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MCR20 ENDCAP REPLACEMENT KIT



RENISHAW®

User's Instruction

RENISHAW®

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INTRODUCTION

This User Instruction leaflet details the procedure to change the MCR20 end caps. There has been a design modification to the rack to ensure that ports 1 and 6 reliably inhibit the TP20 during a module change. Some early design racks may need these replacement end caps to improve probe inhibit in the change cycle.

Caution
Renishaw recommends that the CMM is stationary during this procedure

Procedure
(Please refer to figure 1)

1. Remove screws located in A and B using the 2mm A/F allen key provided.
2. Remove the end cap from the MCR20 rack by sliding the cap away from the ports.
3. Re-fit the modified MCR20 end cap supplied.
4. Fit the M3 x 16mm screws into location A and B using the 2mm A/F allen key.

Where possible, this operation should be completed without removing the MCR20 from its location on the CMM's bed. This prevents the need to re datum the rack for automatic stylus change. If it is necessary to remove the MCR20 to complete this operation, please refer to your CMM supplier for instructions to re-datum the rack.

Please refer to the **TP20 and MCR20 Installation and User's Guide** (part no. H-1000-5008) for more information about using the TP20 probe system.

Renishaw reserves the right to change specifications without notice

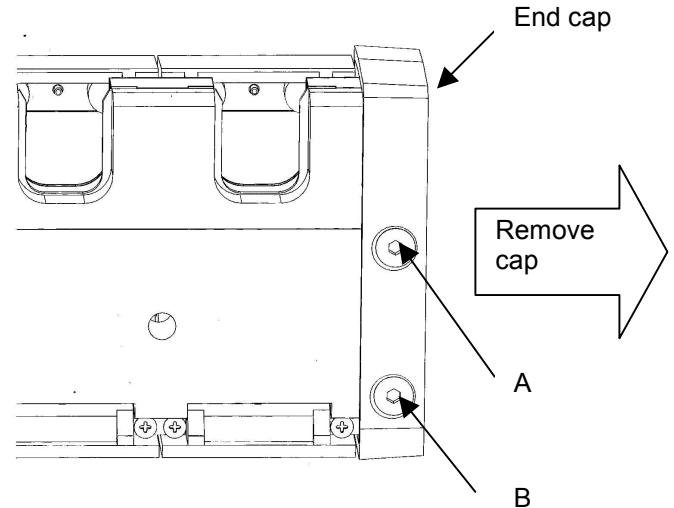


Figure 1 – MCR20 viewed from underneath