



# CT20D TOOL SETTER

# PRODUCT MANUAL



**JIZHI MEASUREMENT & CONTROL  
TECHNOLOGY (SUZHOU) CO., LTD.**

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OFFICIAL ACCOUNT

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## USAGE NOTICE

### About Warranty

Jizhi Measurement and Control has passed the ISO9001 quality management system certification, and has been striving to provide customers with high-quality products and services. Before using the product, please read the manual carefully to understand the performance and structure of the product in detail, and use it correctly. Correct operation can help you avoid misoperation and other problems in use. In addition, the design and manufacture of products are mainly for general industries. Please help us to strengthen the facilities such as fault protection, so that we can provide better safety design to prevent work accidents.

### Warranty Period

One-year warranty and lifetime maintenance will be implemented from the date of arrival or delivery.

### Warranty Scope

During the warranty period, if the product has its own problems, the company provides substitutes or implements free maintenance for the faulty product. If the cause of the failure belongs to the following circumstances, even if it is still within the warranty period, it is not within the scope of the guaranteed object:

- The equipment is damaged due to wrong installation or human impact.
- Disassemble the product, modify, refit or replace the internal parts by yourself.



- Inadvertent use is damaged by water, oil and other substances infiltrated into the machine.
- Failure or damage caused by force majeure such as natural disasters.

### Warranty Liability

The warranty is limited to the single product.

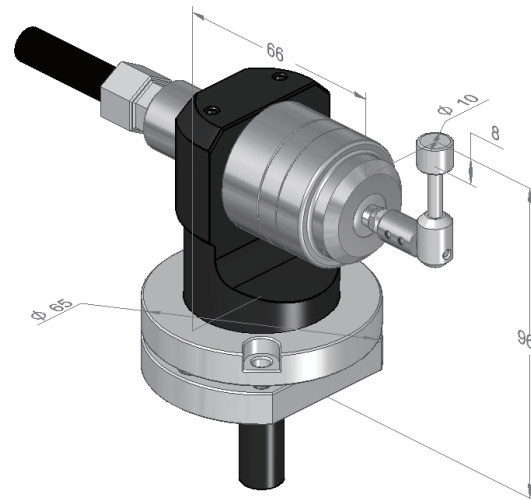
### Others

- After the product is purchased, the appearance, structure, software, price and other contents may be changed without notice.
- If there are many uncontrolled factors in the user and on-site usage, please add additional protection facilities according to actual needs to avoid the possibility of secondary accidents.
- The contents of this manual are not responsible for any damage caused by clerical errors or wording, and the final interpretation right belongs to our company.

## PRECAUTIONS

- It is the responsibility of the machine tool manufacturer to ensure that the user is aware of any hazards in operation, including those described in the product manual, and provides adequate guards and safety linkages. In some cases, the machine tool may incorrectly indicate that the probe is in position, please do not stop the machine movement by the probe signal alone.
- All 0V/Ground connections should be made to the 'star point' of the machine ('star point' is a single point return for all equipment ground and shielded cables). This is very important, failure to follow this rule can cause potential differences between grounds.
- The installation location of the interface must be far away from any potential sources of electrical noise, such as transformers, servo system drives, etc.
- All shields must be connected as described in the operating instructions, and cable runs must not run parallel to high current sources such as motor power cables or near high speed data transmission lines.

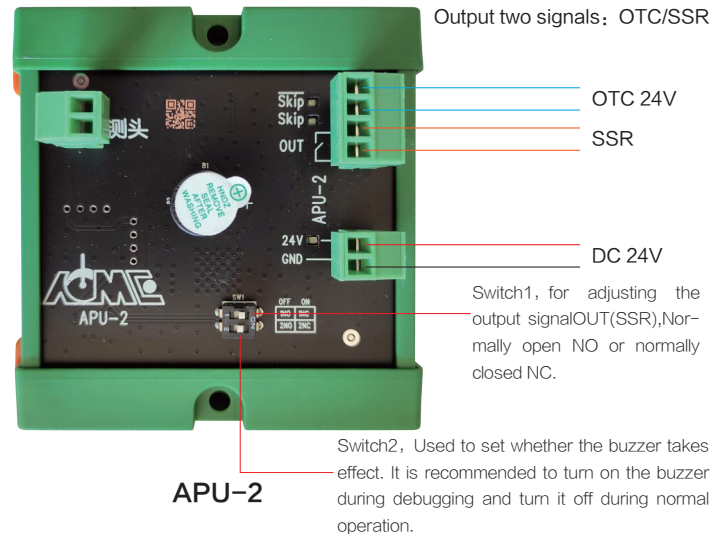
## SPECIFICATIONS PARAMETERS



Parameters	illustrate
Precision	$2\sigma \leq 1\mu\text{m}$ Measuring speed F=50
Trigger direction	$\pm X \pm Y -Z$
Stylus maximum swing angle/Axial setback length	xy: $\pm 12^\circ$ Z: -4
Main body diameter	36 mm
Measuring speed	50 mm/min
Material	Stainless steel
Temperature range	10°C - 50°C
Protection class	IP 68
Trigger life	> 8 million times

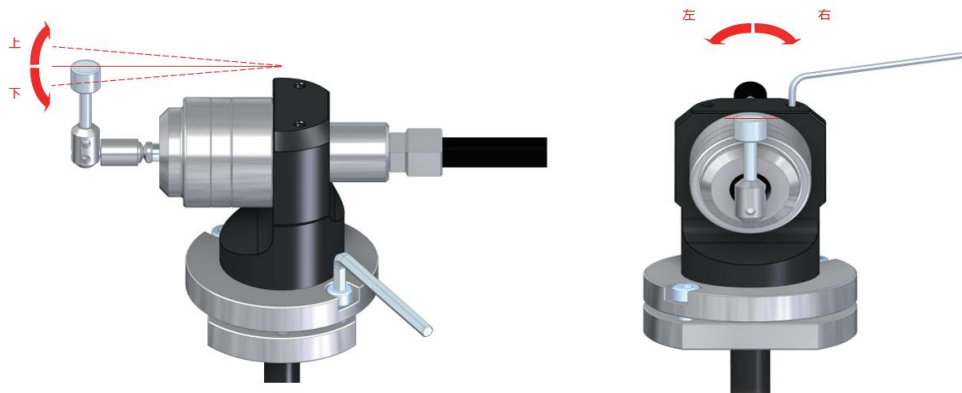
### ELECTRICAL CONNECTION INSTRUCTIONS

Cable access electrical box  
left binding post (No matter positive  
or negative)



## INSTALLATION & ADJUSTMENT INSTRUCTIONS

Install the tool setter on the table, First adjust the contacts by loosening the base bolts **front-to-back** plane, And then through the elastic body top wire to the contact **Left and right directions** plane to adjust, adjusted to 0.03mm以内。



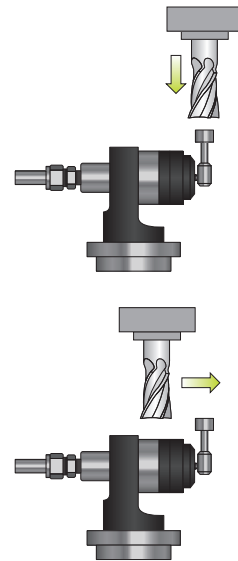
## USE METHOD

1) Axial use, the tip of the knife is facing the contact, and it is triggered directly downward; radial use, reverse rotation of the tool, radial proximity contact triggering.

2) The travel of the tool setter must be considered. Do not press too hard, it may damage the tool setter and the tool.

3) The speed of aligning the tool tip is related to the electrical response speed of the machine side, so be careful not to exceed the specified speed when setting. In order to ensure the accuracy of the tool setter, it is recommended that the speed be set as follows.

50-200mm/min repeatability 0.001mm (When the response speed of the mechanical control system is within 0.5msec), However, when the tool diameter is within 0.5mm, please use low-speed contact. (Also need to choose low contact force type)



## MAINTENANCE INSTRUCTIONS

**There are three main forms of cleaning and preventing chips:** .....

### 1) Jet tube

- Blows away chips and coolant adhering to contact surfaces and tools. The grease and foreign matter that cannot be blown off and stick to the contact part should be cleaned frequently.
- Gas pipe tip screw fittings can break when the tool and chips are impacted strongly.
- The inner diameter of the air pipe passage should be set at 2mm or more.

### 2) Protection cap

- In an environment with chips, if the rubber cover protects the chip and coolant, the protective cover is required when the chips and coolant accumulate and prevent the operation of the movable parts.
- There are fixed (or detachable) and automatic switching types. Used by customers according to the situation.

### 3) Clean up

- Chips and oil that stick to the contacts (super hard) and are difficult to blow off with air, please clean them with an alcohol lamp.
- Around the rubber boot. The clearance between the rubber cover and the air tube, and the accumulation of chips on the outside of the cover may prevent the rubber from moving and moving back. Please clean it.
- Do not open the inside of the rubber shield.



You can follow the instructions to perform maintenance procedures.

Further dismantling and repairs are highly specialized operations and must be carried out by an authorised service centre.

If a product within the scope of warranty needs repair, overhaul or maintenance, please send the product to the supplier for processing.