

Troubleshooting

("R" Zero setter)

	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 clamp holder or remove it.	① Withdrawing handle does not fully revert to unclamp. ② HSK and UTS shank will stick fast. ③ Use of undesignated pull stud bolt (In case of SPZ-NT)	① Turn in loose direction to the end. ② Loosen with force. ③ Use of designated pull stud bolt
2	Poor surface attachment (In case of HSK and UTS shank)	① Dust adhesion to holder, holder support taper, surface portion ② Scratches on holder, holder support taper, surface portion	① Cleaning of holder and holder support ② Grinding with oilstone and sand paper (#3000) as an intermediate procedure
3	Slow clamp handle movement	① Dust seizing in rotation spindle and sliding surface	① • Removal of dust • Ask NT for repair.
4	Failure to attain regulated runout accuracy	① Dust adhesion to holder, holder support taper, surface portion ② Scratches on holder, holder support taper, surface portion	① Cleaning of holder and holder support ② Grinding with oilstone and sand paper (#3000) as an intermediate procedure
5	Slow holder support movement	① Interference with whirl-stop key ② Abrasion and deterioration of bearing	① Fixation with the key lowered ② Ask NT for repair.
6	Poor test indicator movement	① Oil adhesion ② Measuring equipment damage	① Cleaning around measuring equipment ② Replacement of test indicator