

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

			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>