



放電機全方位調整頭

Electrode Comprehensive Adjusting Head Diagram

『放電加工機』在工業上的應用已逾50載，但曾經的輝煌亦敵不過世代的演進！

隨著設備與加工技術的逐年精進，更使其漸漸地退出了模具加工業的主角地位..；而本是其主要配件的

【放電機調整頭】也因各式、各樣精密的 自動化夾治具 的導入，令其使用率是越加低迷！

以至於近二十年來一直未有業者將其當成主角去研發出新款產品..。

有鑒於此，敝司本著駱牛精神、努力思考、精益求精、積極改善，研製的目地只為讓【它】能夠繼續

保有其存在的必要性與實用的特質；也更期待各地業界、同好一起來分享此美麗的成果。

CGM 晟進科技股份有限公司
CHERNG JIN TECHNOLOGY CO., LTD.
500 彰化市彰水路207巷16號
TEL: 04-7632896 FAX: 04-7634579
EMAIL: cg.mold88@msa.hinet.net



www.cgmchuck.com

2024 MAY

放電機全方位調整頭

Electrode Comprehensive Adjusting Head Diagram

此結構台灣及大陸發明專利申請中
Taiwan/China Invention Patent Pending



CGM 晟進科技股份有限公司
CHERNG JIN TECHNOLOGY CO., LTD.

電極校正頭應用 Application

當放電機已安裝本公司夾頭・轉接電極校正頭・可校正未固定於電極座上之電極・可機外預校電極・減少機械停機時間。

For EDM with CGM chuck system, when apply this adjusting head, it can calibrate and pre-calibrate the electrode directly for reducing the machine downtime.

放電機電極庫用電極校正頭

Electrode Calibrating Holder for EDM with Auto Tool (electrode) Changer

HE-70EN 電極調整頭
Electrode Calibrating Holder

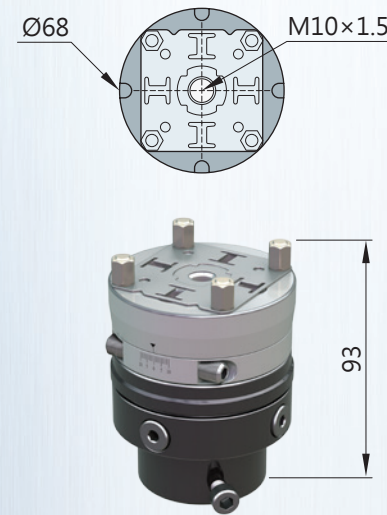
E 型孔位六向調整 (不含定位片)
E type, 6DoF adjusmtnet w/o centering plate



- 平行度調整正負 10 度
- 平面度調整正負 2.5 度
- 治具柄孔最大 Ø25
- 最大吊重 20 Kgs
- 調整螺絲最大鎖緊力 6N-m
- 不附拉桿
- Parallelism adjustment ± 10°
- Flatness adjustment ± 2.5°
- Electrode Max dia. Ø25mm
- Electrode Max. Weight 20 kgs
- Screw tightening torque max. 6Nm
- W/o Drawbar

HE-70E50 電極調整頭
Electrode Calibrating Holder

鎖附 E 型 4H50 定位片
With E Type #4H50 centering plate



重量 Weight 1.74 kgs

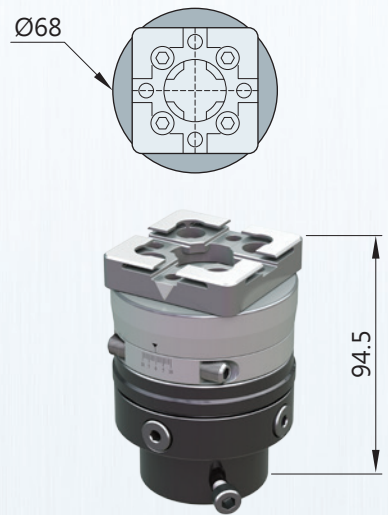
HE-70RN 電極調整頭
Electrode Calibrating Holder

R 型孔位六向調整 (不含定位片)
R type, 6DoF adjusmtnet w/o centering plate



HE-70R50 電極調整頭
Electrode Calibrating Holder

鎖附 R 型 4H54R 定位片
With R Type #4H54R centering plate



重量 Weight 1.9 kgs

調整頭結構圖解 Electrode Calibrating Holder Sturcture Diagram

新款

New Type

表面平整鋼片不變形
拉桿鎖緊位置正常
Flat and smooth surface so the centring plate is not easy deformed All-in-one drawbar is easy tightened at right position

滾柱型止推軸承
高強度轉動順暢零背隙
Thrust Ball Bearing
High strength and smooth rotation w/o backlash

深槽迷宮防塵
Deep groove labyrinth dustproof

兩鋼珠間隔寬
Wider distance between two steel balls

內牙螺桿不受力傾斜
不卡緊咬死、調整精確
螺桿高硬度 HRC 60°
Internal screw won't be tilted out of external force Will not get stuck and can be adjusted accurately
Screw with high hardness HRC-60°

柄槽孔加大至 Ø25
Electrode size Max. Dia. 25mm

舊款

Old Type

螺栓式位置易凹凸不平
易致拉桿鎖緊位置異常
Screw position easy to cause uneven surface
By tightening the screw will case the postion inaccurate easily

鋼珠軸承
Stainless Steel Ball Bearing

淺槽迷宮防塵
Shallow groove labyrinth dustproof

兩鋼珠間隔窄
Narrow distance between two steel balls

牙螺桿易受力傾斜
容易卡緊咬死
Internal screw is easy to tilt by external force
easy to get stuck

原柄槽孔 Ø15
Electrode size Max. Dia.15mm

全方位調整頭

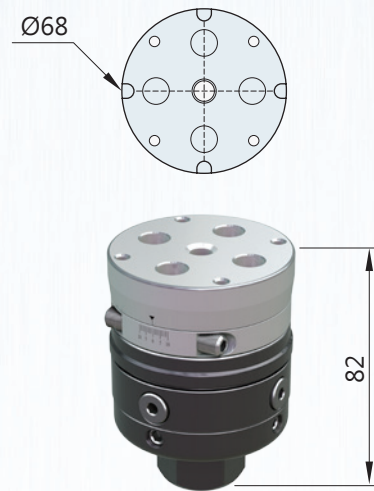
All-round Electrode Calibrating Holder for EDM

HER-70EN 電極調整頭

Electrode Calibrating Holder

E 型孔位十向調整 (不含定位片)

E type, 10DoF adjustmnt w/o centering plate



重量 Weight 1.7 kgs

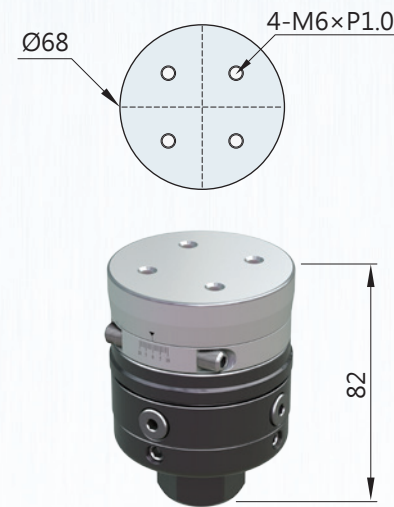
- ER20 夾持孔徑 2 ~ 13mm
- 同心度調整正負 1.5mm
- 平行度調整正負 10 度
- 平面度調整正負 2.5 度
- 最大吊重 10 Kgs
- 調整螺絲最大鎖緊力 6N-m
- 不附拉桿與 ER-20 筒夾
- ER20 clamping dia. Ø2 ~ Ø13mm
- Concentricity adjustment $\pm 1.5\text{mm}$
- Parallelism adjustment $\pm 10^\circ$
- Flatness adjustment $\pm 2.5^\circ$
- Electrode Max. Weight 10 kgs
- Screw tightening torque max. 6Nm
- W/o Drawbar and ER-20 Collet

HER-70RN 電極調整頭

Electrode Calibrating Holder

R 型孔位十向調整 (不含定位片)

R type, 10DoF adjustmnt w/o centering plate



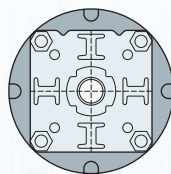
重量 Weight 1.7 kgs

HER-70E50 電極調整頭

Electrode Calibrating Holder

鎖附 **E** 型 4H50 定位片

With E Type #4H50 centering plate



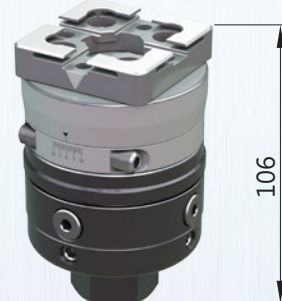
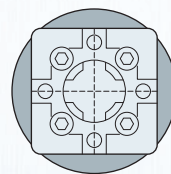
重量 Weight 1.84 kgs

HER-70R50 電極調整頭

Electrode Calibrating Holder

鎖附 **R** 型 4H54R 定位片

With R Type #4H54R centering plate



重量 Weight 2.0 kgs

機上固定型電極校正頭

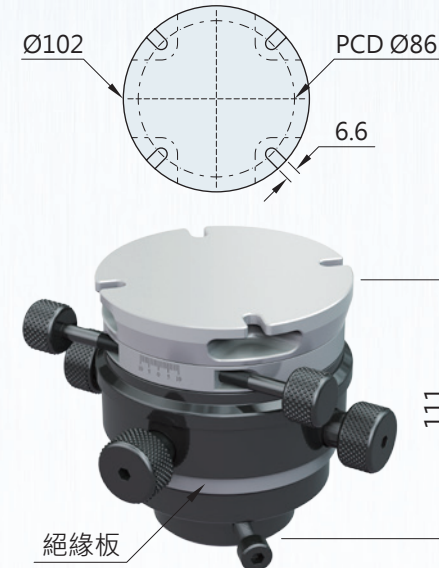
On-machine electrode adjustment head

HE-100B1 機上型電極調整頭

On-machine Electrode Calibrating Holder

有絕緣板 / 側鎖固定型

Has insulation board / Side lock fixed type



重量 Weight 5.2 kgs

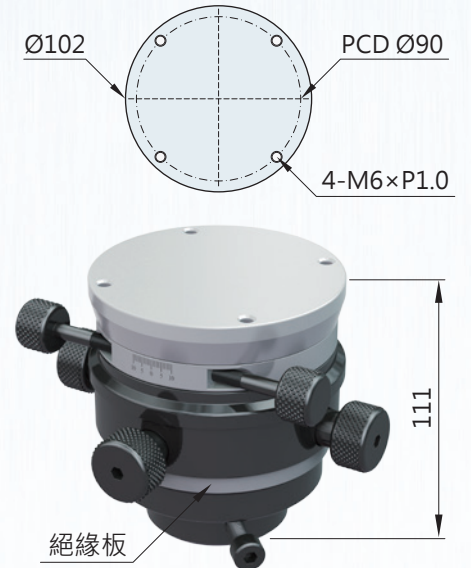
- 平行度調整正負 10 度
- 平面度調整正負 3 度
- 治具柄孔最大 Ø31
- 最大吊重 25 Kgs
- 調整螺絲最大鎖緊力 6N-m
- Parallelism adjustment $\pm 10^\circ$
- Flatness adjustment $\pm 3^\circ$
- Electrode Max dia. Ø31mm
- Electrode Max. Weight 25 kgs
- Screw tightening torque max. 6Nm

HE-100B2 機上型電極調整頭

On-machine Electrode Calibrating Holder

有絕緣板 / 上鎖固定型

Has insulation board / Lockable fixed type



重量 Weight 5.3 kgs

治具定位型電極校正頭

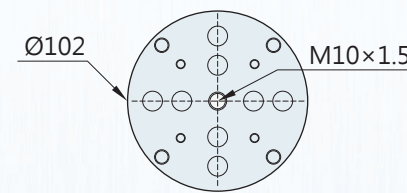
Fixture positioning type electrode adjustment head

HE-100EN 電極調整頭

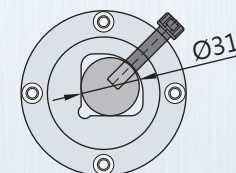
Electrode Calibrating Holder

E 型孔位六向調整 (不含定位片)

E type, 6DoF adjustmnt w/o centering plate



重量 Weight 5.0 kgs

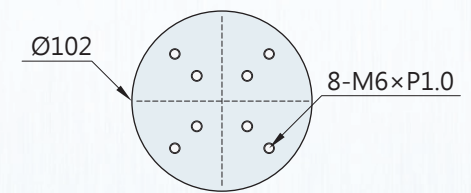


HE-100RN 電極調整頭

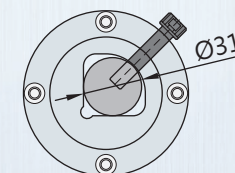
Electrode Calibrating Holder

R 型孔位六向調整 (不含定位片)

R type, 6DoF adjustmnt w/o centering plate



重量 Weight 5.0 kgs



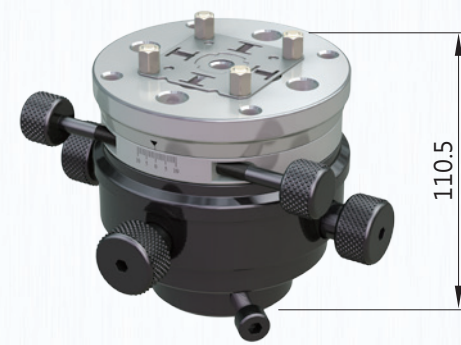
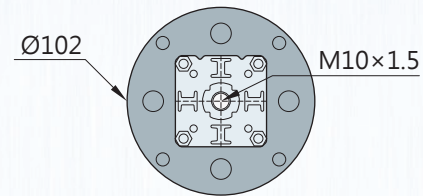
治具定位型電極校正頭

Fixture positioning type electrode adjustment head

HE-100E50 電極調整頭

Electrode Calibrating Holder

鎖附 E 型 4H50 定位片
With E Type #4H50 centering plate

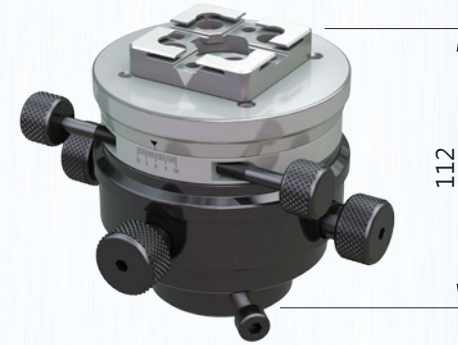
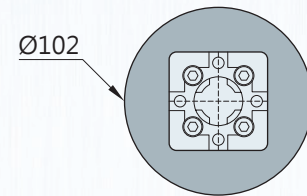


重量 Weight 5.06 kgs

HE-100R50 電極調整頭

Electrode Calibrating Holder

鎖附 R 型 4H54R 定位片
With R Type #4H54R centering plate

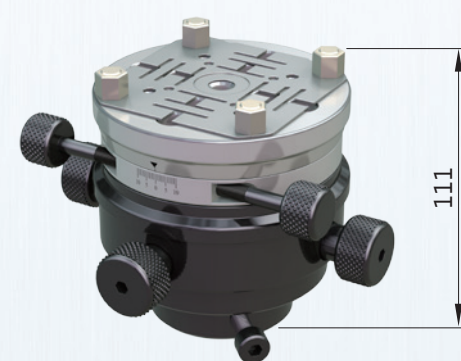
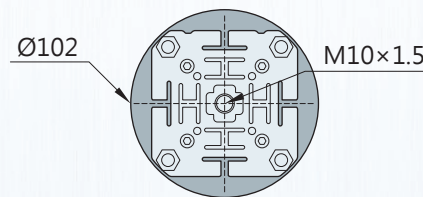


重量 Weight 5.2 kgs

HE-100E80 電極調整頭

Electrode Calibrating Holder

鎖附 E 型 8H80P 定位片
With E Type #8H80P centering plate

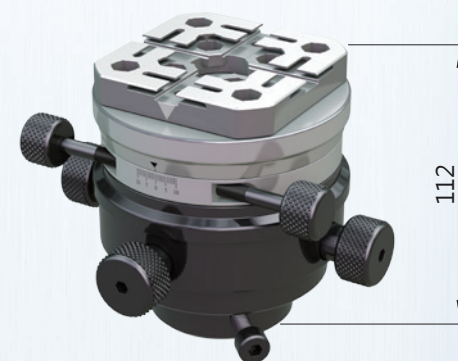
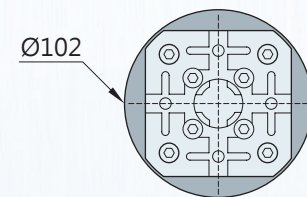


重量 Weight 5.1 kgs

HE-100R80 電極調整頭

Electrode Calibrating Holder

鎖附 R 型 8H80R 定位片
With R Type #8H80R centering plate



重量 Weight 5.5 kgs

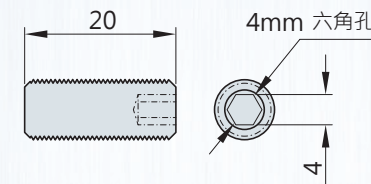
電極校正頭零配件

Adjustment head Accessories

HE-70 型 - 平行度調整螺絲

HE-70 type Parallelism adjustmentscrew

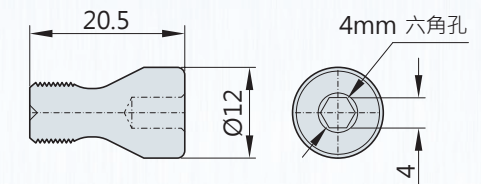
編號 No : HE07000106



HE-70 型 - 垂直度調整螺絲

HE-70 type Verticality adjustmentscrew

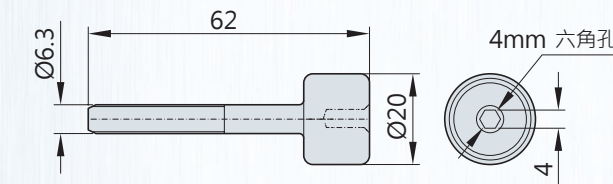
編號 No : HE07000107



HE-100 型 - 平行度調整螺絲

HE-100 type Parallelism adjustmentscrew

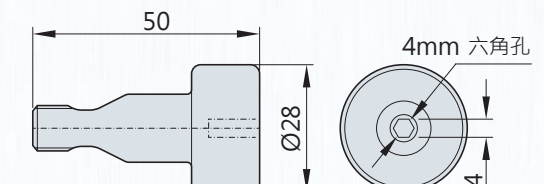
編號 No : HE10000106



HE-100 型 - 垂直度調整螺絲

HE-100 type Verticality adjustmentscrew

編號 No : HE10000107



HE-100 型選購配件

Optional accessories for HE-100 Model



CG-ER40 使用範例
CG-ER40 Usage Examples

CG-ER40 治具夾頭

Jig Chuck



材質 Material : SUS420J2, 50 HRC

① 治具夾頭之筒夾及板手為選購配件
Collet and Wrench are optional.



注意 HE-100B1/B2 無法使用
Note : HE-100B1/B2 Cannot be used