

Troubleshooting

(Spindle face cleaner)

	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 mount to machine.	① "A" dimension (plunger's height) is not correct. ② Used for BBT spindle (BT double face contact spindle for Big Daishowa Seiki) in case of CLE (spindle cleaner).	① Check "A" dimension (plunger's height). ② Unable to use cleaner for BBT spindle in case of CLE. (Cleaner can be broken.)
2	The plunger does not get in the positioning block groove.	① The shape of the plunger does not match with that of the positioning block. ② The orientation ring stopper screw is not tighten enough. ③ Lack of plunger actuation caused the orientation ring to idle. ④ The plunger interfered with the nearby holder in the magazine pot which can be located, due to its specification, at a large-diameter holder. This caused the plunger to shift.	① •Check the machine specification (main shift end view, etc) to be used. •Consult the M/C manufacturer. ② Tighten the stopper screw. ③ Check "A" dimension (plunger's height). ④ Check the swivel specification or empty the pots at the right and the left of the magazine.
3	Unable to clean in case of CLE.	① Deterioration, abrasion and contamination of chamois skin. ② Deterioration of internal parts (spring).	① •Ask NT for repair. •Replacement of taper corn. ② Ask NT for repair.
4	Chamois skin is peeled off in case of CLE.	① Deterioration and abrasion of chamois skin.	① •Ask NT for repair. •Replacement of taper corn.
5	Unable to clean end surface in case of CLF.	① Inappropriate air blowout direction. ② Insufficient air pressure. ③ Low spindle rotation speed in case of center through type.	① Adjustment of air blowout direction. ② Use at an air pressure of 0.4~0.7MPa. ③ Use at a rotation speed of 1000min-1.
6	Air is not supplied in case of CLF.	① Insufficient air pressure. ② Deterioration of seal parts on plunger and coolant pipe, and aging of O-ring on locating block in case of side through type.	① Use at an air pressure of 0.4~0.7MPa. ② •Ask NT for repair. •Consult the M/C manufacturer.