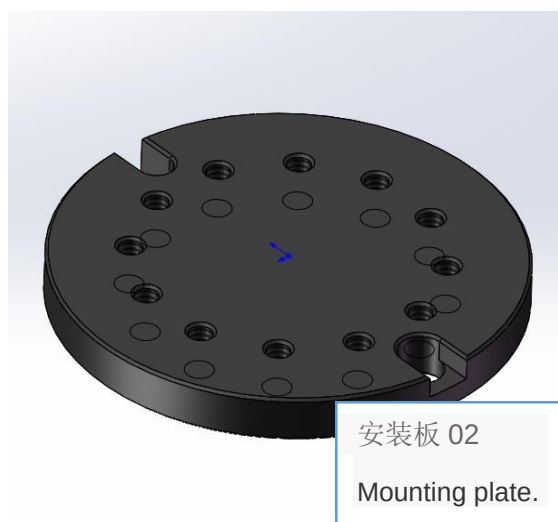
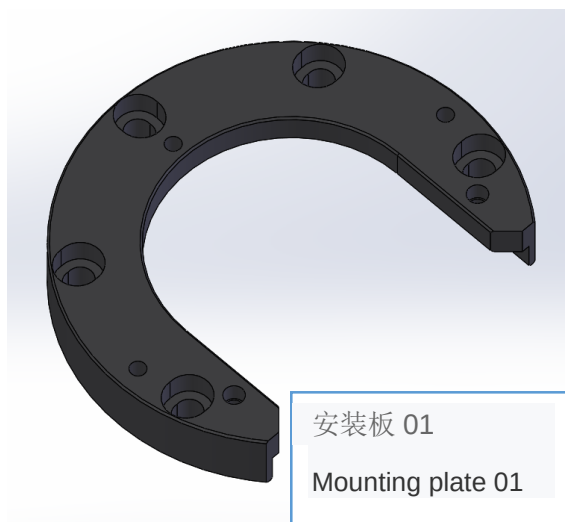
Maintenance and precautions

- 1. 螺杆每 4 小时至少加黄油一次，丝锥轴每 2 小时加机油一次。
1. Add butter to the screw at least once every 4 hours and oil to the tap shaft every 2 hours.
- 2. 生产完成后，攻牙机外形及螺杆清洁放入攻牙机盒子内。
2. After the production is completed, the appearance of the tapping machine and the screw are cleaned and put into the box of the tapping machine.
- 3. 攻牙机连续生产半年至一年寄回厂家检查保养一次（根据实际生产量情况~500 万）。
3. Send the tapping machine back to the factory for inspection and maintenance once a year (according to the actual production volume ~5 million).
- 注意事项：
Notes:
 - 1. 攻牙机拆装时，冲床停在上死点（0 度）。
1. When the tapping machine is disassembled and installed, the punch press stops at the dead point (0 degrees).
 - 2. 送料顺畅、冲床行程、送料角度、气缸定位及检测角度确认 ok，再安装攻牙机。
2. Ensure smooth feeding, press stroke, feeding Angle, cylinder positioning and inspection Angle, and then install tapping machine.
 - 3. 调模高时，需要先拆下攻牙机或驱动部分。
3. When adjusting the mold height, it is necessary to remove the tapping machine or drive part.
 - 4. 操作人员必须经过培训或交接的。
4. Operators must undergo training or handover.
 - 5. 如模具震动较大，攻牙机安装板螺丝定期检查有无松动。
5. If the mold vibration is large, the screw of the tapping machine installation plate should be checked regularly for looseness.



十二. 攻牙机标准配件及专业术语

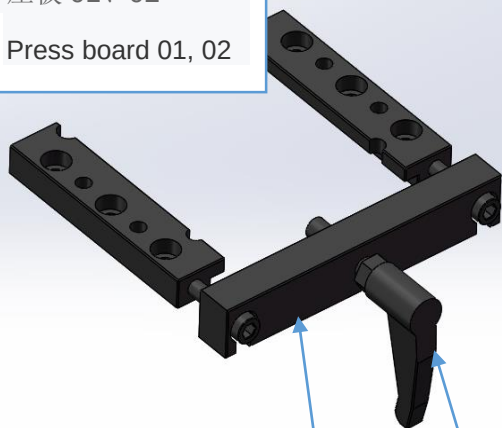
Tapping machine standard accessories and technical terms





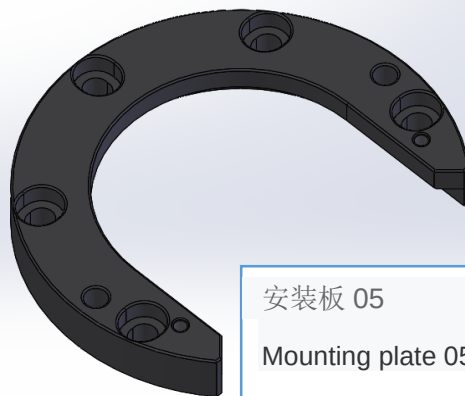
压板 01、02

Press board 01, 02



紧固板、紧固螺丝

Fastening plate and



安装板 05

Mounting plate 05



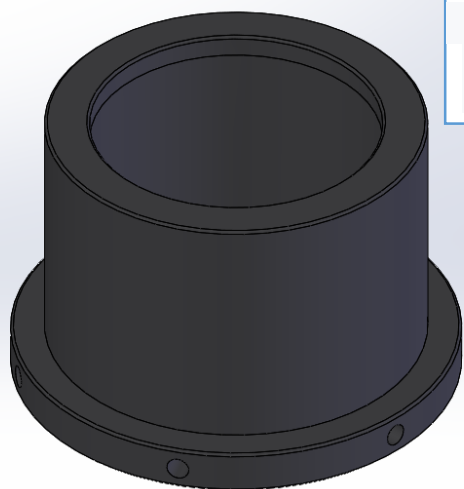
螺杆

The screw

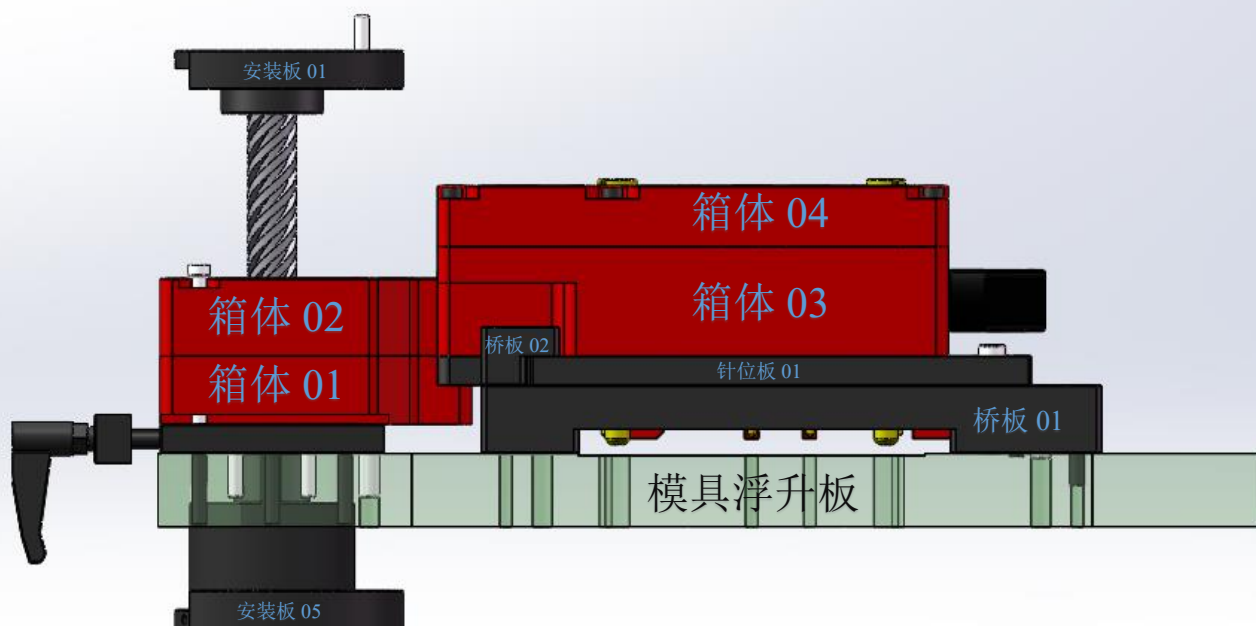


螺母

nut



轴承座
bearing



谢谢观看。

Thanks for watching.