Passive Tool Setter Calibration

The Passive Tool Setter (PTS) has three base attaching screws (Philips) and three adjustment set screws (1/16 Allen) that are 120° apart on the bottom of the base.

By loosening the base attaching screws and adjusting the adjustment screws you can adjust the angle of the top contact plate in relation to the base.

This adjustment should be done when you first receive the tool setter, any time you install or remove the optional magnetic base, and periodically depending on use and environment.

Adjusting Tool Setter using PathPilot

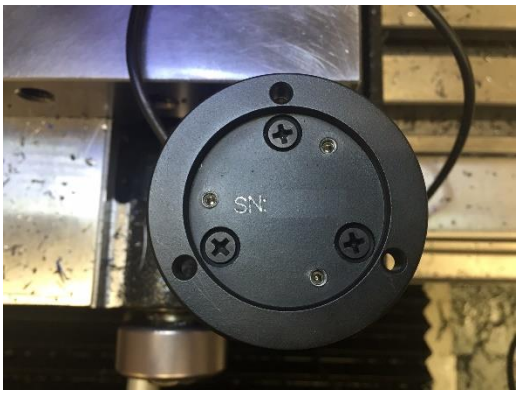
The Tool Setter has three attaching screws (Philips) and three adjustment set screws (1/16 Allen) 120° apart on the bottom of the base (Figure #1).
By loosening the base attaching screw and tightening the adjustment screws you can modify the gap between the base and the body of the tool setter.

1. The first step is to measure the offset of the contact plate:
2. Click on the PROBE tab in the middle of the PathPilot screen and then select the X,Y,Z tab at the top left corner of the screen.
3. Position the tool setter in the location that you want to use for calibrating with one of the base adjusting screws at the 12 o'clock position (picture #2) (do not move until complete).
4. Verify that the Accessory Input indicator lights when you depress the tool setter.
5. Position any pointed tool mounted in the spindle ay the 12 o'clock position of the contact face (picture #3) and select the "Probe Z - Set Work Origin" Icon located in the upper right hand corner of screen.
6. Move the table (not the tool setter) so that the tool is in the 4 o'clock position of the contact face (picture #4) and select the "Find Z-" Icon also located in the upper right hand corner of screen and note the dimension.
7. Move the table again so that the tool is in the 8 o'clock position of the contact face (picture #5) and select the "Find Z-" Icon also located in the upper right hand corner of screen and note the dimension as well.
8. The at the 12 o'clock position is .0000 if the dimension at the 4 or 8 o'clock position is a negative number you will need to tighten the adjusting screw at that location (you may need to loosen the base attachment screws (picture #6).
9. If the dimension at the 4 or 8 o'clock position is a positive number you will need to loosen the adjusting screw at that location and tighten the base attachment screws.
10. After you do adjustments go back to step #3 and repeat the process until you are happy with the offset of the contact plate.
11. After you have completed your adjustments verify that the sealing O-ring is in position (picture #7)

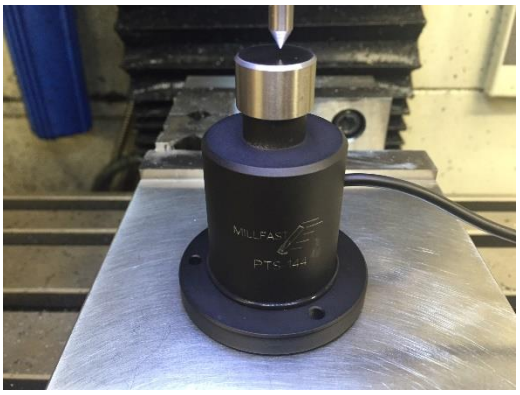
If you have any issues or questions feel free to send us an email at info@millfastproducts.com

Passive Tool Setter Calibration

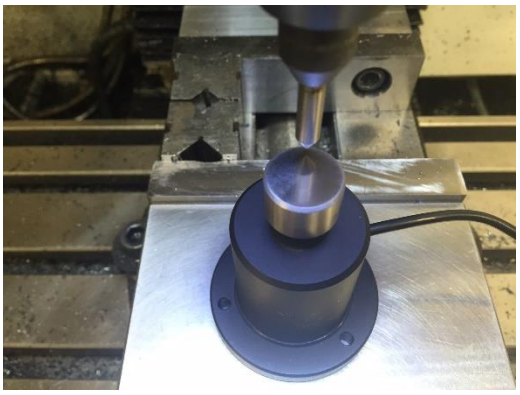
Picture Page



Picture #1

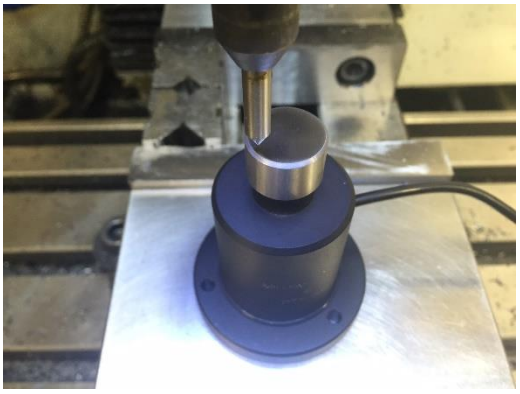


Picture #2

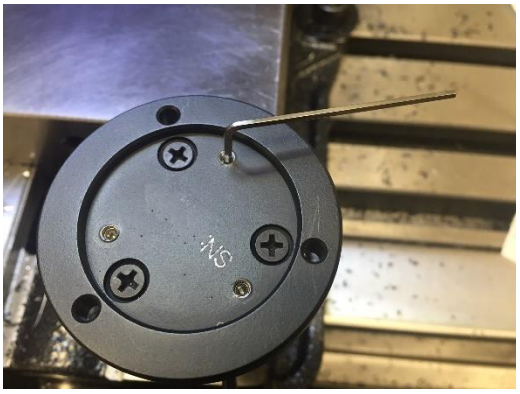


Picture #3

Picture #4



Picture #5



Picture #6

Warning!!!

Any machine tool is potentially dangerous. The automation inherent in a CNC machine presents added risk not present in a manual mill.
Safe operation of the machine depends on its proper use and the precautions taken by the operator.
Read and understand your mills manual prior to its use. Only trained personnel with a clear and thorough understanding of its operation and safety requirements should operate any mill.
Millfast Products accepts no responsibility for machine performance or any damage or injury caused by its use. It is your responsibility to ensure you understand the implications of what you are doing and comply with any legislation and codes of practice applicable to your city, state or nation.