

技术要求:

1. 多轴箱按ZB58011-89《组合机床多轴箱制造技术条件》进行改造,按ZB58011-89《组合机床多轴箱验收技术条件》进行验收。
2. 主轴精度按JB3043-82《组合机床多轴箱精度》标准进行检验。
3. 往主轴箱内注入L-AN46全损耗系统用油。

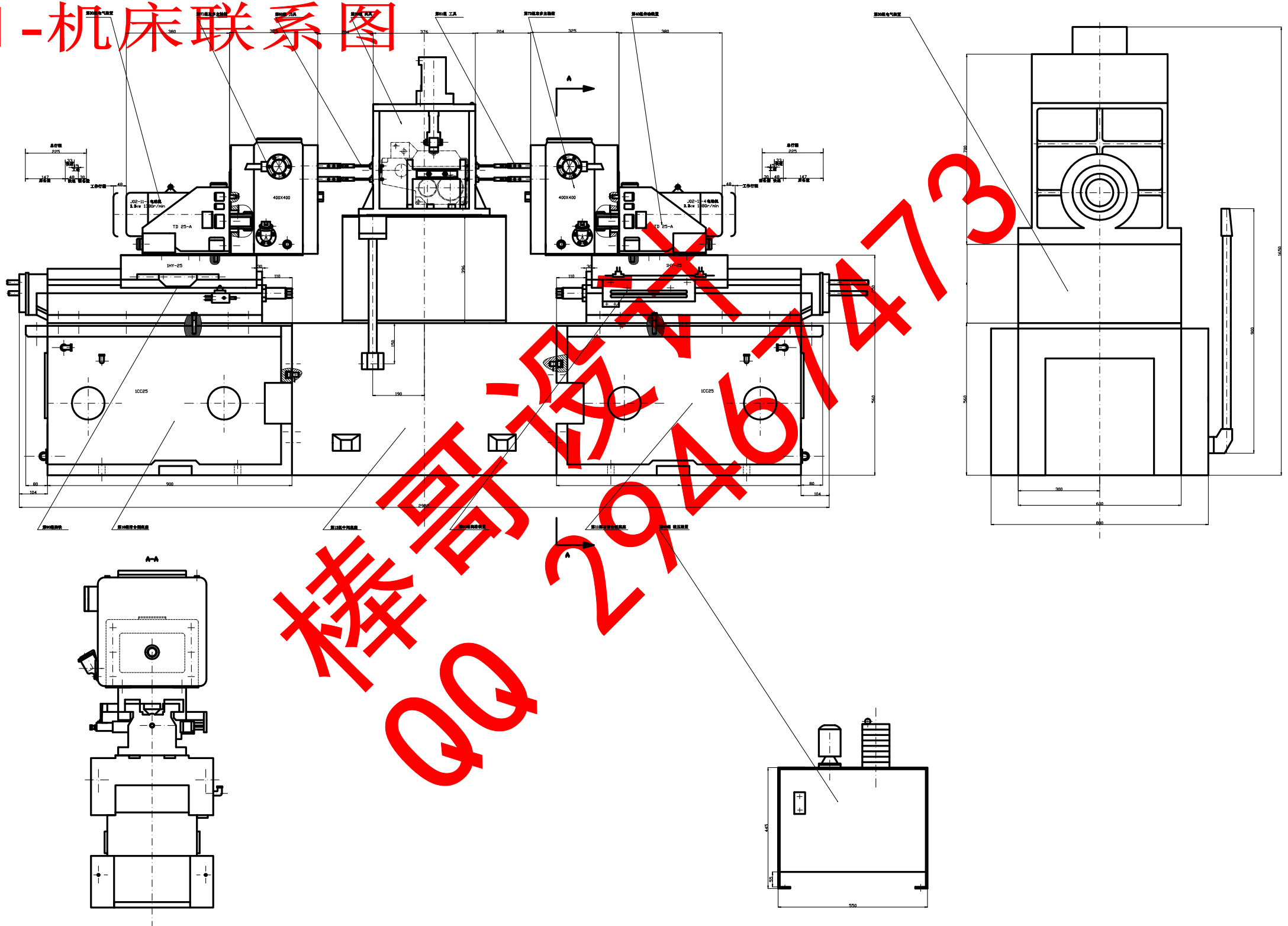
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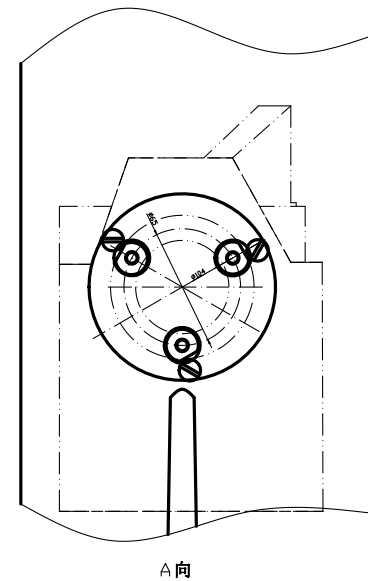
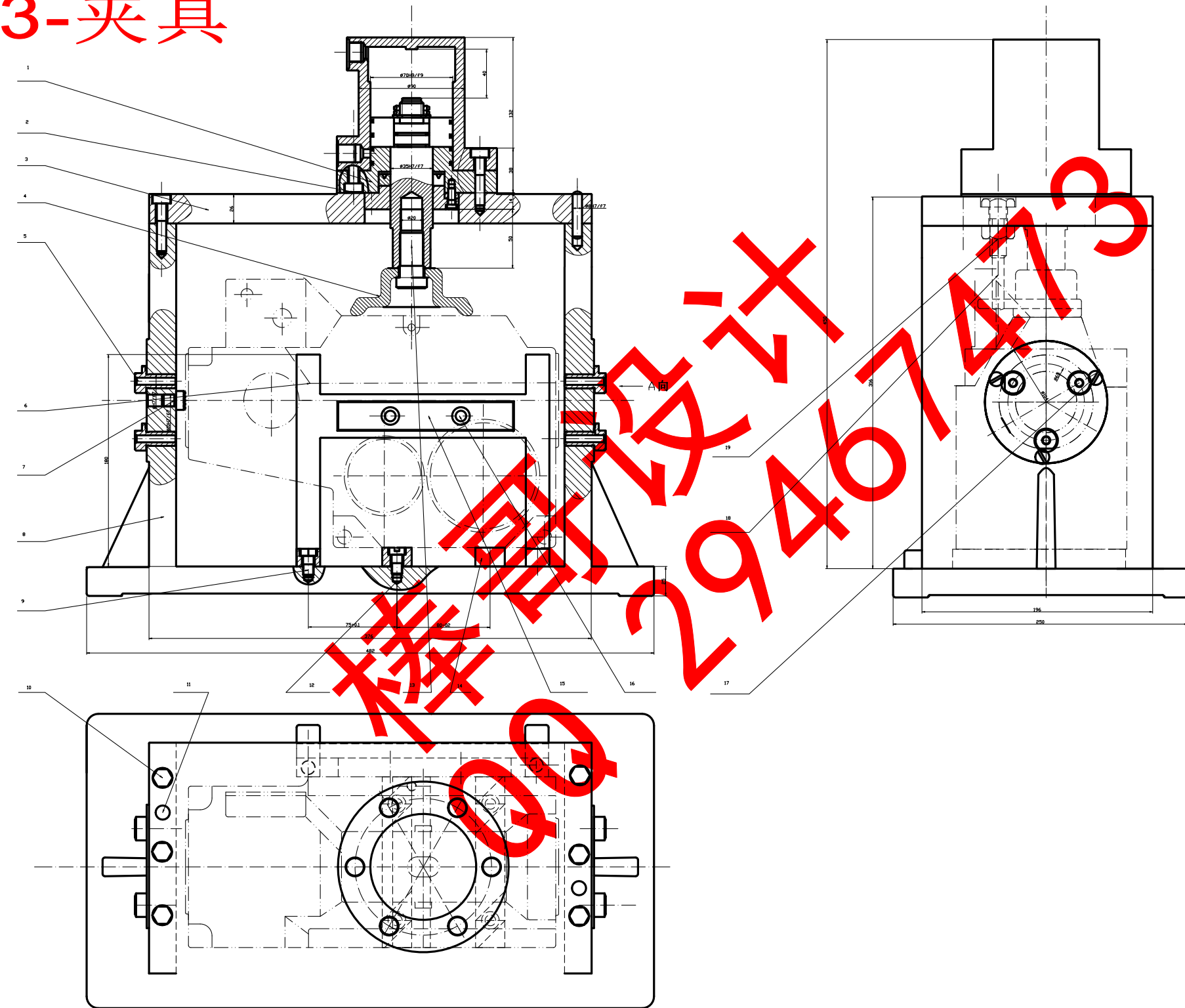
1. 多轴箱按ZBJ58011-89《组合机床多轴箱制造技术条件》进行改造, 按ZBJ58011-89《组合机床多轴箱验收技术条件》进行验收。
2. 主轴精度按JB3043-82《组合机床多轴箱精度》标准进行检验。
3. 往主轴箱内注入3L-AN46全损耗系统用油。

[illegible]

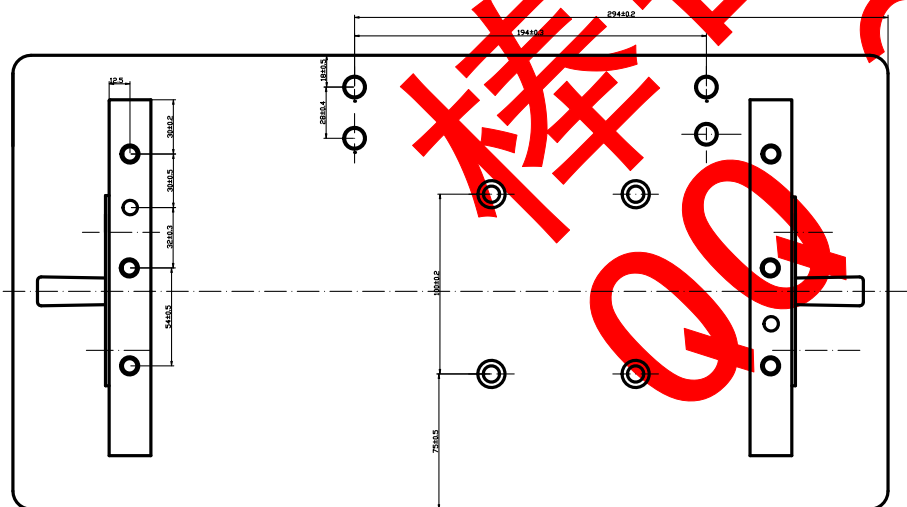
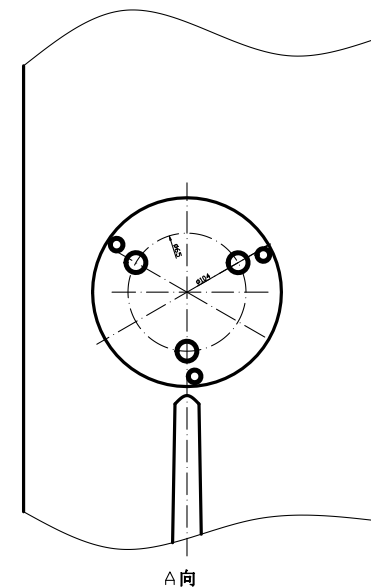
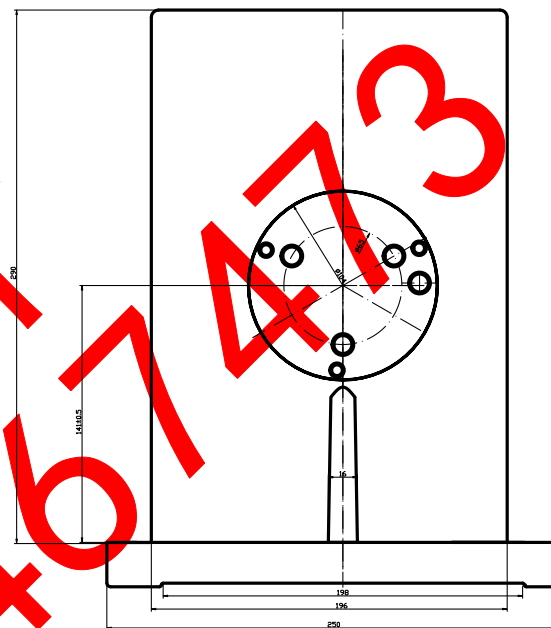
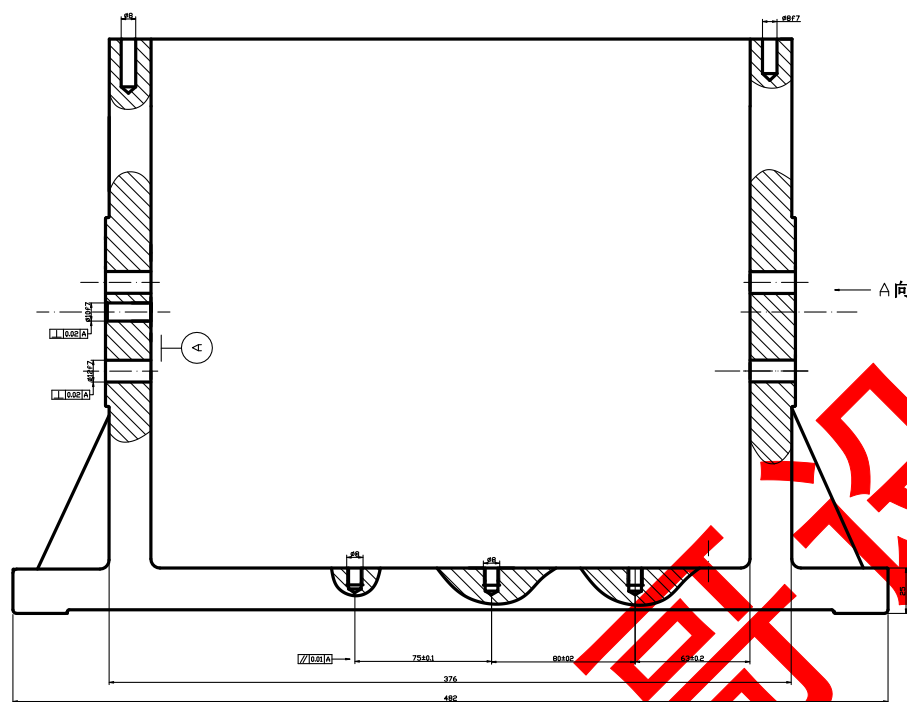
1-机床联系图



3-夹具



4-夹具图



液压

This is a detailed hydraulic schematic diagram for a double-acting cylinder system. The diagram includes the following components and connections:

- Hydraulic Pump (1):** A gear pump at the bottom center, driven by a motor (10).
- Pressure Relief Valve (2):** Located on the pump's pressure line to protect the system from overpressure.
- Directional Control Valve (3):** A 4/3-way valve with a center position, used to direct flow to either side of the cylinder.
- Flow Control Valve (4):** A valve used to regulate the speed of the cylinder's movement.
- Double-Acting Hydraulic Cylinder (5):** The main actuator, shown in a cross-section view at the top. It has two ports for fluid entry/exit.
- Check Valve (6):** A valve that allows flow in one direction only, preventing backflow.
- Sequence Valve (7):** A valve that ensures one hydraulic action occurs before another.
- Pressure Gauge (8):** A gauge used to monitor the system pressure.
- Pressure Relief Valve (9):** Another relief valve located on a branch of the circuit.
- Directional Control Valve (10):** A 3/2-way valve used for specific flow control.
- Flow Control Valve (11):** Another flow control valve in the circuit.
- Directional Control Valve (12):** A 3/2-way valve at the bottom right.
- Directional Control Valve (13):** A 3/2-way valve at the bottom right.
- Directional Control Valve (14):** A 3/2-way valve at the bottom right.
- Directional Control Valve (15):** A 3/2-way valve at the bottom right.
- Directional Control Valve (16):** A 3/2-way valve at the bottom right.
- Directional Control Valve (17):** A 3/2-way valve at the bottom right.
- Directional Control Valve (18):** A 3/2-way valve at the bottom right.

The diagram also includes a large red watermark reading "精哥设计 2946" (Jingge Design 2946) across the center.

动作名称	电液调工作状态			
	1DT	2DT	3DT	4DT
失重工件	-	-	+	-
进给缸快速	+	-	-	-
进给缸工进	+	-	-	-
死挡铁停留	+	-	-	-
进给缸快退	-	+	-	-
进给缸原位停止 失重缸松开	-	-	+	+