MMG Service srl - Via Don Minzoni, 20
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INSTRUCTION

1. Summary

GZ-66 series tool setter is dedicated to CNC engraving and milling machine.
It can be used to detect wear and breakage and correct thermal distortion as well as to preset tool length.

2. Structure, size and main specifications

Please also refer to the tool setter's drawing.

3. Special Considerations

Please control setting speed 50-200mm / min or less.
The tool's center to fall on the center of the setter's surface.
Ensure the parallelism after installation.
Please use blowing device normally.

4. Installation considerations

(1) ***Mechanical***

- *Please try to install it at the place of less iron filing on the workbench.*
- *Please install correctly the tool setter before use.*
- *Recommend the installation on the good level stand, make sure the parallelism of tool setter.*
  (the base of tool setter installed to stand with the M4 Allen screws, installing screw dimensions refer to the drawing)

(2) ***Electrical***

- *Be sure within the rated power range.*

(3) ***Air pipes***

- *Please use the pipe joints, outer diameter of 4mm, inner diameter of 2.5mm.*

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1. **Cautions in operation**

- The ways for tool setting (see Figure 1-1)
- The tool contact surface must be vertically downward.
- Not exceed the stroke of the tool setter, otherwise it will be damaged. (Stroke 5.0 mm)
- The setting speed is related to the electrical response speed of the machine, so please set within the specified speed.
  To ensure accurate setting, we recommend the setting speed 50 : 500mm / min.
  Repeatability 0.002mm (response speed of mechanical control system is 0.5m / sec or more).
- Do not release the contact surface immediately , in order to avoid to damage its internal structure.
- When the tool setting is done you must move up the tool vertically and not laterally.

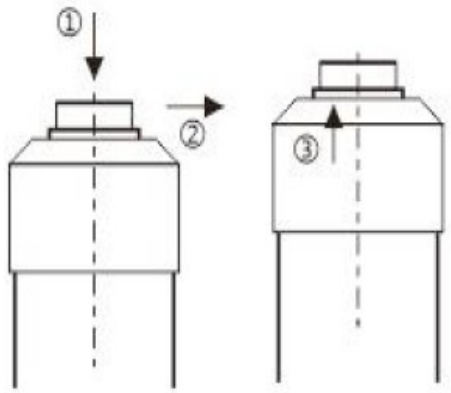

图1-1

1. **Cleaning of contact surface**
   Please clean the rest of iron filing and cutting oil, when the air blowing doesn't work.

2. **Confirmation method of output signal**
   Measurement signal: normally open (NO).
   Over-travel signal: normally closed (NC).

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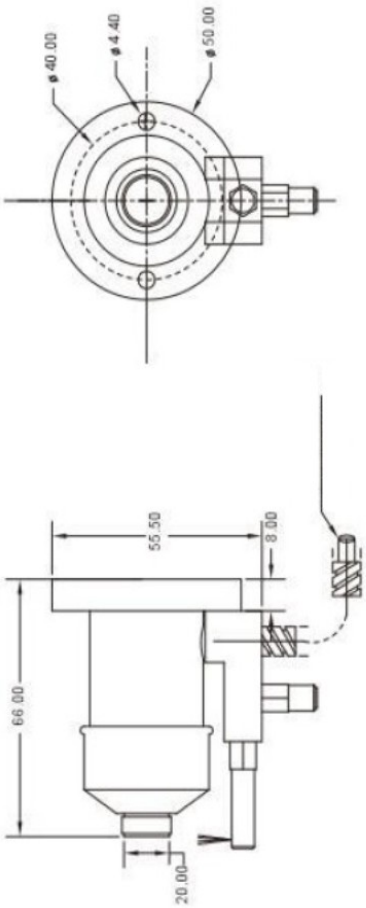

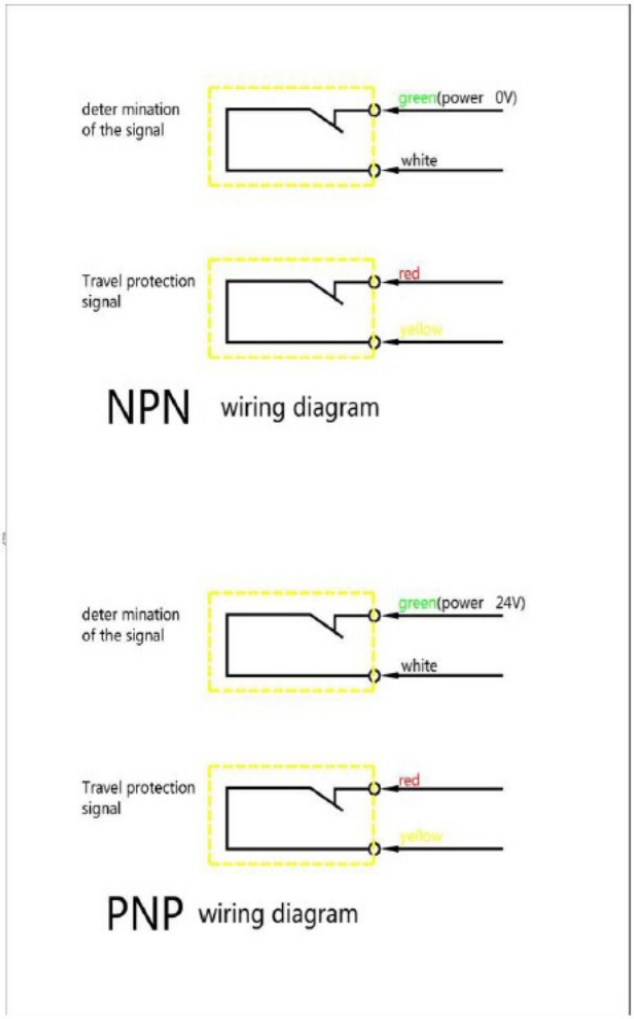

Wiring diagram

function	No.(left to right)	color	spec.	
Measuring signal	1	green	24v	Voltage:10-30V
	2	white	Setting signal	Current:10-20mA
Over-travel signal	3	red		
	4	yellow		