

Troubleshooting

(Projection Type Tool presetter NTP)

	Details of the trouble	Cause	Pulled out of holder. Unable to attach fast to spindle or holder in case of MT shank.
1	Unable to obtain required run-out accuracy.	① Seized or adhered chip and dust to spindle, adapter and holder shank part. ② Scratch and dent in spindle, adapter and holder shank part. ③ M/C-specified pull stud is not used. ④ Over-tightening of retaining bolt accompanying adapter. ⑤ Pulling screw is left attached.	① Cleaning of spindle, adapter and holder shank. ② ・Replacement of spindle, adapter and holder. ・Touching up of area in question (rubbing off with sand paper #1000 and above) Correction (grinding) by NT TOOL is not possible. (Regrinding of spindle and adapter is possible at NIHON ID SYSTEM.) ③ Use of M/C-specified pull stud. ④ Fixing of retaining bolt lightly. (Adapter is not for fixing but for retaining.) ⑤ Removal of pulling screw.
2	Unable to cramp or unclamp holder.	① Pull stud is not attached. ② M/C-specified pull stud is not used. ③ Main power source is not turned on. (Different power source from that of counter.) ④ Insufficient air supply pressure. ⑤ Adapter is not fixed.	① Attachment of pull stud. ② Use of M/C-specified pull stud. ③ Turning on main switch. ④ Adjustment of air pressure; 0.4~0.7MPa. ⑤ Make sure to attach retaining bolt which accompanies adapter, fixing by retaining bolt lightly.
3	Unable to stabilize z-axis height.	① Seized or adhered chip and dust to spindle, adapter and holder shank part. ② Loosening of z-axis dial gauge fixing arm. ③ Pulling screw is left attached.	① Cleaning of spindle, adapter and holder shank. ② Tightening of screws in arm and swiveling part. ③ Removal of pulling screw.
4	Unable to align 0 point.	① Breakage of dial gauge. ② Cross line on screen is in misalignment. ③ Arm is tilted.	① Replacement of dial gauge. ② Loosening of screws in the front of screen to adjust display board. ③ Ask NT for repair. (Readjustment of arm)
5	Dial gauge's needle does not operate smoothly.	① In case of dial gauge for X-axis, fixing screw is loosened. ② Poor movement of probe and breakage of dial gauge.	① Tightening of fixing screw. ② Replacement of dial gauge.
6	Handles of X, Z and main axis do not move smoothly.	① Lack of lubricant in sliding part. ② Breakage of internal bearing. ③ Handle's interference with body.	① Injection of specified lubricant from filler opening of X and Z axis. ② Ask NT for repair. ③ Loosening of handle mounting screw for the sake of

			adjustment.
7	Unable to move jog lever.	<p>① Power source is not turned on.</p> <p>② Circuit protector, or breaker, has tripped.</p> <p>③ Limit location is reached.</p>	<p>① Turning on main switch.</p> <p>② Lifting circuit protector on the back of body.</p> <p>③ Moving jog lever down to the other side.</p>
8	Unable to display digital counter.	<p>① Fuse is burned out.</p> <p>② Counter is in malfunction.</p>	<p>① Replacement of fuse on the back of digital counter.</p> <p>② Ask NT for repair.</p>
9	Z-axis handle lowers itself.	<p>① Abrasion in internal sliding part.</p>	<p>① Ask NT for repair.</p>
10	Holder pops out.	<p>① Adhered oil to spindle, adapter and holder shank part.</p> <p>② High air supply pressure.</p> <p>③ Pull stud adapter shared by MAS and JIS is used.</p>	<p>① Cleaning (degreasing) of spindle, adapter I.D. and tool shank part.</p> <p>② Adjustment of air pressure; 0.4~0.7MPa</p> <p>③ Be careful that holder is lifted up high because of drawing stroke.</p>
11	Difficult to see screen fogged over with mist.	<p>① Used in poor environment. (Misty or wide range of temperature)</p> <p>② Not focused.</p> <p>③ Light receiving part is fogged.</p>	<p>① Use in another place. •Proper operation temperature: 10°~30° •Proper operation humidity: 55%~60% •Away from direct sunlight.</p> <p>② Bringing light receiving part into focus.</p> <p>③ Cleaning of light receiving part.</p>
12	Unable to move switch's lever.	<p>① Switch is broken.</p>	<p>① Ask NT for repair.</p>