

<http://www.yt-ma.com>

本公司主要生产各种型号的机械分度头、机械回转工作台、立铣头、数控分度头、数控回转工作台、数控刀架、数控中心架、交换工作台、专机等。2008年11月通过挪威船级社(DNV)ISO9001:2008质量管理体系认证。“环球”牌F11系列万能分度头，04年获山东省名牌产品称号。“环球”牌AK31系列数控转塔刀架，2011年获山东省名牌产品称号。2012年“环球”牌TK13系列数控回转工作台获山东省名牌产品称号。06年“环球”商标被授予山东省著名商标。“环球”牌产品以质量稳定、性能可靠、信守合同、服务周到而畅销国内外市场。

The compang mainly produces various mechanical dividing heads, mechanical rotary tables, milling heads, NC dividing heads, NC rotary tables, NC turrets, NC steady rests, pallet changers and special machine tools ect. It has passed the quality certification of ISO9001-2008 by DET NORSKE VERITAS(DNV) in Nov., 2008. “Universal” brand F11 series dividing heads was awarded “Shandong Famous Brand” in 2004 and “Universal” brand AK31 series NC turret was awarded “Shangdong Famous Trademark” in 2011.TK13 series NC rotary table was awarded “Shandong Famous Trademark” in 2012. “Universal” trademark was awarded “Shandong Famous Trademark” in 2006. With the stable quality and reliable performance, strictly abide by the contract and better service , “Universal” products have been sold well in both the international and domestic market.

公开承诺

产品实行“三包”，保修期为12个月。

接到用户信息4小时响应，48小时内上门服务。

保修期内48小时上门服务，每延误一个工作日补偿客户500元。

产品免费咨询、免费培训。

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YTUM

烟台环球机床附件集团有限公司

YANTAI UNIVERSAL MACHINE TOOL ACCESSORY GROUP CO.,LTD

数控刀架样本 NC TURRETS



AK31 系列数控转塔刀架

AK30 系列数控转塔刀架

AK3650 伺服转塔刀架

AK33 系列动力数控转塔刀架

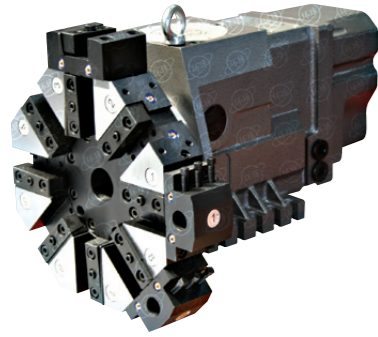
AK27 直边系列数控转塔刀架

AK23 系列数控转塔刀架

AK27(VDI) 系列数控转塔刀架



AK31系列数控转塔刀架 AK31 SERIES NC TURRET



●本产品引进意大利Baruffaldi公司技术生产的高性能机床附件，是数控车床的必备附件，特别适宜全功能数控车床，亦是该车床的核心部分。可多刀夹持，变向转位和任意刀位就近选刀，实现了加工程序的自动化、高效化。

●它采用端面齿作为分度定位元件；分度工位由二进制绝对值编码器识别。刀架定位与锁紧由接近开关发出信号，接近开关与编码器均可直接与pc（可编程序控制器）联机。它籍以配套的必备附件刀盘及各种辅助刀夹（车刀夹、镗刀夹、弹簧夹头、莫氏刀柄）等可完成各种复杂工序的加工。各种辅助刀夹可特殊定货。

●为适应机床需要本产品配备5个规格，每个规格又分8工位和12工位两种供用户选购。

●AK31 series NC turret produced by technology introduced from Baruffaldi S.P.A.Italy is an important equipment of high performance and key part for full-function NC.lathe.it is designed to hold several tools featuring bidirectional indexing and shortest indexing path.So that automation and high accuracy of operational procedures can be realized.

●It utilizes a face gear coupling as indexing mechanism.Indexing sequence is mainly controlled by a binary absolute encoder;Clamping and unclamping of turret are signalled by a proximity switch which is connected together with the encoder to PC.With indispensable matching attachment,turret disc,tool holder(such as turning tool holder,boring tool holder,collet and Morse tool shank),complicated work procedures can be realized.Other tool holders are on special orders.

●AK31 series has 5 specifications,with each having both 8 &12 stations.

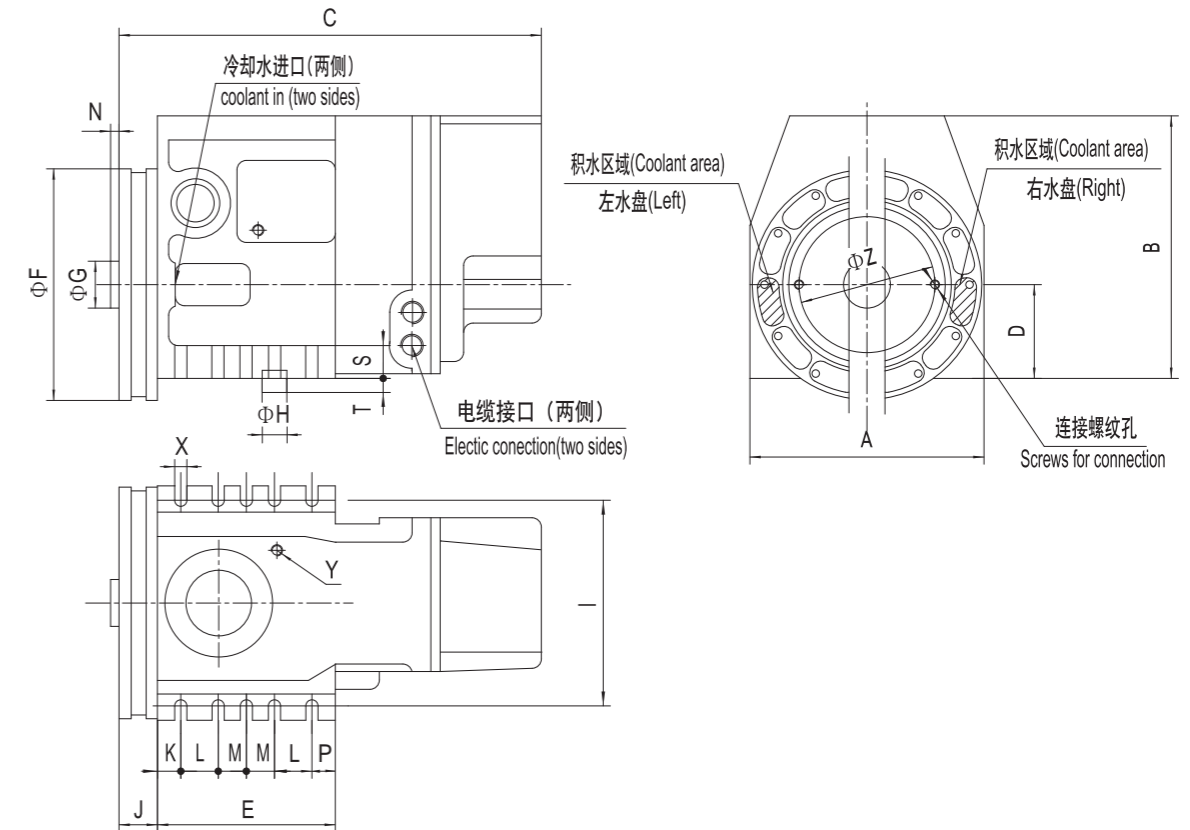
主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

项目Items	规格Specifications	AK3180X ⁸ / ₁₂	AK31100X ⁸ / ₁₂	AK31125X ⁸ / ₁₂	AK31160X ⁸ / ₁₂	AK31200X ⁸ / ₁₂					
中心高 Center height	mm	80	100	125	160	200					
附件最大转动惯量 Max inertia of mass	kg.m ²	1.30	0.80	4.50	3.00	7.50	4.50	32	15	70	22
转位30° 时间 Time for 30° rotation	s	0.19	0.16	0.27	0.22	0.32	0.27	0.50	0.30	0.62	0.34
转位30° 并刹紧时间 Time for 30° rotation & clamping	s	0.58	0.50	0.80	0.68	0.95	0.80	1.50	0.90	1.80	1.02
转位45° 时间 Time for 45° rotation	s	0.29	0.25	0.40	0.34	0.47	0.40	0.75	0.45	0.90	0.50
转位45° 并刹紧时间 Time for 45° rotation & clamping	s	0.67	0.58	0.95	0.79	1.10	0.95	1.75	1.06	2.10	1.19
转位180° 并刹紧时间 Time for 180° rotation & clamping	s	1.54	1.33	2.15	1.80	2.50	2.15	4.0	2.44	5.23	2.70
最大不平衡负重力矩 Max.unbalanced load torque		15	40	60	160	470					
刀孔定位分度精度 Angular indexing accuracy		±6"									
重复定位精度 Repeatability		±2"									
最大允许承重 Max.allowable load capacity	kg	40	120	160	380	500					
分度频率 Indexing frequency	n/h	750	750	750	600	600					
起动功率 Start-off power	KVA	1.1	1.6	1.6	2.8	2.8					
刀架净重 Net weight	kg	不带刀盘 Without disk 65	带刀盘 With disk 103	不带刀盘 Without disk 136	带刀盘 With disk 210	不带刀盘 Without disk 486	带刀盘 With disk 593				
刀架毛重 Gross weight	kg	不带刀盘 Without disk 84	带刀盘 With disk 130	不带刀盘 Without disk 171	带刀盘 With disk 245	不带刀盘 Without disk 466	带刀盘 With disk 600				
箱体尺寸(长×宽×高) Packing dimension	mm	710×550×535	610×450×465	710×623×575	1013×760×750	1010×940×900					

注：以上参数以实物为准，如有变动最终解释权归本公司。



AK31系列数控转塔刀架 AK31 SERIES NC TURRET



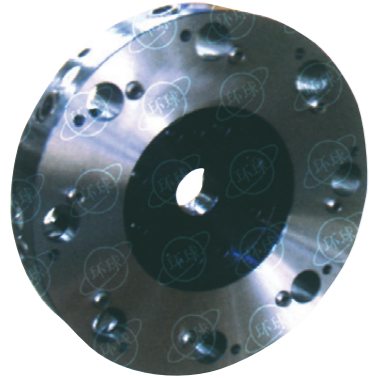
安装尺寸参数：DIMENSIONAL PARAMETER

型号	参数	A	B	C	D	E	F	G	H	I	冷却水口 Coolant	电缆接口 Electric conection
AK3180		210	240	394	80	170	207	40h5	17g6	190	G3/8" G1/2" G3/4"	M20X1.5
AK31100		250	280	451.5	100	190	247	50h5	20g6	220		
AK31125		310	320	470.5	125	230	310	63h5	26g6	280		
AK31160		390	410	656	160	270	390	80h5	32g6	352		
AK31200		470	480	693.5	200	358	465	100h5	/	420		

型号	参数	J	K	L	M	N	P	S	T	X	Y	Z	螺纹孔 Screws
AK3180		36	22	32	32	8	20	23	7.5	10-11	M10X20	120	8-M8深15
AK31100		41	25	40	30	9	25	32	9	10-13	M10X24	145	12-M10深18
AK31125		52	30	44	43	10	26	34	9	10-17	M12X24	182	12-M12深22
AK31160		56	40	48	/	10	30	36	9	10-22	M24X42	220	12-M12深30
AK31200		56	48	60	/	12	50	40	/	10-26	M30X42	300	12-M16深30

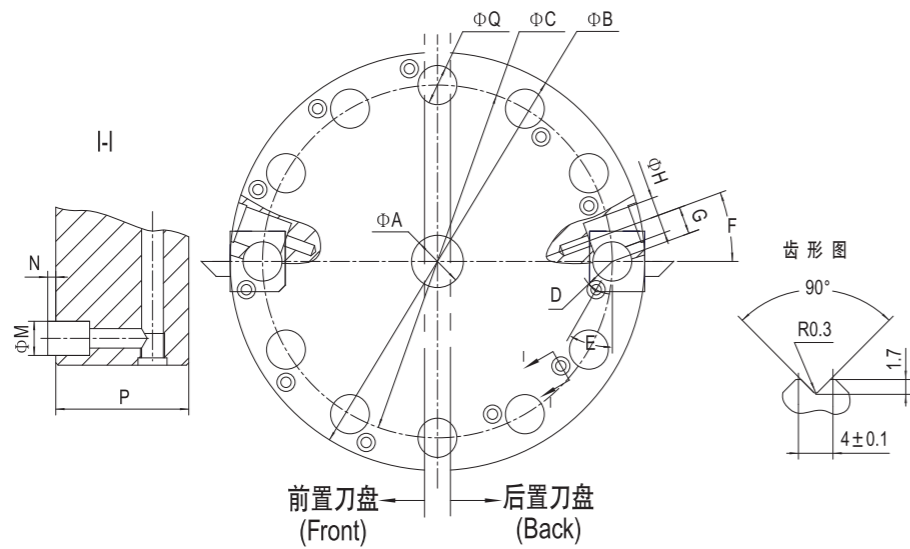


AK31系列VDI系列刀盘 AK31 SERIES VDI TURRET DISK



● 本产品是AK31系列数控转塔刀架的配套产品，也可以用于其它厂家生产的数控刀架。

● This product is for the AK31 series NC turret, also can be used on NC turret manufactured by other factories.



主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

mm

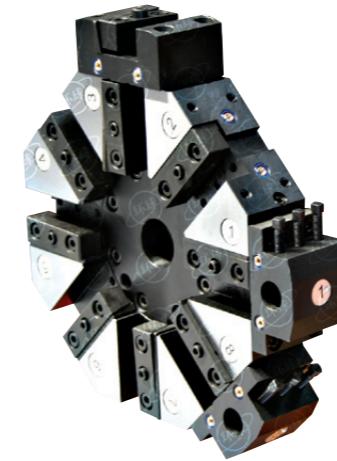
型号Type	A	B	C	D	E	F
AK3180A	40H5	320	270	R25 ± 0.02	30° ± 3'	20°
AK31100A	50H5	400	340	R32 ± 0.02	30° ± 3'	20°
AK31125A	63H5	473	405	R37 ± 0.02	30° ± 3'	25°
AK31160A	80H5	560	460	R48 ± 0.02	30° ± 3'	25°
AK31200A	100H5	740	620	R65 ± 0.02	30° ± 3'	20°

型号Type	G	H	M	N	P	Q
AK3180A	21	28 ^{+0.05} ₀	13.95 ± 0.02	6	56	30H6
AK31100A	24.7	28 ^{+0.05} ₀	13.95 ± 0.02	6	64	40H6
AK31125A	32	40 ^{+0.05} ₀	15.9 ± 0.02	6	79	50H6
AK31160A	39	50 ^{+0.05} ₀	15.9 ± 0.02	6	95	60H6
AK31200A	51	60 ^{+0.05} ₀	19.9 ± 0.02	6	126	80H6

注：以上参数以实物为准，如有变动最终解释权归本公司。

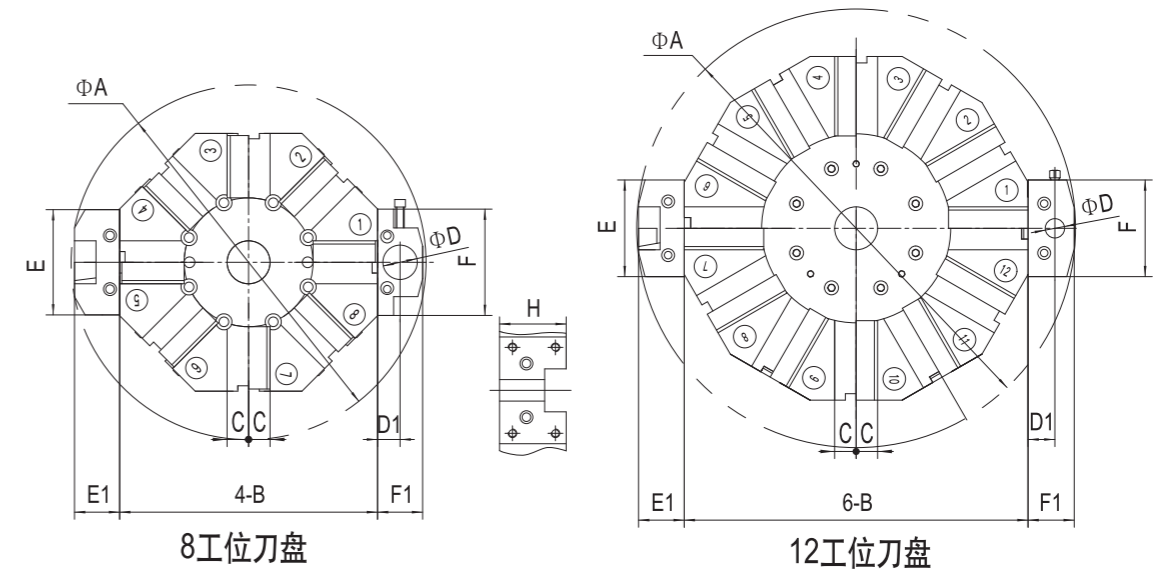


AK31系列刀盘 AK31 SERIES TURRET DISK



● 本产品是AK31系列数控转塔刀架的配套产品。该产品具有双向夹刀，双向出水之特点。

● This product is for the AK31 series NC turret. It can hold tools and cool down in double directions.



主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

mm

型号	参数	A	B	C	D	D1	E	E1	F	F1	H	H1
AK3180X8A-2H		339	240	20	(18)	25	90	48	80	48	60	
*AK3180X8A-2M		332	240	20	(28)	22.5	98	42	98	45	60	
*AK3180X8A-10		374	275	25	(22)	22.5	99	45	99	45	60	
*AK3180X8A-2SN1		430	306	25	40H7	32	106	57	106	60	70	
*AK3180X12-2G		408.4	320	20	(18)	25	90	42.5	85	43	60	
AK3180X12A-2H		369	270	20	(22)	25	-	-	90	48	70	

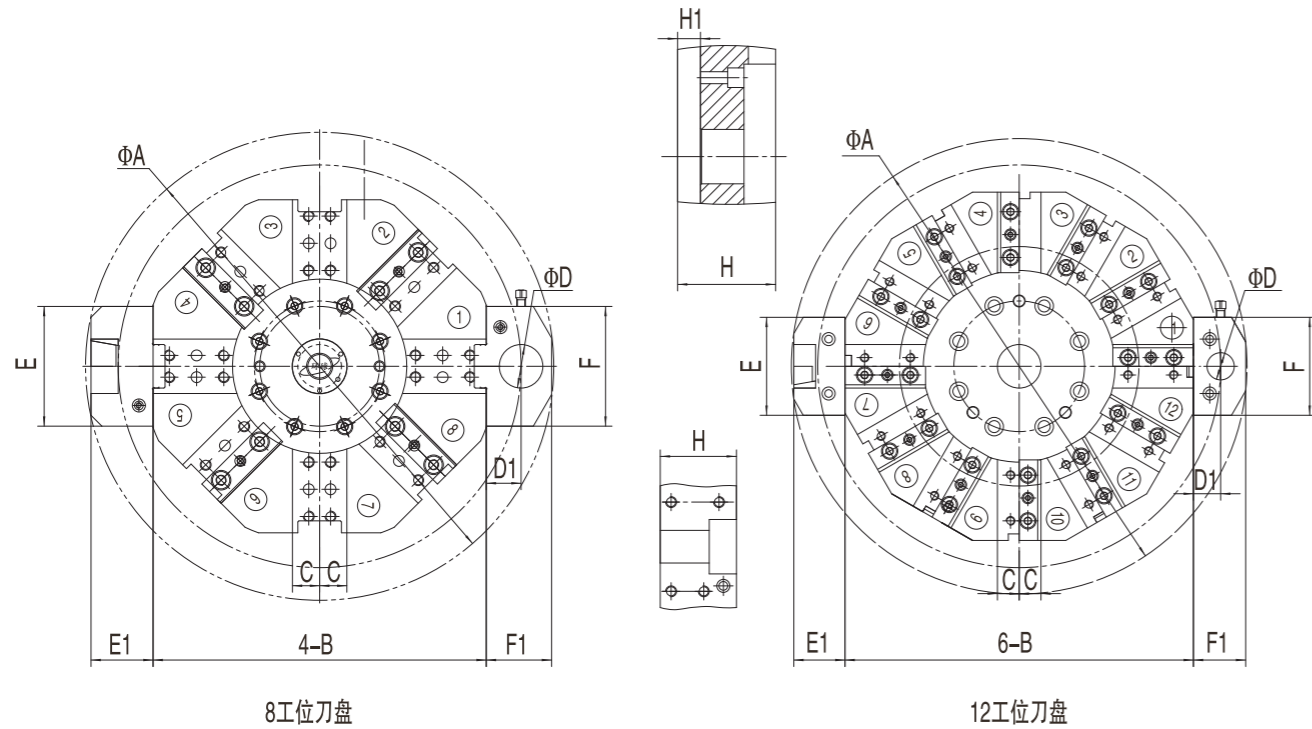
注：() 内尺寸为毛尺寸

注：以上参数以实物为准，如有变动最终解释权归本公司。

注：*为优先推荐选用刀盘



AK31系列刀盘 AK31 SERIES TURRET DISK



8工位刀盘

12工位刀盘

主要规格和参数: MAIN SPECIFICATIONS AND PARAMETER

mm

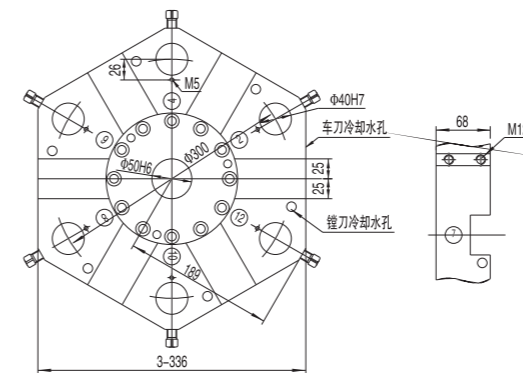
型号	参数	A	B	C	D	D1	E	E1	F	F1	H	H1
*AK31100X8A-10		466	330	25	(37)	35	134	60	130	62	70	
AK31100X8A-2NW1		522.4	360	32	50H7	40	120	65	120	80	90	21
AK31100X8A-2DZ		532	400	25	(38)	35	130	60	130	65	85	
AK31100X8A-10YJ		450	330	25	(28)	35	134	55	130	58	70	
AK31100X12A-2DZ		532	400	25	(28)	35	100	60	100	65	85	
AK31100X12A.10		472	375	25	(22)	22.5	99	45	99	45	60	
*AK31125X8A-10		513	350	32	(37)	40	120	72	120	80	90	
AK31125X8A-2XR		572	410	32	40H7 50H7 60H7	40	150	40	120	80	120	
*AK31125X12A-2DZ		642	480	32	(59)	40	120	57	120	80	110	

注: 以上参数以实物为准, 如有变动最终解释权归本公司
注: *为优先推荐选用刀盘。

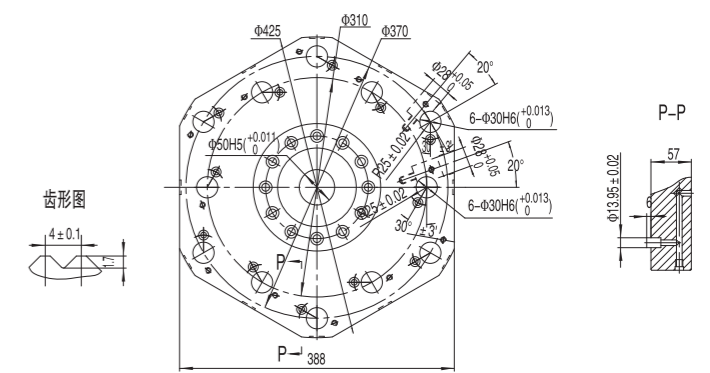


AK31系列特殊刀盘 AK31 SERIES TURRET DISK

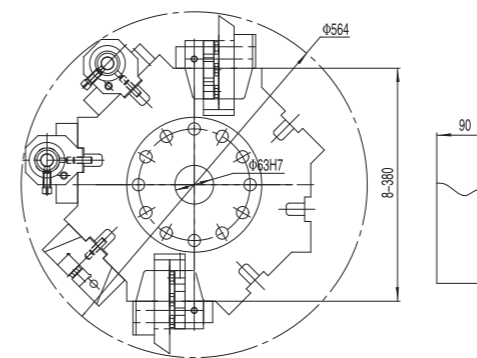
*AK31100X12A-2B刀盘尺寸图



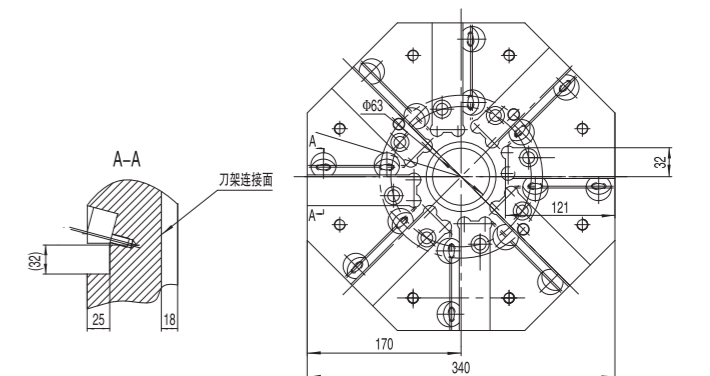
*AK31100X12A-2DMG刀盘尺寸图



AK31125X8A-2YN刀盘尺寸图



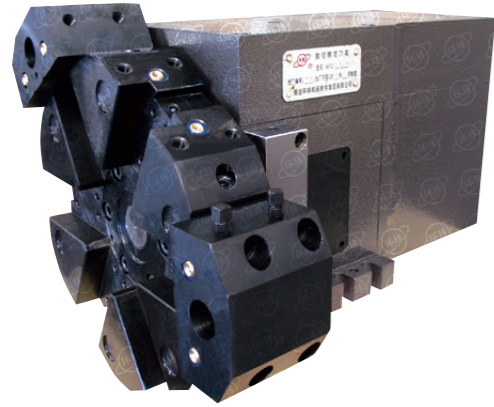
*AK31125X8A-2DLJC1刀盘尺寸图



注: *为优先推荐选用刀盘



AK30系列数控转塔刀架 AK30 SERIES NC TURRET



- 本产品是数控车床的重要功能部件，特别适用普及型数控车床，可多刀夹持，实现加工程序的自动化、高效化。
- 它采用端面齿盘作为分度元件，分度工位由定位盘、机械编码器控制，可任意工位定位。具有精度高、稳定可靠、应用范围广、结构简单、维修方便等特点。

● AK30 series NC turret is an important accessory for NC lathe and especially applicable for all-pervading NC lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of operational procedures can be realized.

● It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a positioning face gear and an encoder. So it features high accuracy, reliability, compact design.

主要规格和参数: MAIN SPECIFICATIONS AND PARAMETER

型号 Type	中心高 Center height (mm)	工位数 No. of position (个)	单位换刀时间 Time of changing tool(s)	最大锁紧力 Max. clamping force (N)	工作可靠性 Reliability of working (h)	电机参数 Motor parameter	刀架净重 (带3个刀夹) Net weight (Kg)	刀架毛重 (带3个刀夹) Gross weight (Kg)	箱体尺寸 (长x宽x高) Packing dimension(mm)
AK3063X6J	63	6	3	20000	>3000	120W 1400r/min	50	59	430 × 354 × 390
AK3080X6J	80	6	3	25000		120W 1400r/min	65	78	500 × 450 × 450
AK3080X8J		8					73	86	
AK30100X6J	100	6	2.85	25000		3N·m 力矩电机 Torque motor	113	135	580 × 560 × 560
AK30100X8J		8			115		137		

精度检验: ACCURACY TESTING

序号 No.	项目 Items	允差 (mm)	序号 No.	项目 Items	允差 (mm)
1	装刀基面对刀架底面的平行度 The parallelism of packing knife face to the bottom face of NC turret	0.100	4	在垂直平面内, 加力F时的最大残余变量 Residual deformation in vertical	0.015
2	重复定位精度 Repeatability accuracy	0.005	5	在水平面内, 加力F1时的最大弹性变量 Max. elastic deformation in horizontal	0.050
3	在垂直平面内, 加力F时的最大弹性变量 Max. elastic deformation in vertical	0.050	6	在水平面内, 加力F1的最大残余变量 Max. elastic deformation in horizontal	0.015

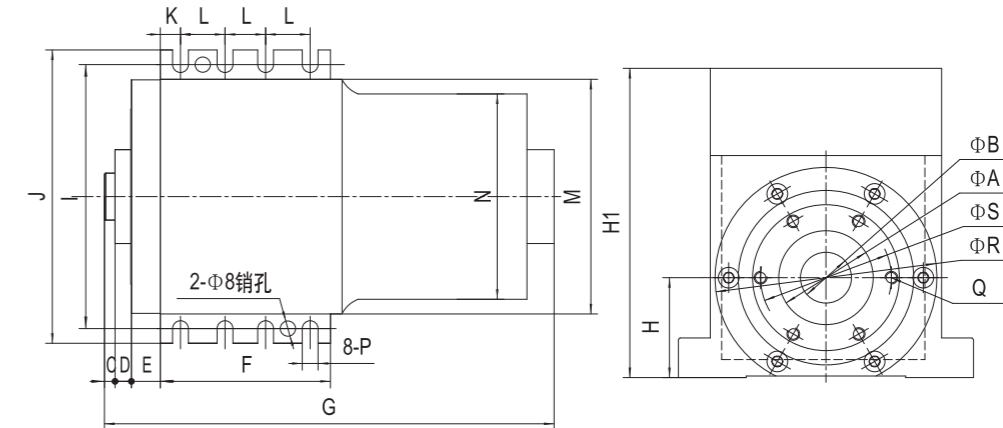
注: AK3063 F=800Nm F1=400Nm; AK3080 F=1000Nm F1=500Nm; AK30100 F=1500Nm F1=800Nm

注: 以上参数以实物为准, 如有变动最终解释权归本公司。

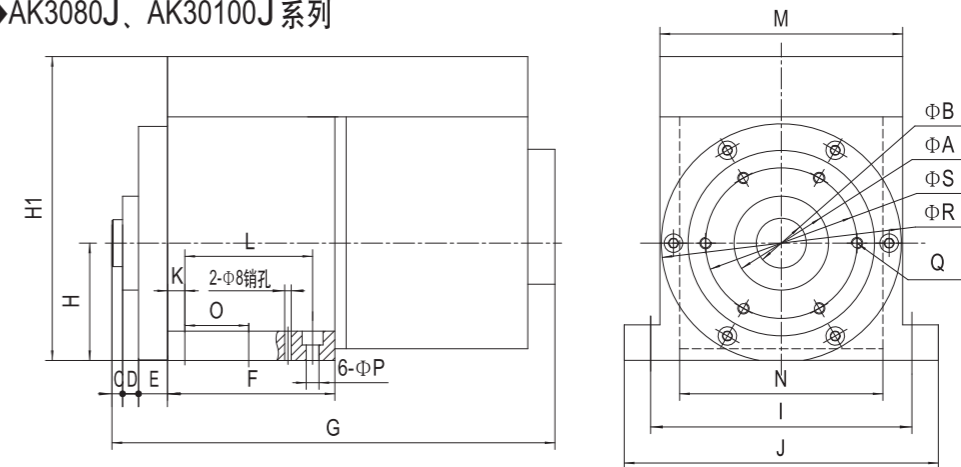


AK30系列数控转塔刀架 AK30 SERIES NC TURRET

◆AK3063J系列



◆AK3080J、AK30100J系列



安装尺寸参数: DIMENSIONAL PARAMETER

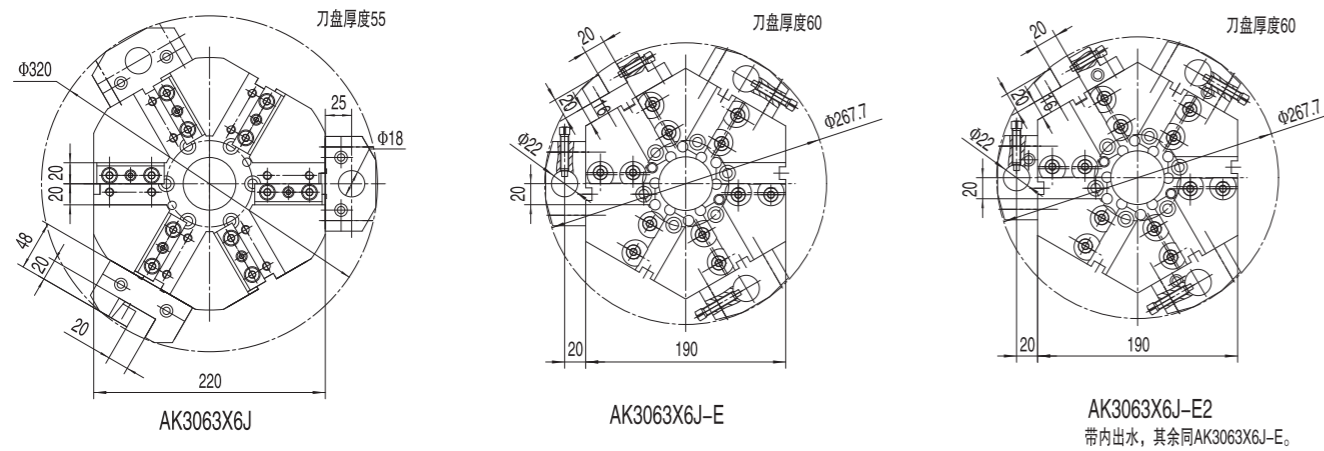
型号	参数	A	B	C	D	E	F	G	H	H1	I
AK3063X6J		58	30	8	11	18	130	348	63	195	165
AK3080X _{6J} 8J		70	30	8	11	18	137	364	80	214	195
AK30100X _{6J} 8J		80	40	9	13	24.5	145	381	100	259	225

型号	参数	J	K	L	M	N	O	P	Q	R	S
AK3063X6J		180	19	30	145	123	/	11	6-M8	139	103
AK3080X _{6J} 8J		220	11	115	170	140	64	11(沉孔Φ18)	6-M8	169	129
AK30100X _{6J} 8J		250	20	110	200	160	70	11(沉孔Φ18)	8-M8	199	150

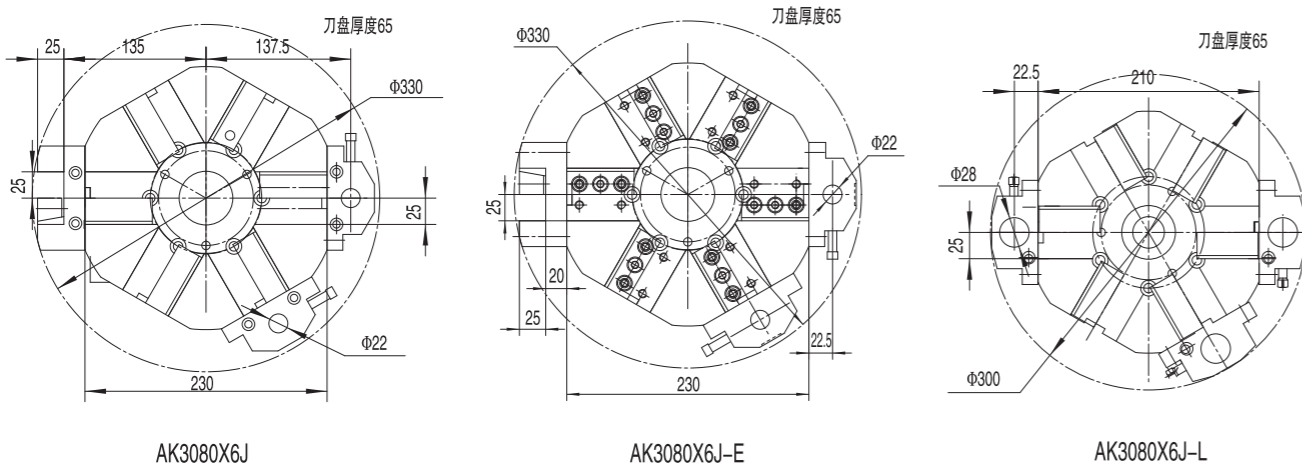
AK30系列刀盘

AK30 SERIES TURRET DISK

◆ AK3063系列



◆ AK3080系列

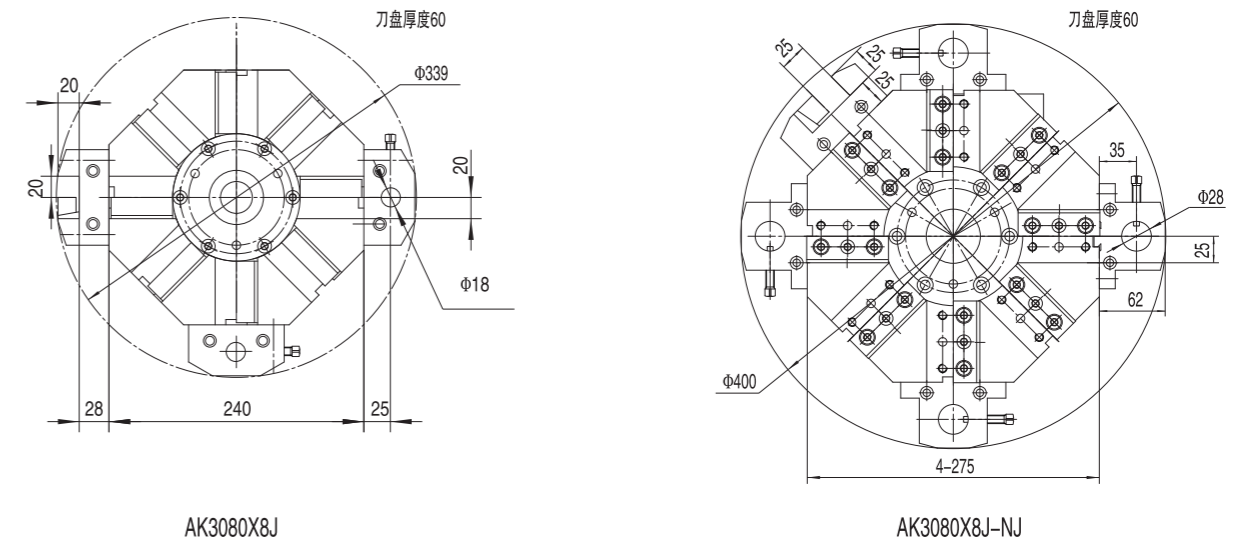


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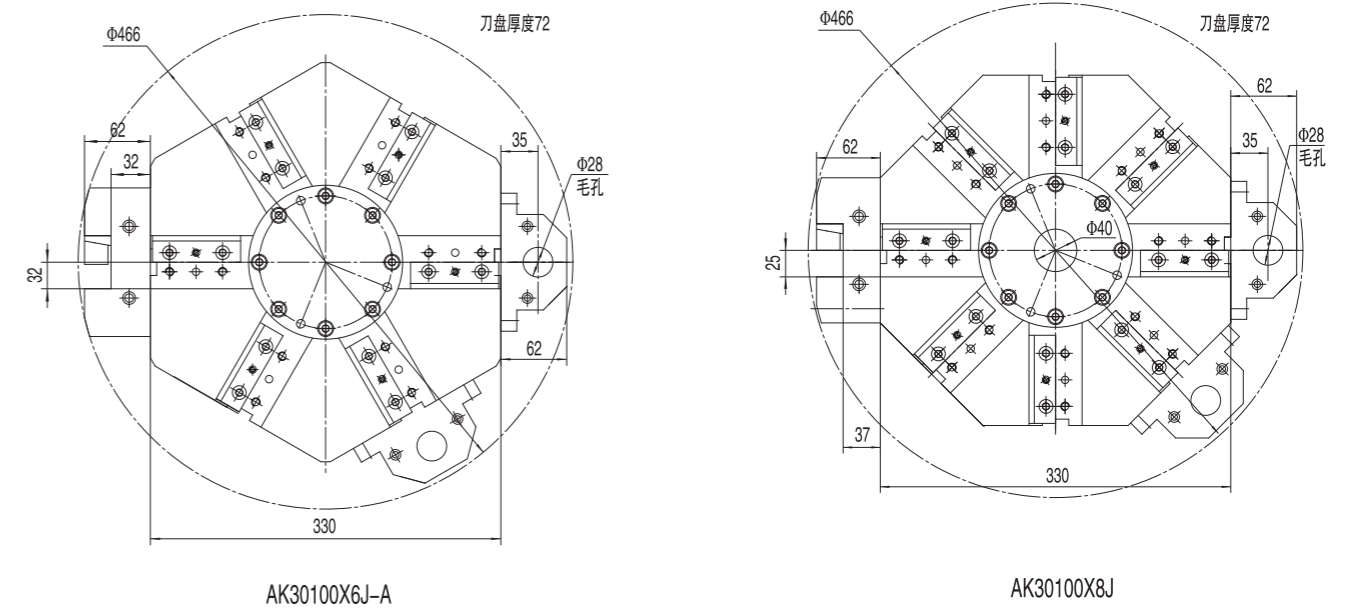
AK30系列刀盘

AK30 SERIES TURRET DISK

◆ AK3080系列



◆ AK30100系列

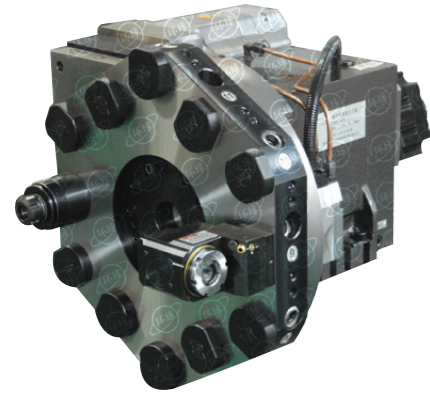


注：以上参数以实物为准，如有变动最终解释权归本公司。



AK33系列数控转塔动力刀架

AK33 SERIES LIVING TOOL NC TURRET



●AK33系列数控转塔动力刀架是我公司在AK36系列液压伺服刀架基础上增加动力模块，自行研发的新型转塔动力刀架。此刀架作为全功能数控机床的重要功能部件，能极大提升机床的加工能力及加工效率。

●本刀架采用端齿盘（三联齿盘）作为分度及定位元件，具有结构紧凑、定位精度高，可靠性好，双向回转和任意刀位就近选刀等特点。

●刀盘及各种辅助刀夹（动力刀夹、车刀夹、镗刀夹、弹簧夹头、莫氏刀柄）可根据客户要求特殊定做。

●AK33 series NC turret is designed by ourselves. It is designed to hold several tools; bidirectionally index and position in the shortest path. Thus automation and high efficiency of operational procedures can be realized.

●It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a binary absolute encoder. It features compact design; high flexibility; high accuracy and reliable performance. With the matching disc, and various supplementary tool holder, such complicated work procedures as turning, boring, drilling, and milling can be accomplished.

●Turret disc and tool holder (such as turning holder, boring tool holder, collet and Morse tool shank) are on special orders.

主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

序号No.	项目Items		AK3380D	AK33100D	AK33125D
1	中心高Center height	(mm)	80	100	125
2	工位数No. of working positions	(个)	8/12	12	12
3	刀孔定位精度Angular accuracy		± 6"	± 6"	± 6"
4	重复定位精度Repeatability		± 2"	± 2"	± 2"
5	30° 转位时间Time for 30° rotation	(s)	0.1	0.15	0.32
6	30° 转位并夹紧时间Time for 30° rotation and clamping	(s)	0.34	0.45	0.95
7	180° 转位并夹紧时间Time for 180° rotation and clamping	(s)	1.54	1.0	2.5
8	最大不平衡重力矩Max unbalanced load torque	(N · m)	15	40	60
9	分度频数Indexing frequency	(n/h)	750	750	750
10	最大转动惯量Max. inertia of mass	(kg · m)	1.3	4.5	1
11	最大载重Max. load capacity	(kg)	40	120	160
12	动力模块	刀柄直径(DIN 69880 VDI tool shank size)	Φ30	Φ30	Φ50
		刀具接口 Coupling	DIN 5482	DIN 5482	DIN 5482
		传动比Transmission ratio	1:1	1:1	1:1
		最高转速(r/min) Max. speed	5000	4000	3000
		最大扭矩(N.m) Max. torque	20	40	60
	最高功率(Kw) Max. power	6	8	10	
13	可配动力刀夹数No. of Rotating tool holders		12	12	12
14	冷却水口Coolant in		G1/4"	G1/4"	G1/4"
15	工作油压	Mpa	2-2.5	2-2.5	2-2.5
16	刀架净重 Net weight	kg			
17	刀架毛重Gross weight	kg	185	245	450
18	箱体尺寸(长×宽×高) Packing dimension	(mm)			

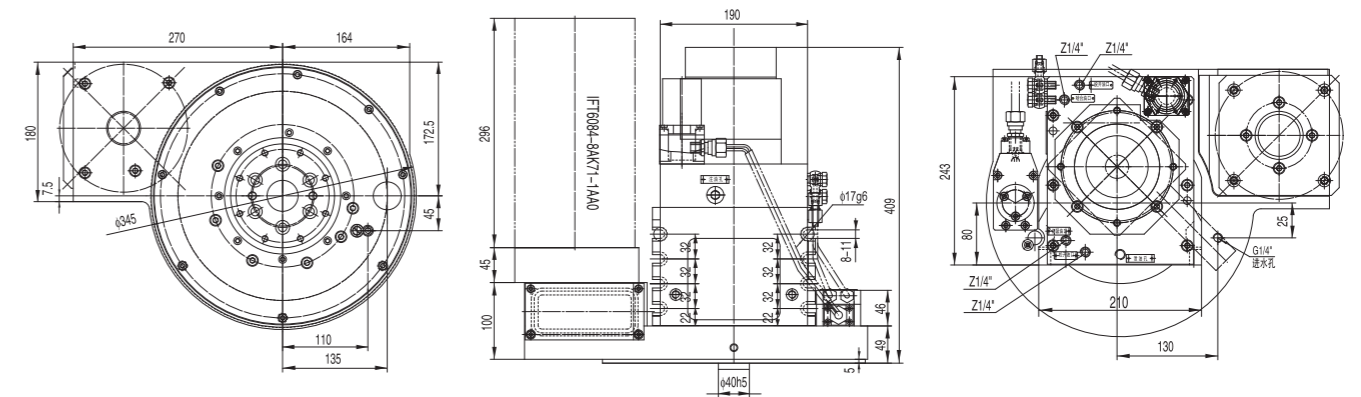
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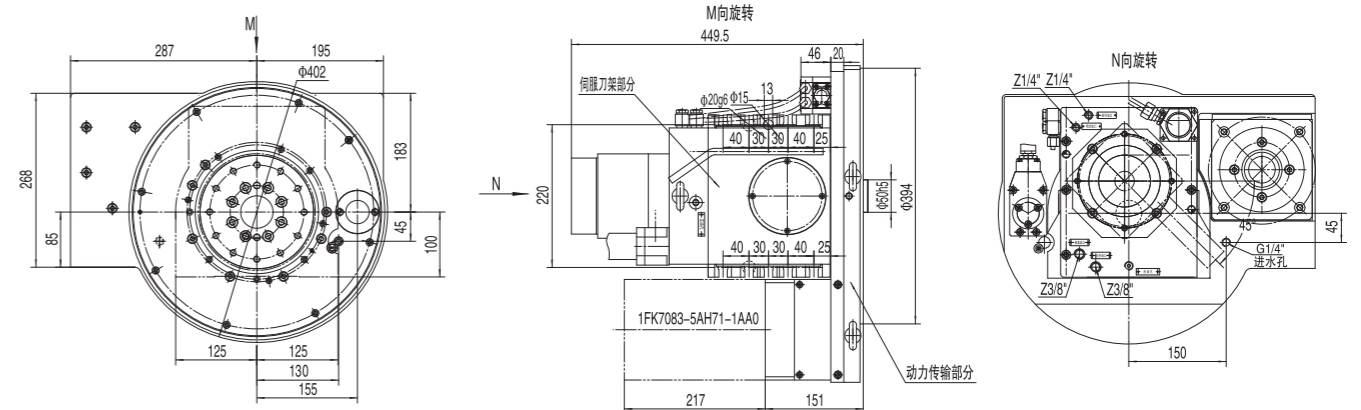
AK33系列数控转塔动力刀架

AK33 SERIES LIVING TOOL NC TURRET

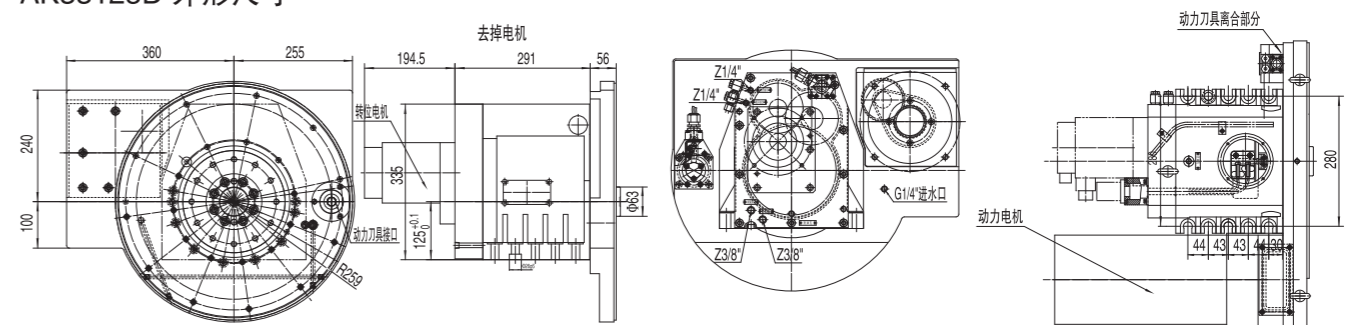
AK3380D 外形尺寸



AK33100D 外形尺寸



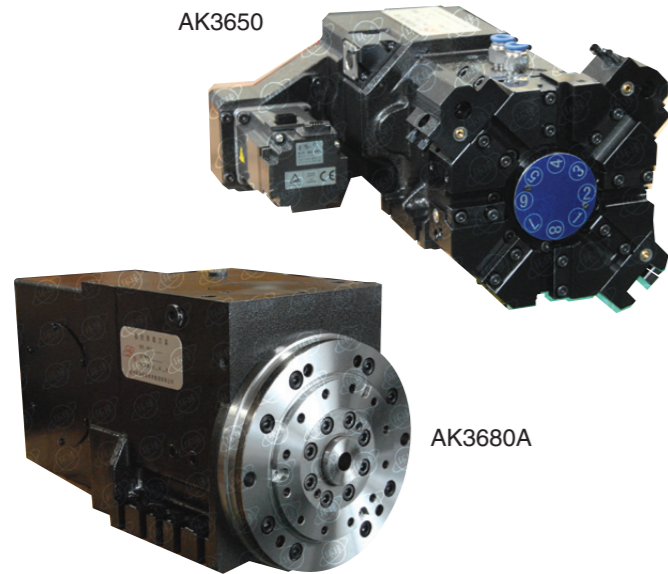
AK33125D 外形尺寸





AK36系列数控转塔刀架

AK36 SERIES NC TURRET



●本刀架系我公司根据市场需求多样化,提高产品可靠性而自行开发的一种以伺服电机进行分度,靠压力油松开,刹紧的一种新型刀架,以端齿盘进行精密定位,可实现双向转位和任意刀位就近选刀。具有定位精度高,结构紧凑,转位速度快,可承受较大切削力,适用范围广等特点。

●This type turret is designed by ourselves,depending on the various of the market demand,to lift the reliability of the product.This new product indexing with servo motor,clamping and unclamping with oil ,minutely orientating with a face gear,can rotate in two sides and choose tool in the shortest distance. It features high accuracy;reliability;more load and wide application.

主要规格和参数: MAIN SPECIFICATIONS AND PARAMETER

序号 No.	项目 Items	AK3650	AK3663	AK3680A	AK36100A	AK36125A	AK36160A
1	中心高Center height (mm)	50	63	80	100	125	160
2	工位数No.of working positions (个)	8	8	8或12	8或12	8或12	8或12
3	最大转动惯量Max.interia of mass (kg · m ²)	0.2	0.8	1.3	4.5	7.5	15
4	30° 转位时间Time for 30° rotation (s)	-	-	0.16	0.15	0.27	0.3
5	30° 转位并刹紧时间Time for 30° rotation and clamping (s)	-	-	0.5	0.45	0.8	0.9
6	45° 转位时间Time for 45° rotation (s)	0.1	0.15	0.29	0.2	0.45	0.75
7	45° 转位并刹紧时间Time for 45° rotation and clamping (s)	0.2	0.25	0.67	0.5	1.1	1.75
8	180° 转位并刹紧时间Time for 180° rotation and clamping (s)	0.5	0.7	1.54	1	2.5	2.44
9	最大不平衡重力矩Max unbalanced load torque (N · m)	7.5	10	15	40	60	160
10	分度频数Indexing frequency (n/h)	60(rev/min)	60(rev/min)	750	750	750	600
11	最大载重Max.load capacity (kg)	15	30	40	120	160	380
12	定位分度精度Indexing accuracy	±6"	±6"	±6"	±6"	±6"	±6"
13	重复定位精度Repeatability	±2"	±2"	±2"	±2"	±2"	±2"
14	系统压力System pressure (MPa)	2.5-3.0	2.5-3	2-2.5	2-2.5	2-2.5	2-2.5
15	刀架净重Net weight kg	不带刀盘Without disk	20.5	75	177		
		带刀盘 With disk	27				
16	刀架毛重Gross weight kg	不带刀盘Without disk	42	95	202	400	
		带刀盘 With disk	75				
17	箱体尺寸(长×宽×高) Packing dimension cm	50×38×38					

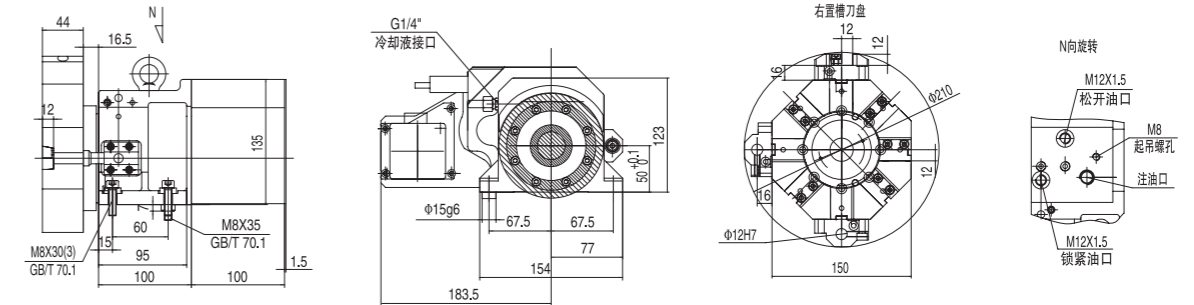
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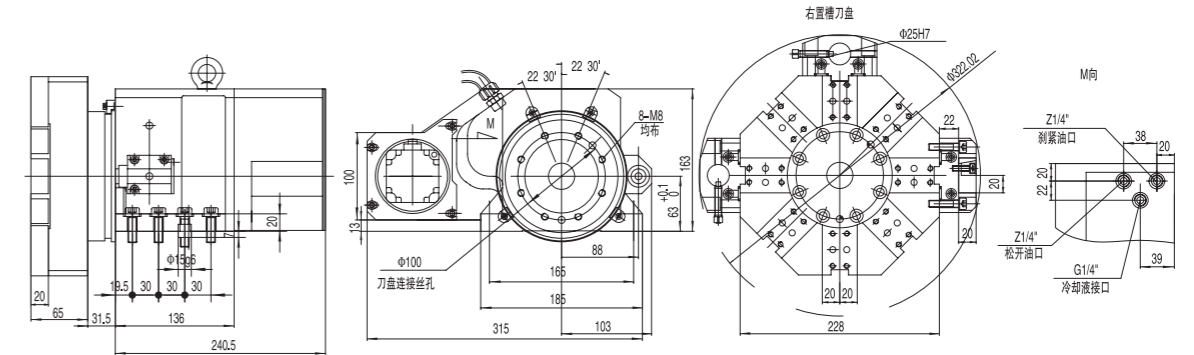
AK36系列数控转塔刀架

AK36 SERIES NC TURRET

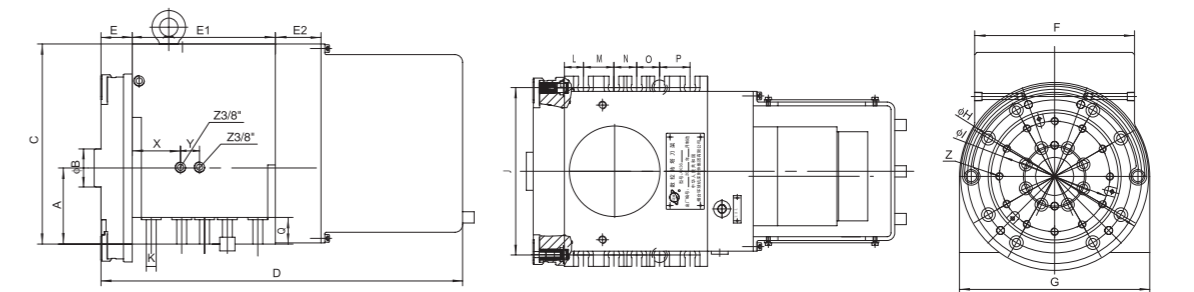
AK3650外形尺寸



AK3663外形尺寸



AK3680A, AK36100A, AK36125A, AK36160A外形尺寸



安装尺寸参数: DIMENSIONAL PARAMETER

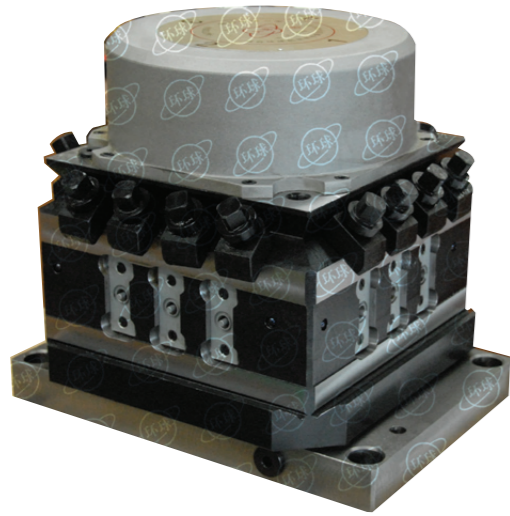
型号	参数	A	B	C	D	E	E1	E2	F	G	H	I	J	K
AK3680A		80	40	243	430.5	36	152.5	56	190	210	208	120	190	8-12
AK36100A		100	50	263	455	41	188	60	210	250	247	145	220	10-13
AK36125A		125	63	335	551.5	52	230	60	190	310	310	182	280	10-17
AK36160A		160	80	405	665.5	56	270	70	240	390	390	220	352	10-22

型号	参数	L	M	N	O	P	Q	X	Y	Z
AK3680A		22	32	32	32	/	20	58	26	8-M8
AK36100A		25	40	30	30	40	32	60	35	12-M10
AK36125A		30	44	43	43	44	34	82	38	12-M12
AK36160A		40	48	56	48	48	36	100	41	16-M12



AK27(VDI)系列数控转塔刀架

AK27(VDI) SERIES NC TURRET



●本产品是数控车床的重要功能部件，特别适用于普及型数控立车、大型卧车；可多刀夹持，实现加工程序的自动化、高效化。

●它采用了国际上流行的电机内藏式结构，端齿盘作为分度元件，分度工位由定位盘、传感器元件控制，可任意工位定位；具有定位精度高、锁紧力大、承载力强、稳定可靠、应用范围广、结构紧凑等特点。

主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

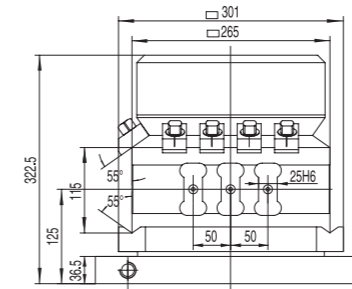
序号No.	项目Items	AK27300×4D	AK27320×6D	AK27380×4-SH	AK27400×4D
1	刀方尺寸(刀夹安装面)Dimension of turret square (mm)	265	284	336	400
2	装刀中心高Height of datum plan (mm)	125	125	160	196
3	单工位换刀时间Time of changing tool per position (s)	4	3.5	6.5	8.5
4	最大锁紧力Max.clamping force (KN)	27.5	27.5	60	100
5	电机力矩Torque of motor (Nm)	5	5	6.4	9.4
6	刀架净重Net weight of turret (kg)	122			430
7	刀架毛重Gross weight of turret (kg)	132			400
8	箱体尺寸Packing dimension (cm)	50×39×45	50×45×45	60×48×48	60×73×54
9	重复定位精度Repeatability (mm)	≤0.005	≤0.005	≤0.005	≤0.005
10	上加力矩Torque in vertical (Nm)	4000	4000	5500	6300
11	上加力弹性变形量Max elastic deformation in vertical (mm)	≤0.060			
12	上加力残余变形量Residual deformation in vertical (mm)	≤0.015			
13	切向加力矩Torque in horizontal (Nm)	2000	2000	3000	3200
14	切向力弹性变形量Max.elastic deformation in horizontal (mm)	≤0.060			
15	切向力残余变形量Residual deformation in horizontal (mm)	≤0.015			

注：以上参数以实物为准，如有变动最终解释权归本公司。

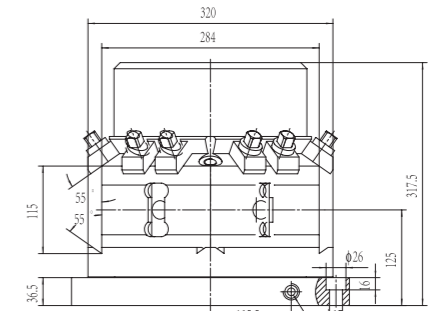


AK27(VDI)系列数控转塔刀架

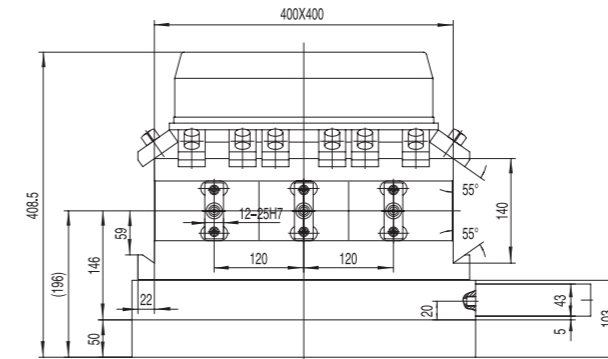
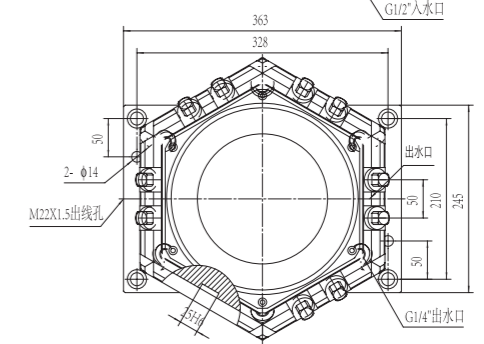
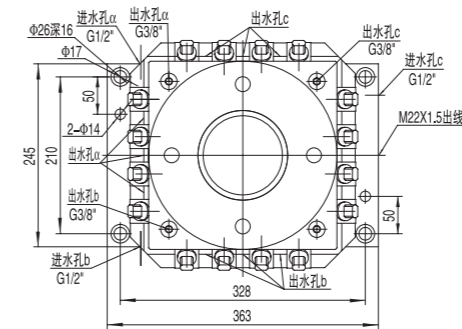
AK27(VDI) SERIES NC TURRET



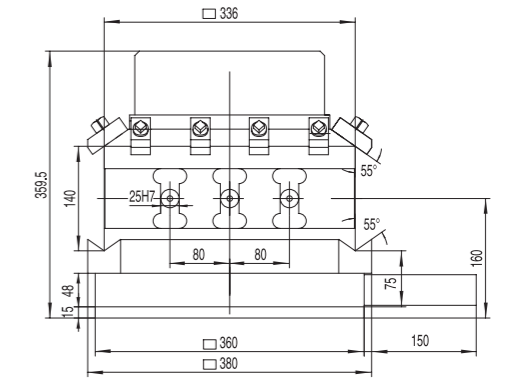
AK27300X4D



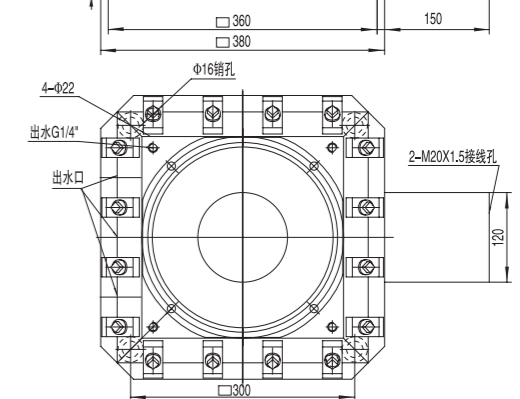
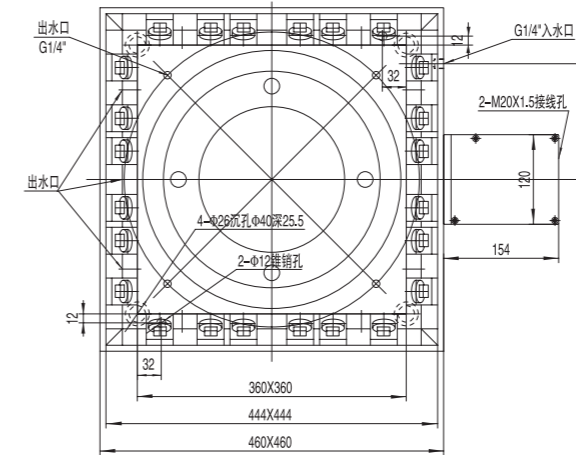
AK27320X6D



AK27400X4D



AK27380X4-SH

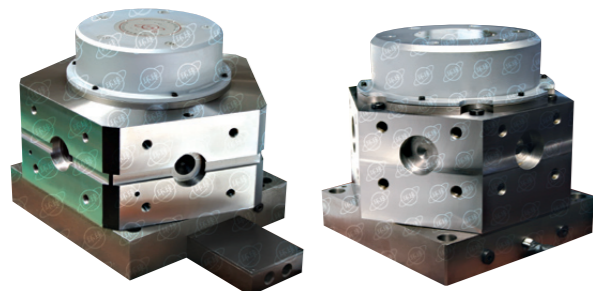
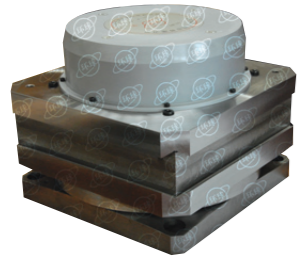




AK27直边系列数控转塔刀架

AK27 SERIES NC TURRET

AK27440 × 4C直边双燕尾



AK27380 × 5C1直边带接线盒 AK27300 × 6C直边转塔刀架

●AK27 series NC turret is an important accessory for NC lathe and especially applicable for NC vertical lathe and large NC horizontal lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of operational procedures can be realized.

●It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a positioning face gear and transducers. So it features high accuracy, reliability, wide application and compact design.

主要规格和参数: MAIN SPECIFICATIONS AND PARAMETER

序号No.	项目Items	AK27300 × 4C*	AK27300 × 6C*	AK27320 × 6B*	AK27380 × 5C1*	AK27380 × 6E*	AK27380 × 6D*	AK27440 × 4C*	AK27440 × 6QY
1	刀方尺寸Dimension of turret square (mm)	300	300	320	380	380	380	440	440
2	装刀中心高Height of datum plan (mm)	125	160	125	205	205	135	160	160
3	单工位换刀时间Time of changing tool per position (s)	4	3.5	4.6	6.2	5.5	5.5	8.5	8.5
4	最大锁紧力Max. clamping force (KN)	27.5	27.5	40	60	60	60	100	100
5	电机力矩Torque of motor (Nm)	5	5	5	6.4	6.4	6.4	9.4	9.4
6	刀架净重Net weight of turret (kg)	140	149		260	254		312	311
7	刀架毛重Gross weight of turret (kg)	155	155		282	275	220	337	336
8	箱体尺寸Packing dimension (cm)	58 × 46 × 47	59.5 × 46 × 46	58 × 46 × 44	74 × 53 × 51	74 × 53 × 51	61 × 48 × 50	68 × 58 × 50	60 × 60 × 48
9	重复定位精度Repeatability (mm)	≤ 0.005							
10	上加力矩Torque in vertical (Nm)	4000			5500			6300	
11	上加力弹性变形量Max elastic deformation in vertical (mm)	≤ 0.060							
12	上加力残余变形量Residual deformation in vertical (mm)	≤ 0.015							
13	切向加力矩Torque in horizontal (Nm)	2000			3000			3200	
14	切向力弹性变形量Max. elastic deformation in horizontal (mm)	≤ 0.060							
15	切向力残余变形量Residual deformation in horizontal (mm)	≤ 0.015							

注: ()内尺寸为毛尺寸。

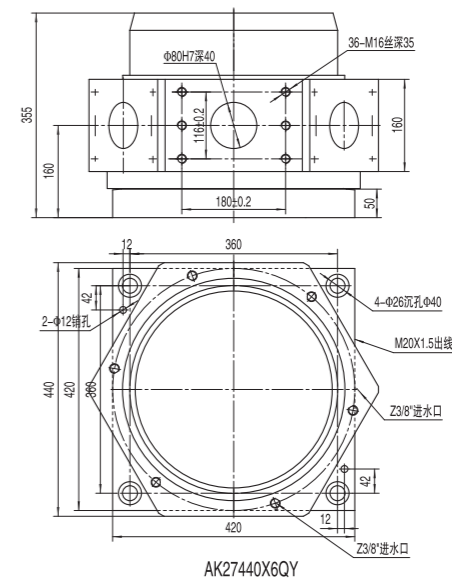
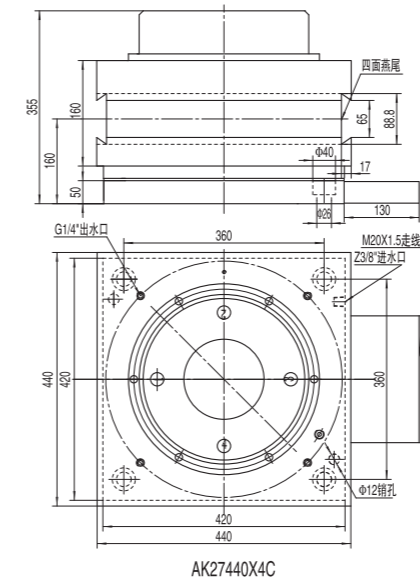
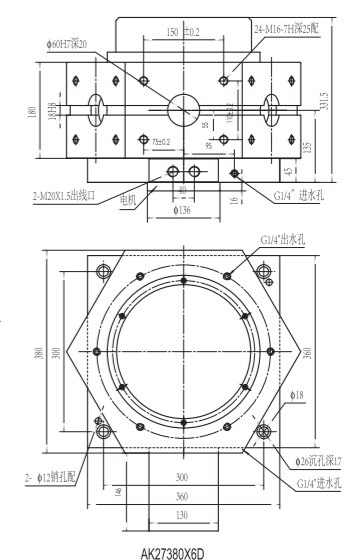
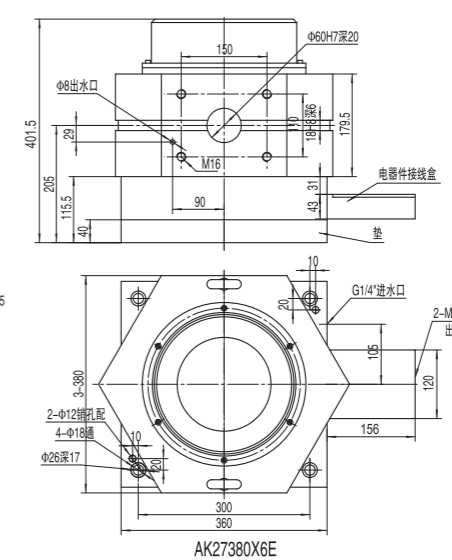
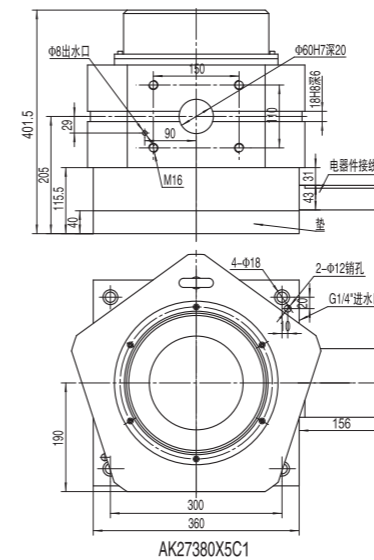
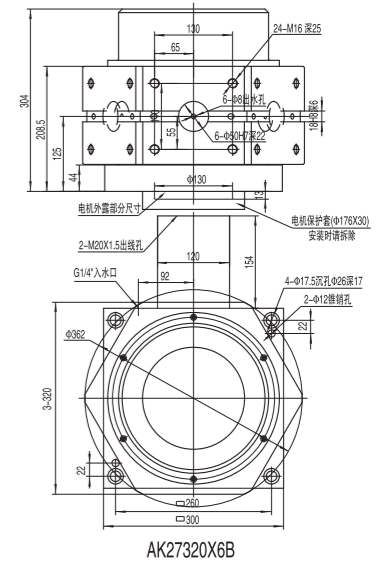
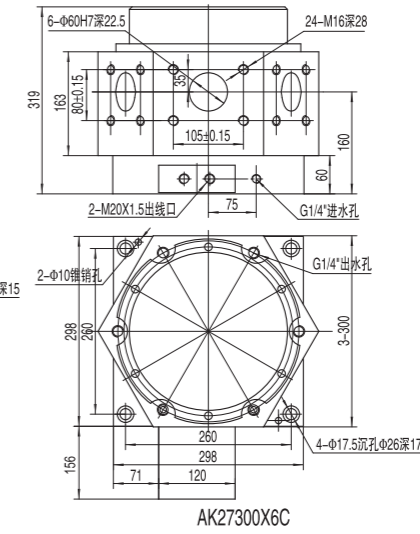
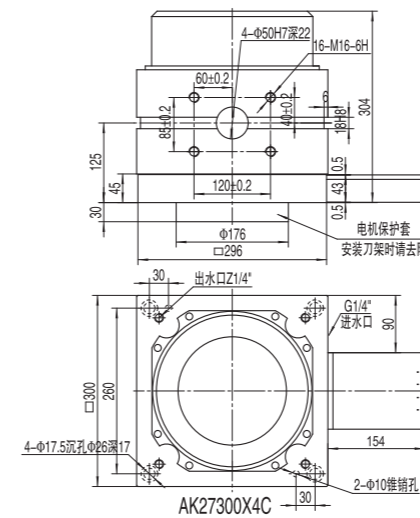
带*者为带接线盒。AK27440 × 4C为直边双燕尾。

注: 以上参数以实物为准, 如有变动最终解释权归本公司。



AK27直边系列数控转塔刀架

AK27 SERIES NC TURRET





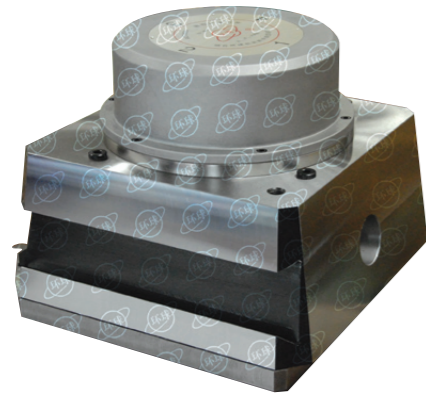
AK27斜8° 双燕尾系列数控转塔刀架

AK27 SERIES NC TURRET

4边双燕尾



3边燕尾1边光孔



● 本产品是数控车床的重要功能部件，特别适用于普及型数控立车、大型卧车；可多刀夹持，实现加工程序的自动化、高效化。

● 它采用了国际上流行的电机内藏式结构，端齿盘作为分度元件，分度工位由定位盘、传感器元件控制，可任意工位定位；具有定位精度高、锁紧力大、承载力强、稳定可靠、应用范围广、结构紧凑等特点。

主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

序号No.	项目Items	AK27320 × 4QY5	AK27320 × 5QY	AK27380 × 4C	AK27380 × 4QY5	AK27380 × 6QY	AK27450 × 4D
1	刀方尺寸Dimension of turret square (mm)	320	320	380	380	380	450
2	装刀中心高Height of datum plan (mm)	90	90	95	95	95	105
3	单工位换刀时间Time of changing tool per position (s)	6.5	6.5	6.5	6.5	5.5	8.5
4	最大锁紧力Max.clamping force (KN)	40	40	60	60	60	100
5	电机力矩Torque of motor (Nm)	5	5	6.4	6.4	6.4	9.4
6	刀架净重Net weight of turret (kg)	116		175	175		
7	刀架毛重Gross weight of turret (kg)	133		230	195		
8	箱体尺寸Packing dimension (cm)	44 × 44 × 40	50 × 50 × 48.5	50 × 46 × 48	50 × 46 × 48	50 × 46 × 48	58 × 58 × 51.5
9	重复定位精度Repeatability (mm)	≤0.005	≤0.005	≤0.005	≤0.005	≤0.005	≤0.005
10	上加力矩Torque in vertical (Nm)	4000	4000	5500	5500	5500	6300
11	上加力弹性变形量Max elastic deformation in vertical (mm)	≤0.06					
12	上加力残余变形量Residual deformation in vertical (mm)	≤0.015					
13	切向加力矩Torque in horizontal (Nm)	2000		3000		3000	3200
14	切向力弹性变形量Max.elastic deformation in horizontal (mm)	≤0.06					
15	切向力残余变形量Residual deformation in horizontal (mm)	≤0.015					

注：()内尺寸为毛尺寸。

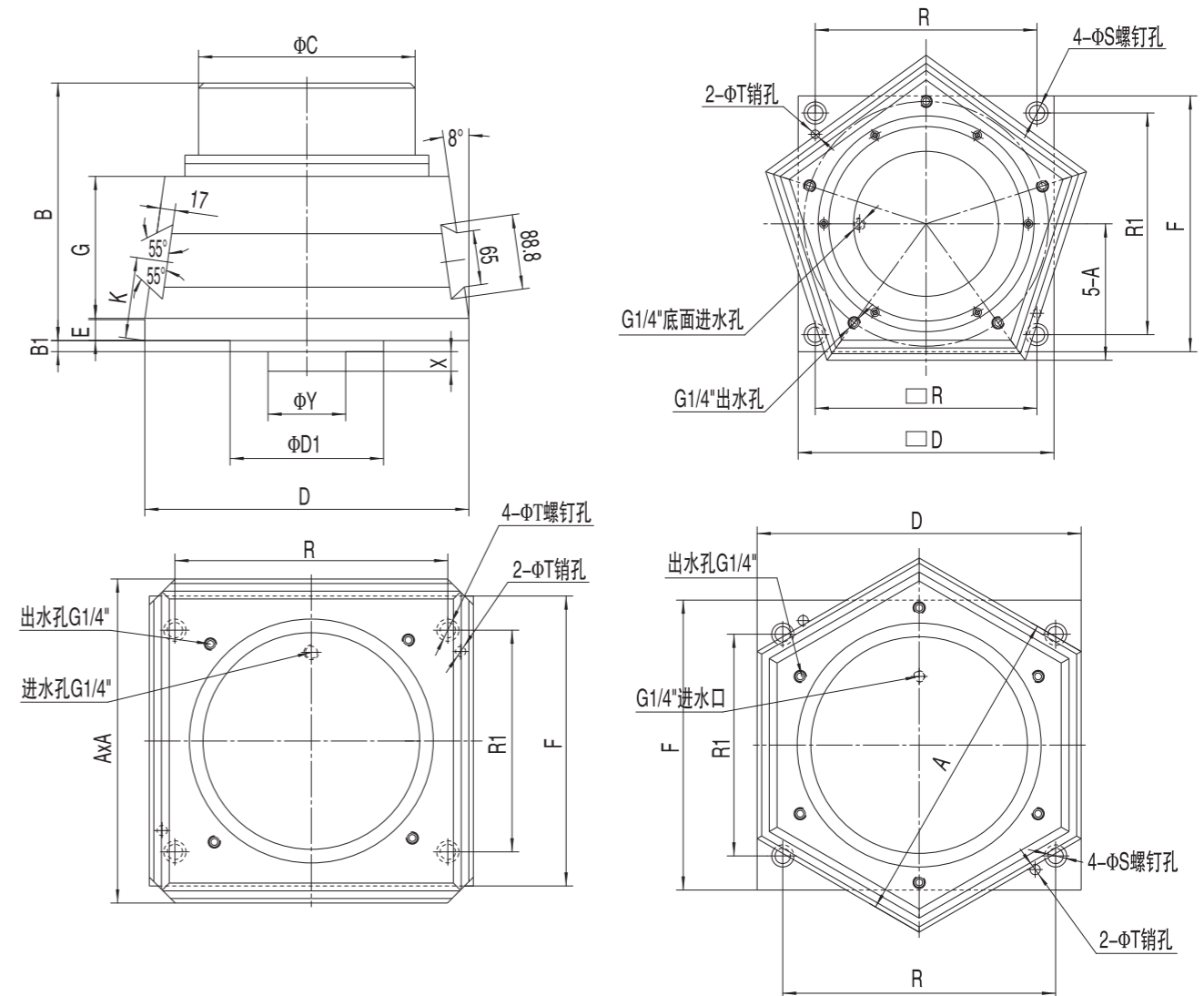
AK27380 × 4C为3边燕尾 1边光孔(Φ55)。其余为4边燕尾。

注：以上参数以实物为准，如有变动最终解释权归本公司。



AK27斜8° 双燕尾系列数控转塔刀架

AK27 SERIES NC TURRET



安装尺寸参数：DIMENSIONAL PARAMETER

型号	参数	A	B	B1	C	D	D1	E	F	G	K	R	R1	S	T	X[注]	Y[注]
AK27320X4QY5		320	285	8	253	300	180h6	25.5	300	163.5	90	260	260	18	12	30	176
AK27320X5QY		160	285	8	253	300	180h6	25.5	300	163.5	90	260	260	18	12	30	176
AK27380X4C		380	305	13	254	380	180h6	25.5	340	166.5	95	320	260	18	12	30	176
AK27380X4QY5		380	305	13	254	380	180h6	25.5	340	166.5	95	320	260	18	12	30	176
AK27380X6QY		380	305	13	254	380	180h6	25.5	340	166.5	95	320	260	18	12	30	176
AK27450X4D		450	340	15	360	450	260h7	35	450	190	105.3	360	360	22	12	/	/

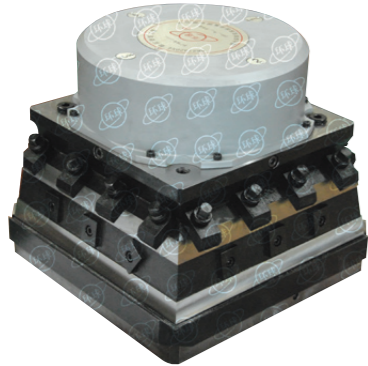
[注]：此尺寸参数为电机保护套的尺寸（非刀架安装定位部分）。



AK27斜8° (其它) 系列数控转塔刀架

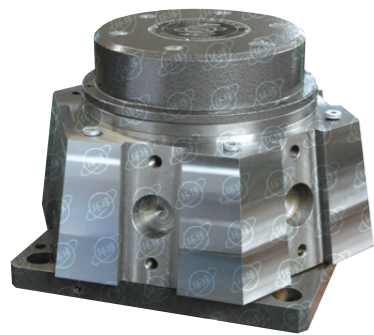
AK27 SERIES NC TURRET

单燕尾带压块

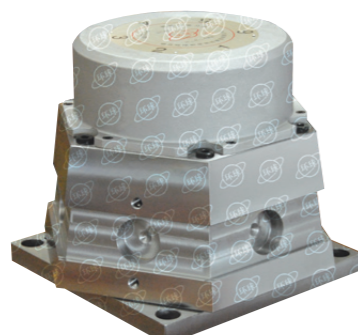


●AK27 series NC turret is an important accessory for NC lathe and especially applicable for NC vertical lathe and large NC horizontal lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of operational procedures can be realized.

●It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a positioning face gear and transducers. So it features high accuracy, reliability, wide application and compact design.



斜8° 竖键槽



斜8° 横键槽

主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

序号No.	项目Items	AK27320 × 4C	AK27380 × 4E	AK27450 × 4C	AK27320 × 6QY1	AK27380 × 6C	AK27440 × 6C
1	刀方尺寸Dimension of turret square (mm)	320	380	450	320	380	440
2	装刀中心高Height of datum plan (mm)	90	109	110	90	109	110
3	单工位换刀时间Time of changing tool per position (s)	4	4	8.5	5	3.5	8.5
4	最大锁紧力Max. clamping force (KN)	27.5	34	100	40	34	100
5	电机力矩Torque of motor (Nm)	5	6.4	9.4	5	6.4	9.4
6	刀架净重Net weight of turret (kg)	113	175	284		170	
7	刀架毛重Gross weight of turret (kg)	125	195	305		190	
8	箱体尺寸Packing dimension (cm)	50 × 50 × 40	54 × 54 × 43	55 × 55 × 48	44 × 40 × 44	54 × 54 × 43	60 × 60 × 48
9	重复定位精度Repeatability (mm)	≤0.005	≤0.005	≤0.005	≤0.005	≤0.005	≤0.005
10	上加力矩Torque in vertical (Nm)	4000	5500	6300	4000	5500	6300
11	上加力弹性变形量Max elastic deformation in vertical (mm)	≤0.06					
12	上加力残余变形量Residual deformation in vertical (mm)	≤0.015					
13	切向加力矩Torque in horizontal (Nm)	2000	3000	3200	2000	3000	3200
14	切向力弹性变形量Max. elastic deformation in horizontal (mm)	≤0.06					
15	切向力残余变形量Residual deformation in horizontal (mm)	≤0.015					

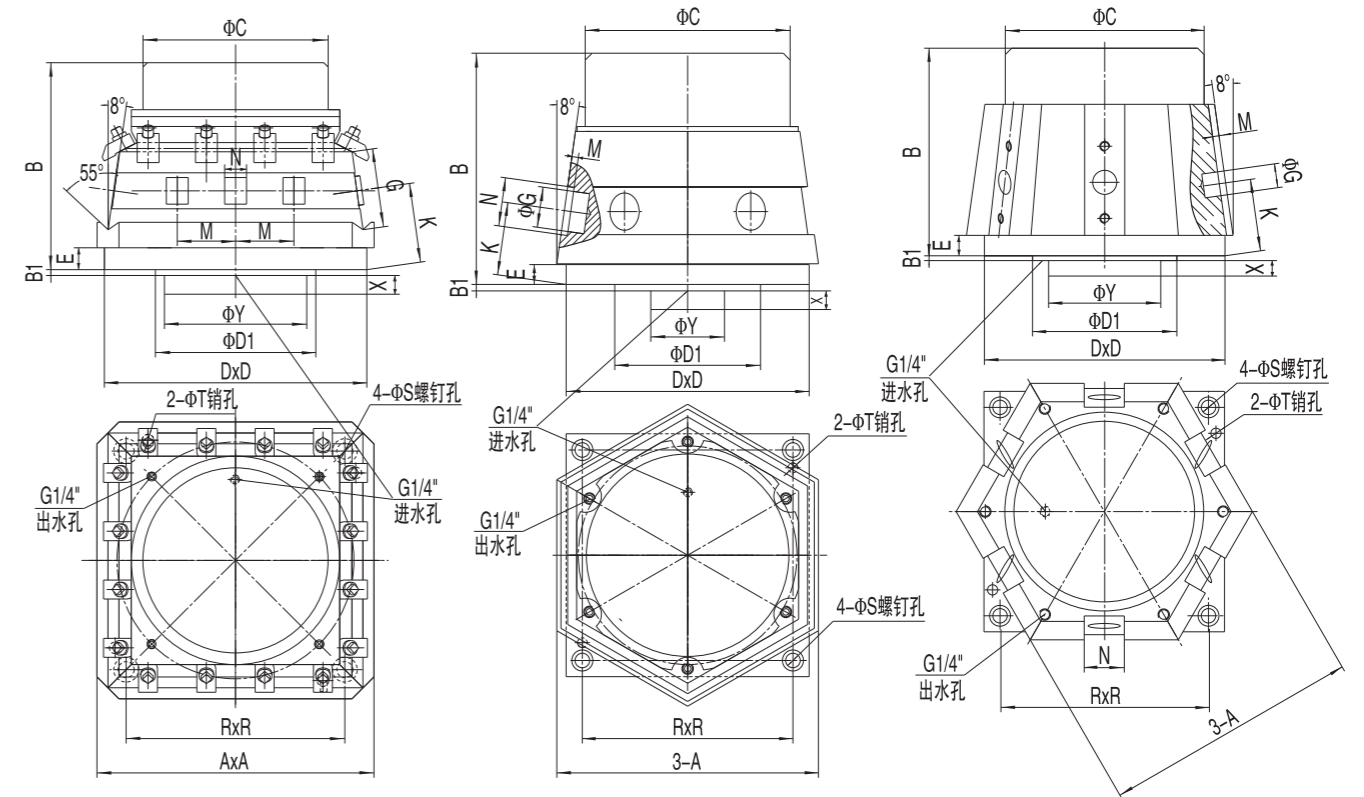
注：()内尺寸为毛尺寸。

注：以上参数以实物为准，如有变动最终解释权归本公司。



AK27斜8° (其它) 系列数控转塔刀架

AK27 SERIES NC TURRET



AK27320X4C
AK27380X4E
AK27450X4C

AK27320X6QY1

AK27380X6C
AK27440X6C

安装尺寸参数：DIMENSIONAL PARAMETER

mm

型号	参数	B	B1	C	D	D1	E	K	G	R	S	T	X[注]	Y[注]	M	N	
AK27320X4C		320	285	8	254	300	180	25	90	90	260	18	10	30	176	70	25
AK27380X4E		307	8	254	360	220h6	30	109	108	300	22	16	30	176	80	30	
AK27450X4C		450	340	10	345	400	320h6	35	115	110	340	22	16	/	/	90	30
AK27320X6QY1		286	8	253	300	180h6	25.5	90	(50)	260	18	12	30	176	8	60	
AK27380X6C	(390)	307	8	254	360	220h6	30	109	(50)	300	22	16	30	176	15	70	
AK27440X6C		342	8	356	400	320h6	35	110	80	340	22	16	/	/	10	90	

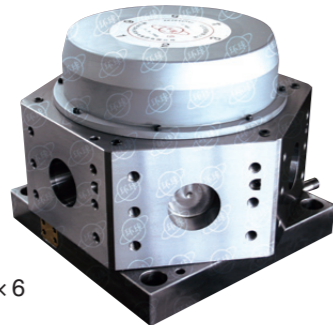
[注]：此尺寸参数为电机保护套的尺寸（非刀架安装定位部分）。



AK26系列伺服刀架 AK26 SERIES



AK26380 × 5



AK26440 × 6

●本产品是数控车床的重要功能部件，特别适用于大型卧车、数控立车；可多刀夹持，实现加工程序的自动化和高效化。

●它采用电机内藏式结构，由伺服电机直接驱动，端齿盘作为分度元件，液压刹紧松开，具有分度精度高、转位稳定可靠、应用范围广、结构紧凑等特点。

●AK26 series Hor. Servocontrol turret is an important accessory for NC lathe and especially applicable for heavy NC vertical lathe and large NC horizontal lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of operational procedures can be realized.

●It utilizes a face gear coupling as indexing mechanism. Servo driving and hydraulic pressure controlling loosen and clamp. It features high accuracy, reliability, wide application, compact design.

主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

mm

项目Items		AK26380 × 5	AK26380 × 4	AK26440 × 6
回转中心到装刀面的距离	mm	190	190	220
装刀孔中心高	mm	205	205	160
单工位换刀时间	s	1.5	2	2.9
最大锁紧力	N	120000	120000	130000
电机最大转矩	Nm	7.2	7.2	14.3

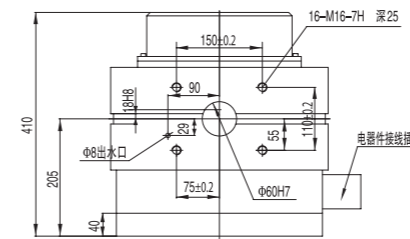
精度检验：ACCURACY TESTING

项目Items		AK26380 × 5	AK26380 × 4	AK26440 × 6
重复定位精度	mm	0.005	0.005	0.005
上加力矩FSL	Nm	5000	5000	7000
FSL引起弹性变形量	mm	0.06	0.06	0.06
FSL引起残余变形量	mm	0.015	0.015	0.015
切向加力矩FqL	Nm	3000	3000	4000
FqL引起弹性变形量	mm	0.06	0.06	0.06
FqL引起残余变形量	mm	0.015	0.015	0.015

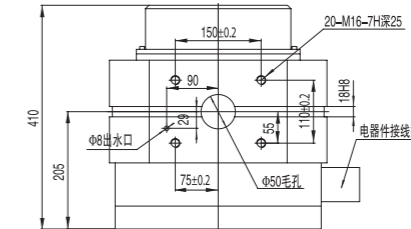
注：以上参数以实物为准，如有变动最终解释权归本公司。



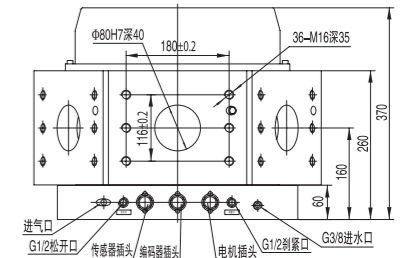
AK26系列伺服刀架 AK26 SERIES



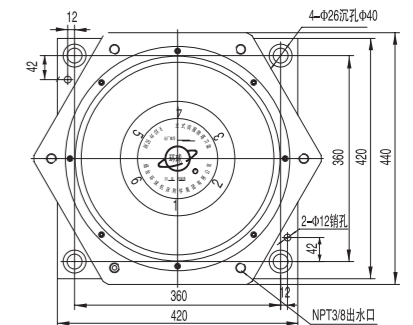
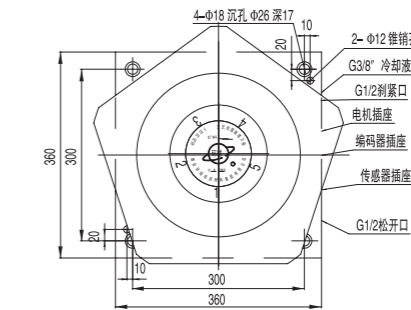
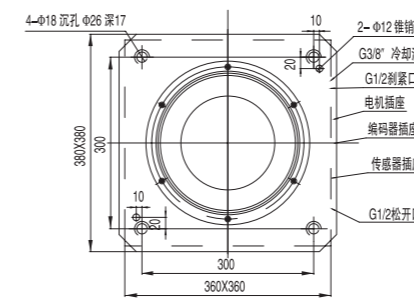
AK26380X4



AK26380X5

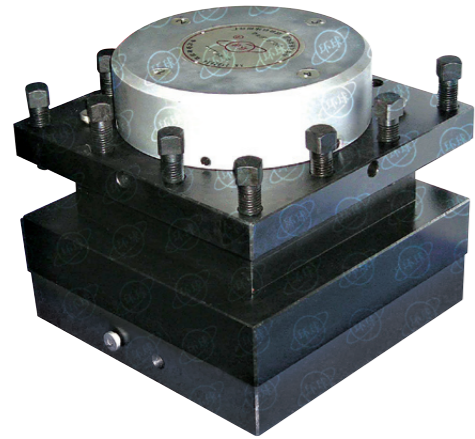


AK26440X6





AK23系列数控转塔刀架 AK23 SERIES NC TURRET



- 本产品是数控车床的重要功能部件，特别适用大型卧车、数控立车；可多刀夹持，实现加工程序的自动化、高效化。
- 它采用了国际上流行的电机内藏式结构，端齿盘作为分度元件，分度工位由定位盘、传感器控制，可任意工位定位；具有定位精度高、锁紧力大、承载力强、稳定可靠、应用范围广、结构紧凑等特点。

● AK23 series NC turret is an important accessory for NC lathe and especially applicable for large NC horizontal lathe and NC vertical lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of procedures can be realized.

● It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a positioning face gear and transducers. So it features high accuracy, reliability, wide application and compact design.

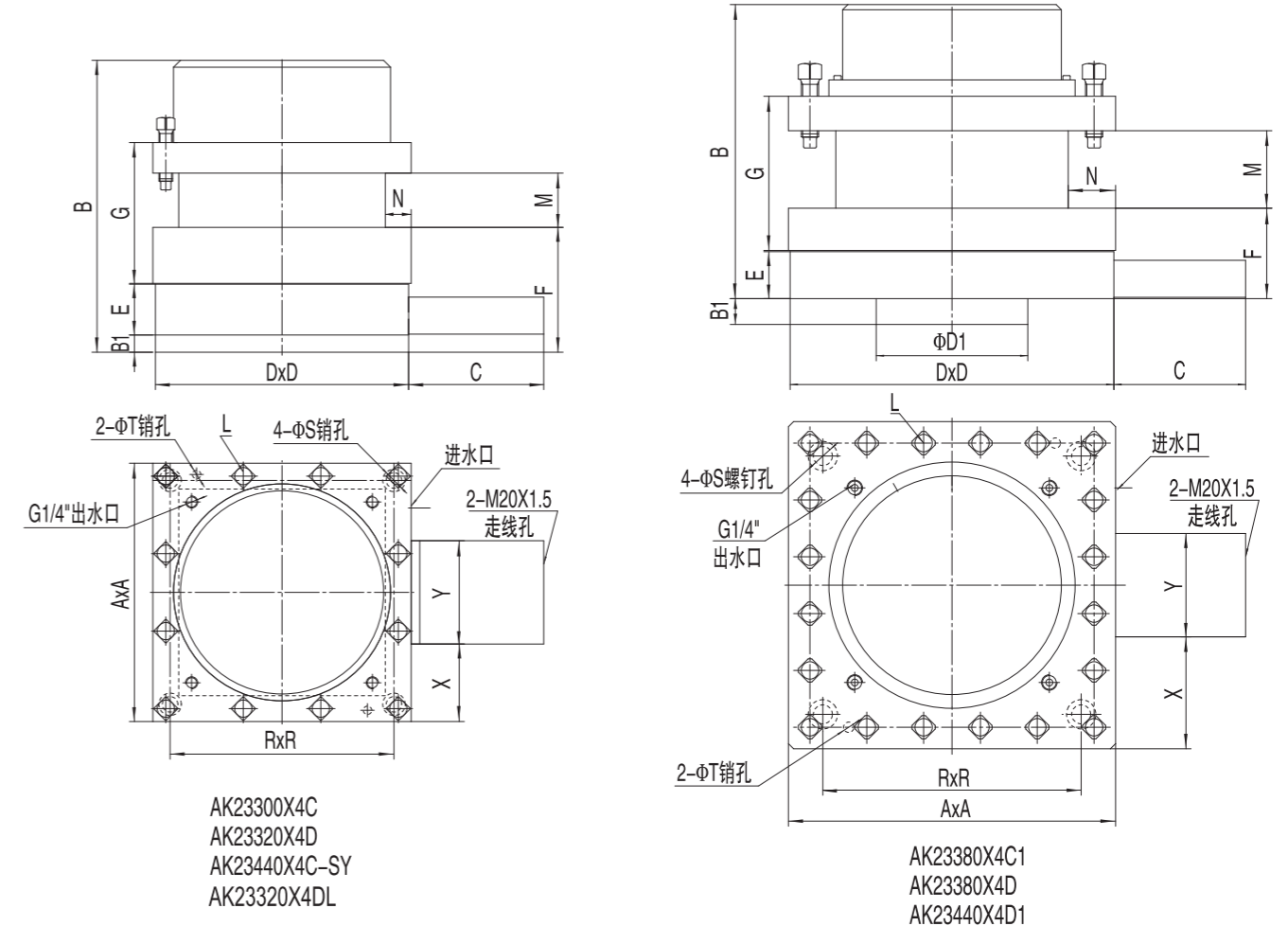
主要规格和参数: MAIN SPECIFICATIONS AND PARAMETER

项目 Items	AK23300X4C	AK23320X4D	AK23320X4DL	AK23380X4C1	AK23380X4D	AK23440X4C-SY	AK23440X4D1
刀台方寸 (mm) Dimension of turret square	300	320	320	380	380	440	440
基准面高 (mm) Height of datum plane		130	130	110	105	145	145
单工位换刀时间 (s) Time of changing tool per position	4	4	4	4	6	8.5	8.5
最大锁紧力 (N) Max. clamping force		27500	27500	34000	60000	100000	100000
电机力矩 (Nm) Torque of motor	5	5	5	6.4	6.4	9.4	9.4
重复定位精度 Repeatability		0.005	0.005	0.005	0.005	0.005	0.005
上加力矩 F _{ql} (Nm) Torque in vertical	4000	4000	4000	5500	5500	6300	6300
上加力弹性变形量 (mm) Max elastic deformation in vertical	≤0.06						
上加力残余变形量 (mm) Residual deformation in vertical	≤0.015						
切向加力矩 F _{ql} (Nm) Torque in horizontal	2000		3000		3200		
切向力弹性变形量 (mm) Max. elastic deformation in horizontal	≤0.06						
切向力残余变形量 (mm) Residual deformation in horizontal	≤0.015						
刀架净重 (kg) Net weight of turret	143	154	160	205	203	254	255
刀架毛重 (kg) Gross weight of turret		168	170	230	228	281	285
箱体尺寸 (长X宽X高) Packing dimension	560X460X470	590X420X470	590X420X470	610X510X470	634X514X503	664X574X526	664X574X526

注：以上参数以实物为准，如有变动最终解释权归本公司。



AK23系列数控转塔刀架 AK23 SERIES NC TURRET



安装尺寸参数: DIMENSIONAL PARAMETER

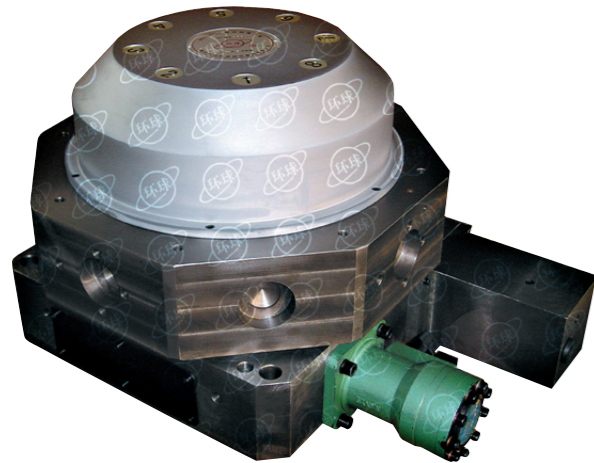
项目	参数	A	B	B1	C	D	D1	E	F	G	L	M	N	R	S(沉孔)	T	X	Y
AK23300X4C		300	339	20	156	300	/	59.5	145	163.5	12-M16	63	30	260	18(26)	10	90	120
AK23320X4D		320	326	10	130	316	/	56.5	130	163.5	12-M20	65	40	260	18(26)	10	22	220
AK23320X4DL		320	326	10	130	316	/	56	130	163.5	12-M20	55	40	260	18(26)	10	22	220
AK23380X4C1		380	341	13	130	376	220h6	50	110	166	20-M20	70	55	300	22(34)	16	60	220
AK23380X4D		380	341.5	30	156	376	Φ176*	55	105	179	20-M20	90	55	300	22(34)	12	130	120
AK23440X4C-SY		440	370	/	130	420	/	50	145	225	20-M20	80	50	360	26(40)	12	110	220
AK23440X4D1		440	370	10	156	420	260h6	50	145	225	20-M20	80	50	360	26(40)	12	155	130

注：*为电机保护套高出尺寸，非定位止口。

AK2330X4C、AK23320X4D、AK23380X4D进水孔为G1/4"/G3/8", AK2380X4C1、AK23440X4C-SY、AK23440X4D1进水孔为Z3/8"。



AK22系列数控转塔刀架 AK22 SERIES NC TURRET



●AK22系列数控刀架主要为大型数控车床及数控卧式车床设计的，采用液压马达驱动液压缸松开、刹紧，转位时刀台不抬起，接近开关发信。

●本刀架采用端齿盘作为定位元件，具有刹紧力大、转位精度高、转动平稳、动作简捷、密封性能良好等特点，适用于各类大型零件的加工。

●AK22 series NC turret is designed mainly for the NC vertical and horizontal lathe. It clamps and unclamps by Hydraulic pressure motor, rotating without lifting.

●It utilizes a face gear coupling as indexing mechanism. So it features high accuracy; reliability; rotating smoothly; good airproof, fit to machining big parts.

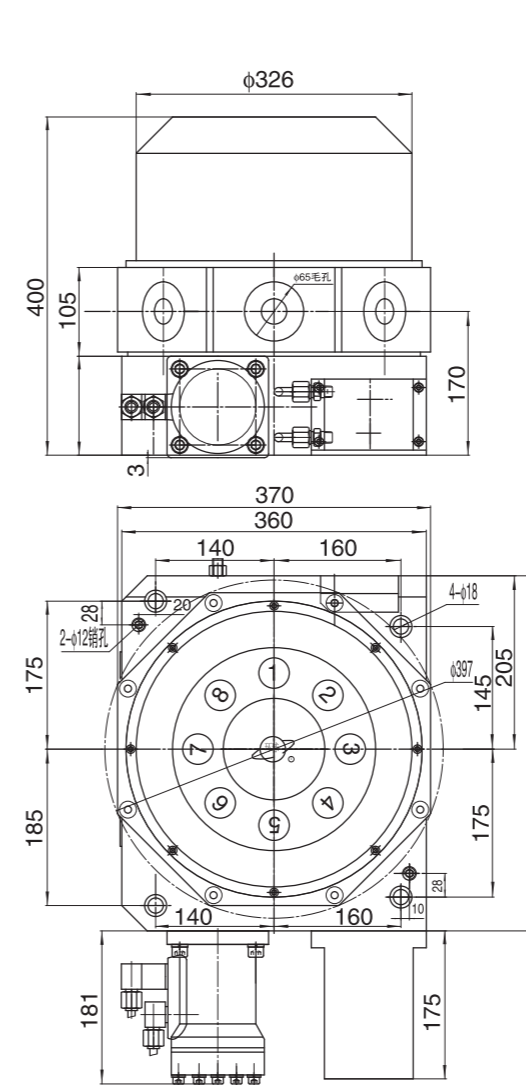
主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

序号 No.	项目 Items	规格 Specifications	AK22370X8A	AK22540X8C
1	装刀基准孔高	Centre height of knife bore (mm)	170	204.5
2	刀架转速	Rotating speed (r/min)	≤8	
3	转位时间 (一个工位)	Time for rotation (per position) (s)	≤3	≤4
4	最大承受上加力矩	Max torque in vertical (N.m)	5000	6000
5	最大承受切向力矩	Max torque in horizontal (N.m)	2500	3000
6	重复定位精度	Repeatability (mm)	0.005	
7	系统压力	System pressure (Mpa)	3	
8	刀架净重	Net weight (kg)	250	485
9	刀架毛重	Gross weight (kg)	282	525
10	箱体尺寸 (长X宽X高)	Packing dimension (mm)	789X521X573	920X656X570

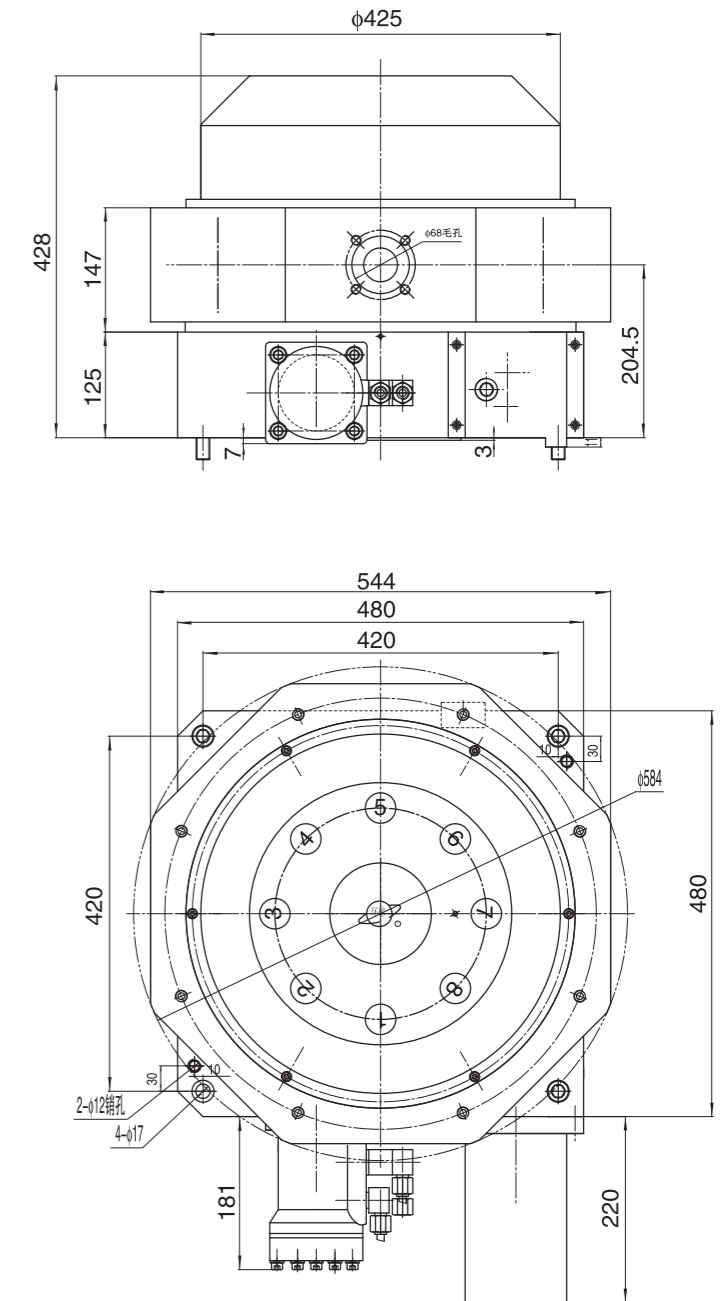
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AK22系列数控转塔刀架 AK22 SERIES NC TURRET



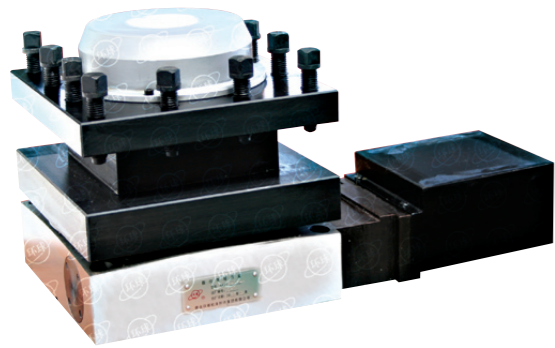
AK22370 × 8A外形图



AK22540 × 8C外形图



AK21系列数控转塔刀架 AK21 SERIES NC TURRET



- 本产品是数控车床的重要功能部件，特别适宜经济型数控车床；可多刀夹持，实现了加工程序的自动化、高效化。
- 它采用端齿盘作为分度定位元件；分度工位由定位盘、霍尔传感器控制，可任意工位定位。具有精度高、稳定可靠、应用广泛、结构简单、维修方便等特点。

● AK21 series NC turret is an important accessory for NC lathe and especially applicable for economic NC lathe. It is designed to hold several tools and automatically index. Thus automation and high efficiency of operational procedures can be realized.

● It utilizes a face gear coupling as indexing mechanism. Indexing sequence is mainly controlled by a positioning face gear and a HALL transducer. So it features high accuracy; reliability, compact design and easy maintenance.

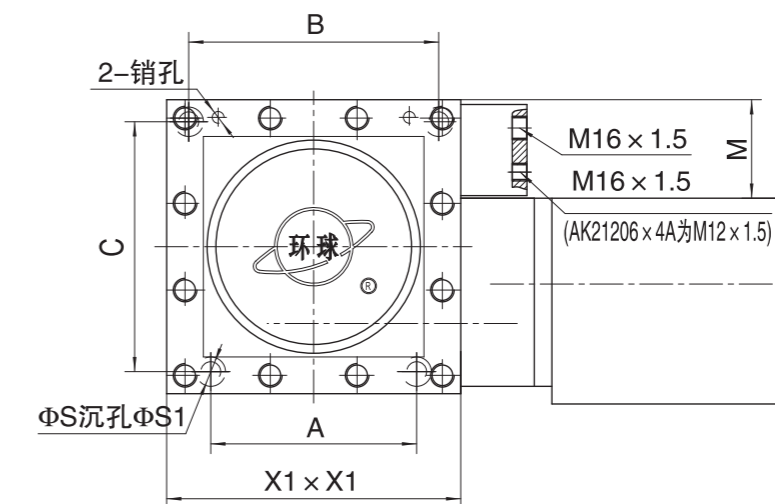
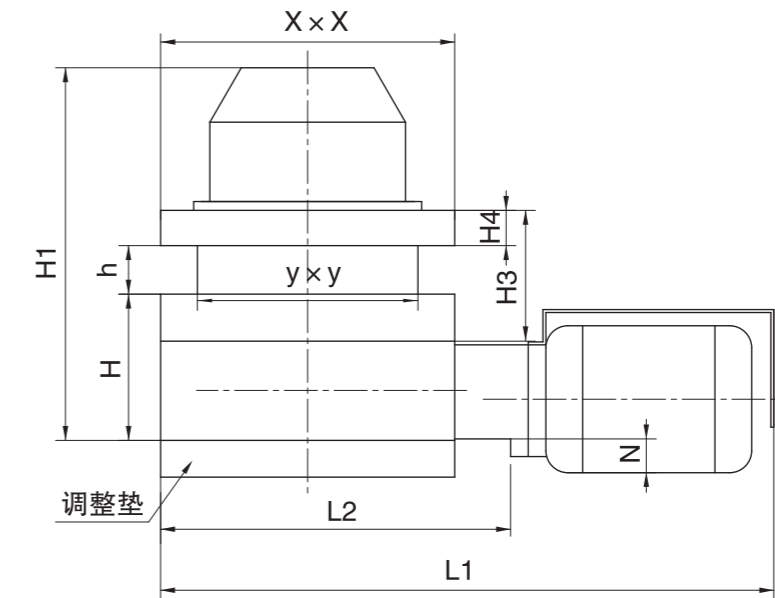
主要规格和参数：MAIN SPECIFICATIONS AND PARAMETER

序号 No.	项目 Items	AK21206X4A	AK21240X4F	AK21300X4D
1	刀台方 Dimension of turret (mm)	206	240	300
2	工位数 No. working positions (个)	4	4	4
3	装刀基面高 Centre height of datum plane (mm)	≥106	≥120	140
4	单工位转换时间 Time of one position rotation (s)	3.15	2.9	3.9
5	刀架转速 Rotating speed (r/min)	17	20	15.6
6	最大切向力矩 Max. torque in horizontal (N.m)	800	1000	2750
7	最大倾覆力矩 Max. torque in vertical (N.m)	2000	2500	5500
8	重复定位精度 Repeatability	0.008		
9	毛重 Gross weight (kg)	71	89	172
10	净重 Net weight (kg)	60	74	157
11	箱体尺寸(长宽高) Packing dimension (cm)	58X28X42	59X39X41	73X48X46

注：以上参数以实物为准，如有变动最终解释权归本公司。



AK21系列数控转塔刀架 AK21 SERIES NC TURRET



安装尺寸参数：DIMENSIONAL PARAMETER

型号 Type	A	B	C	L1	L2	H1	H	X	X1	y	h	S	S1	M	H3	H4	N
AK21206X4A	148	170	172	430	238	261.5	106	206	200	150	40	13.5	20	67	110.5	33	25
AK21240X4F	210	210	210	478	330	260	120	240	240	164	50	13.5	20	92.5	143	35	16
AK21300X4D	220	250	250	537	/	341	140	300	300	230	60	22	33	140	133	33	/