

# 1020-0080...0160, 1020 (FW/F11) 系列万能分度头

## 1020-0080...0160, 1020(FW/F11) SERIES UNIVERSAL DIVIDING HEAD



1020(FW/F11)型万能分度头是铣床上的主要附件之一，利用分度刻度环和游标、定位销和分度盘以及交换齿轮，能将装卡在顶尖间或卡盘上的工件分成任意角度，可将圆周分成任意等份，辅助机床利用各种不同形状的刀具进行各种沟槽、正齿轮、螺旋正齿轮、阿基米德螺线凸轮等的加工工作。该产品还备有圆工作台，将它安装在分度头的主轴上，工件可直接紧固在工作台上，也可利用装在工作台上的夹具紧固，可完成工件多方位加工。

1020-3125(F11125C)、1020-3160(F11160C)、1020-4100(F11100AL)、1020-4125(F11125AL)、1020-4160(F11160AL)型万能分度头，是根据用户要求特殊订货的产品。本产品是在1020-0125(F11125A)、1020-0160(F11160A)型万能分度头的基础上进行了改进，能承受较大负荷。1020-0100(F11100A)、1020-0125(F11125A)、1020-0160(F11160A)型万能分度头、与1020-0080(FW80)一样，分度手把为左置。

The universal dividing head, Type 1020(FW/F1) is one of the most important attachment for milling machine. With the help of this dividing head, the workpiece held between centers, or on a chuck can be rotate to any angle as desired and the periphery of a workpiece can be divided into any divisions of equal parts. By means of all kinds of cutters, the dividing head can also help milling machine to perform the milling operation for flute, spur gear, spiral flute, Archimedean cam, helical flute and etc.

The dividing head is equipped with a face plate that can be mounted onto the spindle nose. The workpiece can be mounted on the face plate, thus, cutting can be carried out on 4-sides of a workpiece.

1020-3125(F11125C)、1020-3160(F11160C)、1020-4100(F11100AL)、1020-4125(F11125AL)、1020-4160(F11160AL) is designed for the consumers special needed, the shafting is improved to support heavy load.

The universal dividing head, type 1020-0100(F11100A)、1020-0125(F11125A)、1020-0160(F11160A) is the same as 1020-0080(FW80) of the structures, and the operation handle is setted on the left.

### 主要规格和参数: Main specifications

规格 Specifications		项目 Items	1020-0080 (FW80)	1020-0100 (F11100A)	1020-0125 (F11125A)	1020-0160 (F11160A)
中心高 Center height mm			80	100	125	160
主轴由水平位置向上转动的角度 Swivel angle of spindle from it horizontal position(upward)			≦ 90°	≦ 95°	≦ 95°	≦ 95°
主轴由水平位置向下转动的角度 Horizontal position(downward)			≦ 6°	≦ 5°	≦ 5°	≦ 5°
分度手轮每转主轴回转角度 Rotating angle of spindle for one complete revolution of dividing handle			9° (540grad., 1'each)	9° (540grad., 1'each)	9° (540grad., 1'each)	9° (540grad., 1'each)
游标最小示值 Minimum value of vernier			10"	10"	10"	10"
蜗杆副传动比 Worm gear ratio			1:40	1:40	1:40	1:40
主轴孔锥度(莫式) Taper of spindle bore			MT3	MT3	MT4	MT4
定位键宽度 Width of the locating key mm			14	14	18	18
主轴法兰盘定短锥直径 Diameter of short taper of spindlenose for mousing flange mm			φ 36.541	φ 41.275	φ 53.975	φ 53.975
分度盘孔数 Hole numbers on index plate	A盘Plate	24,25,28,30,34,37,38,39,41,42,43	24,25,28,30,34,37,38,39,41,42,43	24,25,28,30,34,37,38,39,41,42,43	24,25,28,30,34,37,38,39,41,42,43	
	B盘B plate	46,47,49,51,53,54,57,58,59,62,66	46,47,49,51,53,54,57,58,59,62,66	46,47,49,51,53,54,57,58,59,62,66	46,47,49,51,53,54,57,58,59,62,66	
变换齿轮 Change Gear	模数 Module	1.5	1.5	2	2	
	齿数 Teeth Number	25,30,35,40,50,55,60,70,80,90,100	25,30,35,40,50,55,60,70,80,90,100	25,30,35,40,50,55,60,70,80,90,100	25,30,35,40,50,55,60,70,80,90,100	
分度手柄-整转主轴单个分度误差 Individual indexing error of the spindle for one complete revolution of dividing handle			60"	±45"	±45"	±45"
主轴在任意1/4圆周上的累积误差 Cumulate error at any 1/4 periphery of spindle			±1'	±1'	±1'	±1'
最大承载 Max.bearing Kg			80	100	130	130
净重 Net weight Kg			36	(63)67	(104)110	(120)130
毛重 Gross weight Kg			45	(75)79	(120)126	(139)149
箱体尺寸 Case dimensions mm			542x403x220	616X465X265	635X530X310	710X535X342