



**TLP-400E  
Tool Presetter  
OPERATION MANUAL**



## Unpacking and Clean-up

To ensure good performance of your tool presetter, clean it properly and install it accurately before use.

As soon as you receive your tool presetter, we recommend that you follow these procedures:

1. Inspect the crate and check if the machine has arrived in good condition. If not, inform the distributor or shipper immediately.
2. After unpacking, disassemble the base fixing bolts.
3. Stabilize the machine when lifting or moving.
4. Remove the protective coating thoroughly with a soft cloth moistened with kerosene.
5. Do not use acetone, gasoline or lacquer thinner for this job. Do not use solvents on plastic parts as it will dissolve the plastic.

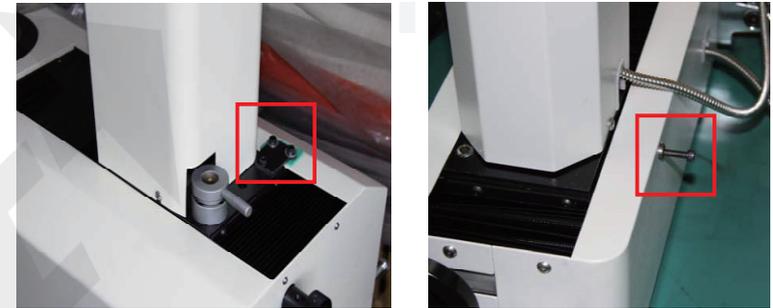
Note: Clean taper shank and spindle sleeve during measurement, and avoid sundries to avoid friction and injury of spindle during rotation.

Machine



Preparation

A. Loosen the lock piece that tightens the X-axis.



TLP-300H

B. Loosen the screw on counter-balance



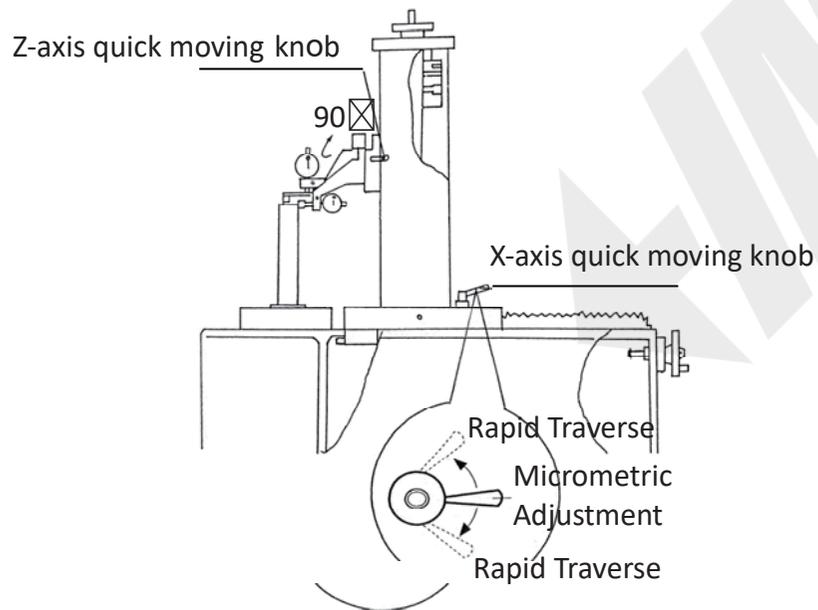
C. Check if the power source is normal or not.

D. Check if all parts are lubricated properly.

E. Check if the spindle is clean or not.

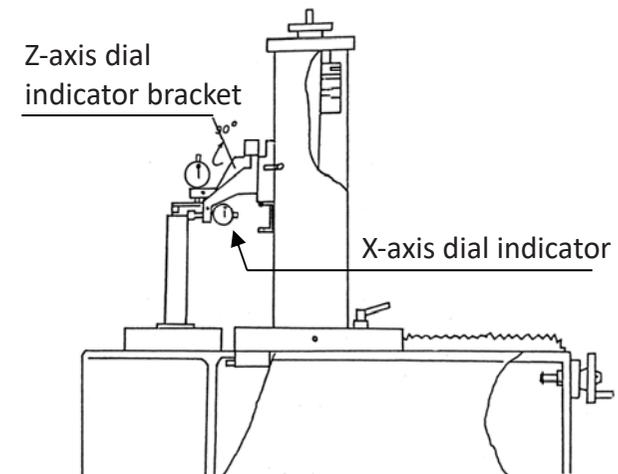
**Quick Moving Operation (Except TLP-300H)**

1. When performing quick moving on Z-axis press the moving handle, then move the Z-axis up or down.
2. When performing quick moving on X-axis, shift the X-axis moving handle to left or right for performing quick moving. Set the handle at center for micrometric adjustment.
3. If you need to perform quick moving on X and Z-axes simultaneously, first shift the X-axis moving handle to left or right, then use the Z-axis moving handle to perform upward, downward, right and left movements.



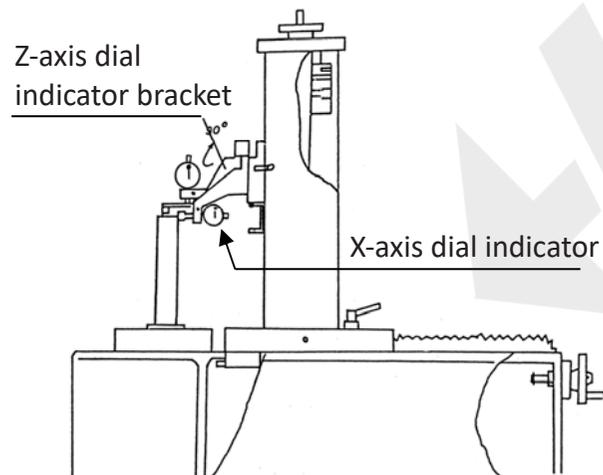
**Zero-Setting on X-axis**

1. Fit a standard rod into the spindle holder, Clean the spindle before fitting.
2. Move away the Z-axis dial indicator bracket by turning it clockwise. This will avoid bumping against the standard rod when performing zero-setting on X-axis.
3. Adjust the probe of the dial indicator on X-axis until it touches the standard rod. Turn the dial indicator until the first "0" is indicated.
4. Set the value on the digital readout of X-axis the same as the diameter of the standard rod. Now the zero setting procedures are done. Make sure the value displayed on the digital readout is diameter or radius.



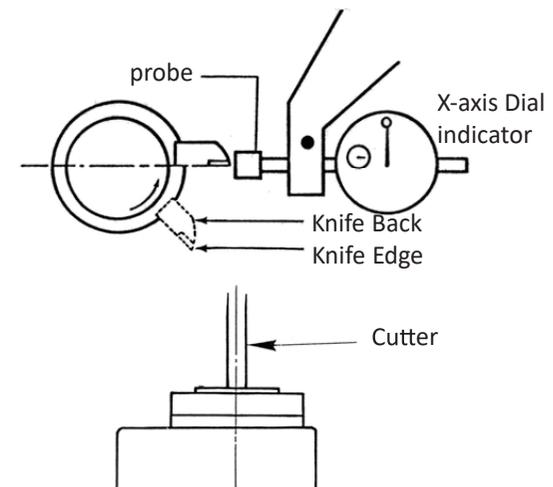
**Zero-setting on Z-axis**

1. Adjust the Z-axis dial indicator bracket to a proper position.
2. Move Z-axis until the probe of the dial indicator touches the reference plane of the standard rod. Turn the dial indicator until the first "0" is indicated.
3. Set the value on the digital readout of Y-axis the same as the length of the standard rod are accomplished.



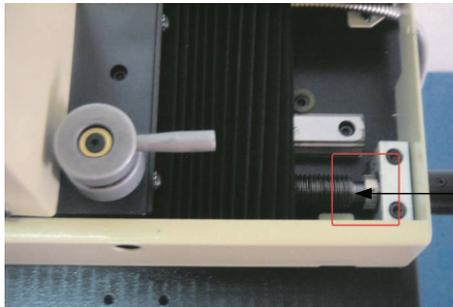
**Measuring Procedures**

1. Make sure zero-setting has been made.
2. Fit a cutter into the spindle holder.
3. For measuring on TLP-300H, it is suggested to spray a little oil to facilitate rotation.
4. When turning the cutter, have the knife back touch the probe at first.
5. When the probe touches the highest point of the cutter, and the dial indicator is turned to the first zero position, then the value displayed on the digital readout is the cutter size.



**X-axis Gap Adjustment**

1. In case excessive gap occurs, make adjustments by turning the pressure screw, located on the slide block on X-axis, clockwise until a proper position is obtained. Or you may replace the
2. Additionally, you may turn the nut, located on the transmission screw, until the proper position is obtained.



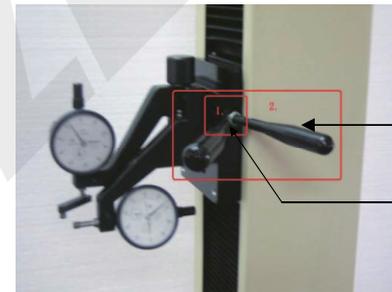
Adjust by turning this nut when excessive gap on X-axis occurs.

**Gap Adjustment Nut on X-axis**

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**Z-axis Gap Adjustment**

1. In case slipping occurs when making micrometric adjustment, turn the pressure screw clockwise on Z-axis until the proper position is obtained. Or you may replace the pressure spring.
2. Additionally, you may loosen the nut that tightens the rapid traverse handle on Z-axis, or you may replace the pressure spring.



Z-axis Gap Adjustment Device

Rapid Traverse Handle on Z-axis

In case slipping or excessive gap on Z-axis occurs, loosen this nut for adjustment. A spring is built in the adjustment device. In case of spring fatigue, contact the manufacturer to purchase new replacement spring.