

CENTERING HOLDER INSTRUCTION MANUAL

NIKKEN
VER.1

Thank you for your purchase of this Nikken product. Please read the following information to enable the correct use of this product. Please keep this manual where the operator can refer to this whenever necessary.

■Preparation

1. Installation of Dial Gauge.

- Fit the attached dial gauge with M6 screw as per the illustration Fig.1.
- ※Locate the dial gauge indicator perpendicular to the main shank.

■Setting of dial gauge read-out range

1. Turn the fine adjust screw ① in a CW direction till it stops.
 2. Loosen the setting screw ② with attached Hexagon wrench.
 3. Turn the dial gauge adjust screw ③ in a CCW direction and set the sub-indicator to "0".
 4. Tighten the setting screw ② to fix the dial adjust screw ③.
 5. Turn the fine adjust screw ① CCW to set the sub-indicator to "5".
- ※With the above set up, the measurement can be taken within 5mm of the internal or external diameter of the work piece to be measured.
 - ※In order to extend the measuring range, it can be adjusted to MAX. 10mm with the fine adjust screw ①.

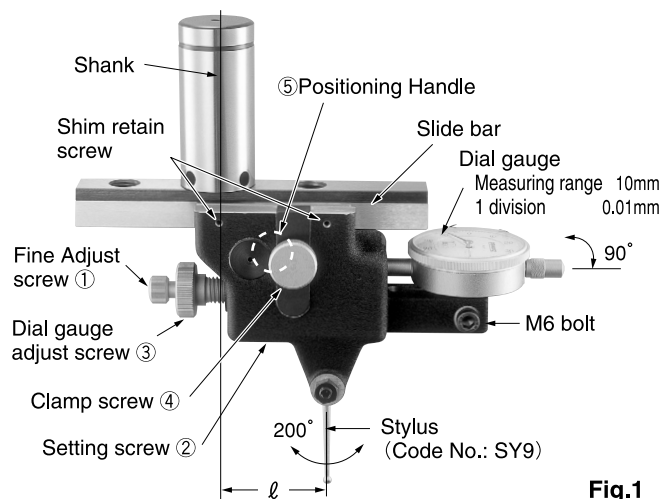


Fig.1

■Adjustment of the measuring position

1. Hold the Centering Holder with Nikken Milling Chuck and set them on the machine spindle.
 2. Check the measuring radius = l .
 3. Loosen the clamp screw ④ and shift the spindle to the measuring radius = l by Positioning Handle ⑤.
- ※MAX. measuring radius l max = 120mm.
 - ※Set the centering holder at the suitable position on the Slide Bar for the diameter to be measured. (Please refer to the below) Please make sure that the dial gauge can be seen at the set up.
4. Tighten the clamp screw ④ to fix.

【Specification】

Code No.	ID of Milling Chuck ϕD	Measuring range
SY22-120	$\phi 22$	0 ~ $\phi 240$
SY32-120	$\phi 32$	
SY42-120	$\phi 42$	

The explanation of the Code No.

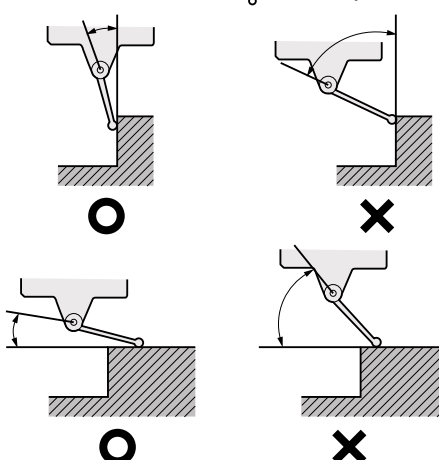
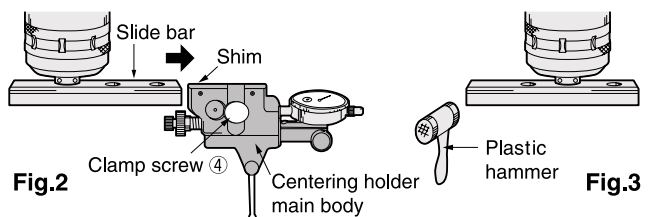
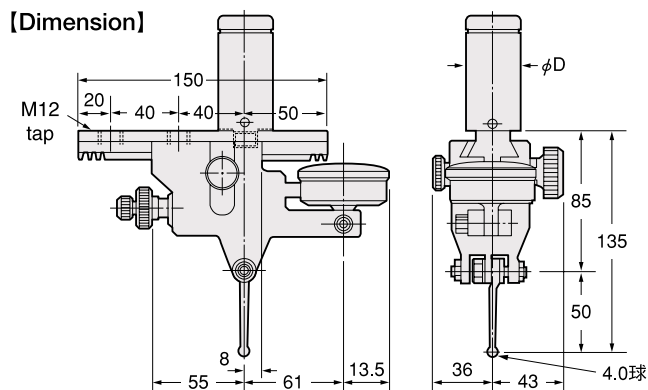
SY 32 - 120
 MAX. measuring radius
 Shank dia.: $\phi 22, 32, 42$ mm
 Symbol of centering holder

★The dial gauge of 0.01mm indication is standard accessory.
 ★MT shank (MT2~MT6) is also available as an option.

■Change of the shank fitting location on the Slide Bar

1. Loosen the clamp screw ④ and take the centering holder off the Slide Bar. (Fig.2)
 2. Lightly tap the left-hand side of the Slide Bar with plastic hammer and remove the bar from the shank in the machine spindle.
 3. Set the holder on another suitable position on the bar and fix it with the soft hammer.
- ※Please pay attention not to damage the slide bar when tapping it because damage may cause the problem to re-fit the centering holder on the slide bar. (Fig.3)
4. Set the Centering Holder on the Slide Bar.
- ※The Shim on the Centering Holder is not fixed to the holder so please pay attention not to drop on the floor.
 - ※Please make sure that the shim retain screw is not over tightened or it might cause the difficulty of slide the holder on the bar.
5. Adjust the holder to the radius to be measured and fix the location with tightening of the clamp screw ④.

【Dimension】



⚠ Caution

- Please pay attention for the handle to avoid dropping or hit the holder.
- Please make sure that the water/coolant has been wiped away and the coolant should not be splashed on the dial gauge or it might cause the breakage of the dial gauge.
- Although the measuring probe is adjustable (200°), please make sure that the adjustment is adequate without creating any interference to the work piece. Otherwise, it might cause the defect of measuring accuracy or damage of the holder.
- For long term storage, always use a soft and clean cloth to remove moisture, and put a small amount of a rust inhibitor thinly on the holder, not on the dial gauge, and store in a clean, dry place.

The above is basic safety information for the use and handling of our product. Please contact us for further information. Please note that we will not accept any responsibility for the breakdown or accident due to any modification carried out on the rotary table by the customer without our approval.

NIKKEN
NIKKEN KOSAKUSHO WORKS, LTD.

Head office : 5-1, 1-chome, Minamishinden, Daito, Osaka, Japan
 Tel : 072-869-5820 Fax : 072-869-6220
<http://www.nikken-world.com> e-mail:osaka@nikken-kosakusho.co.jp