WD6~8 SERIES
ELECTRICAL TOOL CARRIER
PRODUCTION INTRODUCTION

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CATALOGUE

1.GENERAL DESCPRIPTION

It sends out signs by no-touching unite,and adopts double resersing pins to locate partly,then it locates precisionly by double-teeminal.It adopts cam to lock up.This construct is brief.It is notonlyconvenient but also credibly.At same time it could be loaded six or eight tools. SO it could be fitted for complex lathe-machining.It has the more short time than the general square carrier when it changes tool.It could extend the road of lathe beacause you may choose the assisantly finishment to machine the inner hole.

2.WORKING PRINCE

When the carrier receives the changing tool signal from the microcomputer,relay starts,and the worm gear and worm shaft makes the locking cam apart,then fluted disc was departed. Tool plate move to cutter spacing which is demanded.When hall units issues cutter spacing signal,motor reverse to complete the primary setting by the locking pin. The cam is locked as three-terminal-tooth plates meshing each other,then precision setting is completed.The motor was breaked,and the pole of delivering message emited the sign of being at location.At this time cutting will start.

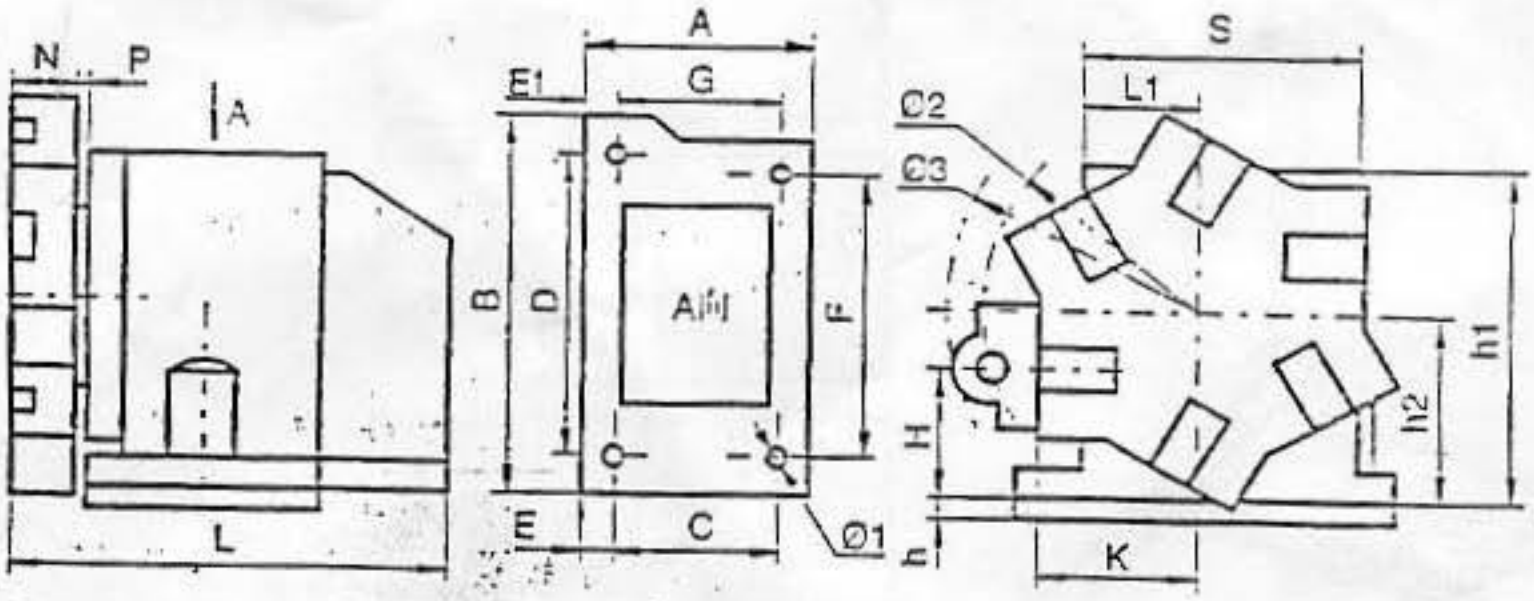
3.TOOL CARRIER PREFORMANCE

Changing tool signal----motor rotating clockwise----cutter table turning----cutter spacing signal----motor reversing ----primary setting----precision setting and carrier locking----overcurrent and motor stopping----response signal for changing tool----cutting

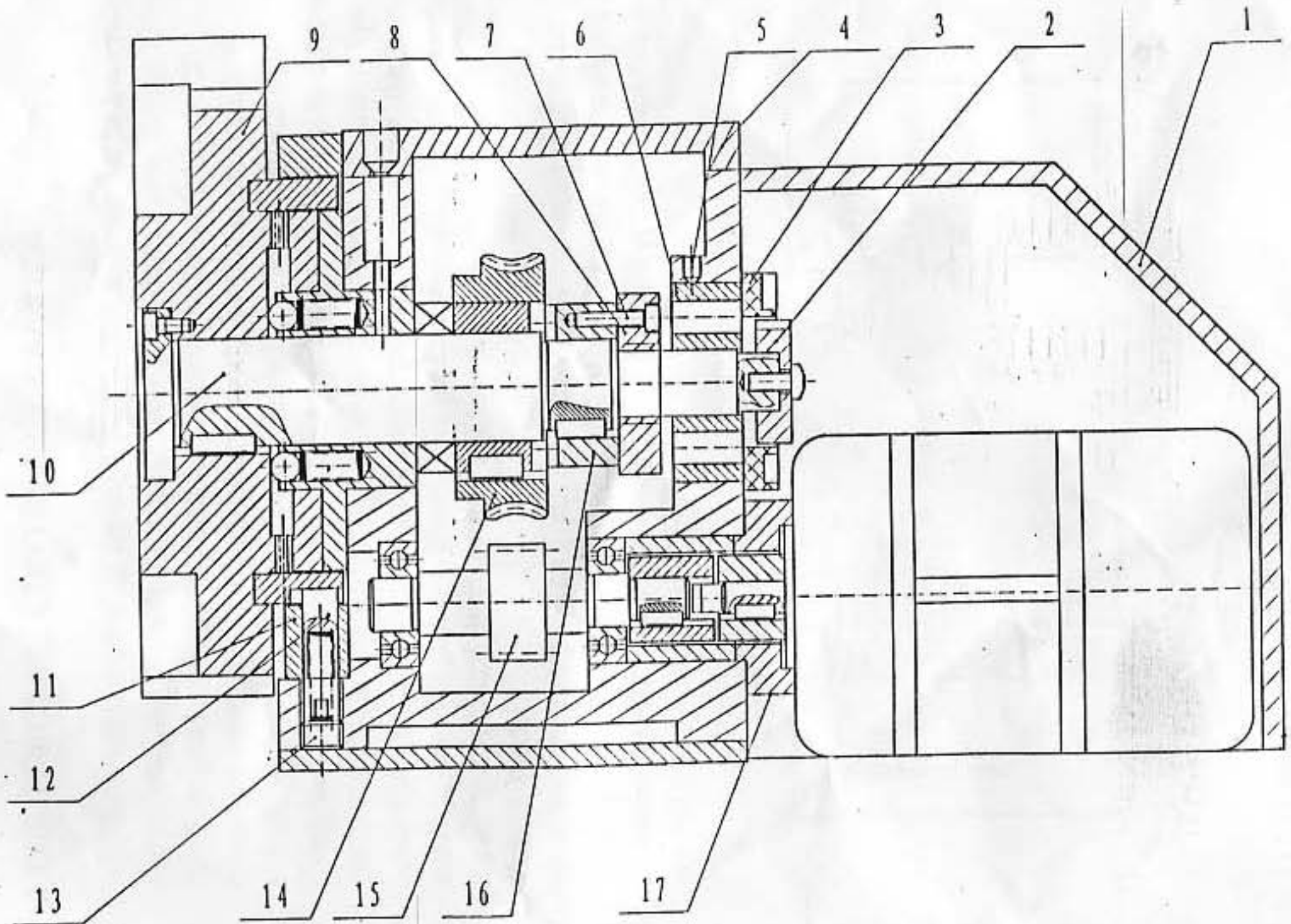
4.TECHNOLOGICAL INDEX

Model	Changing tool time(s)			Max torque (N.m)	Reaptability accuracy (mm)	Motor Power (w)	Motor speed (r/min)	Net Weight (Kg)
	60°	120°	300°					
WD6~8-C0625	1.5	2	3.5	8	<0.005	60	1400	25
WD6~8-C6125	1.5	2	3.5	8	<0.005	60	1400	30
WD6~8-C6132	1.5	2	3.5	30	≤0.005	120	1400	40
WD6~8-C6136	1.5	2	3.5	30	<0.005	120	1400	42
WD6~8-C6140	1.5	2	3.5	40	<0.005	120	1400	44

5.TOOL CARRIER SKETCH AND DIMENSION



Model	Dimension																				Td. S
	H	h	A	B	C	D	E	E	F	G	K	N	P	L	L1	h1	h2	Φ1	Φ2	Φ3	
WD6~8-C0625	59		133	164	106	144	12	38	144	80	62	35	2	318	45	172	100	11	196	240	16	120
WD6~8-C6125	59	7	133	164	106	144	12	38	144	80	62	35	2	318	45	172	100	11	196	240	16	120
WD6~8-C6132	78	13	160	224	140	200	10	10	185	140	92	55	3	370	68	200	118	11	248	330	20	155
WD6~8-C6136	78	20	160	224	140	200	10	10	185	140	92	55	3	370	68	200	118	11	248	330	20	155
WD6~8-C6140	78	24	160	224	140	200	10	10	185	140	92	55	3	370	68	200	118	11	248	330	20	155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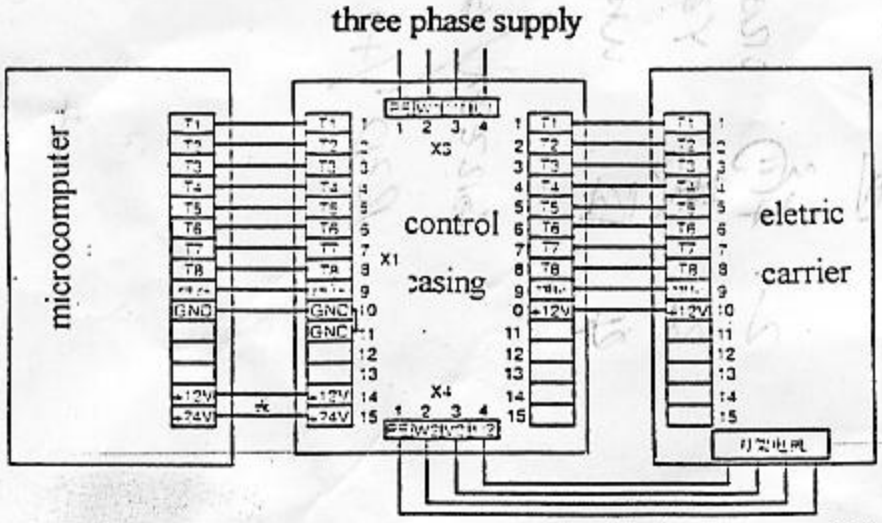
6.THE ELECTRIC CONTROL OF CARRIER

The electric control of motor-driven carrier is divided into heavy current part and weak current part. There is the three phase supply drives the three phase AC asynchronous motor for the clockwise and anti-clockwise rotation in the heavy current part, thus the actions such as unlock, dislocation, lock and others are realized. Weak current part is composed of position sensor. Each Hall unit is corresponding to a working position of the motor driven carrier. according to the difference of the mode that the microcomputer control the motor driven carrier, the terminal mode of the Hall unit is different. We take four working position carrier for an example and describe it in two cases:

1) 5/3T model

When changing the tool, microcomputer put corresponding cutter spacing wires (T1--T4) to the ground. Then wait for the answer signal. The actions of carrier such as unlock, rotation and lock are all completed by control casing.



2) 15T model

When changing tool, microcomputer put the positive turning signal to the ground, then defect corresponding cutter spacing wires (T1--T4). After the carrier arrives the proper location, cancel the positive turning signal and issue the conversion turning signal.