

Code	Taper	Accuracy
4771-30	BT30	1 μ m
4771-40	BT40	1 μ m
4771-50	BT50	1 μ m

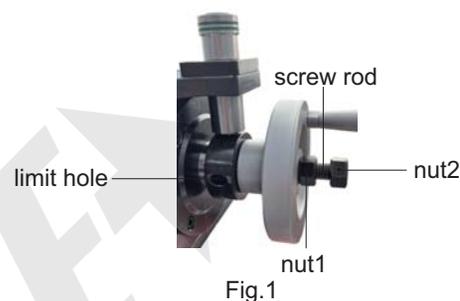


1. Shank runout tester is mainly used to measure the radial runout of shanks, collets and cutting tools.

2. Calibration:

- When calibrating, it is necessary to keep the mounting hole and standard shank clean.
- Turn the handwheel to align the locking device with the limit hole (Fig.1), pull up the locking device and put it down to make the locking device enter the limit hole, and the handwheel cannot be turned at this time.
- Use a wrench to loosen the nut1, and then loosen the nut2 until the screw rod can be pulled out (if the screw rod is not installed on the tester, the calibration starts from the installation of the standard shank).
- Align the groove of standard shank with the limit block and install the standard shank (Fig.2).

- Install the screw rod and slightly tighten the nut2, then tighten the nut1 with a wrench, and pull up the limit device to make the handwheel turn.
- Check the standard shank to ensure the runout accuracy $\leq 1\mu\text{m}$.



3. Measurement:

- When measuring, it is necessary to keep the surface of mounting hole and shank clean.
- Install the shank and measure (Fig.3).
- Turn the hand wheel, get the result from the indicator after the pointer is steady.



4. Notices:

- The shank should be handled gently to avoid affecting the accuracy.
- During measurement, get the reading after the pointer is steady.
- Measuring faces should be carefully protected from being scratched or damaged. It should be oiled to prevent rust after use.