OPERATION INSTRUCTION
Zero Setter

Attention: The zero setter should be aligned with the center of the instrument during calibration and use (Fig.4)

Code	Height	Accuracy
2394-100A	100mm	±0.01mm
2397-502A	50mm	±0.01mm

2397-502A

2394-100A

1-Anvil
2-Soket screw
3-Knob

4-Dial
5-Magnetic switch

1. Clean the top plane and the bottom before use.
2. Before use, it is necessary to set zero. Turn the knob to let the arrow of 'SET' points upper (fig. 1). Press the top plane, rotate the bezel until the long needle points to zero, while the short needle also points to zero (fig. 2). It is required to check regularly if the zero is properly set.
3. How to use Turn the knob to let the arrow of 'USE' points upper(fig. 3). Put the zero setter on the working table, series 2397 has magnetic base and series 2394 has magnetic base with on-off switch. Let the cutting tool touch the top plane. The indicator shows the difference between the height of the cutting tool and standard height. In fig. 4, the reading of indicator is 0.20, so the height between cutting tool and working table is 50-0.20=49.80mm.

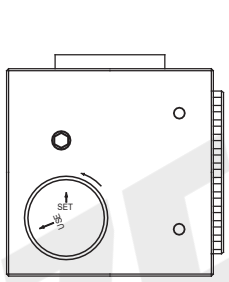

Fig.1

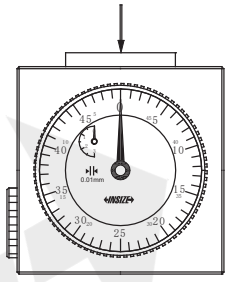

Fig.2

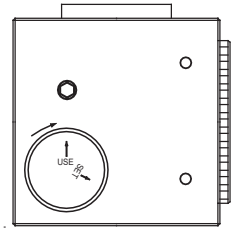

Fig.3

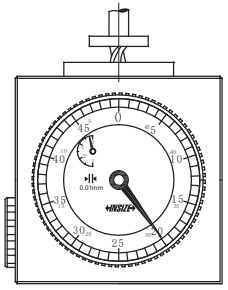

Fig.4

4. Try to prevent oil from entering the anvil gap during use. If oil gets into the gap of anvil, the anvil will be stuck. The cleaning steps are as follows:
---Turn the socket screw with a hexagon wrench until it is completely withdrawn, and take out the stop pin (Fig.5)
---Take out the anvil, wipe the anvil and the wall of guide sleeve with a clean cloth (Fig.7)
---Align the key slot of anvil with the mounting hole of socket screw, and then install it into the guide sleeve (Fig. 6)
---Install the small end of the stop pin into the mounting hole and lock the socket screw

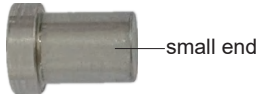

Fig.5 stop pin

Fig.6 anvil

Fig.7

MN-2397-E
V2