

Trouble Shooting



File No : TS31103

Error Code : 00001

SOP名稱: SOP名稱: Adjustment of Backlash for GXA-S series GXA-S背隙調整

For Model 機型: New Machine.jpg



Use Tools(使用工具圖片):



A:Dial indicator (千分錶).jpg

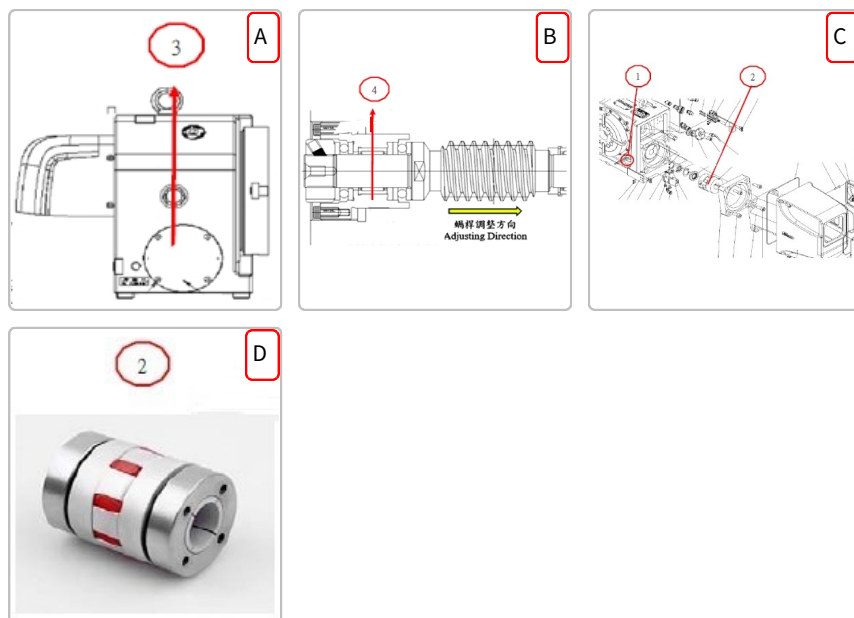
B:Flat Screwdriver (平口螺絲起子).jpg

C:Jig - T - slot wrench(T溝板手-治具).-
jpg

D:Tensiometer (推拉力計).jpg

E:T-Wrench (T型扳手).jpg

Illustration(維修部位說明):



A:Coupling (聯軸器).jpg

B:Cover (軸封蓋).jpg

C:Plug (塞蓋).jpg

D:Sleeve of Worm Shaft (調整測套管).-
jpg

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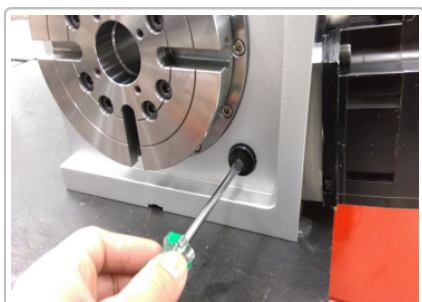


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Step 1



Illustration(步驟說明)：

使用平口螺絲起子移除塞蓋。

Remark(備註補充)：

* ToolA



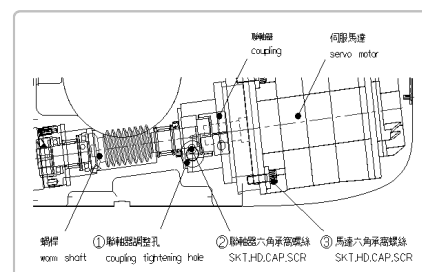
Step 2



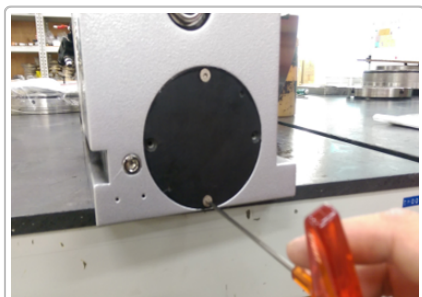
Illustration(步驟說明)：

Rotatemotoruntiltool
B(4mm)can reach M5screwsonpa
rt②.Loosethescrews.Atremark②
SKT.HD.CAP.SCR.轉動馬達至可將
T型板手**4mm**套入聯軸器上的M5
螺絲②後，將螺絲放鬆。

Remark(備註補充)：



Step 3



Illustration(步驟說明)：

RemoveFlat.HD.SKT.SKR*
4pcsbytool
B(2.5mm).Removepart③.使用T型
板手**2.5mm**拆開皿型螺絲4只，將
軸封蓋取下。

Remark(備註補充)：

* ToolB



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Step 4



Illustration(步驟說明)：

LooseSKT.HD.CAP.SCR*
2pcsbytoolB(3mm).使用T型板手
3mm放鬆內六角螺絲M4螺絲2只
。

Remark(備註補充)：

* ToolB



Step 5



Illustration(步驟說明)：

LockM6x50Lscrews*
2pcsonpart④.Ro- w
tatepart④bythe2scre
s.Rotateclockwisetoreduce
backlash;Rotate
counter-clockwisetoincrease
backlash.*Itisrecommendedto
rotateuptoquarter(1/4)turnatone
time.在套管座鎖上M6x50L螺絲2
只，應用2只螺絲轉動套管座，順
時針方向為縮小蝸桿蝸輪背隙，
逆時針方向為放大蝸桿蝸輪背隙
。*建議一次最多轉動1/4圈。

Remark(備註補充)：

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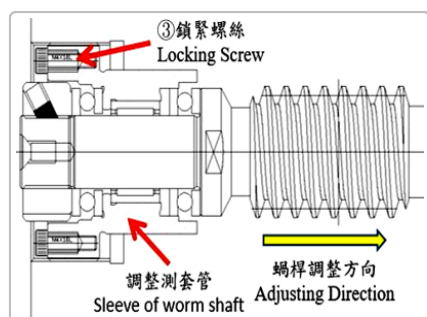


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Step 6



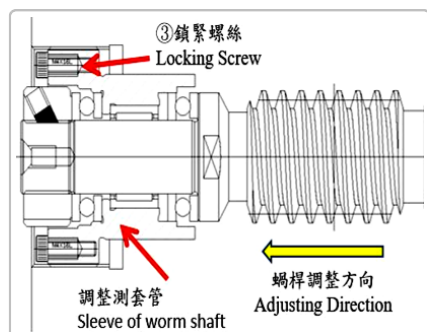
Illustration(步驟說明)：

If the backlash is too large, rotate M6x50L * 2 pcs on part ④ clockwise to reduce backlash. 若背隙過大時，在套管座上的M6x50L螺絲2只以順時針旋轉調整側套管來減少蝸桿蝸輪背隙。

Remark(備註補充)：



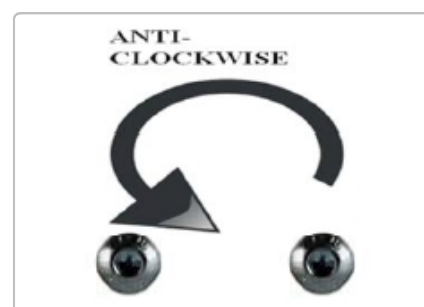
Step 7



Illustration(步驟說明)：

If the backlash is too small, rotate M6x50L * 2 pcs on part ④ anti-clockwise to increase backlash. 若背隙過小時，在套管座上的M6x50L螺絲2只以逆時針旋轉調整側套管來增加蝸桿蝸輪背隙。

Remark(備註補充)：



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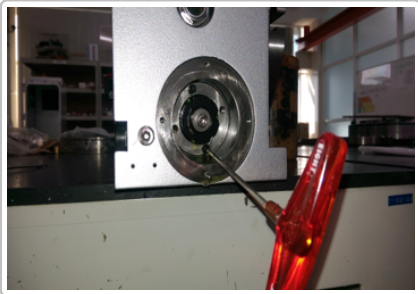
Step 8

Illustration(步驟說明) :

TightenSKT.HD.CAP.SCR*2pcs. 鎖緊內六角螺絲M3螺絲2只。

Remark(備註補充) :

* ToolB



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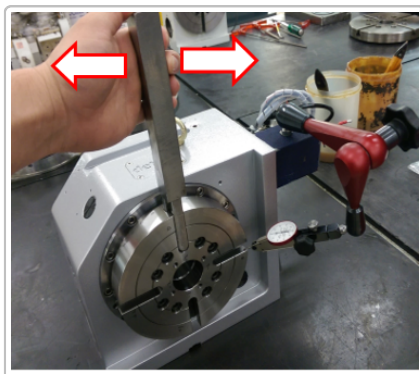


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Step 9

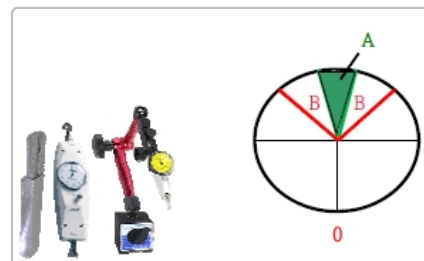


Illustration(步驟說明)：

1.將千分錶吸附在本體上,錶針量測在盤面一處T型溝側邊2.使用治具T溝板手插入盤面其他T型溝,使用推拉力計距離盤面外緣約100mm左右,順時針施力約10~15Kg後放鬆觀察千分錶數值.3.使用治具T溝板手插入盤面其他T型溝,使用推拉力計距離盤面中心半徑約100mm左右,逆時針施力約10~15Kg後放鬆觀察千分錶數值.4.間隙須在0.005~0.01mm,如果太大或太小需重複操作調整至範圍1.The dial indicator is adsorbed on the body, and the dial needle is measured on the side of T-slot ditch on the table plate surface. 2. Insert the T - slot wrench of the jig into other T-slot of the table plate, use the tensiometer to distance about 100mm from the outer edge of the table plate, apply about 10~15Kg clockwise force, then loose and observe the value of the dial indicator. 3. Insert the T slot wrench of the jig into other T-slot of the disk surface, use the tensiometer to distance about 100mm from the center radius of the disk surface, apply about 10~15Kg counter clockwise force, then loose and observe the value of the dial indicator. 4. The clearance must be 0.005~0.01mm. If it is too large or too small, repeat the operation to adjust it to the range.

Remark(備註補充)：

* Standard value/標準值 : 0.005~0.01mm * The indication of dial gauge/千分錶示意 : (1) A: Backlash/背隙值 (2) B: Flexible Deformation/彈性變形量



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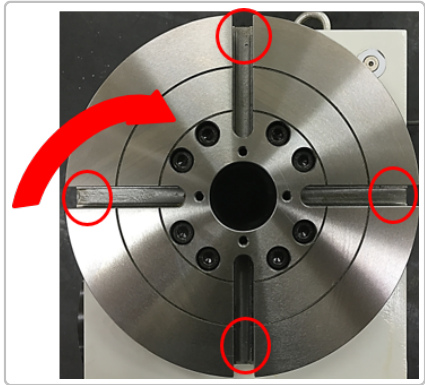
Step 10

Illustration(步驟說明) :

Adjust backlash on the circumference of rotary table at 90 degrees intervals as Fig.10-1. Repeat step 5-step 10 until the alignment is in the regulation n.(0.005mm-0.01mm) 蝸輪分為4點,量測間距為90度(分度盤旋轉的角度)。每轉90量測一次,檢查數據平均值。重複步驟5~8將背隙調整到0.005mm~0.01mm。

Remark(備註補充) :

* Tool C



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Step 11

Illustration(步驟說明)：

After adjusting backlash, rotate the motor until the tool B (4mm) can reach the M5 screw on part ②. Tighten the screw. (At remark ② SKT.HD.CAP.SCR.) Re-assemble part ③ and part ① in the reverse order. The adjustment of backlash for GXA-S series is complete. 背隙調整完畢後，轉動馬達至可將T型扳手4mm套入聯軸器上的M5螺絲②後，將螺絲鎖緊。依序將塞蓋以及蝸桿封蓋裝回，即完成蝸桿蝸輪的背隙調整。

Remark(備註補充)：

* Tool B

