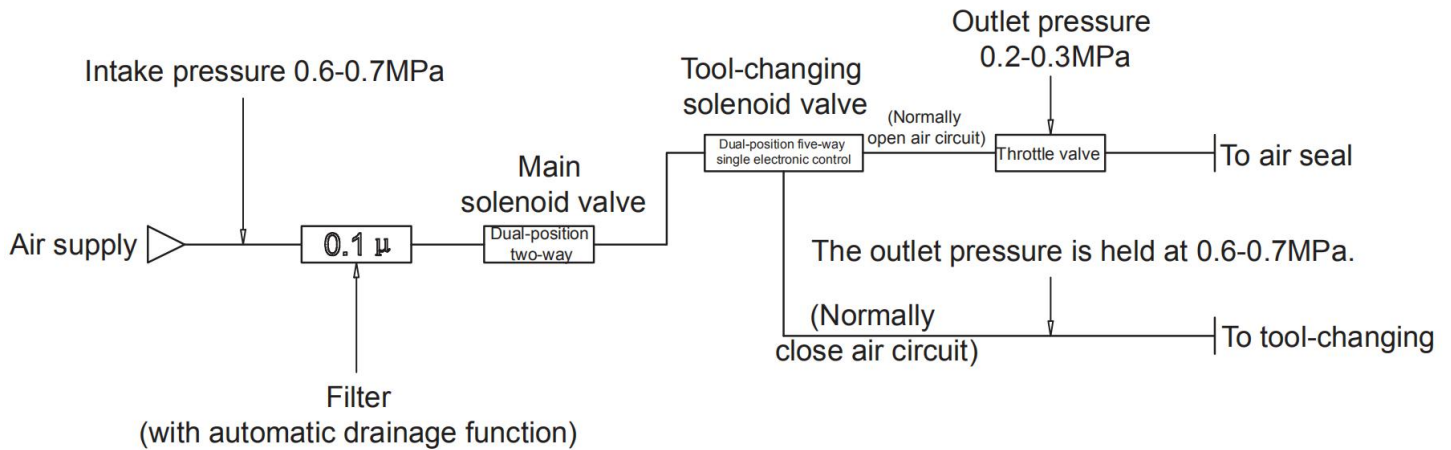


GDL70-24Z/9.0 Air supply connection method and description of air-cooled tool-changing motorized spindle



Note:

1. The main solenoid valve links with the main switch of machine tool, and the ventilation shall be carried out once the machine tool is started.
2. The normally open air circuit of the dual-position five-way single electronically controlled solenoid valve is connected to the air seal, and the normally close air circuit is connected to the tool-changing. When the motorized spindle completely stops, the power-on normally close air circuit of the tool-changing solenoid valve is connected to the cylinder for the tool-changing, the cylinder is actuated to complete the tool changing while completing the tool-changing and dust removal. At this time, the air seal is closed. After the new tool handle enters the tapered hole of the spindle, the tool-changing solenoid valve is powered off to cut off the air inlet, and then air pipe is connected to the atmosphere. At this time, the air circuit is ventilated, the cylinder resets the spindle to lock the new tool handle, and the tool-changing operation is completed.
3. The tool-changing pressure shall be stable. Otherwise, it is easy to cause that the tool-changing signal is instable.
4. The button switch is directly used to control the dual-position five-way single electronically controlled solenoid valve for the manual tool-changing.
5. The proximity switch, tool-removal solenoid valve and the tool magazine work with the control system for the automatic tool-changing.
6. The manual or automatic tool-changing can be carried out only when the motorized spindle stops completely. The manual or automatic tool-changing will be invalid when the motorized spindle rotates.