

Thank you for your purchase of NIKKEN products. We can recommend our products with our confidence, however, please read this manual for long terms. And, please keep it where the operator can refer to it whenever necessary.

Please read this instruction carefully before using your Height Presetter HP-50K

1. Always keep clean the top and the base surfaces of the presetter and ensure that there's no swarf or coolant on the workpiece surface or the cutting tool. Failure to do so may cause the error of the measuring.
2. Please note that this equipment is not applicable to nonconductive workpiece.
3. Please do not exceed the stroke of the presetter so as to avoid damaging the presetter.


1 Operations

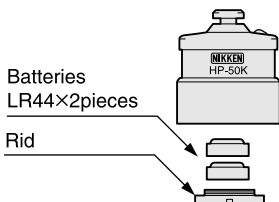
Set the HP-50K on the workpiece surface to be measured. The red lamp is activated as soon as the cutting tool touches the top surface of the presetter, which means the location is exactly 50mm from the reference surface.

According to the above, the workpiece reference point and the tool length can be also obtained. When the presetter sets on the side of the workpiece, the cutting tool diameter compensation value can be also obtained.

2 Changing of the batteries

The batteries can last for approximately (two) months as normal use.

 Please ensure that the batteries are set correctly at the changing.

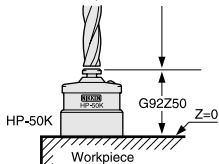


〈Tool length compensation value〉

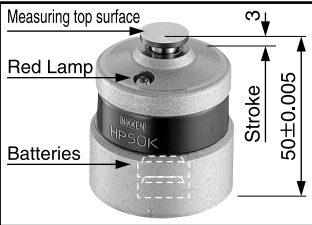
Program example
G92 Z50
G43 Z0 H01

Z axis reference point

Display value = Compensation value = H01



3 Parts description



CAUTION

- HEIGHT PRESETTER can not be used for the work piece without conductivity.
- Please avoid to use under presence of coolant.
- Quotation fee of the repair is always necessary whether repair or not.

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