

No.	001 - 24
job classification	Maintenance
target machine	CNC lathe

SHIOZAWA NEWS

Manufacturer	Tecno Wasino
Model	J1
Task	Chuck & cylinder replacement

【Overview of repair machines】

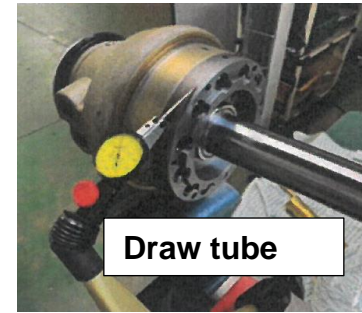


【Chuck side】



【Cylinder side】

【Key points of the exchange operation : Run-out checks of cylinders, feed tubes and chucks and confirmation of mounting accuracy.】

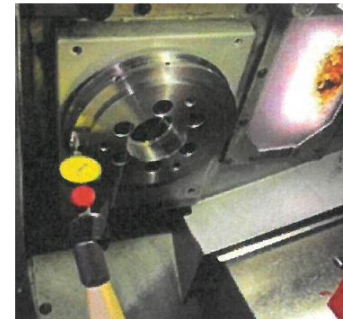


Draw tube

【Run-out of flange for cylinder】



【Run-out of feed tube】

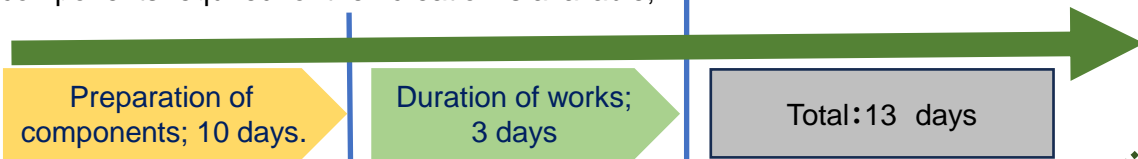


【Run-out of chuck flange】

【Implementation details and approximate man-hours】

- ◆ Mounting and adjustment of flanges for cylinders; run-out of outer circumference within 5 μ .
- ◆ Mounting and adjustment of feed tube (to check seating) and journal; run-out 8 μ , front/rear within 5 μ .
- ◆ Chuck mounting and adjustment; run-out of outer diameter within 3 μ , run-out of end face within 2 μ .

Man-hours when the components are available and the technical documentation of the components required for their creation is available;



【Overview of replacement works】

Preliminary inspection and preparation

- ◆ In principle, replacement chuck parts shall be arranged by the customer
- ◆ In cases where Shiozawa makes arrangements, it is possible to handle models from manufacturers that have already been replaced. Otherwise, acquisition of technical data, design, etc. are required and the delivery date will be discussed separately.

works

- ◆ Even if customer arrangements and technical documentation have been provided, 10 days after customer approval are required for preparation.
- ◆ It takes three days for the replacement, including electrical wiring work.

Factors causing additional items.

- ◆ If drawbars, backplates, etc. need to be manufactured, the delivery time is further added depending on the availability of technical data.