Product note

Mounting 11008063
TRAUB TNL 18, TRAUB TNL 20

Mounting 10826369
TRAUB TNL 32

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Note on applicability

Illustrations in this publication may deviate from the product supplied. Errors and ommissions due to technical progress expected.

A word on copyright

INDEX TRAUB

Mounting and preadjustment block

For more information on the preadjustment block, see product information W9800003EN.
It contains a short description and instructions on installing and removing the counter-weights and the mounting.

up to 12.2013

11008063
TRAUB TNL 18
TRAUB TNL 20

from 01.2014

up to 12.2013

10826369
TRAUB TNL 32

from 01.2014

up to 12.2013

10444808
Preadjustment block
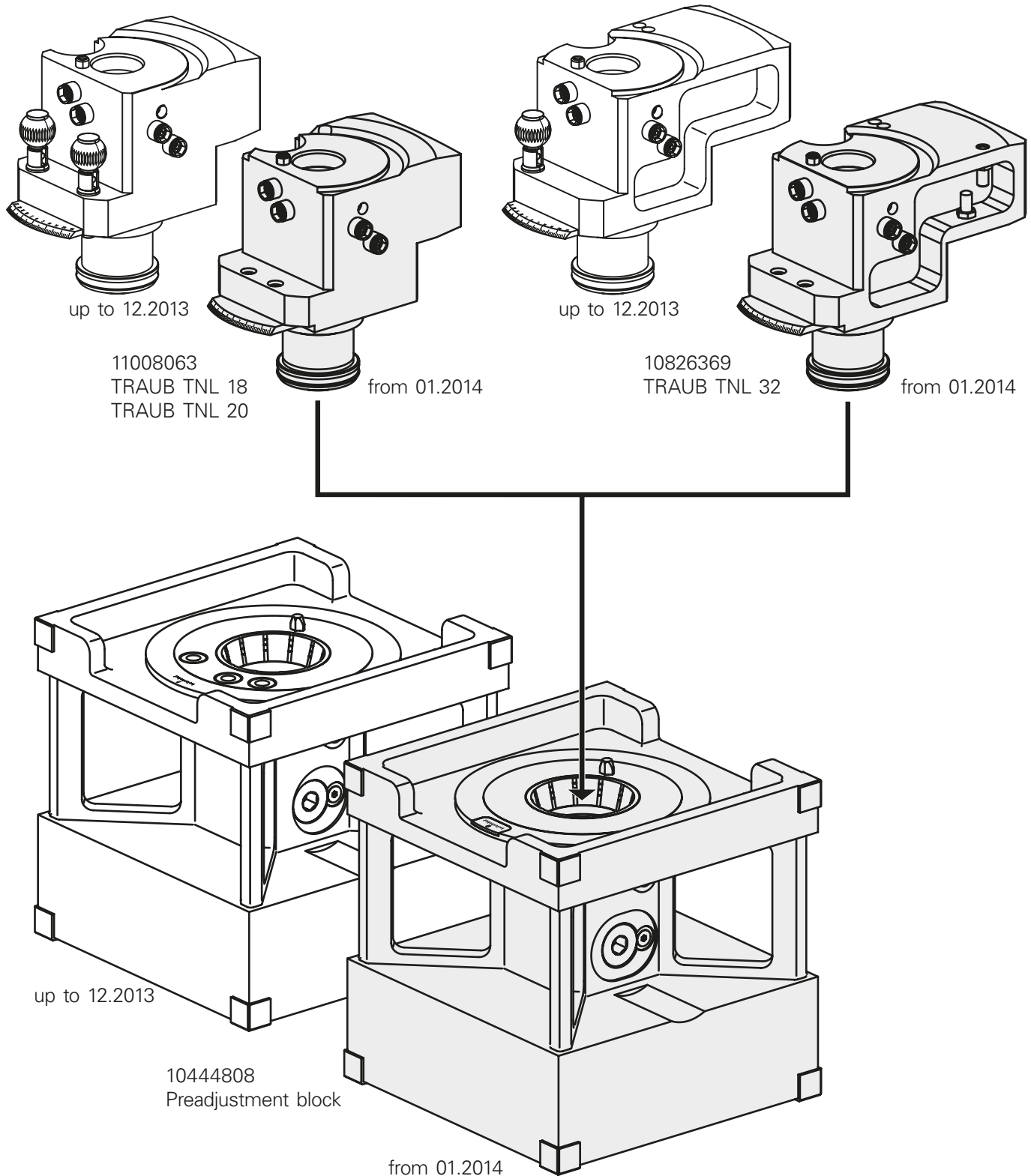
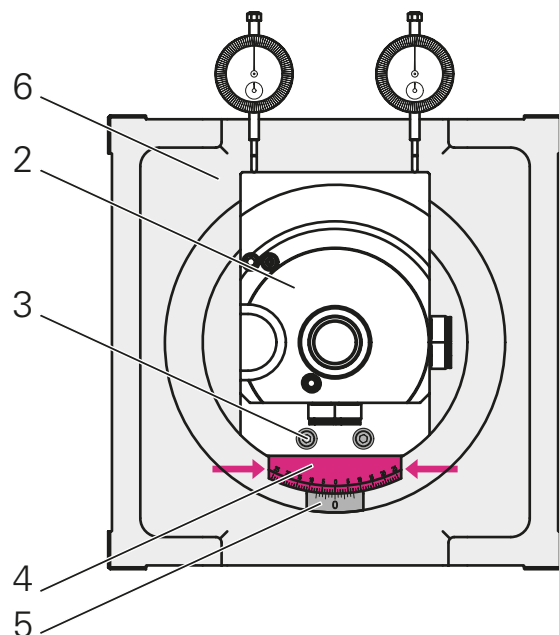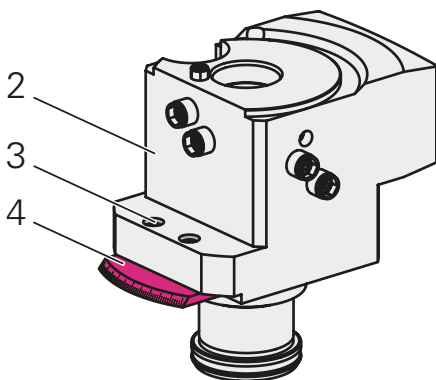from 01.2014

Adjusting the mounting scale

The drawing shows the mounting 11008063 for TRAUB TNL 18, TNL 20 with design date from 01.2014, the scale must be adjusted also for mounting 10826369 for TRAUB TNL 32.

Adjustment

- Install mounting *(2)* in preset block *(6)*,
  refer to product note W9800003EN for instructions

- Run dial gauge *(1)* along surface
  and align the mounting *(2)*
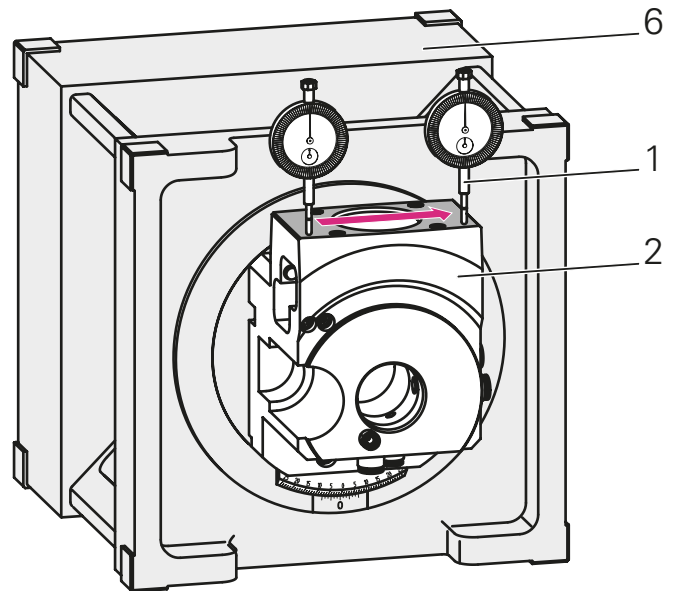
- Loosen both cylinder head screws *(3)* of the mounting *(2)*

- Align the scale plate *(4)* of the mounting *(2)* to the scale *(5)* the preset block *(6)*

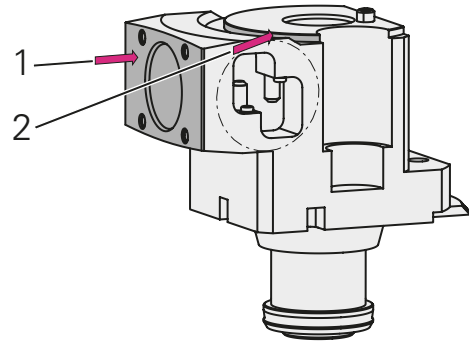- Loosen both cylinder head screws *(3)* of the mounting *(2)*

Zero points with compact shank D45mm

The drawing shows the mounting 11008063 for TRAUB TNL 18, TNL 20 with design date from 01.2014, the scale adjustment can be used also for mounting 10826369 for TRAUB TNL 32.
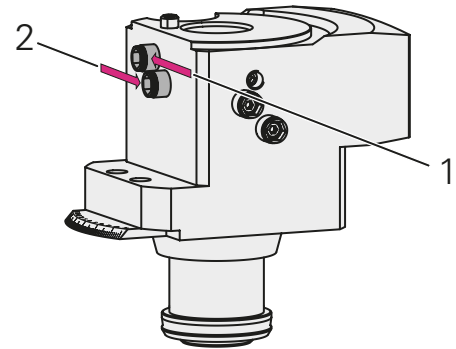
Determining the zero point on the X-axis

- Area measurement *(1)*, the measured value is a radius value, for entering into the tool memory, this value must be doubled

- Radius measurement *(2)*, the measured value is a radius value, 40 mm must be subtracted, for entering into the tool memory, this value must be doubled
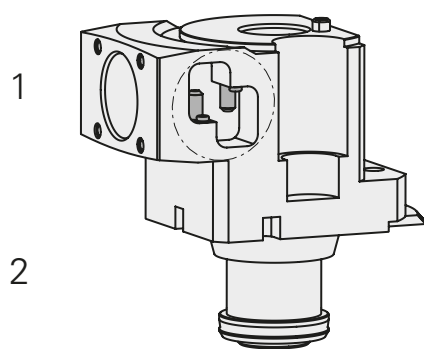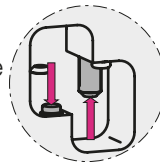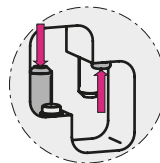
Determining the zero point on the Y-axis

- Select depending on the mounting position *(1, 2)*

Determining the zero point on the Z-axis

- Turning towards main spindle *(1)*

- Turning towards counter spindle *(1)*

- Turning towards main spindle *(2)*
  Tool holders with machining towards the main spindle can partly not measured in the correct mounting position.
  In this case, the sign of the measured value must be inversed.

# Zero points with shank D36mm

The drawing shows the mounting 11008063 for TRAUB TNL 18, TNL 20 with design date from 01.2014, the scale adjustment can be used also for mounting 10826369 for TRAUB TNL 32.
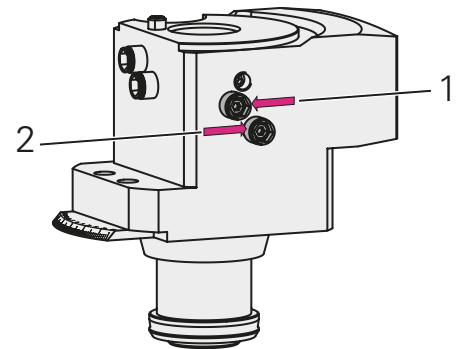
Determining the zero point on the X-axis

- For internal turning tools *(1)*

- For external turning tools *(2)*,
  the measured value is a radius value,
  for entering into the tool memory, this value
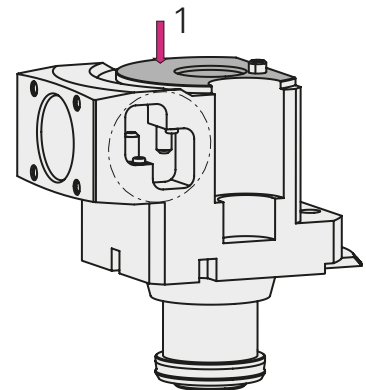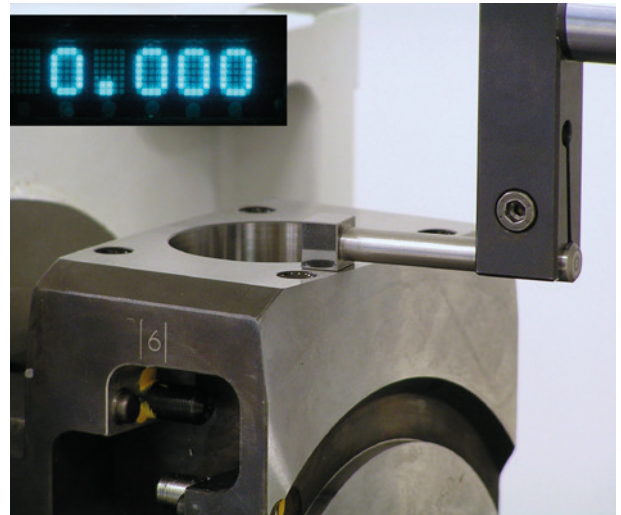 must be doubled
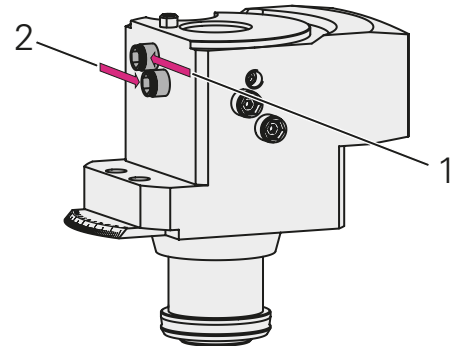
Determining the zero point on the Y-axis

- Select depending on the mounting position *(1, 2)*

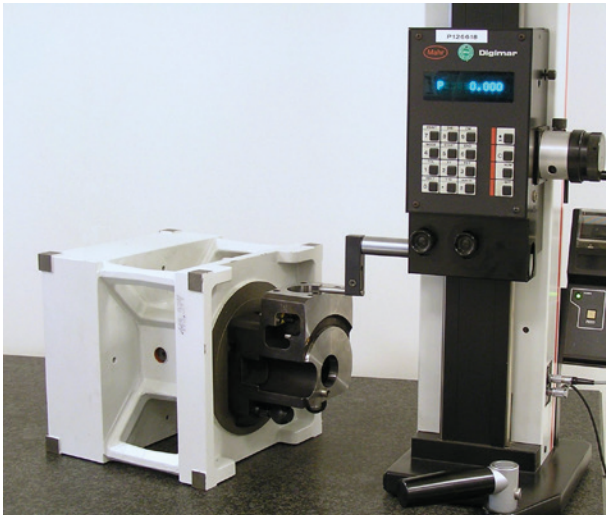## Determining the zero point on the Z-axis
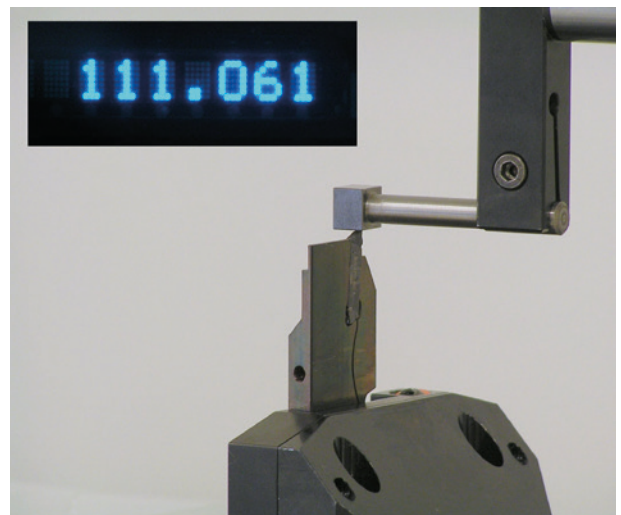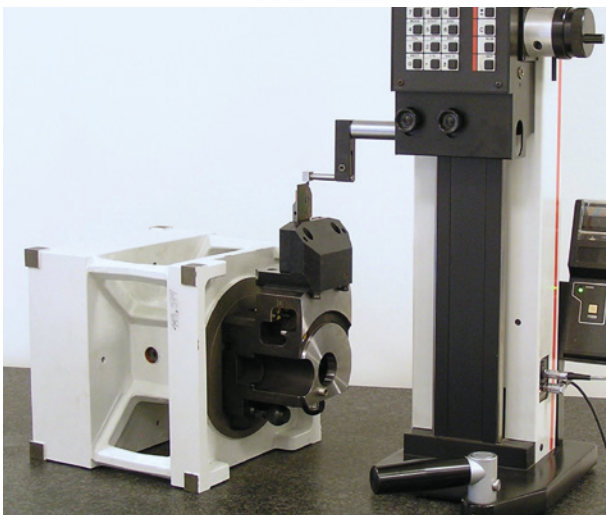
- Area measurement *(1)*

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, zero point setting

X-axis, grooving tool holder, measure tool tip

The measured value is a radius value,
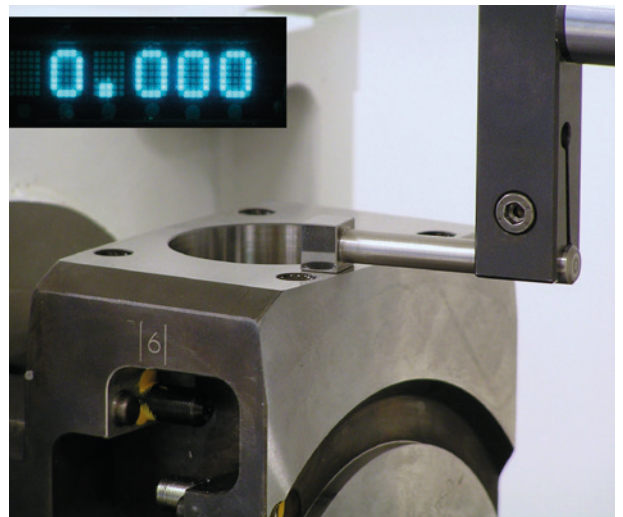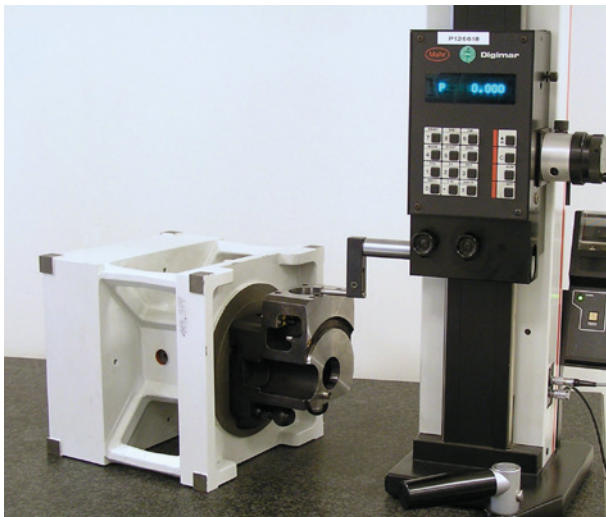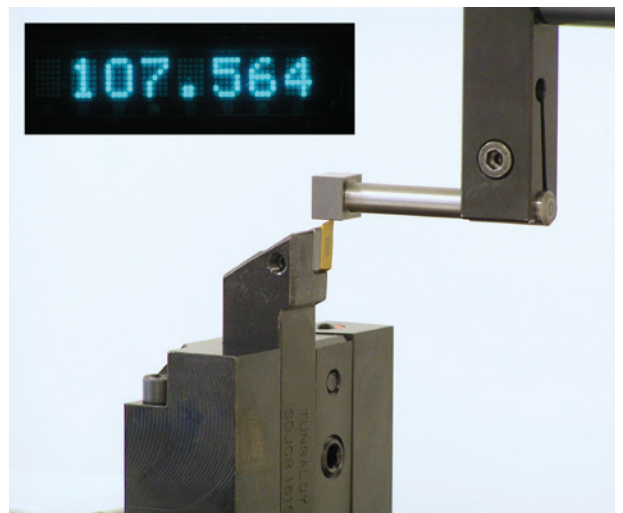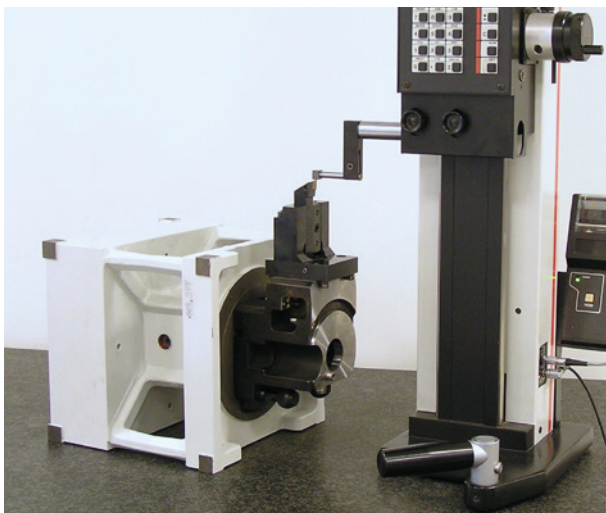for entry into the tool memory, this value must be doubled

Application example
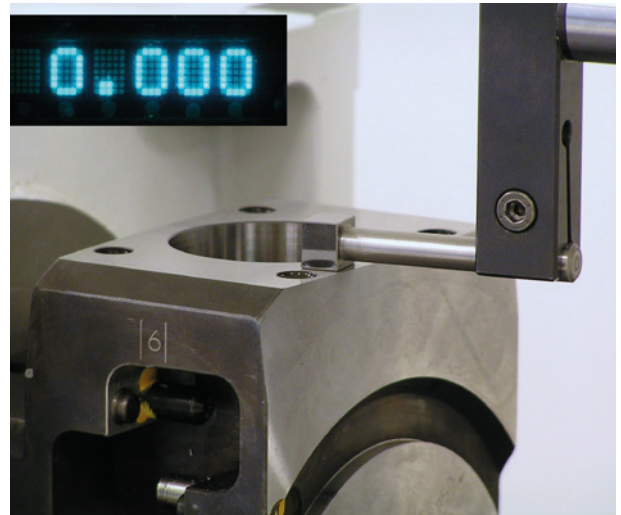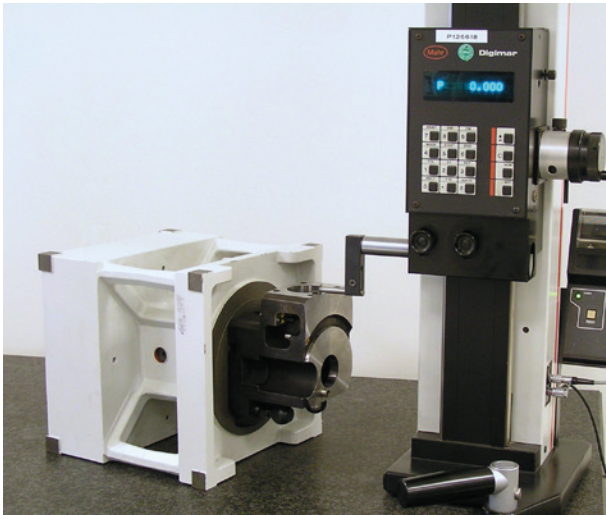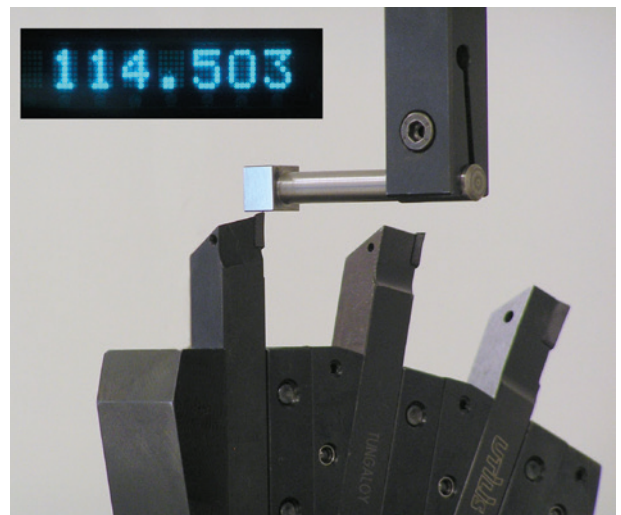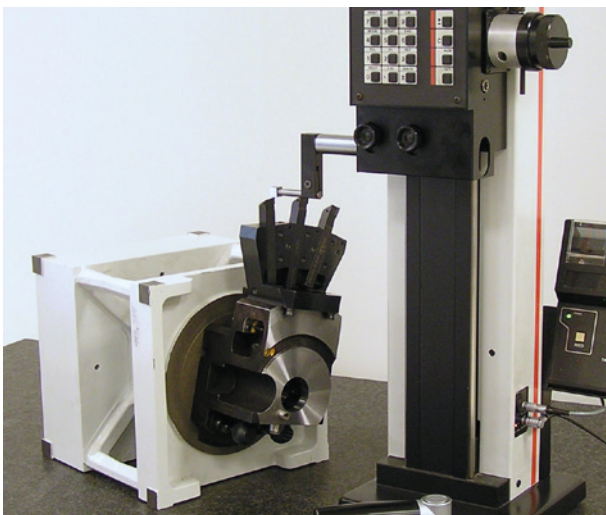
Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, zero point setting

X-axis, turning tool holder, measure tool tip

The measured value is a radius value,
for entry into the tool memory, this value must be doubled

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, zero point setting

X-axis, triple turning tool holder, measure tool tip

The measured value is a radius value,
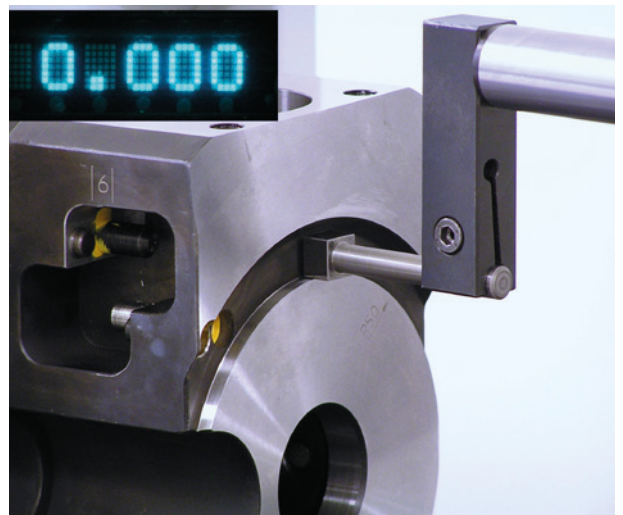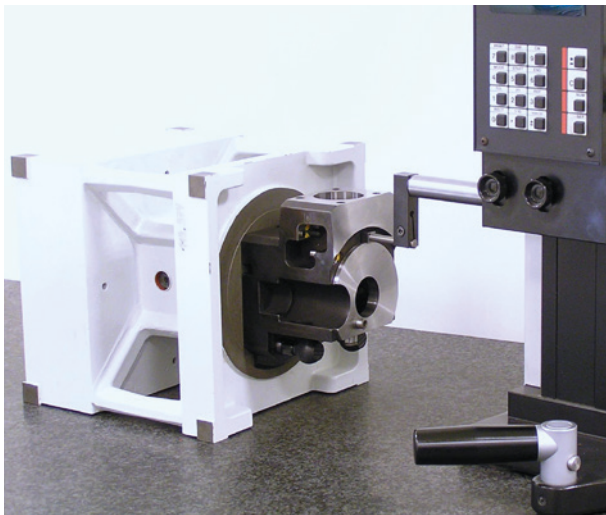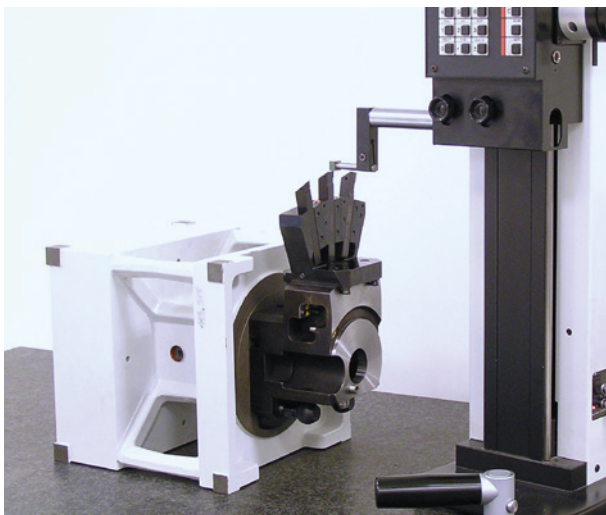for entry into the tool memory, this value must be doubled

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, radius measurement, zero point setting

X-axis, radius measurement, triple turning tool holder, measure tool tip

The measured value is a radius value; 40 mm must be subtracted for 11008063 (75 mm for 10826369), for entering into the tool memory, this value must be doubled
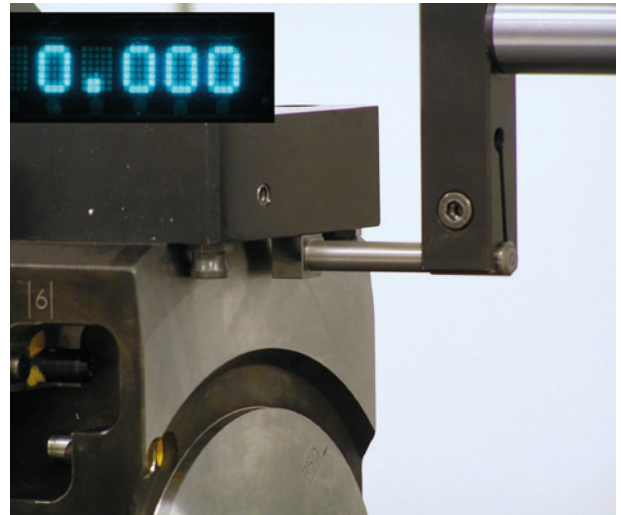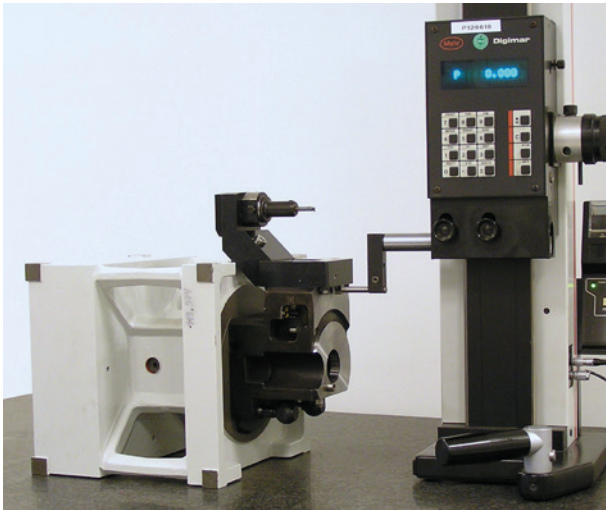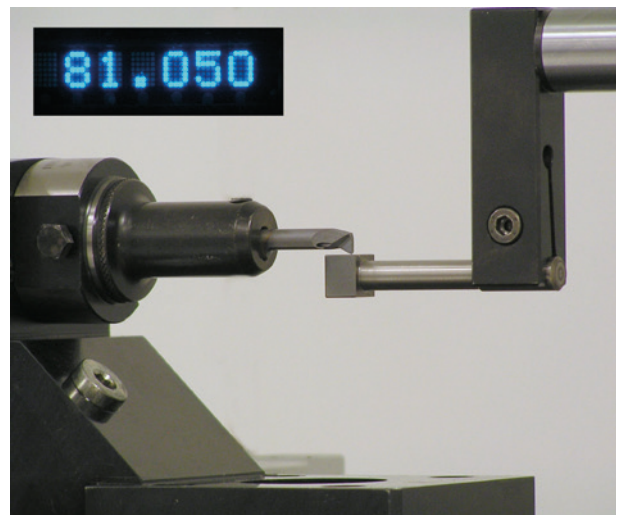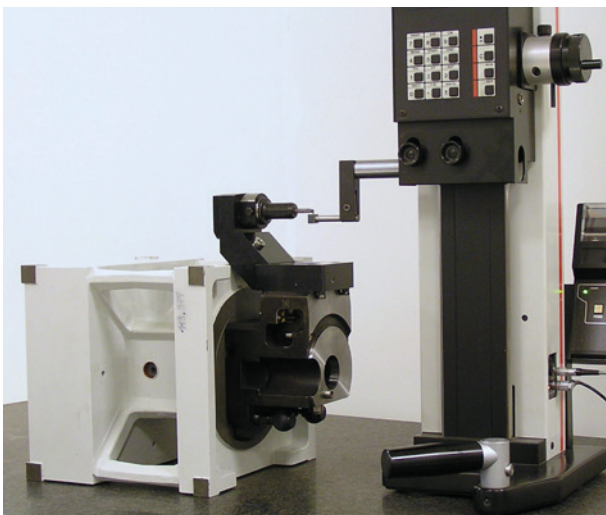
Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, zero point setting

X-axis, base holder with mounting D24, measure tool tip

The measured value is a radius value,
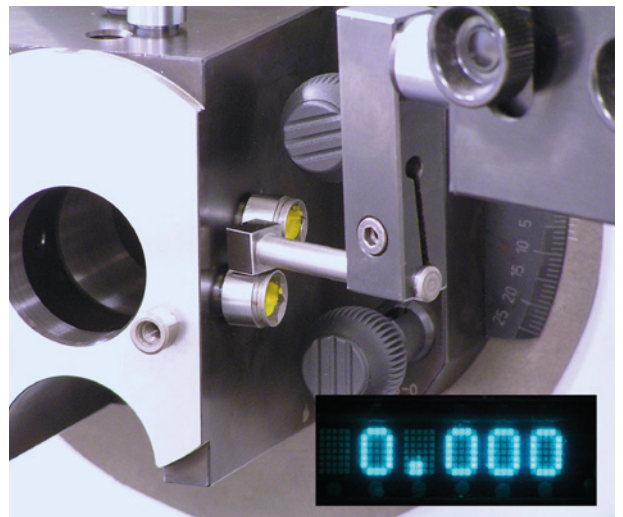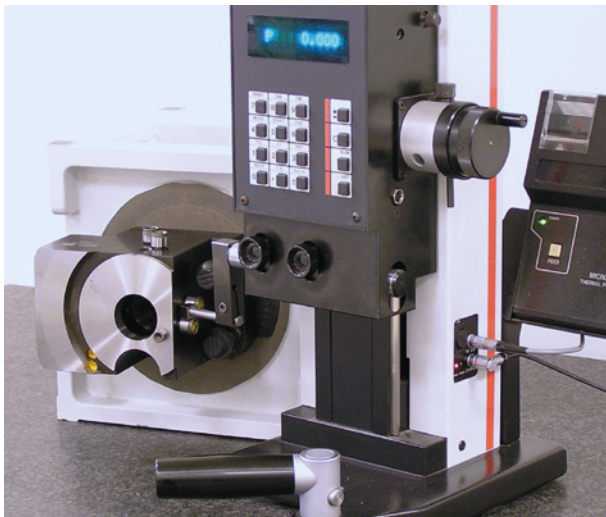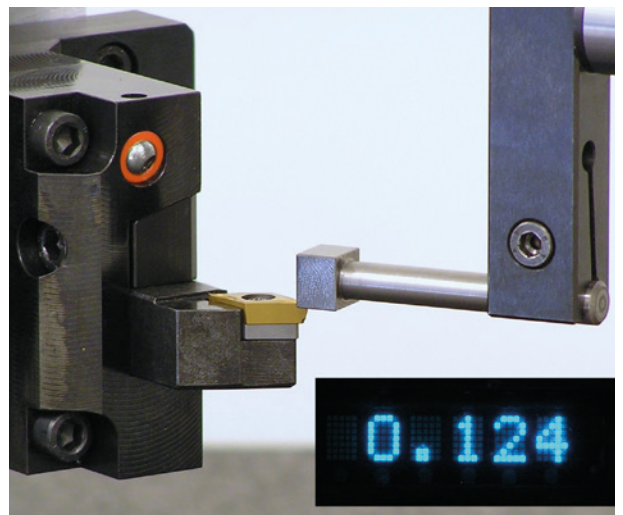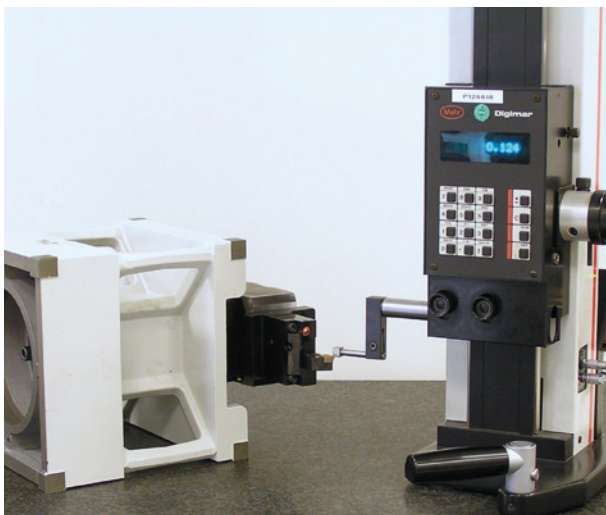for entry into the tool memory, this value must be doubled

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Y-axis, zero point setting
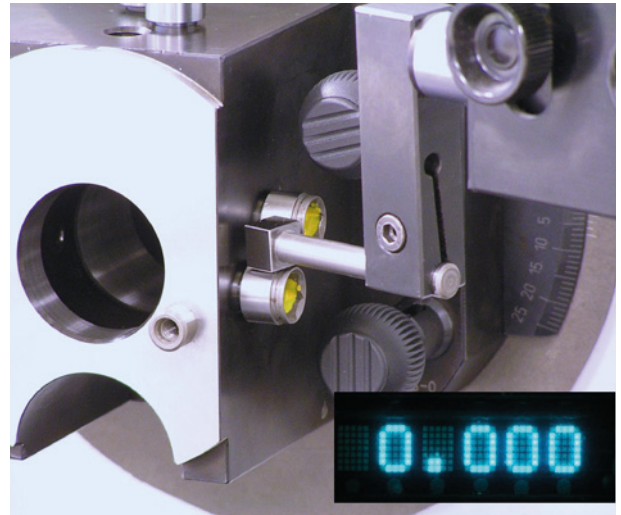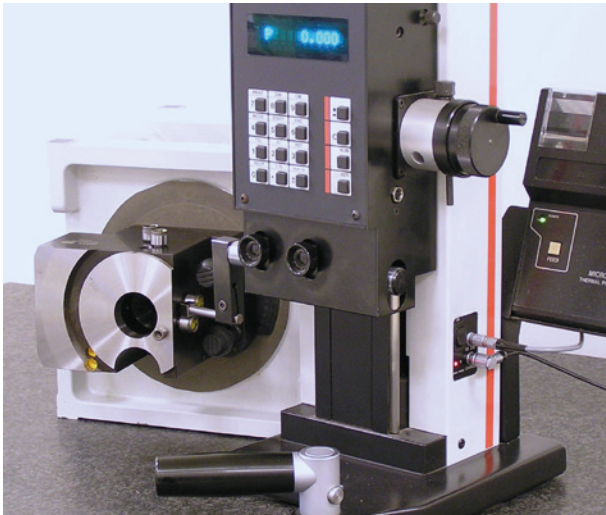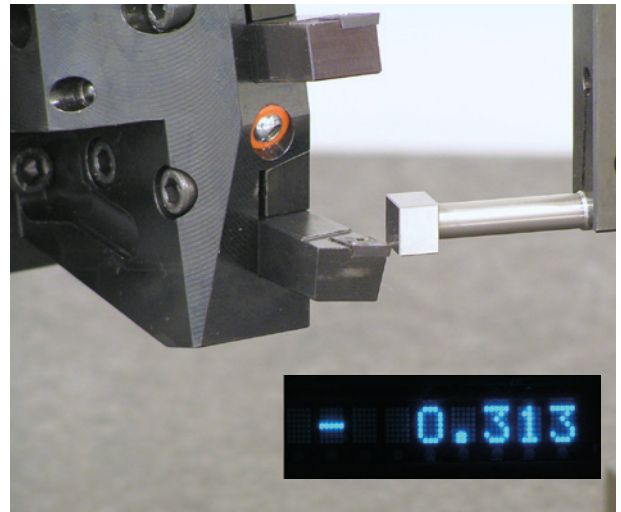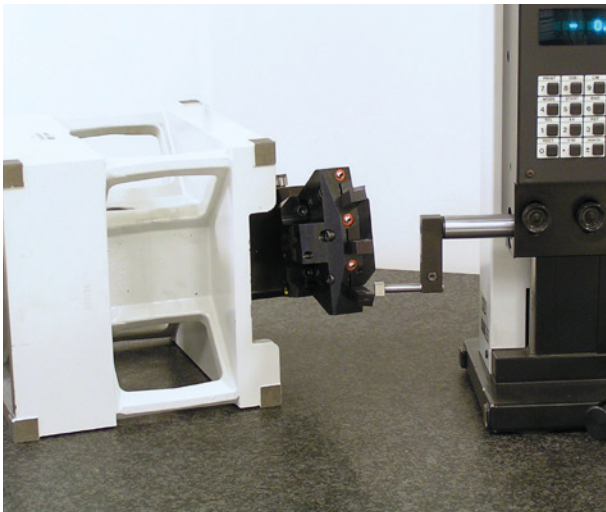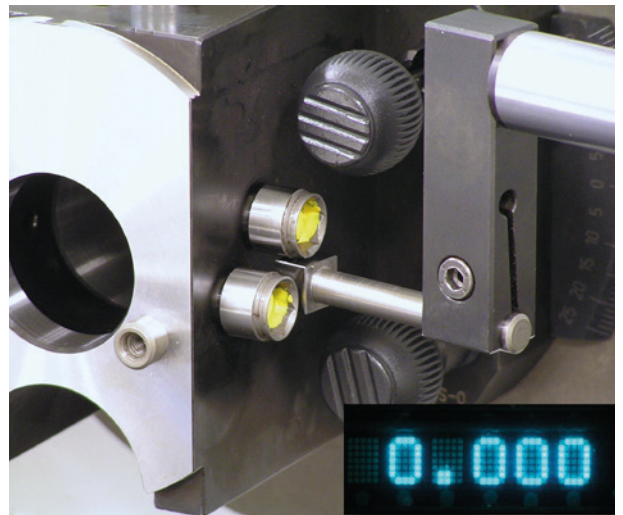
Y-axis, turning tool holder, measure tool tip
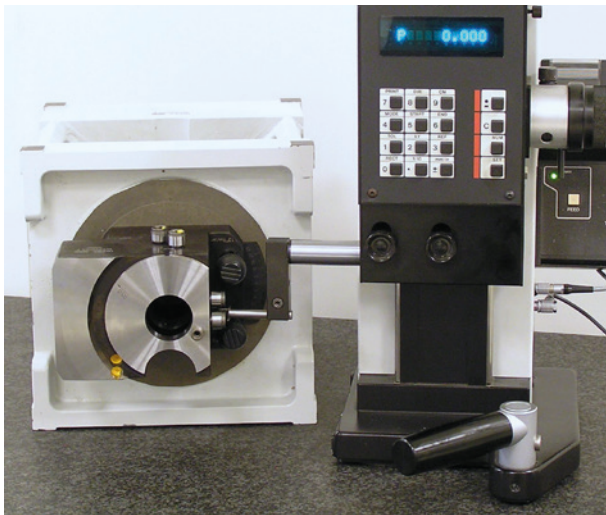
Application example
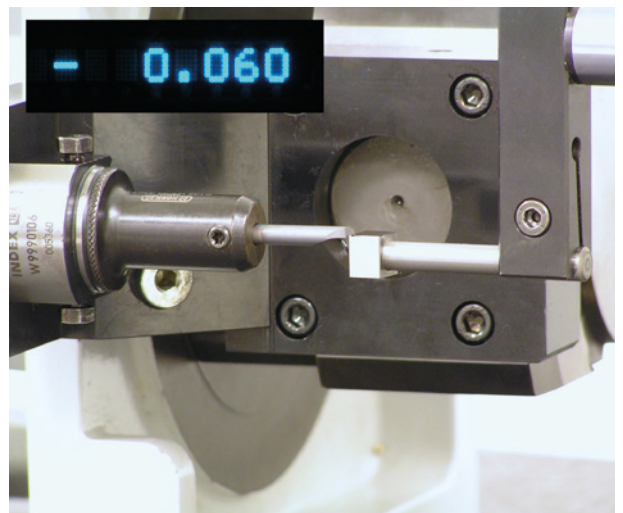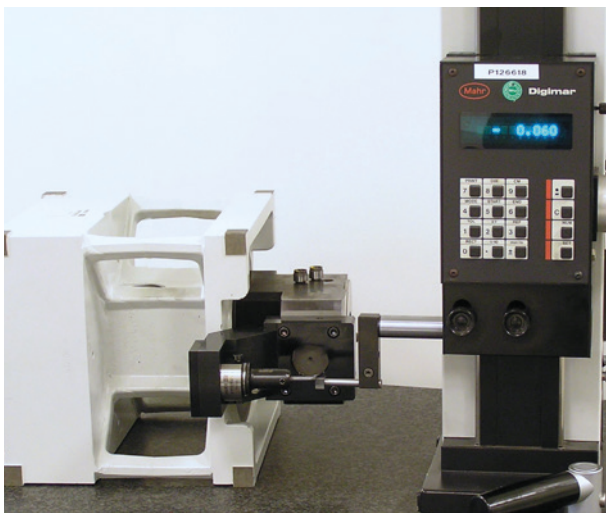
Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Y-axis, zero point setting

Y-axis, triple turning tool holder, measure tool tip

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Y-axis, zero point setting

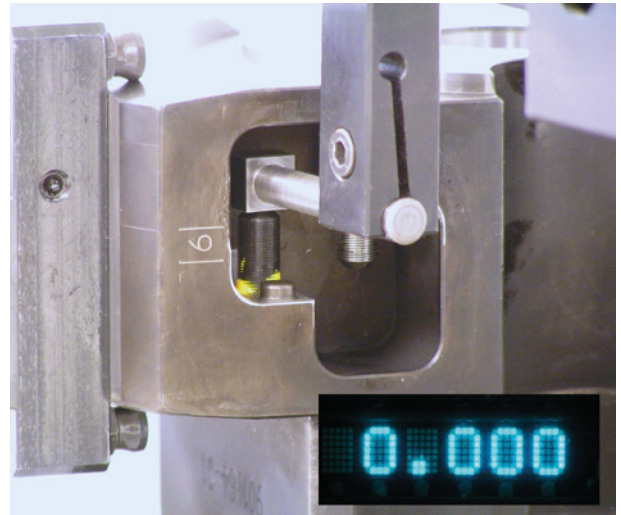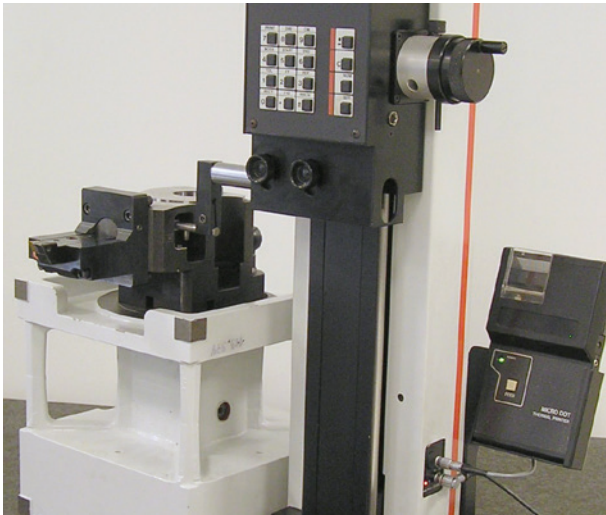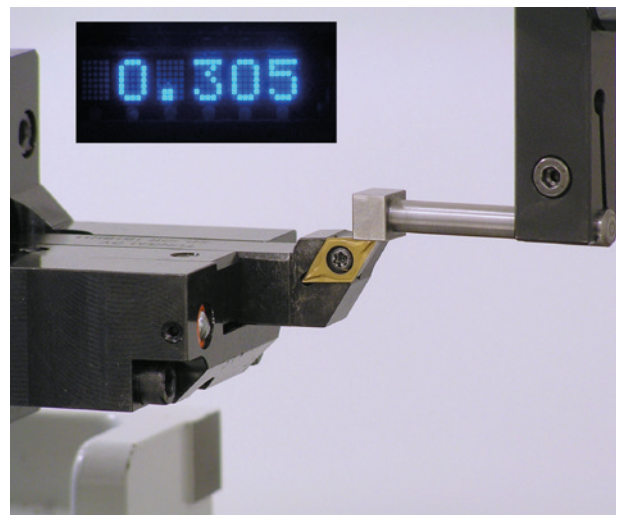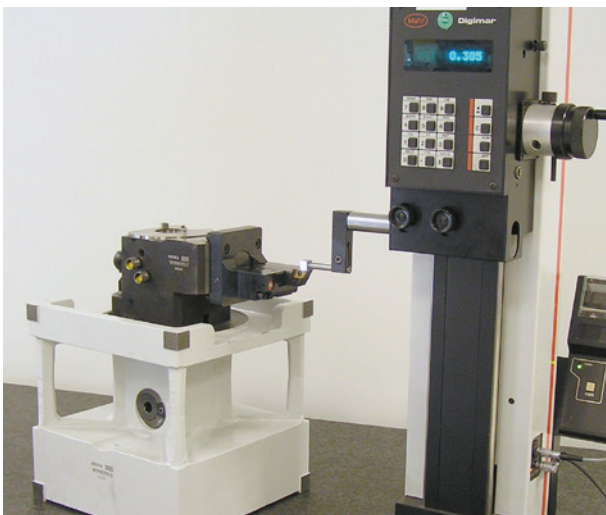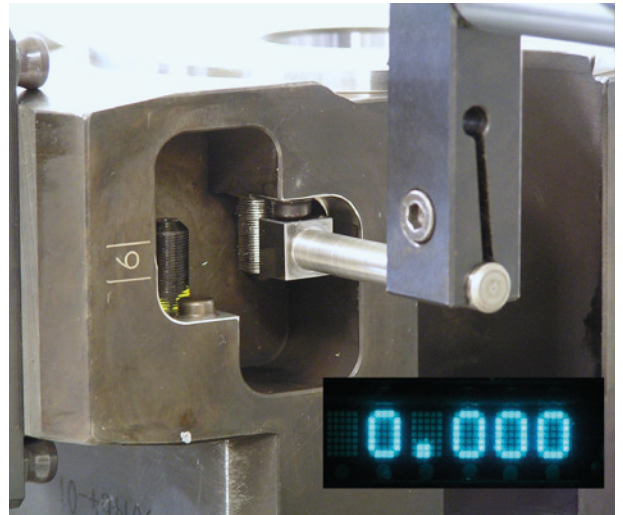## Y-axis, base holder with mounting D24, measure tool tip

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Z-axis, zero point setting
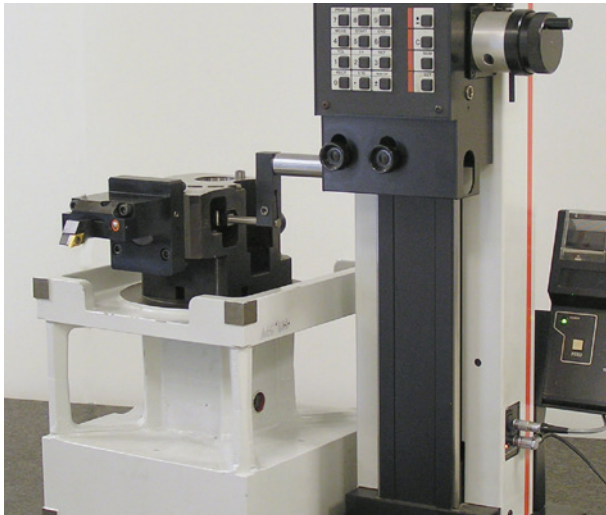

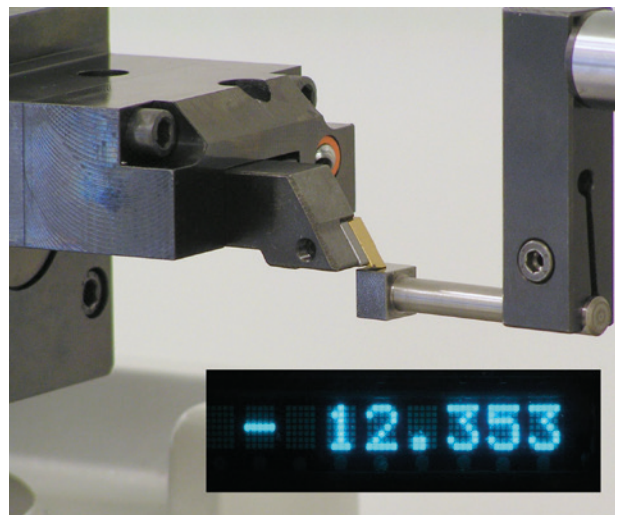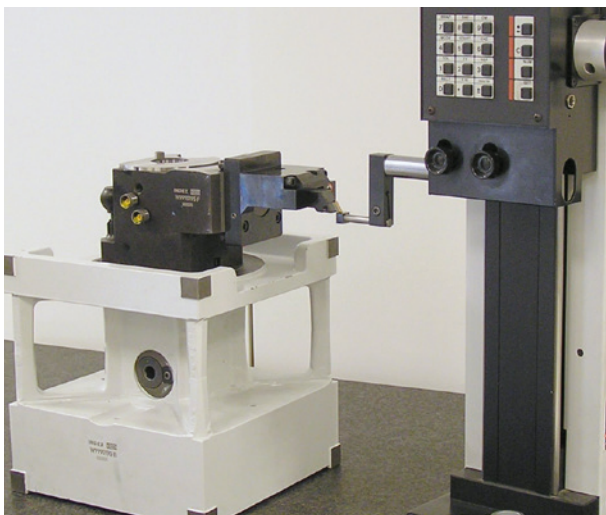## Z-axis, turning tool holder, measure tool tip

Application example

Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Z-axis, zero point setting, turning towards counter spindle

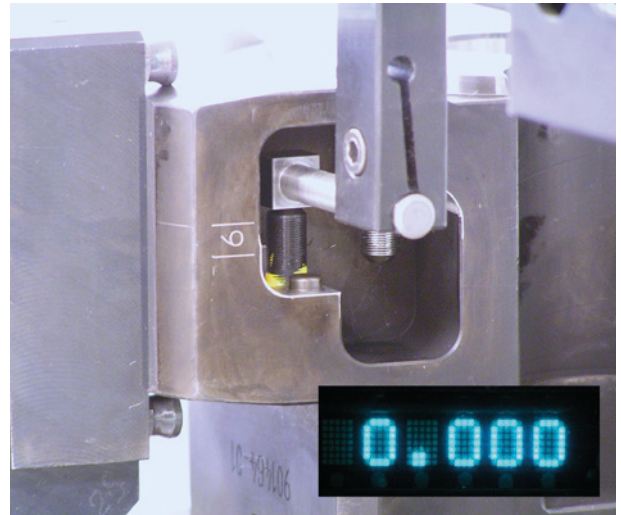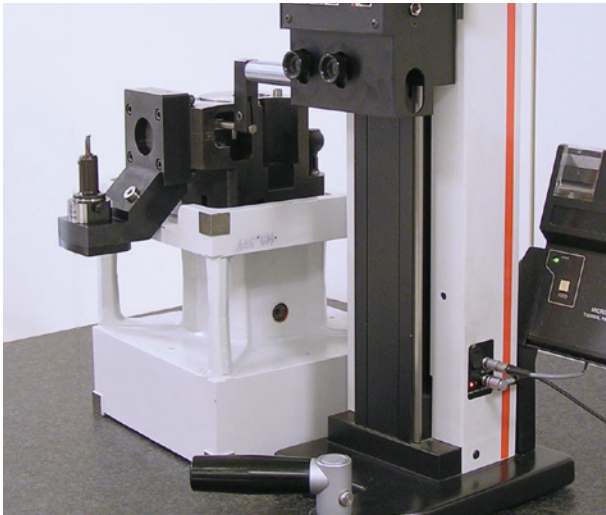### Z-axis, turning tool holder, turning towards counter spindle, measure tool tip
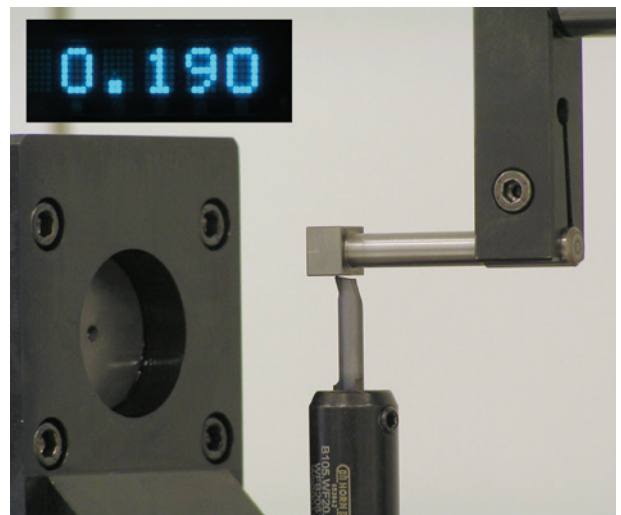
Application example
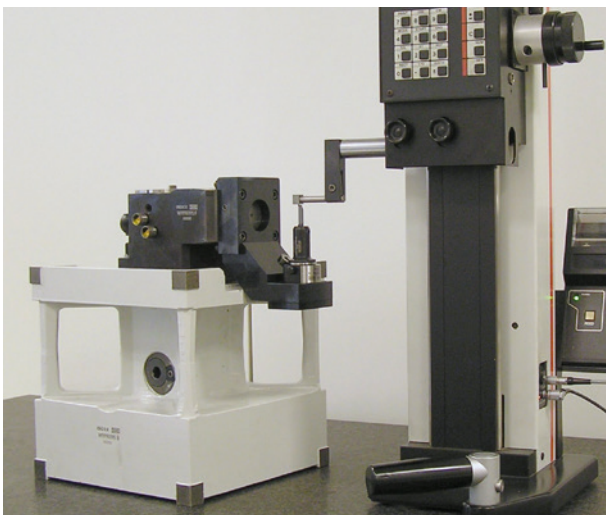
Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Z-axis, zero point setting

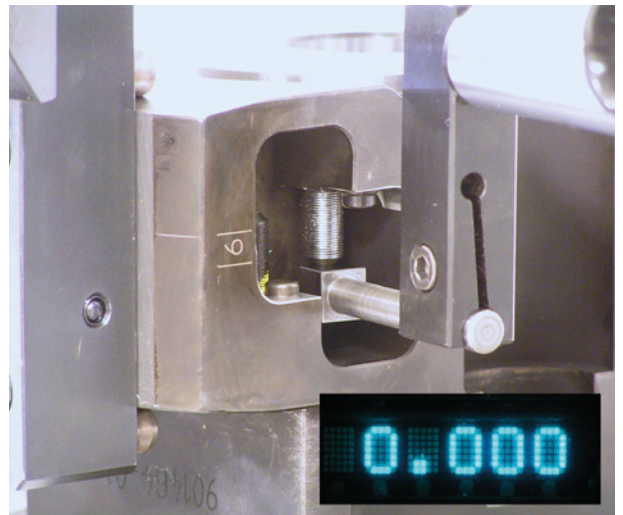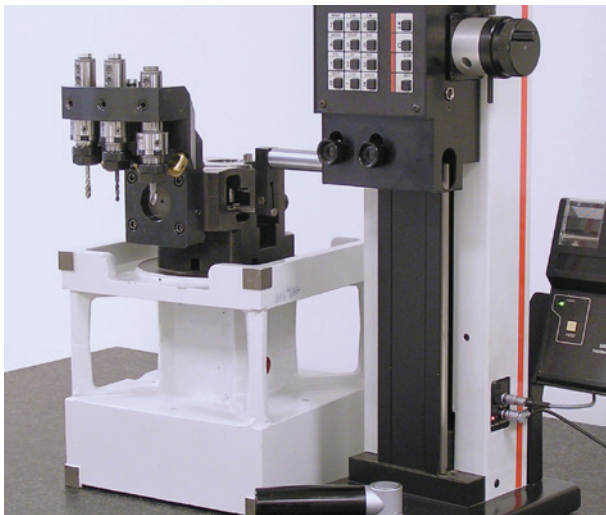## Z-axis, base holder with mounting D24, measure tool tip

Application example
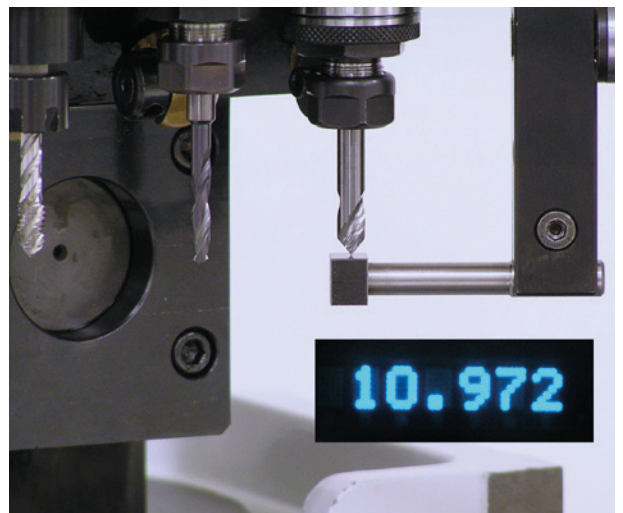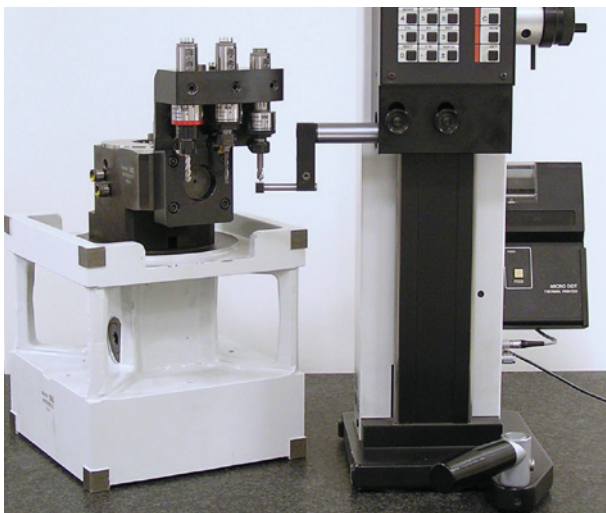
Tool holder system TRAUB compact shank D45

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Z-axis, zero point setting

Z-axis, triple base holder, measure tool tip

Tool holders with machining towards the main spindle partially cannot be measured in the correct installation position. In this case, the sign of the measured value must be inversed: + becomes - and - becomes +.

Application example
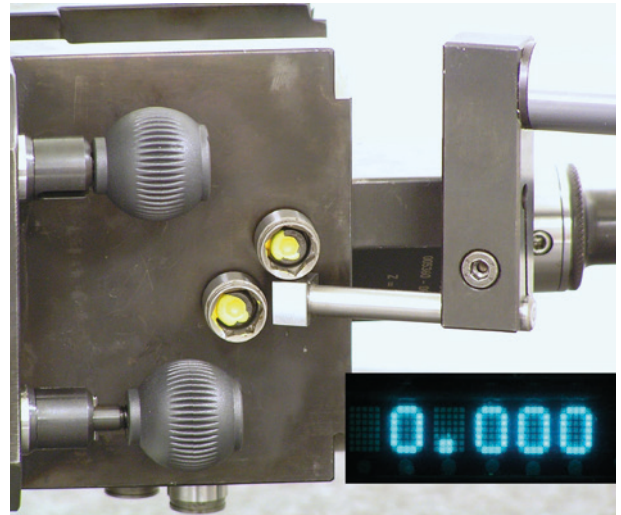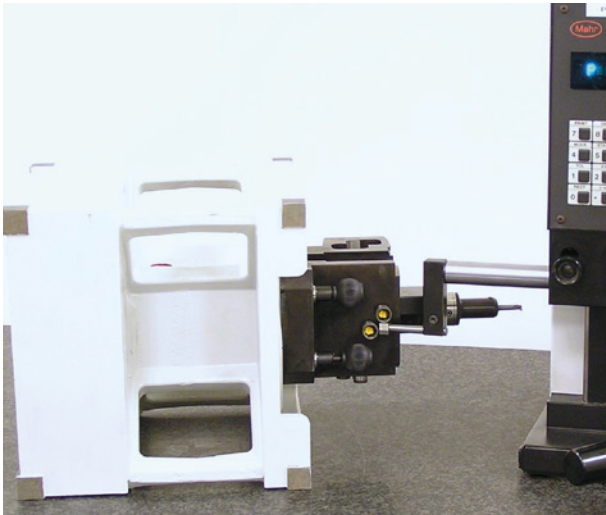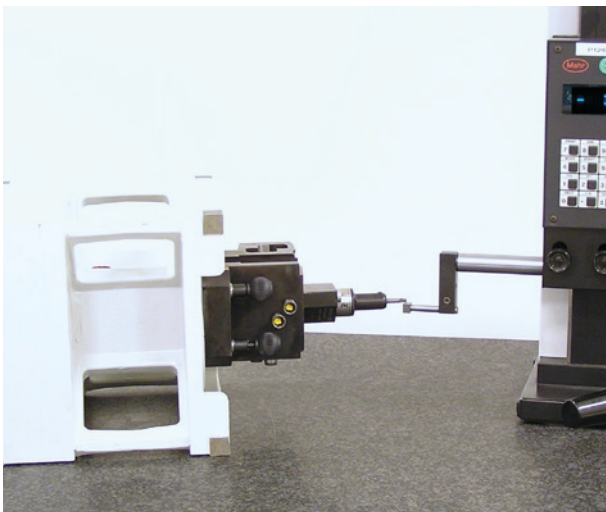
Tool holder system TRAUB shank D36

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

X-axis, zero point setting

X-axis, base holder with mounting, measure tool tip

The measured value is a radius value,
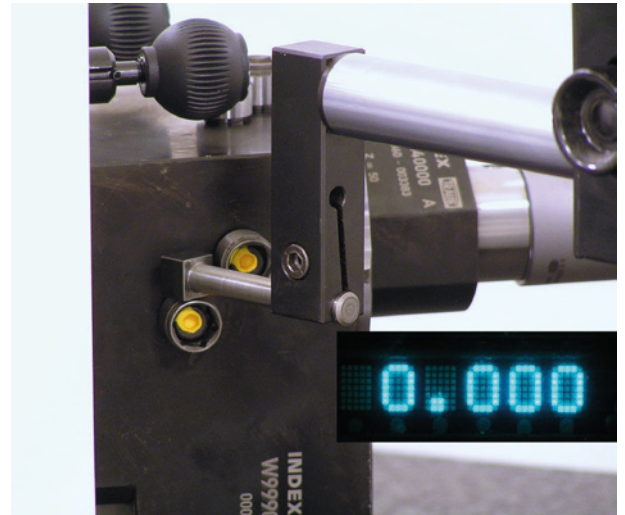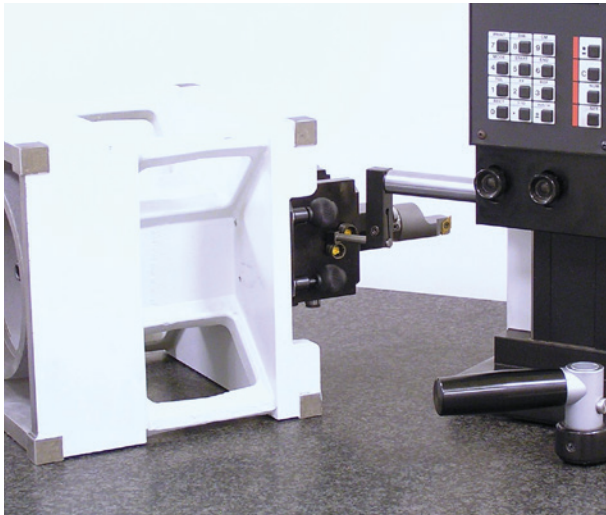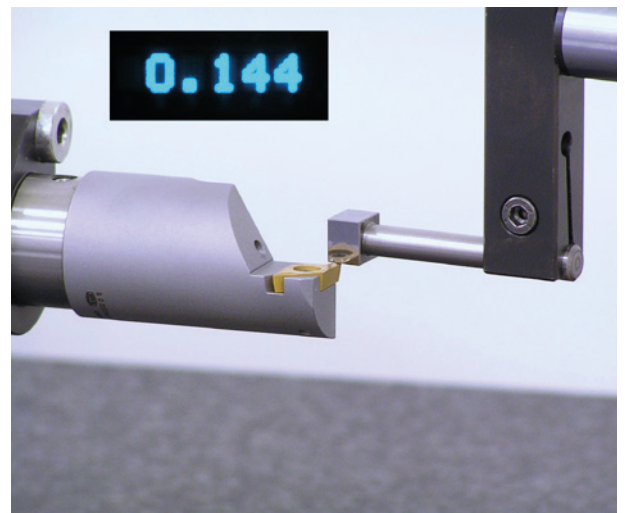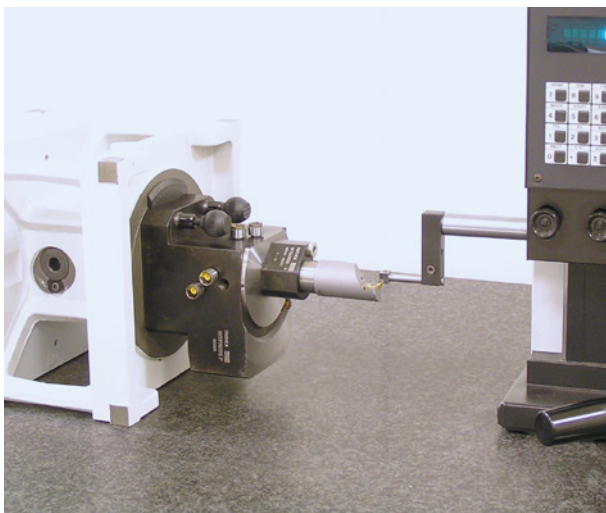for entry into the tool memory, this value must be doubled

Application example

Tool holder system TRAUB shank D36

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Y-axis, zero point setting

Y-axis, base holder with external turning tool, measure tool tip

Application example
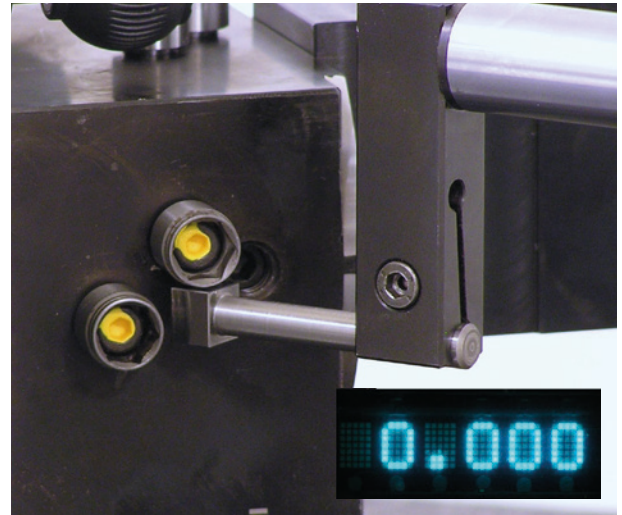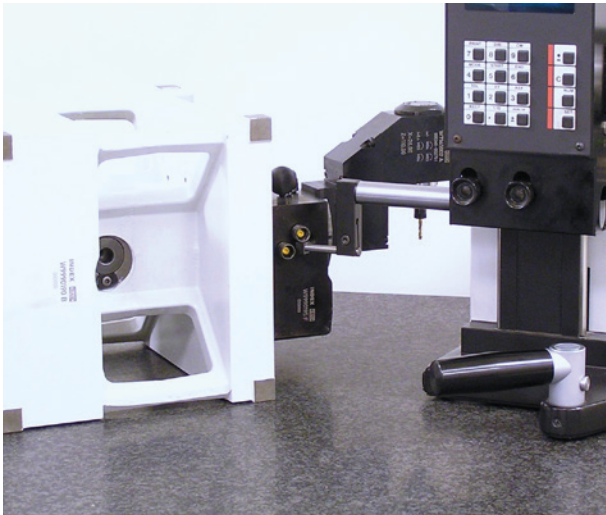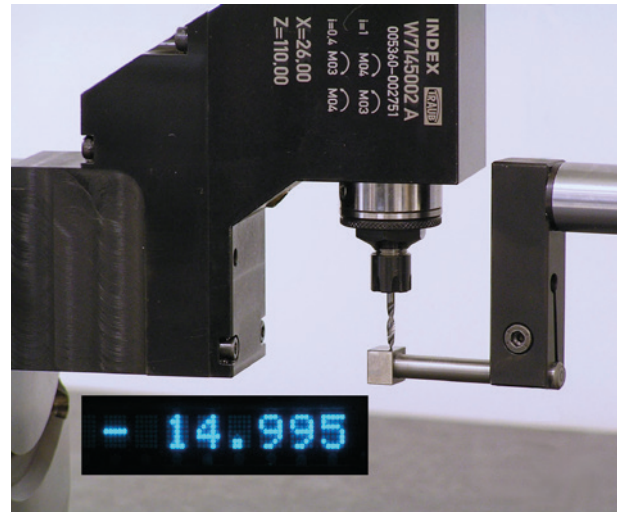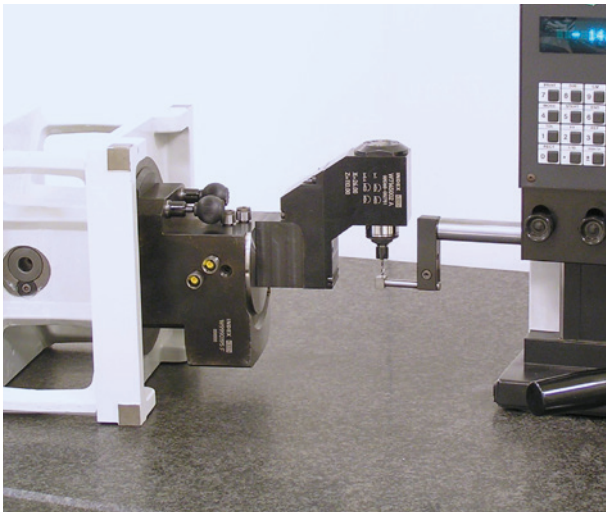
Tool holder system TRAUB shank D36

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Y-axis, zero point setting
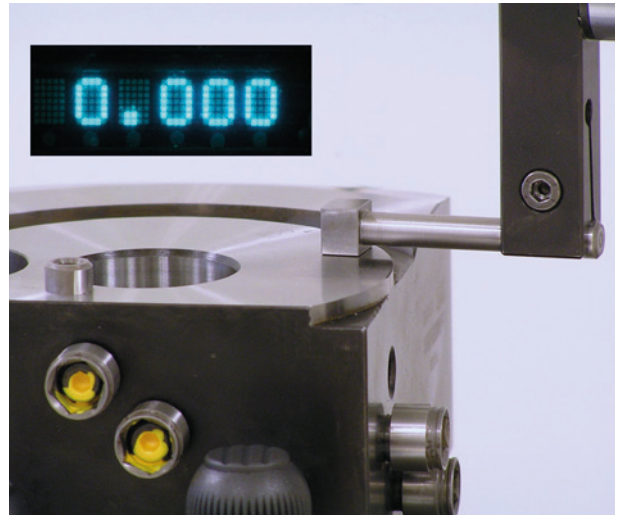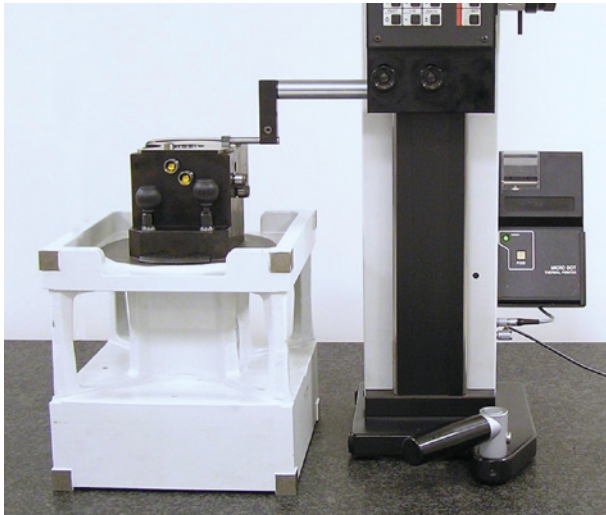

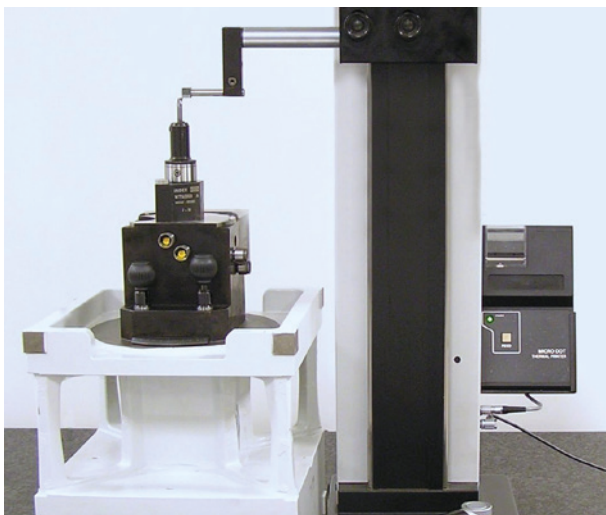## Y-axis, milling unit, measure tool tip

Application example

Tool holder system TRAUB shank D36, with mounting 11008063

Mounting 11008063 shown with design date up to 12.2013, valid also for 10826369

Z-axis, zero point setting

Z-axis, base holder with internal turning tool, measure tool tip

INDEX

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