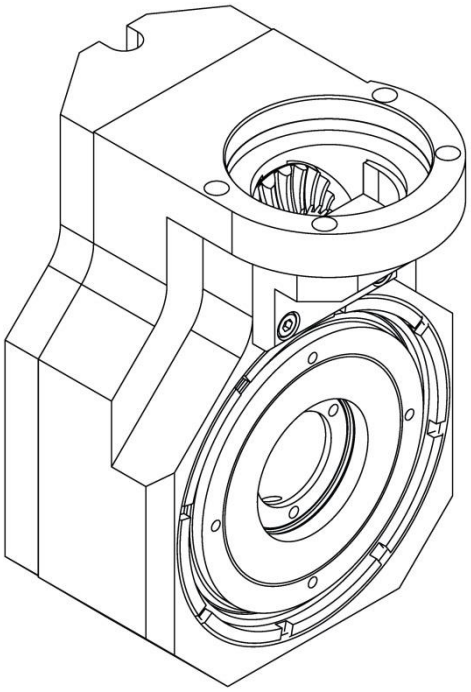
GSW-255

Français

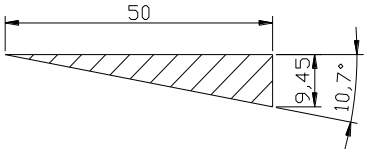
1. Pour fixer le porte-outil sur la machine, il faut le placer sur l'axe B et utiliser la goupille pour le positionnement. Serrer, les 4 vis de fixations (important, veillez à ce que les vis aient la même force de serrage).

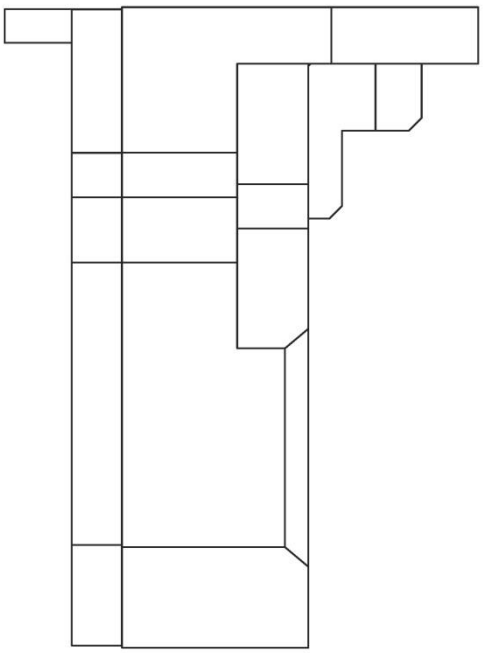


2. Trouver le centre de la broche et l'introduire comme point 0 tout en vous assurant que le porte outil est bien à 90° de la broche de reprise

3. Calculer l'angle pour le filet que vous voulez produire.

$$\tan \alpha = \frac{2p}{\pi(D + d_n)}$$





4. Ajuster l'angle du porte-outil à tourbillonner à l'aide de la motorisation de l'axe B.

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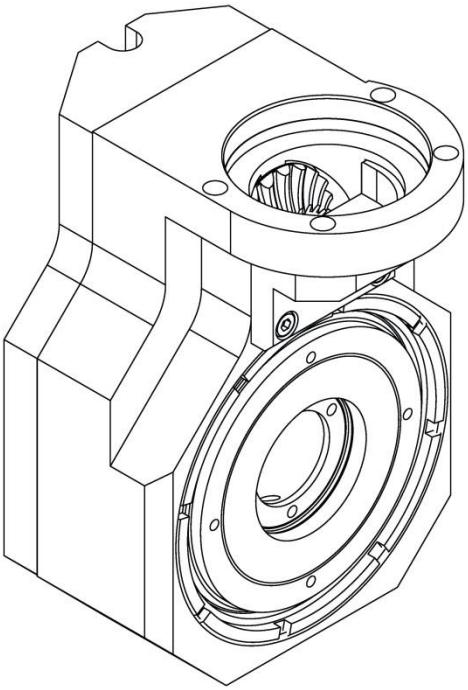
GSW-255

English

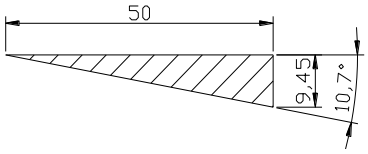
1. To fix the tool holder on the machine, you have to put it on the axis B and use the pin for the positioning.
   Then tighten the 4 screws of fixations (Important, make sure that the screws have the same strength of tightening).

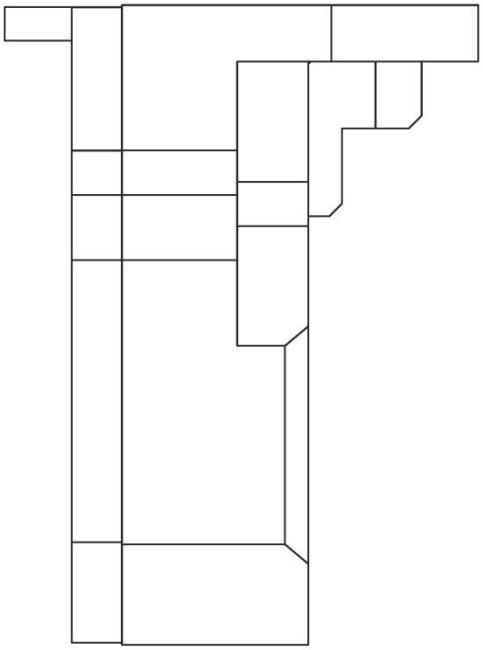


2. Find the center of the broach and set this point as 0. Make sure the tool holder is straight 90° from the sub-spindle.

3. Calculate the angle for the work piece you would like to produce.

$$\tan \alpha = \frac{2p}{\pi(D + d_n)}$$



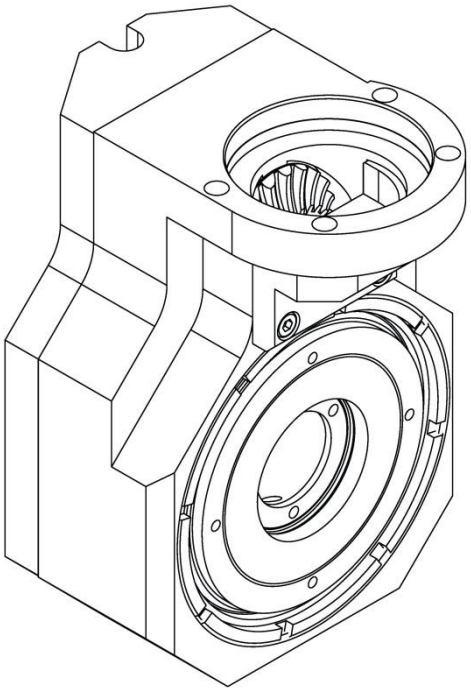


4. Adjust the angle from the whirling tool holder with the motorization from the axis B.

GSW-255

Deutsch

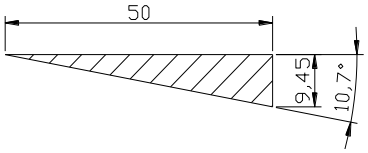
1. Um den Werkzeughalter an der Maschine zu befestigen, müssen Sie in auf den B Achse tun und zentrieren Sie es mit dem Positionierstift.
   Ziehen Sie die 4 Schrauben an (Wichtig, beobachten Sie darauf, dass die Schrauben dieselbe Spannkraft haben).

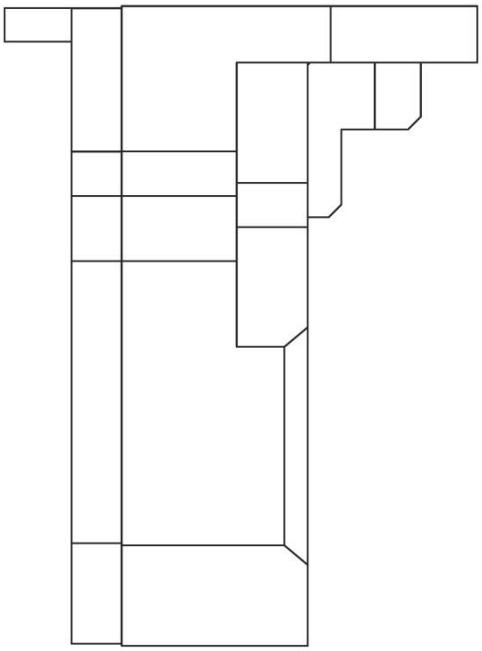


2. Finden Sie das Zentrum von der Spindel und geben Sie es ein wie den 0 punkt von dem Werkzeughalter. Sie müssen richtig um 90° von der Hauptspindel sein.

3. Berechnen Sie den Winkel für das Gewinde die Sie machen wollen.

$$\tan\alpha = \frac{2p}{\pi(D + d_n)}$$





4. Um den Winkel zu einstellen, benutzen Sie die Motorisierung von der Achse B.

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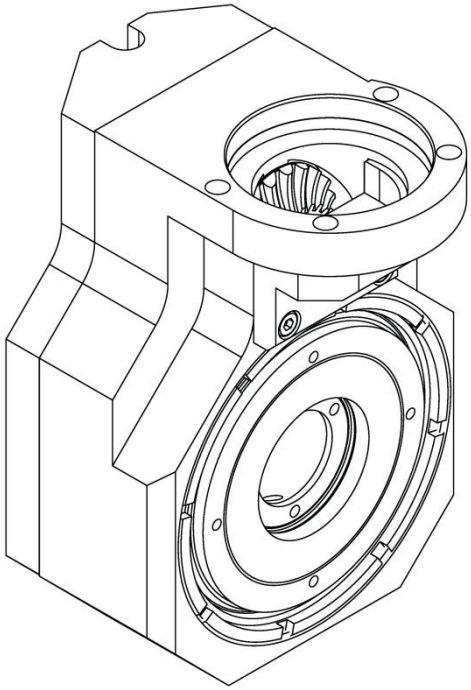
Italiano

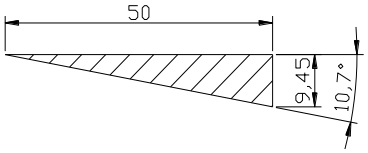
1. Per fissare il porta-utensile sulla macchina, posizionare il porta utensile sull'asse B e utilizzare il pin per il posizionamento.
   Serrare le 4 viti di fissaggio (importante, guardare che le viti hanno la stessa forza di serraggio).

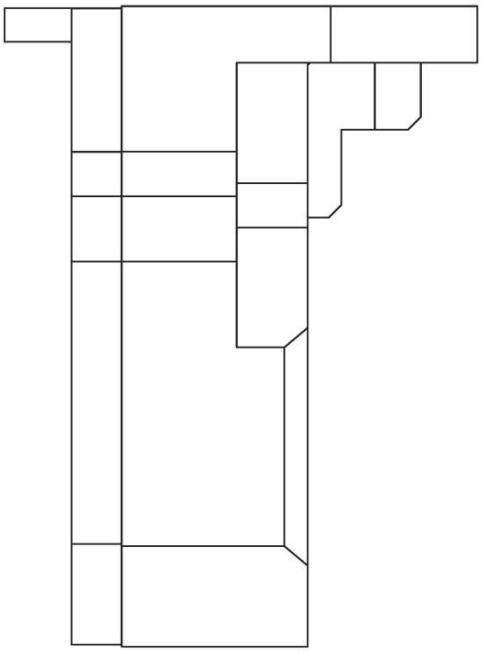


2. Trovare il centro del mandrino e inserirlo come punto 0, pur assicurando che il portautensile è a 90 ° rispetto al mandrino di prelevamento.

3. Calcolare l'angolo della filettatura che si desidera produrre.

$$\tan \alpha = \frac{2p}{\pi(D + d_n)}$$





4. Regolare l'angolo del porta utensile con la motorizzazione del asse B.

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