

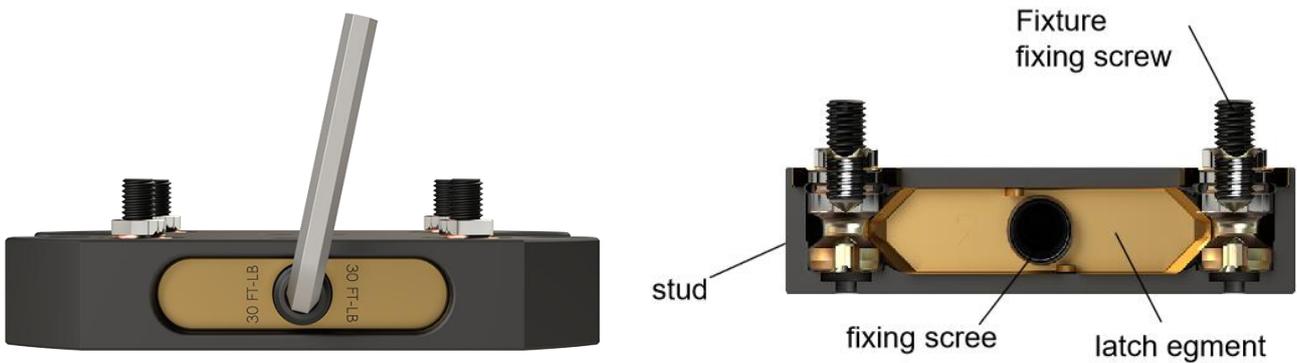
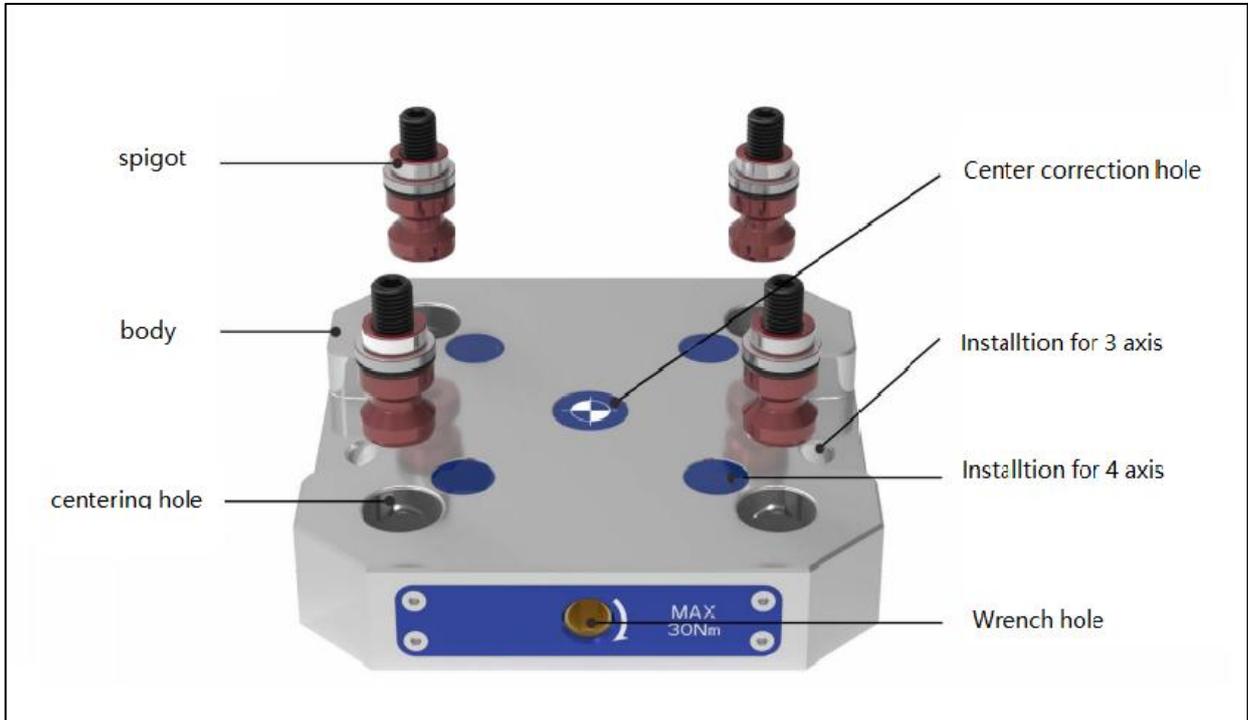
Zero Point Base Plate User Manual



1. General

- Keep the contact surface between the zero point base plate and the work piece is clean and free of debris.
- Keep the studs hole clean and plug it with a rubber plug when not in use.
- Do NOT over torque. Observe max torque marked on the base plate body.
- There are micro holes on the blue cover. When installing the fixing screws, please use an air gun to aim at the small holes and remove the cover.
- The center hole of the bottom plate has been finely ground and can be used for calibration, No need to purchase additional calibration substrates.
- When machining soft jaws, clamp on a small spacer block or shim with desired operating torque. This will stabilize the jaws during the modification process.
- For heavy work pieces, after processing, if you want to remove the work piece, there is a possibility of sticking. It is caused by surface oil film. You can clean it with an air gun first and remove it vertically.

2. Base Plate Description

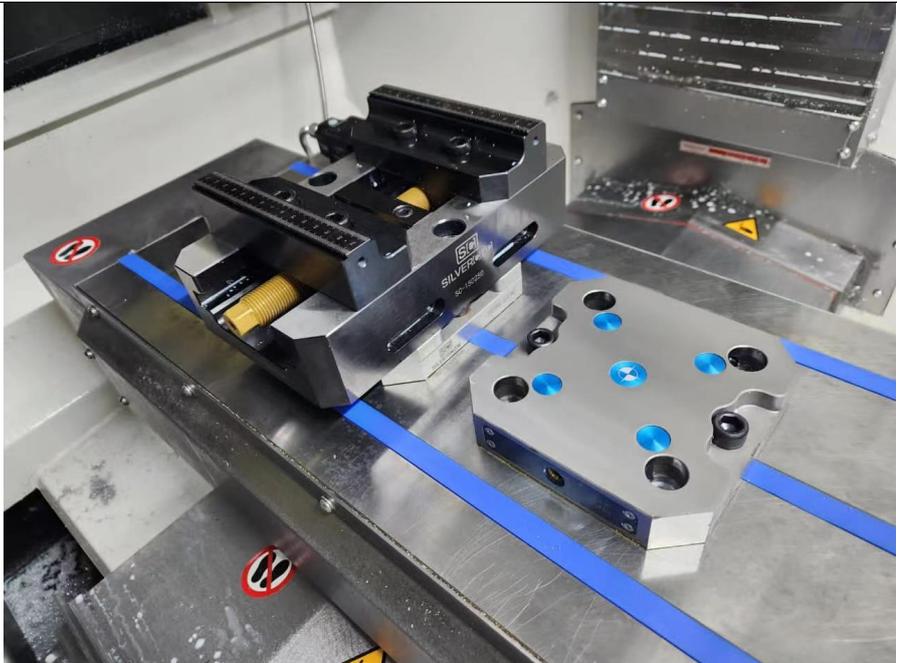


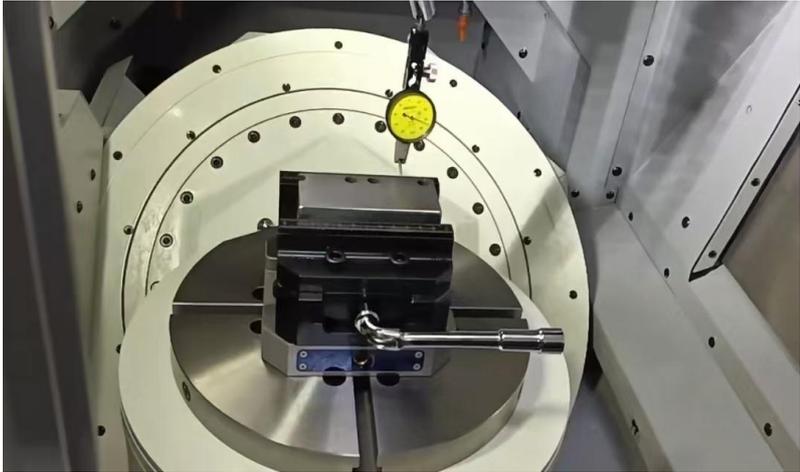
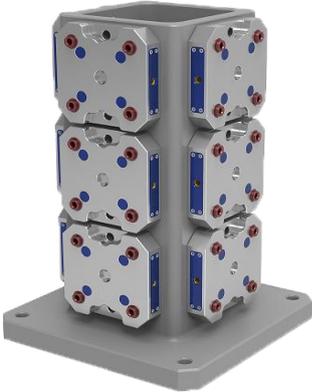
Note:

There are micro holes on the blue cover. When installing the fixing screws or center calibration, please use an air gun to aim at the small holes and remove the cover.

3. Base plate Installation

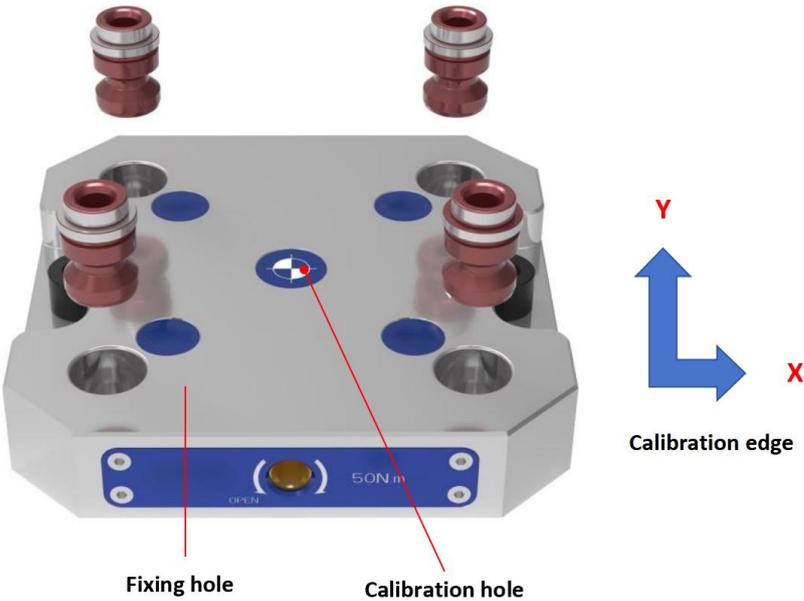
The Base plate can be installed on your 3, 4, and 5-axis CNC machines, follow are common ways of use:

<p>3axis table</p>	
<p>4axis rotary table face plate</p>	

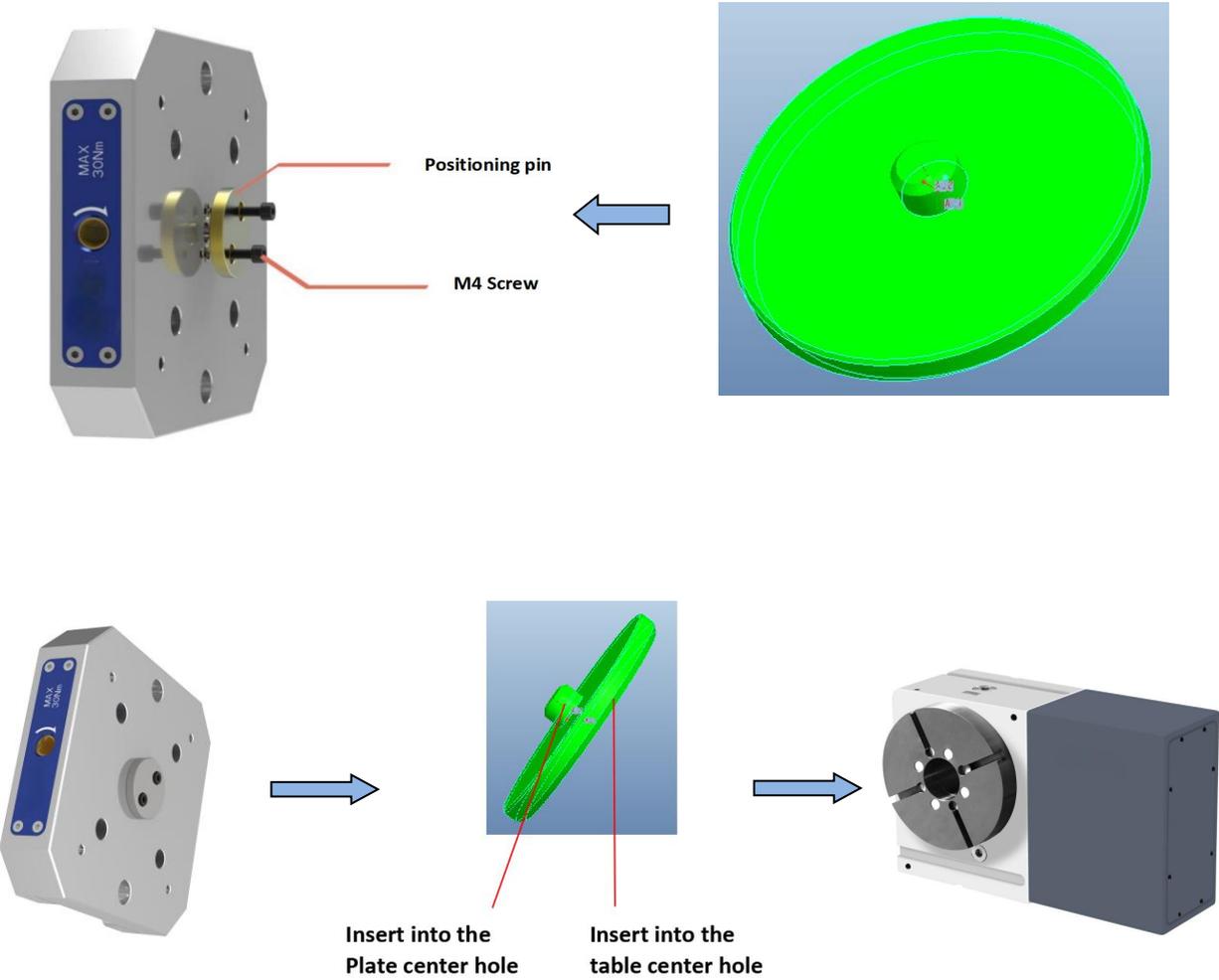
<p>5axis worktable</p>	
<p>Horizontal CNC</p>	

Install the base plate on table

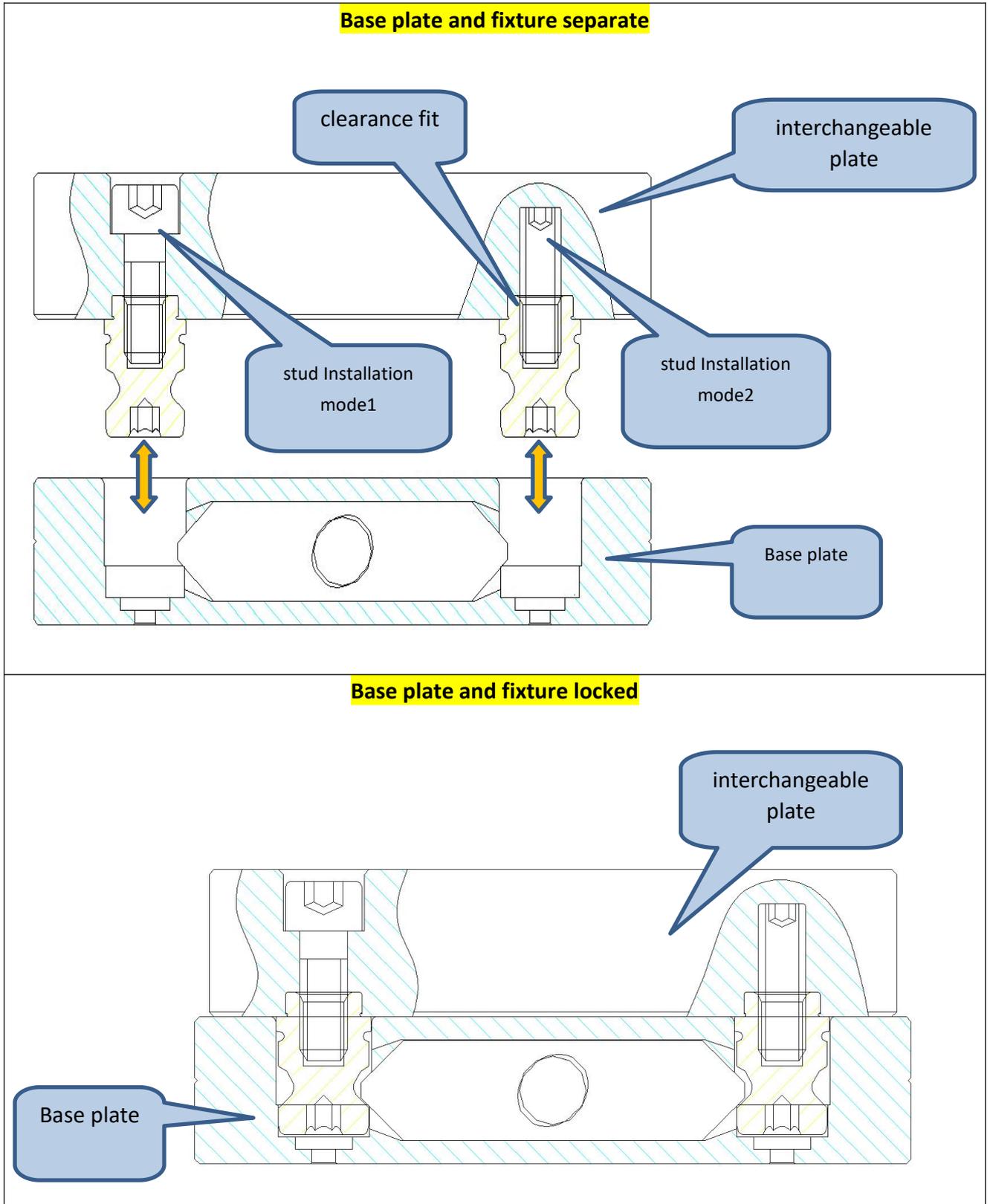
1. Open the blue dust cover with an air gun and fix the bottom plate with screws.
2. Calibrate with a dial gauge, ensure that the straight edge of the base plate is parallel to the machine tool XY axis.



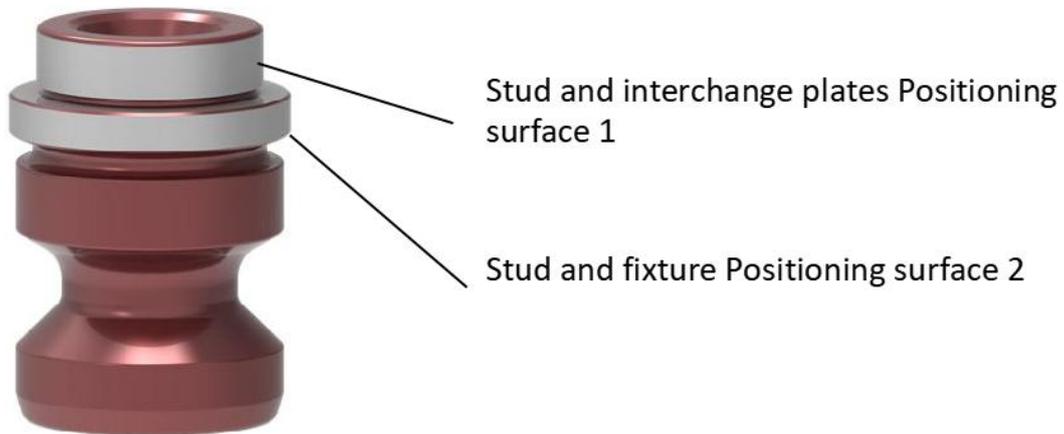
Install the base plate on 4axis rotary table



4. Fixture instruction

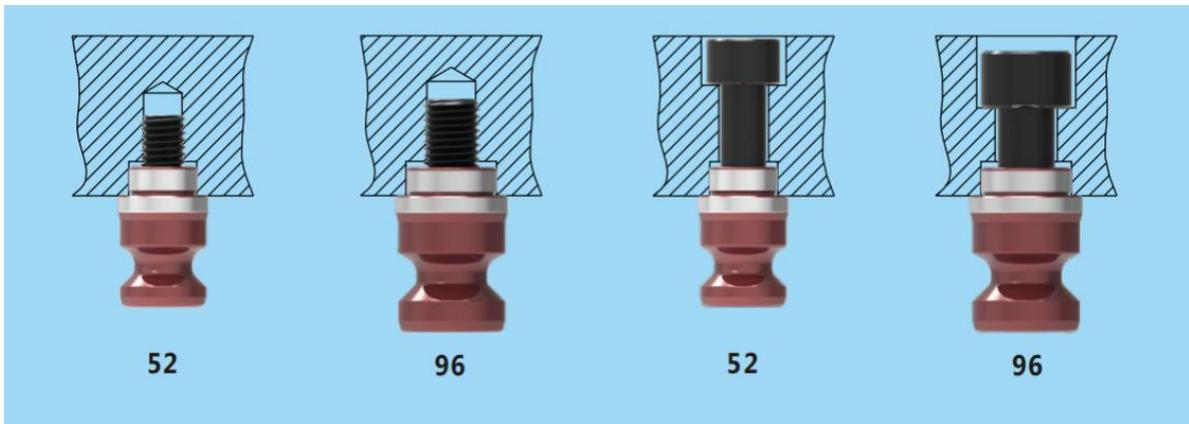


5. Studs instruction



☆ Note: the stud and the exchange plate should be interstitial. When installing stud, lubricate the cylinder surface to prevent straining the surface.

Studs locking



6. Common anomalies

Symptom	Cause	Action
Can't lock tightly	Excessive torque	Remove the locking block, loosen the locking pin and reinstall it
	Wrong rotation direction	Please pay attention to the identification of the rotation direction of the plate
The locking mechanism is stuck	Studs hole have many iron filings	Remove iron filings and pay attention to dust prevention
	Collision occurs	Remove the locking block, loosen the locking pin and reinstall it
Accuracy is not good	Uneven installation	Clean the worktable before installation
	Surface scratches	Regular maintenance
Unable to retrieve studs and work piece	The oil film on the contact surface is stuck tightly	Blow air into the contact surface

7. Maintenance and Storage

If a base plate is to be unused for an extended amount of time, please follow these storage guidelines:

- Clean off all chips, debris and fluids (coolant)
- Lubricate all internal components with grease
- Spray or coat all external surfaces with rust preventative
- Store in dry/climate controlled environment

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