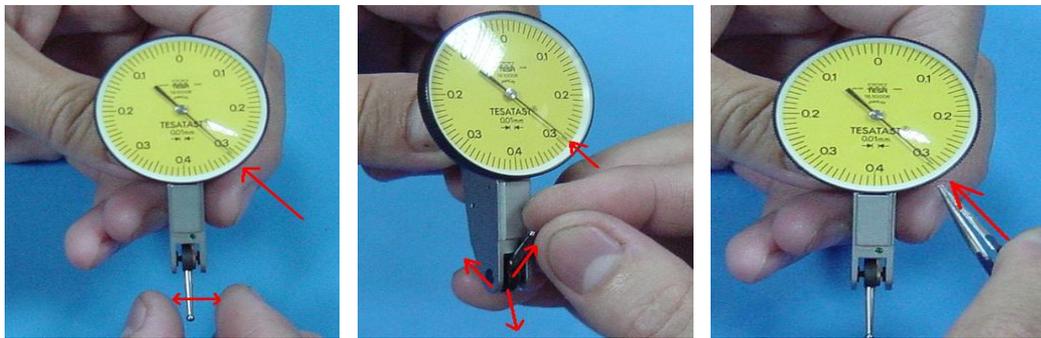


槓桿表之基本概念及維修

一、槓桿表基本判斷有無損壞

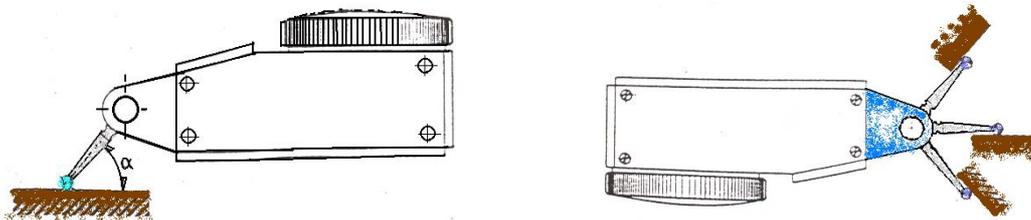


1. 指針的位置是否於 5 點鐘方向。
2. 外觀有無受損。
3. 測頭座左右無間隙。
4. 任一方向，指針均能歸回同一點。

二、槓桿表之特色

1. 用來比較量測使用，量測平面度、偏擺、直度、位置差....等。
2. 雙向均可以量測。
3. 受磁性影響較小。
4. 測頭座可以有 240 度的角度可以選擇。
5. 非常低之量測壓力（短針 0.15N，長針 0.06N） $1\text{N} = 980\text{g}$ 。

三、槓桿表使用注意事項



1. 任何角度，測針應儘量與工件保持平行。
2. α 角為餘弦誤差。

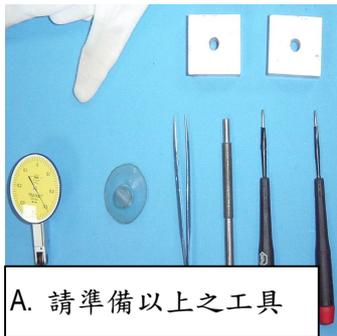
四、槓桿表之保養

基本上，槓桿表不需要保養，亦不要上油以保持其準確性。

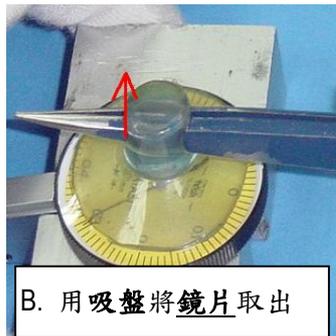
五、鎢鋼測針與紅寶石測針有何差別？

鎢鋼測針會導電、導磁較不適合於精密或放電加工。

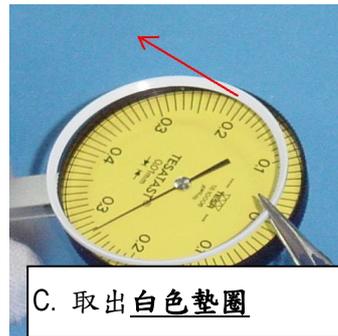
六、槓桿表之分解



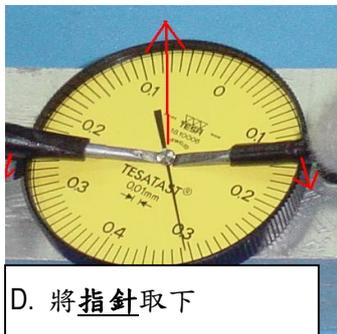
A. 請準備以上之工具



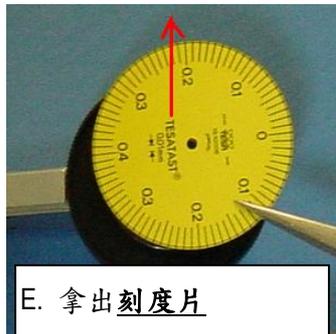
B. 用吸盤將鏡片取出



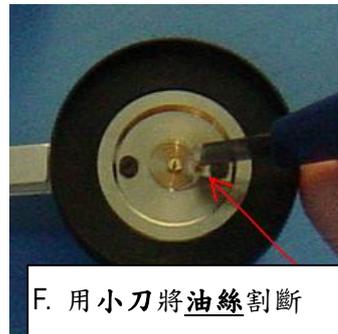
C. 取出白色墊圈



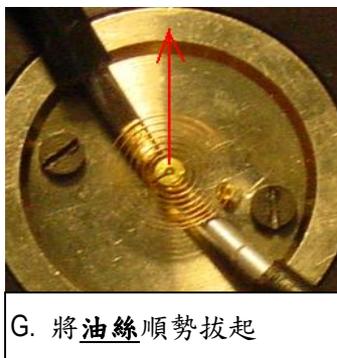
D. 將指針取下



E. 拿出刻度片



F. 用小刀將油絲割斷



G. 將油絲順勢拔起



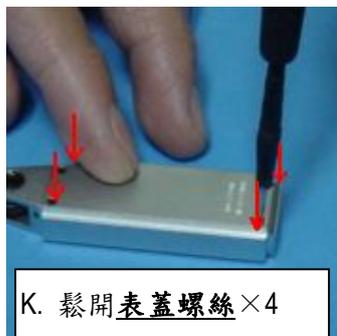
H. 鬆開托盤螺絲×2



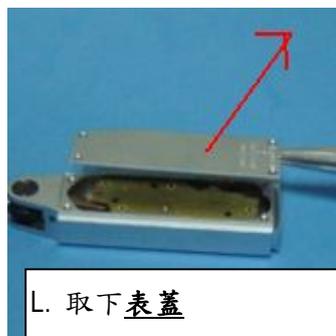
I. 將油絲托盤取出



J. 取出 中心軸



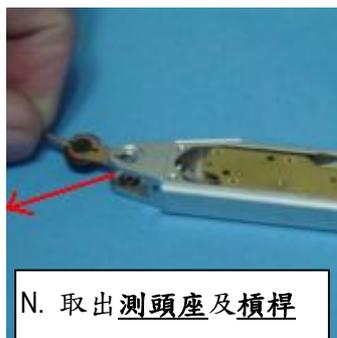
K. 鬆開 表蓋螺絲 × 4



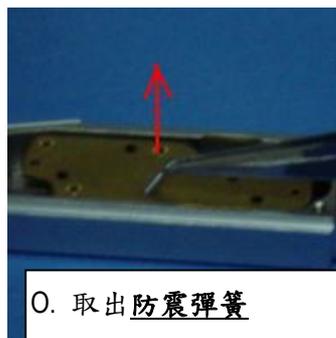
L. 取下 表蓋



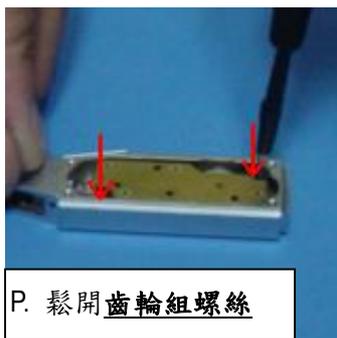
M. 將 測頭座軸承 取下



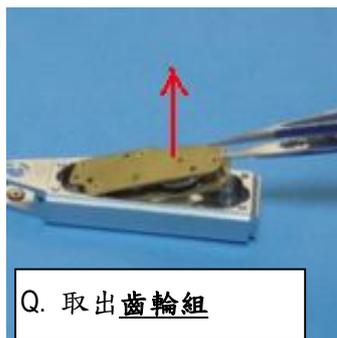
N. 取出 測頭座及槓桿



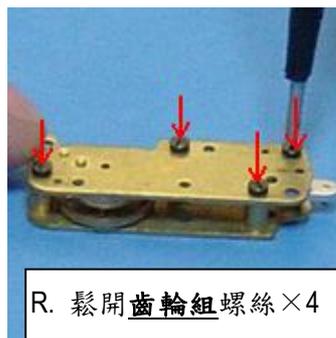
O. 取出 防震彈簧



P. 鬆開 齒輪組螺絲



Q. 取出 齒輪組



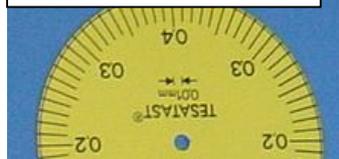
R. 鬆開 齒輪組螺絲 × 4

現在你已經將槓桿表完全分解了，請徹底檢查並清洗乾淨。

七、槓桿表零件表



023047 小鏡片
023048 大鏡片



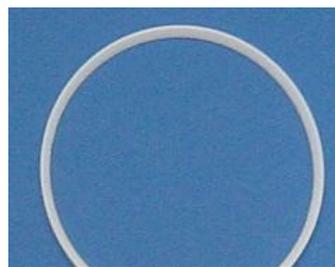
023068 短腳百分小錶
023069 短腳百分大錶
023070 長腳百分小錶
023071 長腳百分大錶
023066 短腳千分小錶
023067 短腳千分大錶



023035 短指針
023036 長指針



023044 油絲



023039 小白色墊圈
023040 大白色墊圈



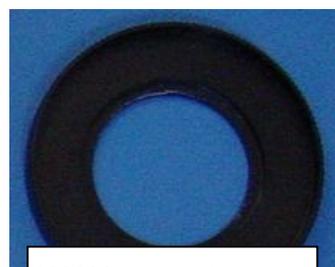
023049 托盤螺絲



023042 油絲托盤



023043 轉盤彈簧



023003 小轉盤
023004 大轉盤



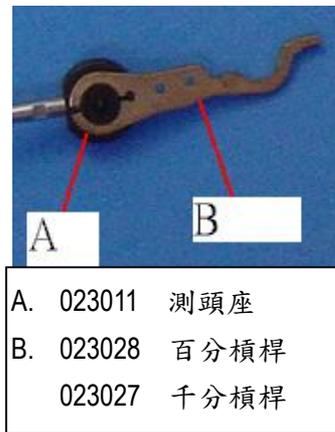
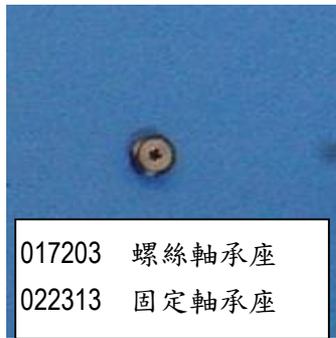
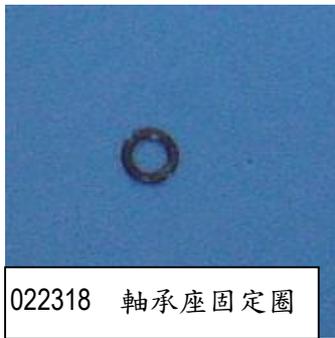
023024 中心軸



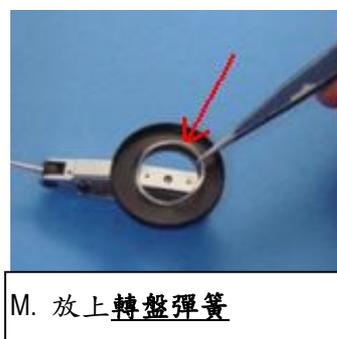
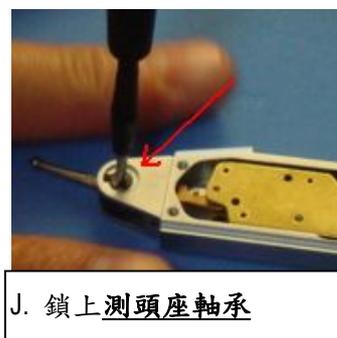
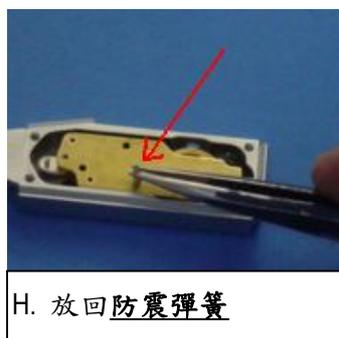
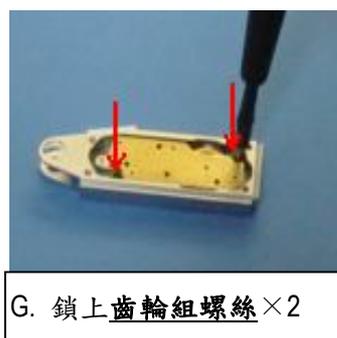
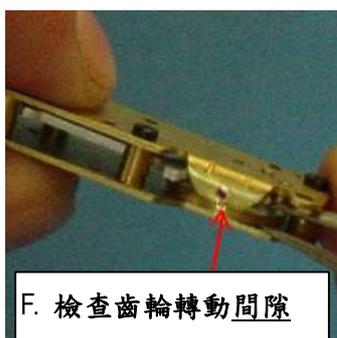
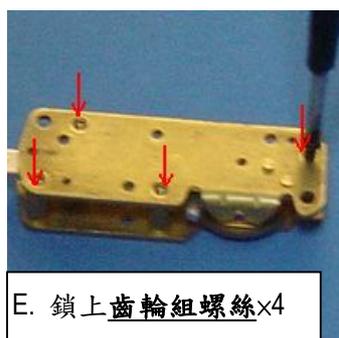
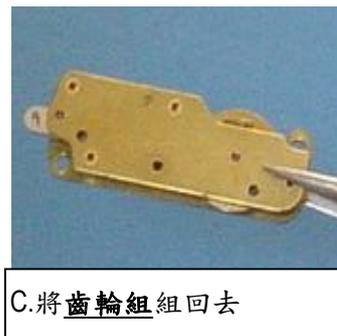
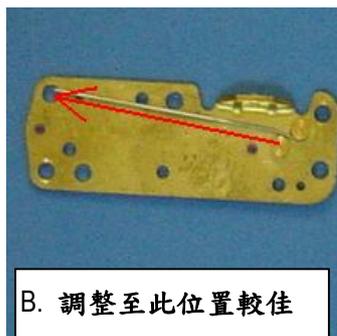
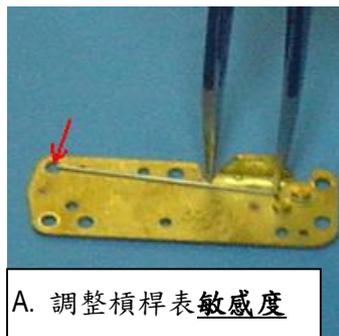
023051 錶蓋螺絲×4



023045 錶蓋

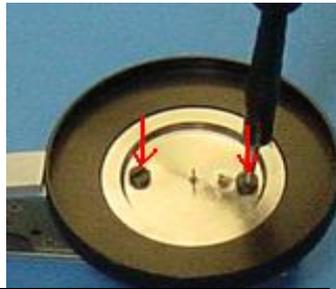


八、槓桿表之組合步驟

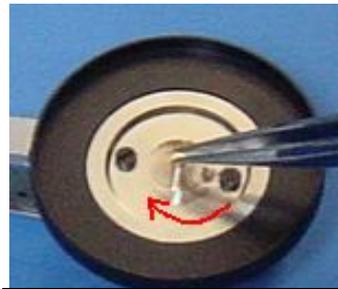




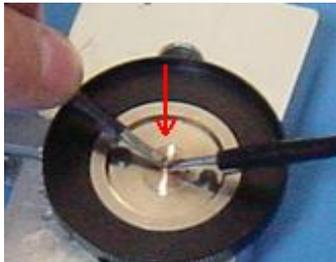
N. 將油絲托盤對正放入



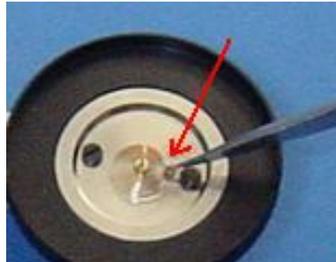
O. 鎖上托盤螺絲×2



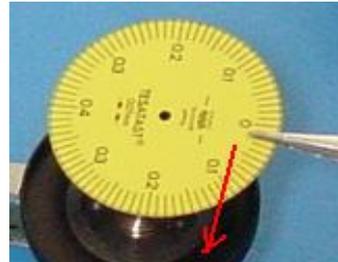
P. 將油絲小心對正放入



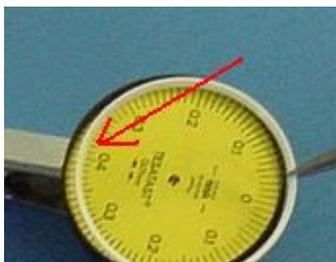
Q. 將油絲壓至最底處



R. 將油絲用快乾來固定



S. 放上刻度片



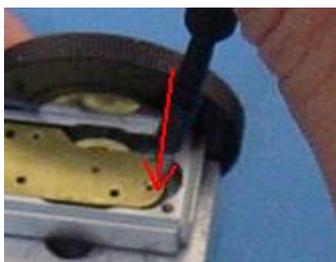
T. 將白色墊圈放入



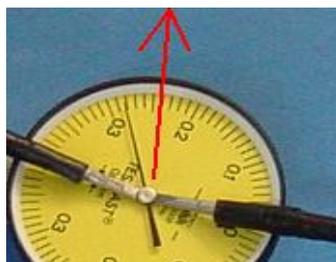
U. 將齒輪組上蓋翹開些



V. 將油絲轉 2/3 圈



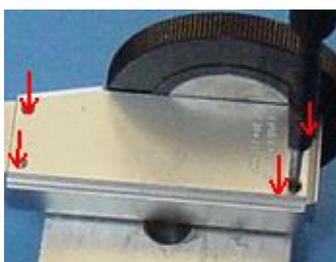
W. 在將齒輪組上蓋壓回



X. 將指針取下



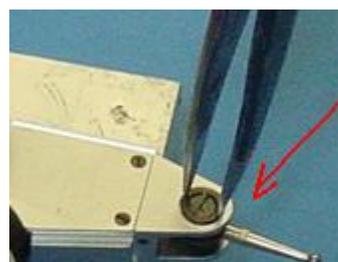
Y. 指針固定於五點方向



Z. 鎖上表蓋螺絲×4



1. 裝上鏡片



2. 確實將軸承座固定住

完成上述之步驟，槓桿表已經維修完成了。