

第四届中国杭州国际钟表珠宝 商业大会

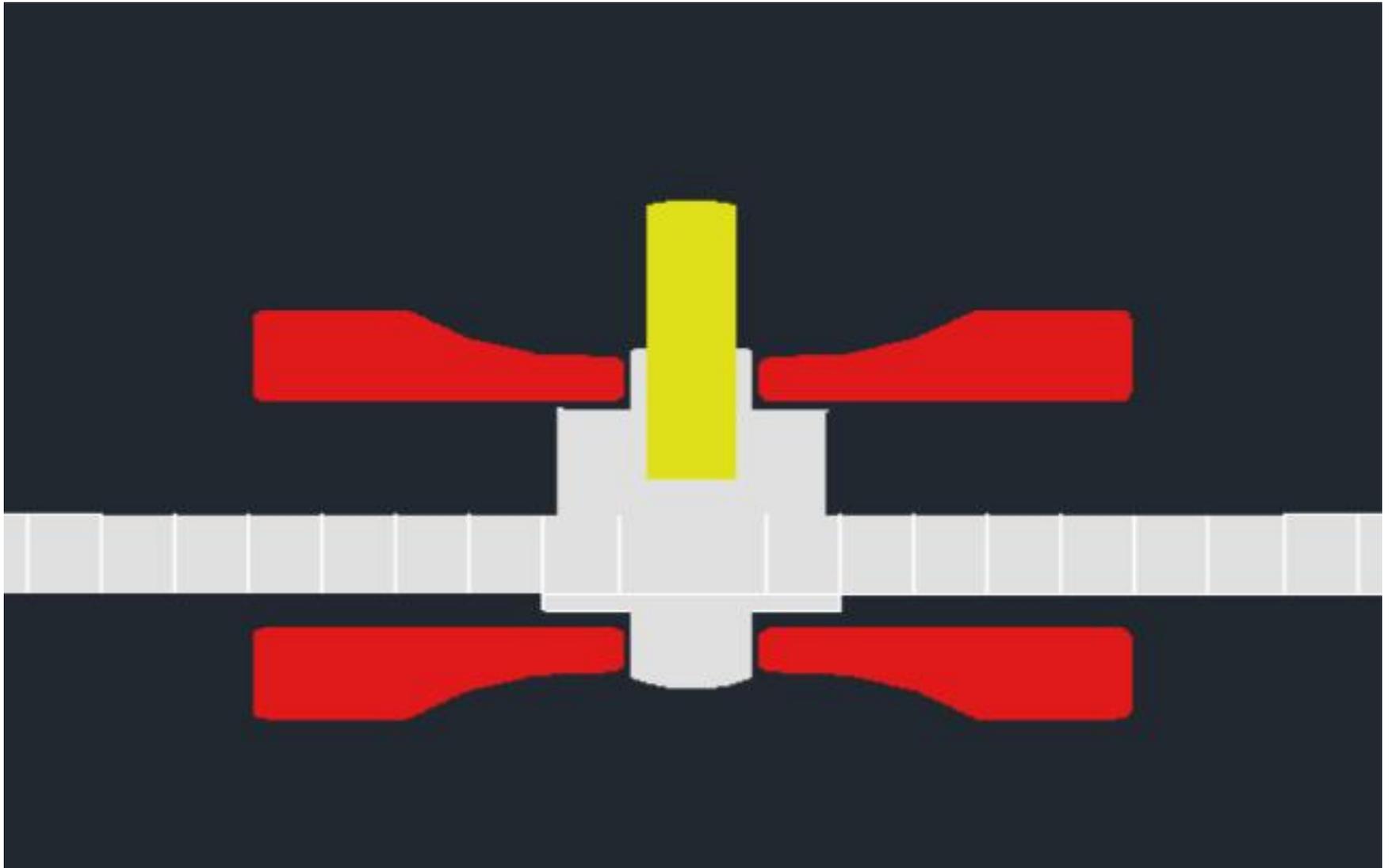
暨华众博艺钟表维修现场交流分享

—接轴(手工钻接小针轴)

1

- 1.传统钻接一般会在原件上退火,退火无论如何都会影响到原件质量!
- 2.种秒轴榫不同其它轮子的榫,因为要装秒针,不加焊取秒针时可能把种上去的拔下来,加焊又影响原件质量

2黄色部分为种上去小针轴



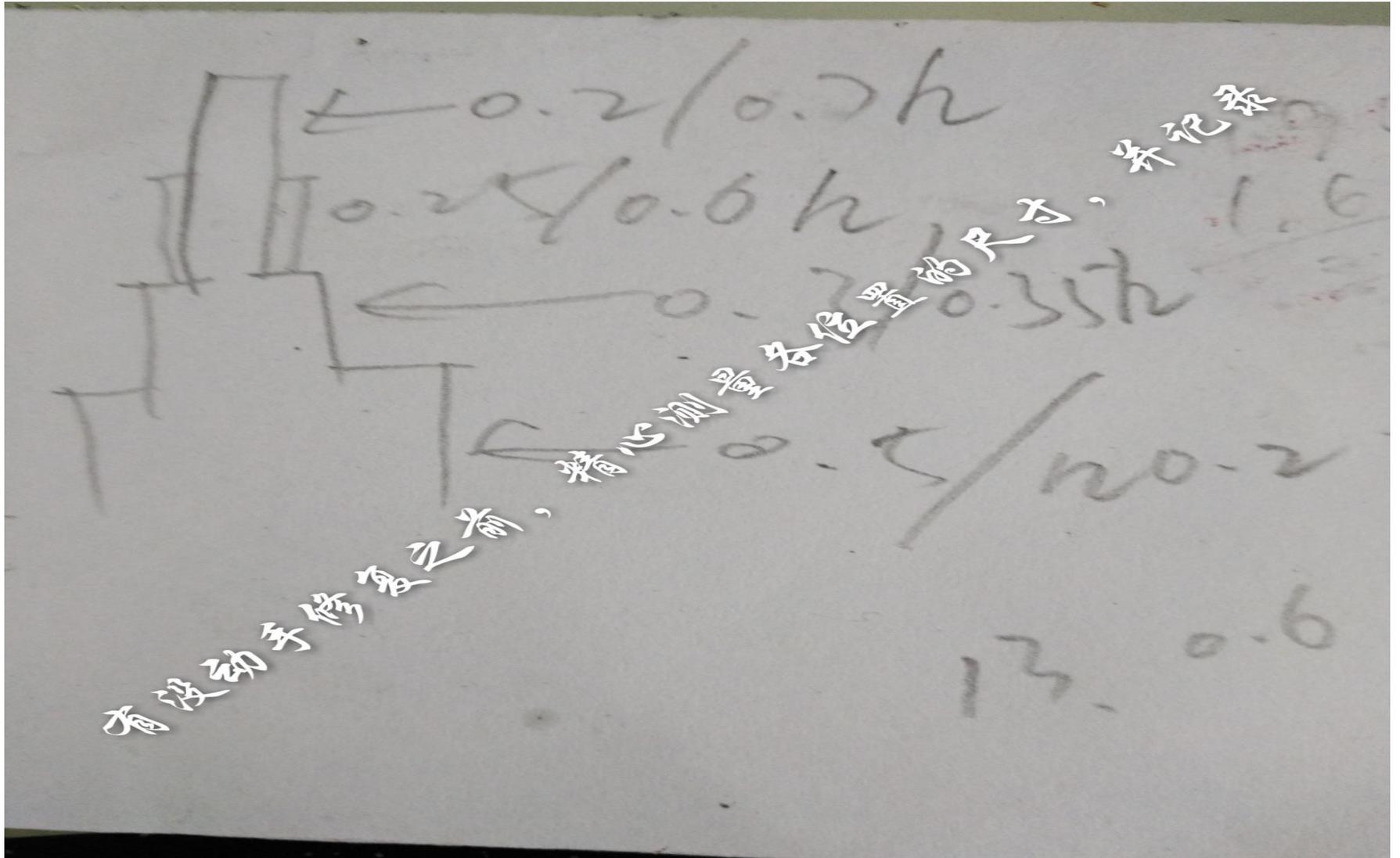
3

- 1.如何才能做到不影响原件质量而取秒针又不会有任何问题呢__**不退火.不加焊**,下面我们来讨论一下,看下实际操作案例
- 2.尽量简单实用些

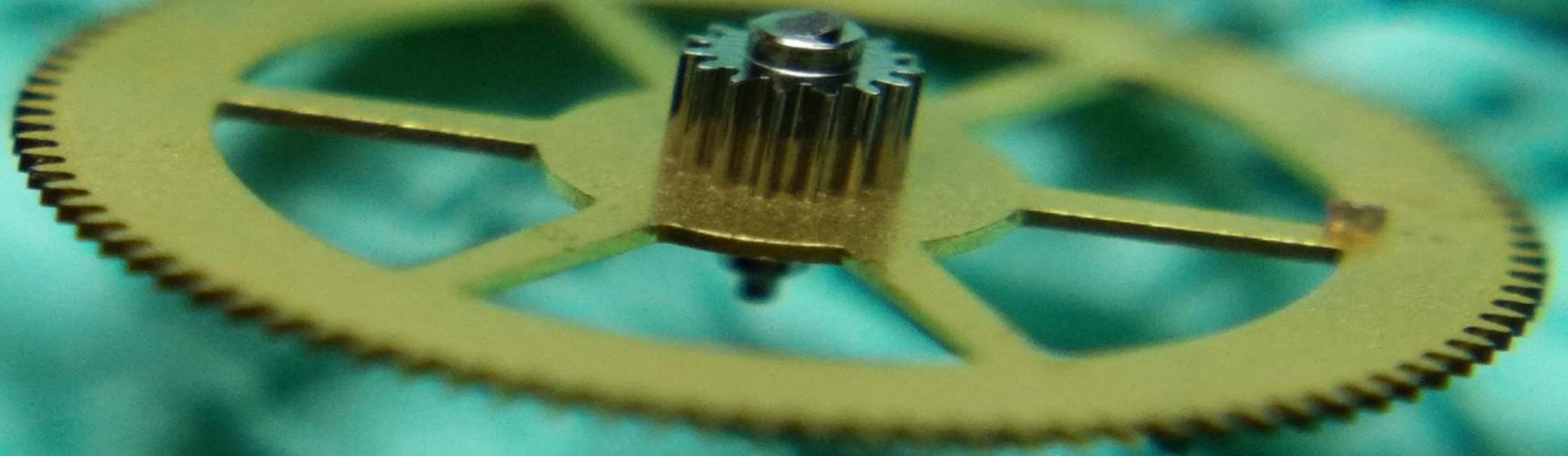
4坏件



5 测量并记录



重点



6用油石磨一个平台



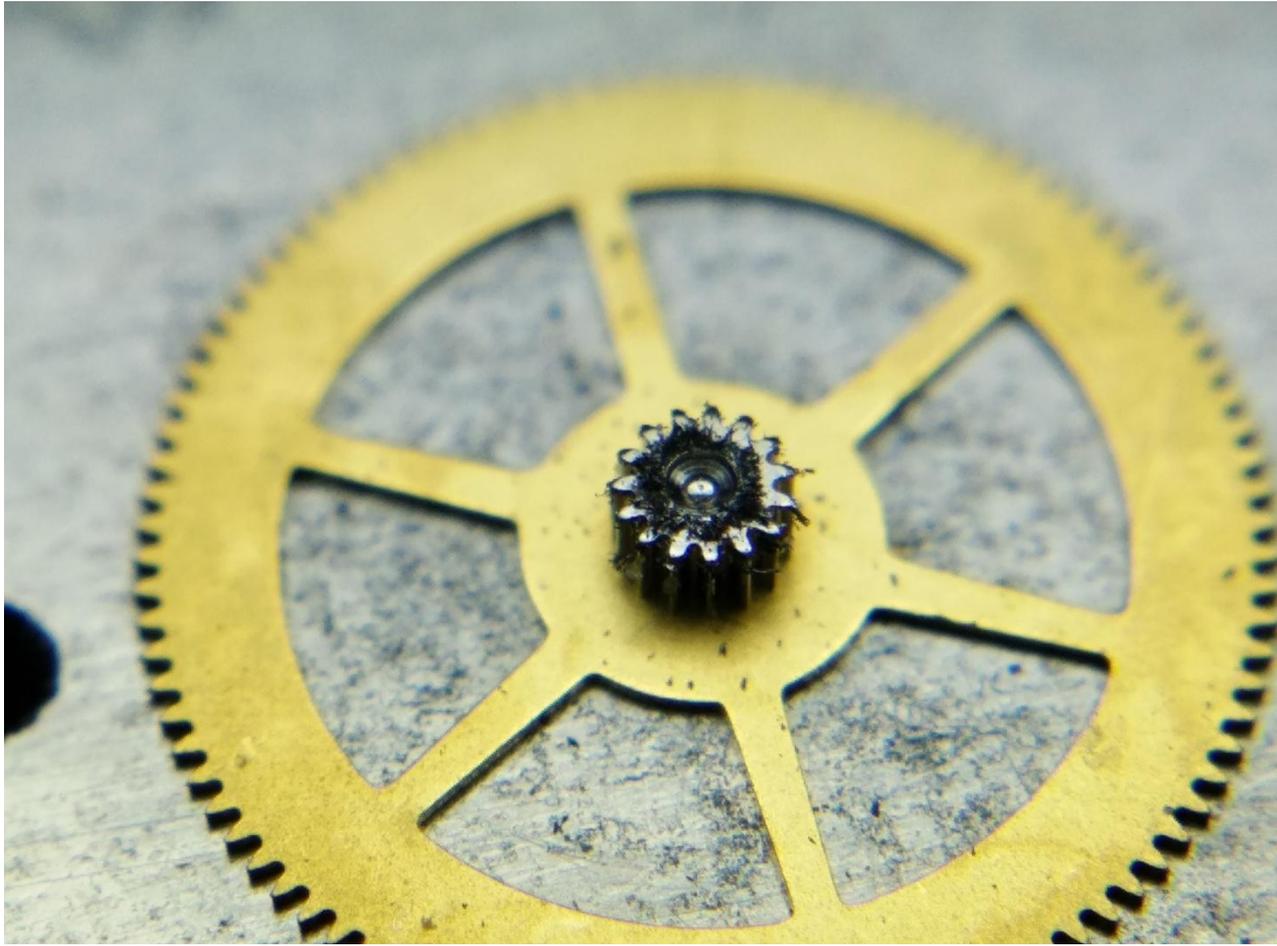
7用尖钻头钻取中心位



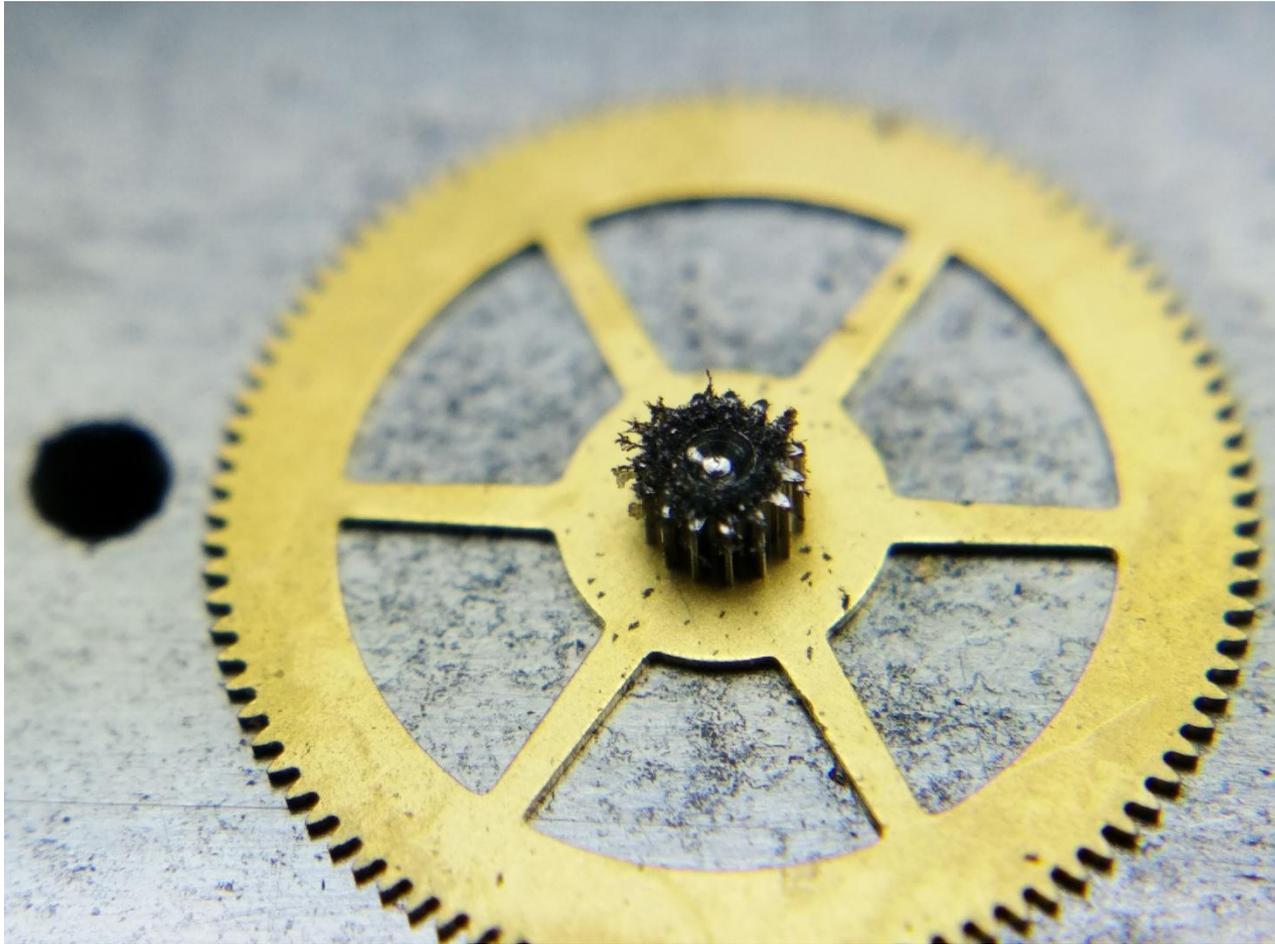
8 简易的工具



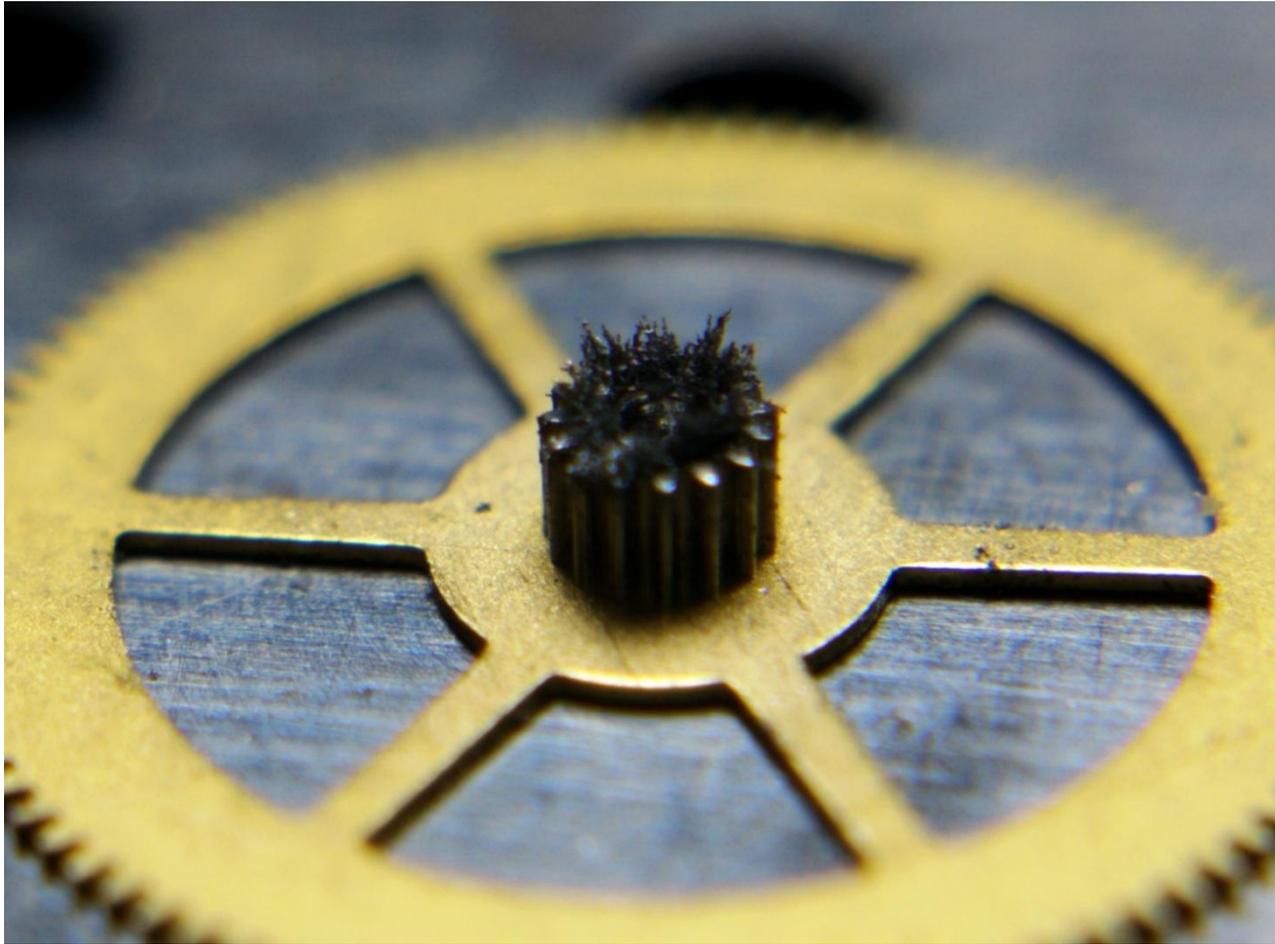
9钻



10钻



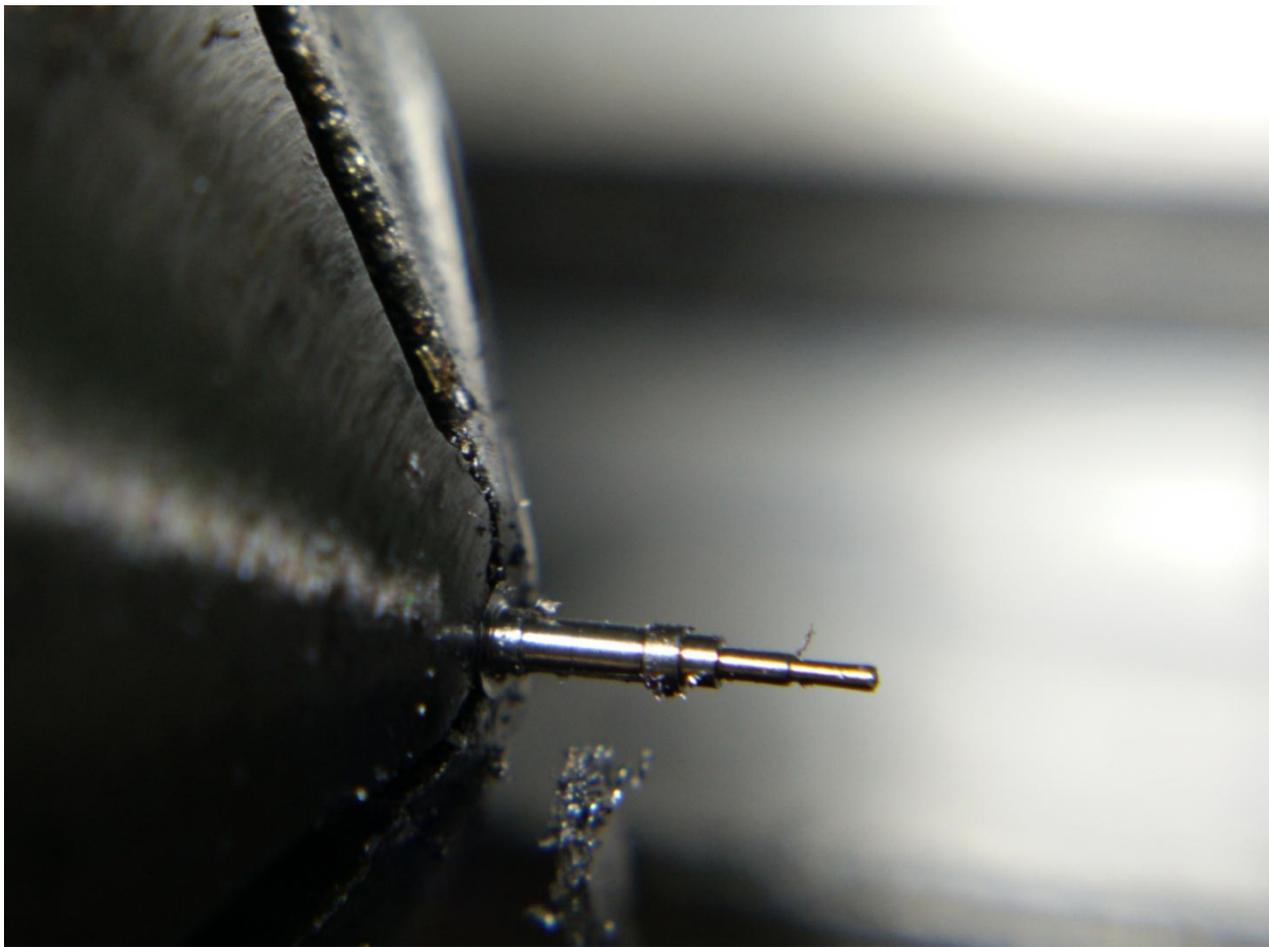
11 钻



12几分钟后一个孔就钻出来了



13车或锉一条轴



14轴坯



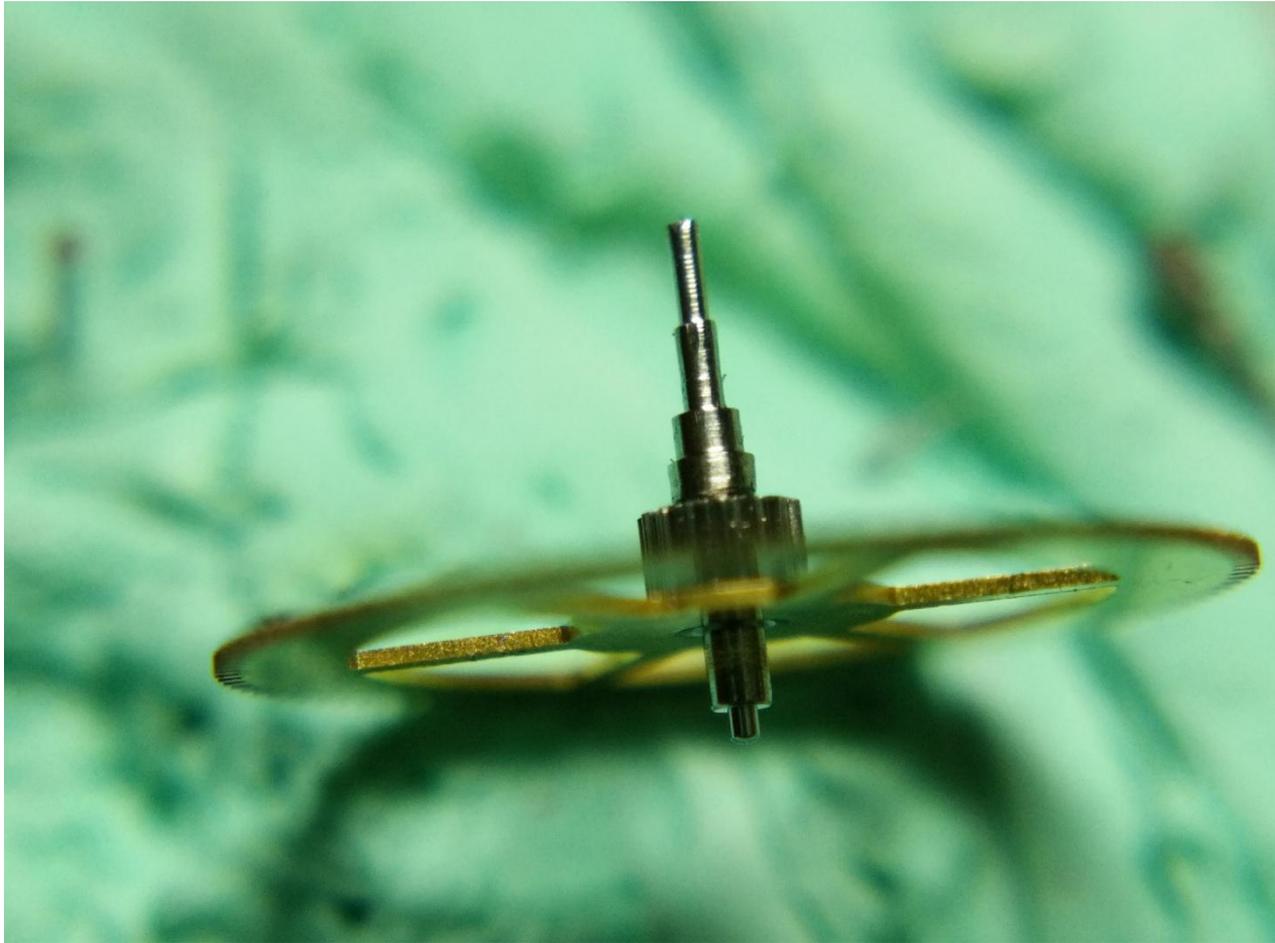
15



16把轴敲进孔里



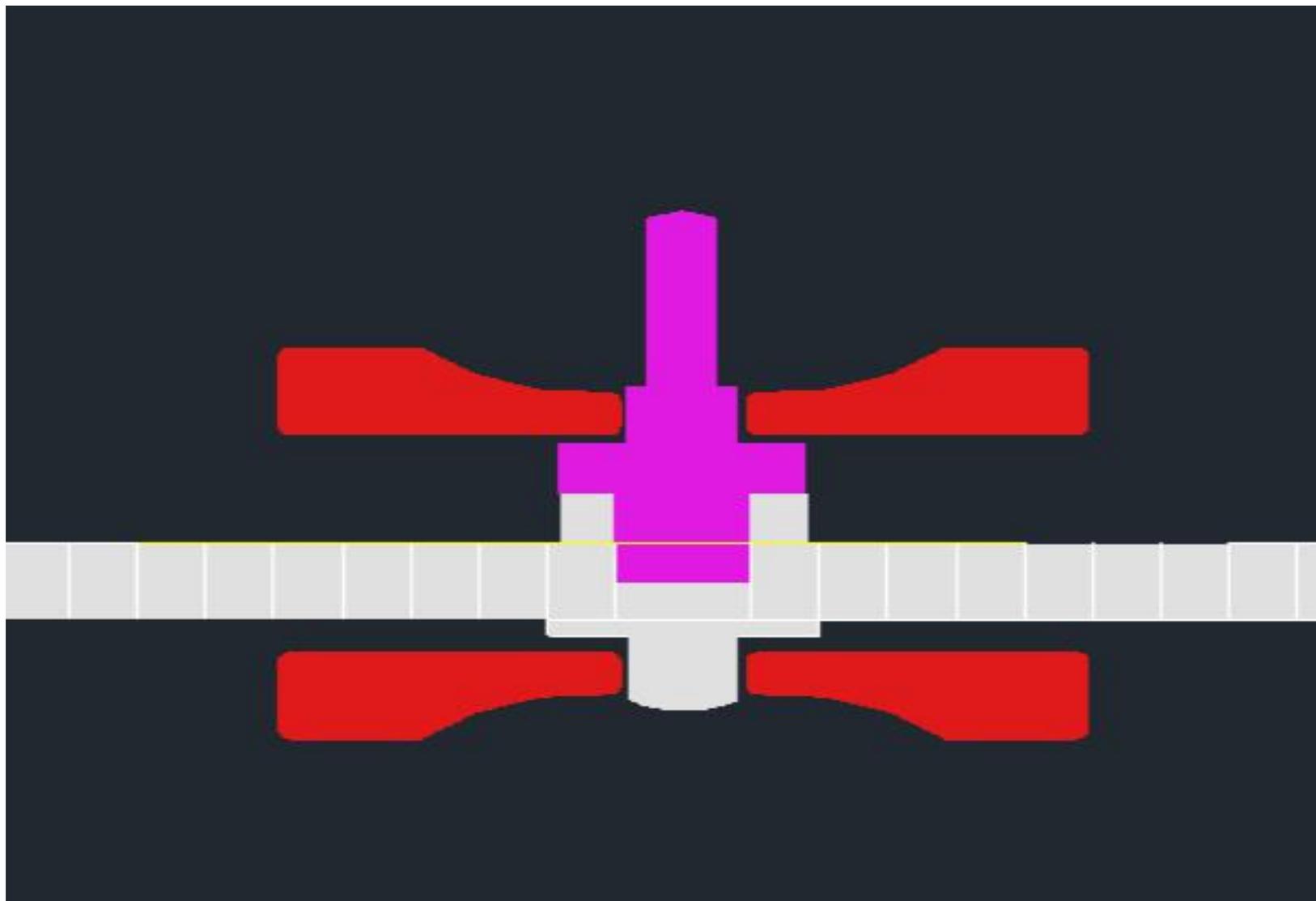
17



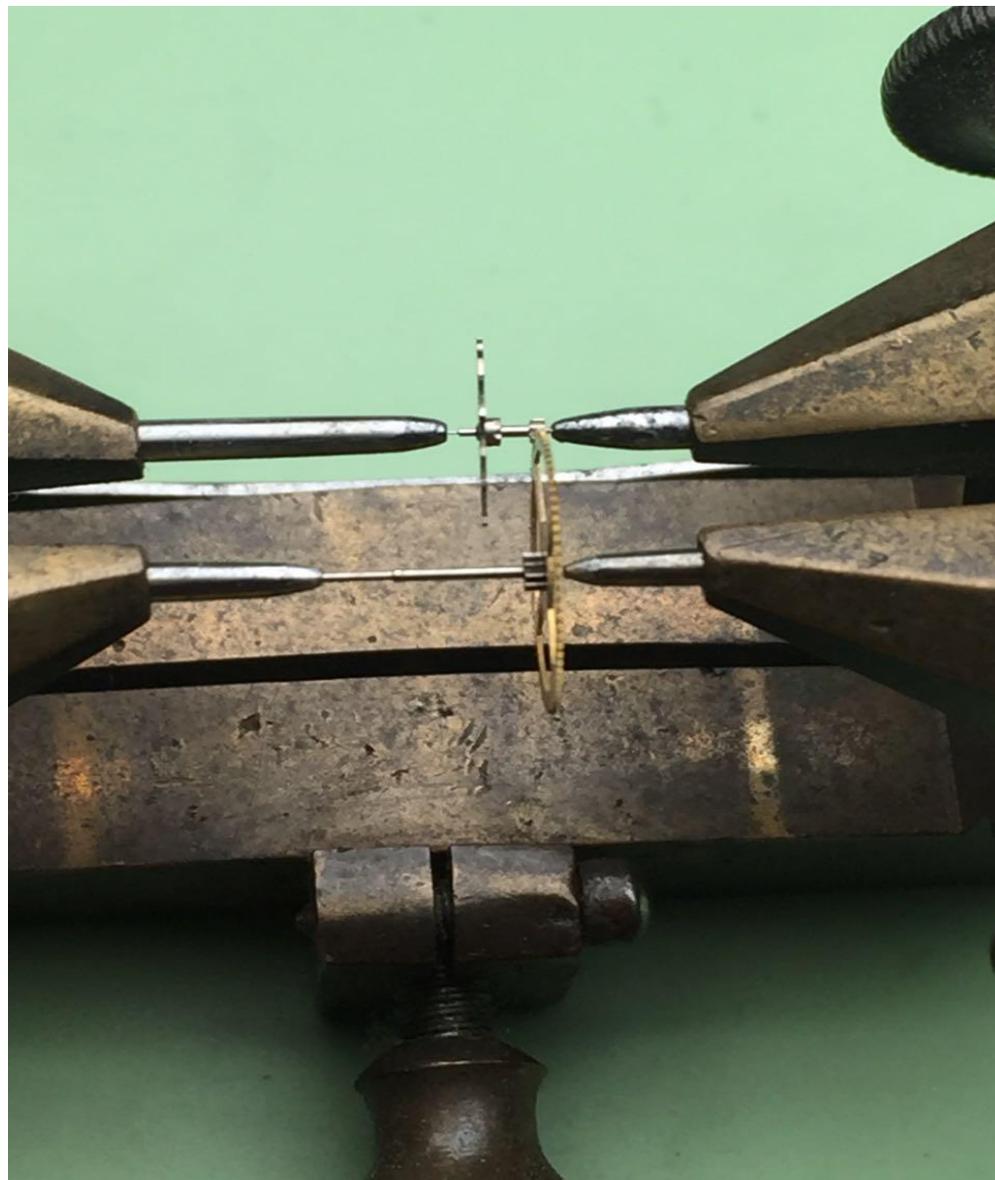
18用油石光亮



19紫色部分为种上去的小针轴



20平衡调试



1. 新秒棒钻接方法 (个人想法)

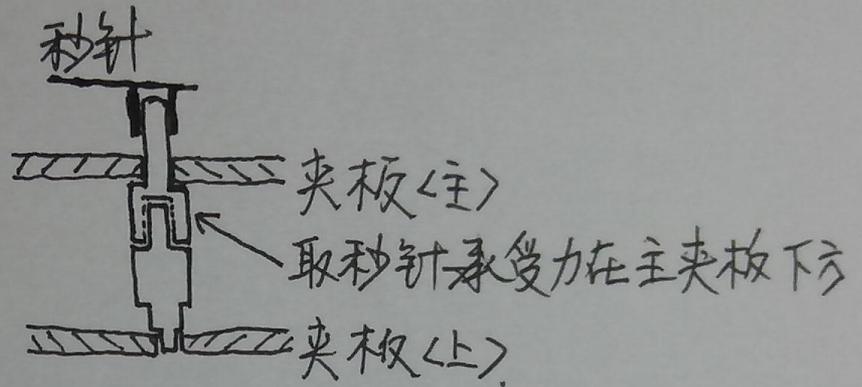
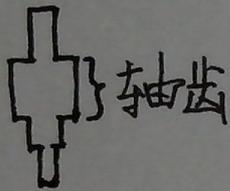
① 手工棒



①
+



② 坏件



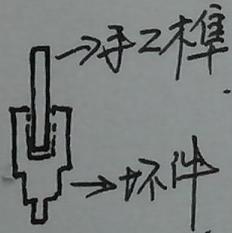
2. 接棒一般有两种. 钻接. 焊接. (焊接原工件容易退火. 钢质变软).

3. 传统接棒方法. (以上图的秒轴为例)

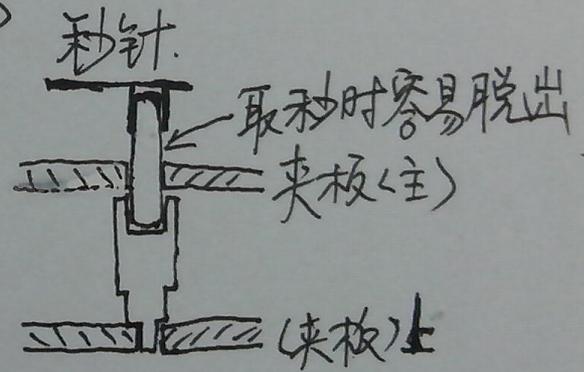
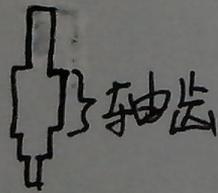
① 手工棒



在坏件上打孔



② 坏件





谢谢大家__卢国朝 2016