

# NC4+ Blue non-contact tool setting system



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# Before you begin

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Renishaw warrants its equipment and software for a limited period (as set out in the Standard Terms and Conditions), provided that they are installed and used exactly as defined in associated Renishaw documentation. You should consult these Standard Terms and Conditions to find out the full details of your warranty.

Equipment and/or software purchased by you from a third-party supplier is subject to separate terms and conditions supplied with such equipment and/or software. You should contact your third-party supplier for details.

## CNC machines

CNC machine tools must always be operated by fully-trained personnel in accordance with the manufacturer's instructions.

## Care of the system

Keep system components clean and treat the unit as a precision tool.

## Patents

Features of the NC4+ Blue unit non-contact tool setting system and features of similar Renishaw products, are the subject of one or more of the following patents and/or patent applications:

CN 113242954	EP 4664161
CN 115413316	JP 7680468
CN 117697537	US 11511384
EP 3864368	US 11904426
EP 4127603	US 12385734

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## Intended use

The NC4+ Blue unit is a laser-based non-contact tool setting system that provides high-speed/high-precision measurement of cutting tools on a machining centre under normal operating conditions.

## Safety

### Information to the user

The NC4 set-up tool (Renishaw part no. A-4114-8000, sold separately) is supplied with non-rechargeable lithium metal batteries. Refer to the battery manufacturer's literature for specific battery operating, safety and disposal guidelines.

- Do not attempt to recharge the batteries.
- Replace the batteries only with the specified type.
- Do not mix new and used batteries in the product.
- Do not mix different types or brands of batteries in the product.
- Ensure that all batteries are inserted with the correct polarity in accordance with the instructions in this manual and indicated on the product.
- Do not store the batteries in direct sunlight.
- Do not expose the batteries to water.
- Do not expose the batteries to heat or dispose of the batteries in a fire.
- Avoid forced discharge of the batteries.
- Do not short circuit the batteries.
- Do not disassemble, apply excessive pressure, pierce, deform or subject the batteries to impact.
- Do not swallow the batteries.
- Keep the batteries out of the reach of children.
- If the batteries are swollen or damaged do not use them in the product and exercise caution when handling them.
- Dispose of waste batteries in accordance with your local environmental and safety laws.

Ensure that you comply with international and national battery transport regulations when transporting the batteries or this product with the batteries inserted. Lithium metal batteries are classified as dangerous goods for transportation and require labelling and packaging in accordance with the dangerous goods regulations before being offered for transportation. To reduce the risk of shipment delays, should you need to return this product to Renishaw for any reason, do not return any batteries.

In all applications involving the use of machine tools, eye protection is recommended.

## Information to the machine supplier / installer

It is the machine supplier's responsibility to ensure that the user is made aware of any hazards involved in operation, including those mentioned in Renishaw product literature, and to ensure that adequate guards and safety interlocks are provided.

If the NC4+ Blue unit fails, the output signal may falsely indicate beam not blocked. Do not rely on signals from the NC4+ Blue unit to halt the movement of the machine.

## Information to the equipment installer

All Renishaw equipment is designed to comply with the relevant UK, EU and FCC regulatory requirements. It is the responsibility of the equipment installer to ensure that the following guidelines are adhered to, in order for the product to function in accordance with these regulations:

- any interface MUST be installed in a position away from any potential sources of electrical noise (for example, power transformers, servo drives);
- all 0 V/ground connections should be connected to the machine "star point" (the "star point" is a single point return for all equipment ground and screen cables). This is very important and failure to adhere to this can cause a potential difference between grounds;
- all screens must be connected as outlined in the user instructions;
- cables must not be routed alongside high current sources (for example, motor power supply cables), or be near high-speed data lines;
- cable lengths should always be kept to a minimum.

## Equipment operation

If this equipment is used in a manner not specified by the manufacturer, the protection provided by the equipment may be impaired.

## Warnings

Use of controls or adjustments or performance of procedures other than those specified within this publication may result in hazardous radiation exposure.

Switch off the power supply before carrying out maintenance on the NC4+ Blue system.

When using the NC4+ Blue system, basic safety precautions must always be followed to reduce the risk of fire, electric shock and personal injury, including the following:

- Read all instructions before operating this product.
- The device must only be installed and used by competent, trained personnel.
- Use eye protection to protect against mechanical hazards, coolant and swarf.
- Avoid inhalation of coolant vapour from the machine tool.
- Do not block the air exiting from the transmitter, receiver or air blast apertures.
- The sound power emitted by the air blast equipment can range from 70.3 dB at 0.3 MPa (43.51 psi) to 78.2 dB at 0.6 MPa (87.02 psi). It is the responsibility of the integrator to ensure a suitable noise assessment is performed when the equipment is put into use.
- Prevent direct exposure of the eyes to the laser beam.
- Ensure that the beam is not reflected into the eyes via any reflective surface.



### CAUTION – LASER SAFETY

The laser used in the Renishaw NC4+ Blue non-contact tool setting system emits visible blue light at a wavelength of 405 nm and has a power output of less than 1 mW.

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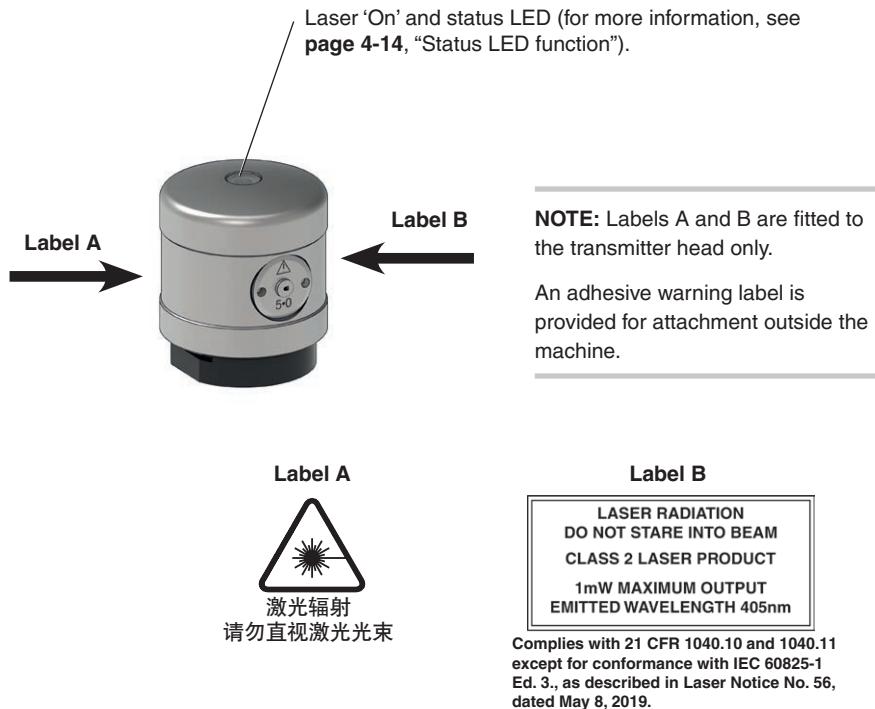
The NC4+ Blue unit is classified as a Class 2 laser product as defined by BS EN 60825-1:2014.

Complies with 21 CFR 1040.10 and 1040.11 except for conformance with IEC 60825-1 Ed. 3., as described in Laser Notice No. 56, dated May 8, 2019.

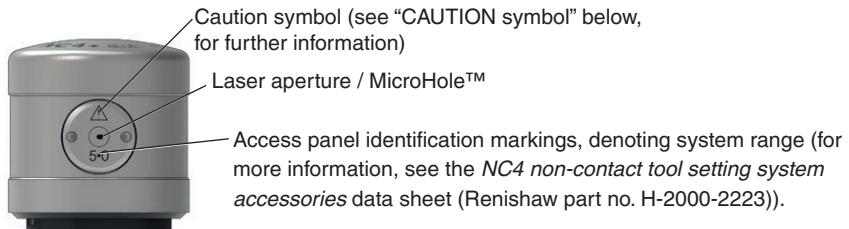
BS EN 60825-1:2014 directs to attach a laser warning label and explanatory label.

A warning label and explanatory label are permanently fixed to each side of the transmitter (Tx) housing (see **page 1-6**, “Laser safety and warning labels”, for further information). An adhesive warning label is also provided. Renishaw advise attaching this label to the outside of the machine tool, in a visible location.

## Laser safety and warning labels



## Location of the laser aperture



### CAUTION – LASER SAFETY

The access panel is to be removed for service purposes only using the special tool supplied.

Before removing the panel, switch off electrical power to the transmitter head to avoid exposure to the laser beam.



### CAUTION SYMBOL

The caution symbol on the access panel denotes the following:

**CAUTION – Class 3R Laser radiation when open. Avoid direct eye exposure.**

This text is not included on the access panel due to the limited space available.

# NC4+ Blue basics

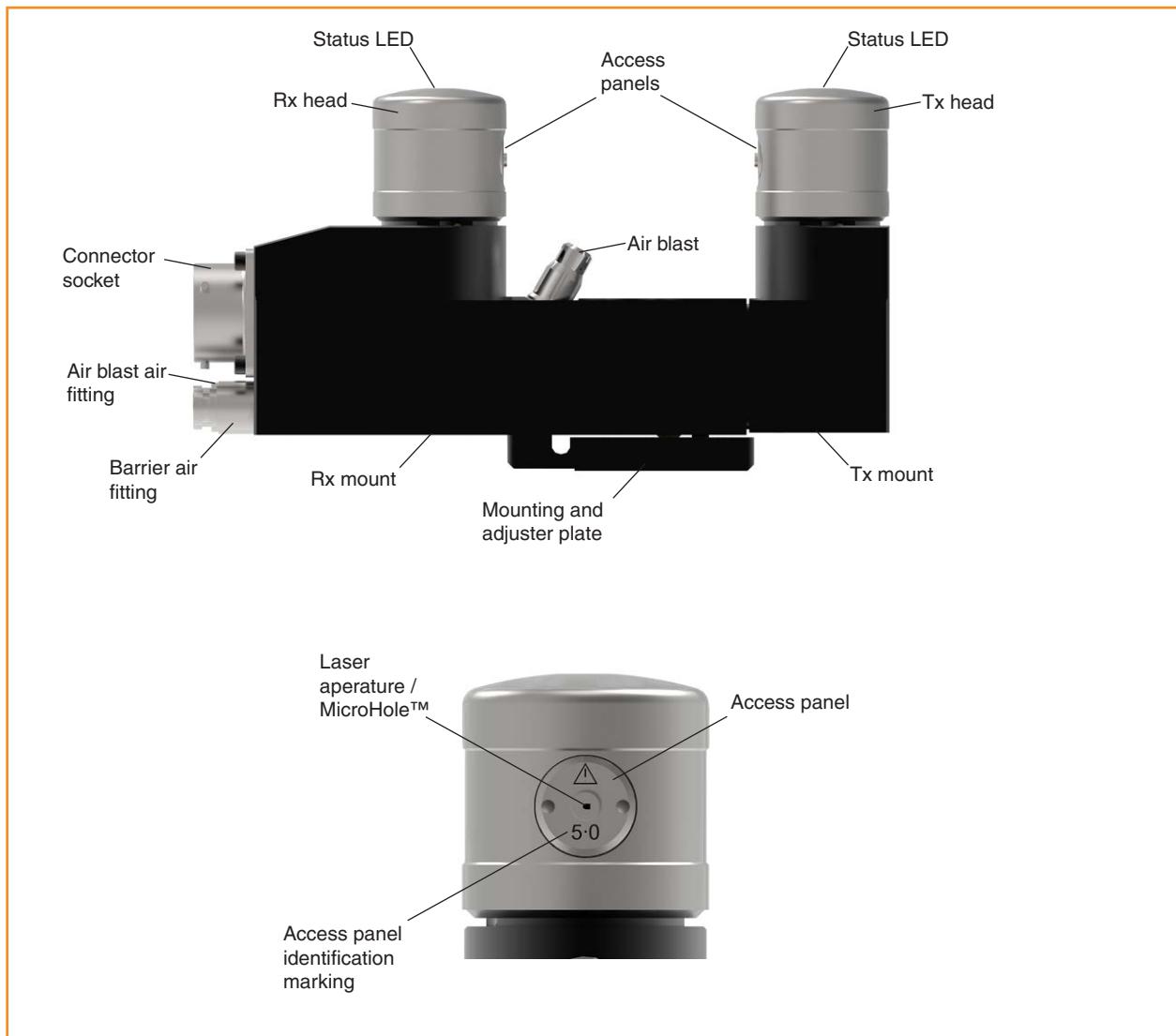
## Introduction

This guide describes how to install, configure, maintain and service the Renishaw NC4+ Blue non-contact tool setting system.

The NC4+ Blue unit is a laser-based non-contact tool setting system that provides high-speed/high-precision measurement of cutting tools on a machining centre under normal operating conditions.

As a tool moves through the laser beam, the system detects when the beam is broken. Output signals sent to the controller allow the presence of a tool and the position of the tip to be established. This can be used to determine the dimensions of tools (tool measurement) or condition of tools (broken tool detection).

## NC4+ Blue unit components



## Guidelines for best practice

- The NC4+ Blue unit is a precision device and must be handled with care.
- Ensure that all mountings are secure.
- Keep electrical contacts clean.
- Mount the NC4+ Blue unit in a position that limits the risk of it being subjected to impact when operating the machine.
- Mount the NC4+ Blue unit in a position where it will not be affected by a build-up of swarf. Do not allow excessive waste material to build up on or around the NC4+ Blue unit.
- Cables, piping and conduit should be suitably secured to avoid damage and loads being transferred to the NC4+ Blue unit.
- Optimum performance is achieved by continuously supplying air and power to the NC4+ Blue unit.
- The NC4+ Blue unit is protected by a continuous stream of clean air. Approximately once a month, inspect the optics for contamination. The service interval may be extended or reduced depending on experience.
- The NC4+ Blue barrier air supply must conform to BS ISO 8573-1 air quality of Class 1.4.2 and be moisture-free.

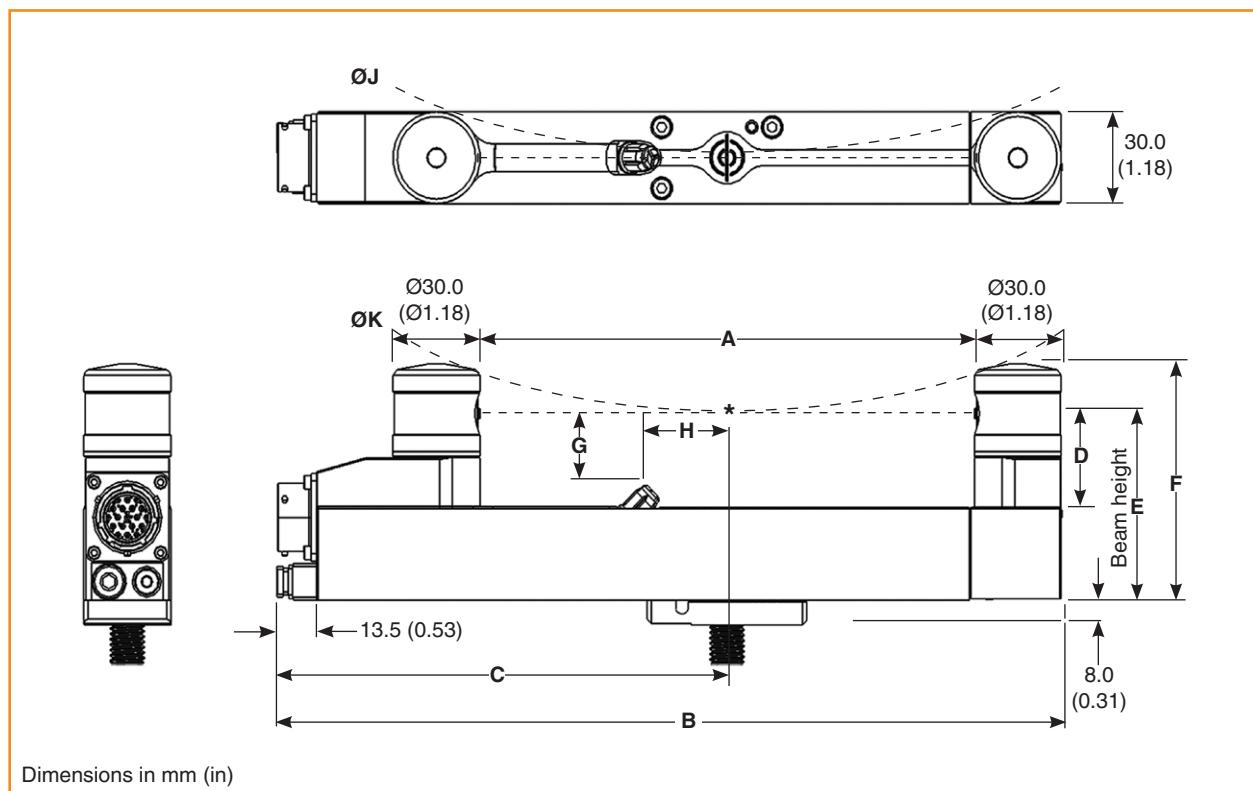
## NC4+ Blue specification

<b>Principal application</b>	High-precision, high-speed non-contact tool setting and tool breakage detection on all sizes of vertical and horizontal machining centres, multi-tasking machines and gantry machining centres.	
<b>Transmission type</b>	Hard-wired transmission	
<b>Compatible interfaces</b>	NCi-6, NCSI, NCi-E	
<b>Repeatability</b>	F100 and F100-10	±0.10 µm (4 µin) 2σ
	F115 and F145	±0.50 µm (20 µin) 2σ
	F230 and F300	±0.75 µm (30 µin) 2σ
<b>Tool setting and tool breakage detection</b> (minimum tool or feature size)	F100-10 systems	Ø5 µm (197 µin)
	F100 systems	Ø15 µm (591 µin)
	F115 systems	Ø30 µm (1181 µin)
	F145 systems	Ø50 µm (1968 µin)
	F230 systems	Ø100 µm (3937 µin)
	F300 systems	Ø200 µm (7874 µin)
<b>Output signal</b> (from NCi-6 interface unit)	<p>Two voltage-free, solid-state relays (SSR). Each can be either normally open or normally closed (selectable via a switch). Current (maximum) 50 mA, voltage (maximum) ±50 V.</p> <p>The interface contains an auxiliary relay which can be used for switching the output between the NC4+ Blue and a spindle probe. This relay can also be used to control an air blast solenoid (optional).</p>	
<b>Supply voltage</b> (to interface)	11 Vdc to 30 Vdc	
<b>Supply current</b> (to interface)	120 mA @ 12 Vdc, 70 mA @ 24 Vdc	
<b>Supply protection</b>	Resettable fuses in interface. Reset by removing power and cause of fault.	
<b>Electrical connection arrangement</b>	<p><b>Systems with connector:</b> Connector socket.</p> <p><b>Hard-wired systems:</b> Cable on the end of the unit.</p> <p>Other configurations are available on request.</p>	
<b>Cable</b> (to interface)	<b>Specification</b>	Ø6.0 mm (0.24 in), two twisted pairs, two individual cores plus screen, each core 18 × 0.1 mm insulated.
	<b>Length</b>	12.5 m (41.01 ft)
	<b>Electrical connection</b>	<p><b>Systems with connector:</b> cable with bayonet-type plug, connector socket on the end of the unit.</p> <p><b>Hard-wired systems:</b> cable on the end of the unit.</p> <p>Other configurations are available on request.</p>
<b>Barrier air pneumatic supply</b>	<p>Air supply must conform to BS ISO 8573-1: 2010 Class 1.4.2. 6.0 bar (87.02 psi) maximum.</p> <p><b>Systems with connector:</b> Ø4.0 mm (0.16 in) air pipe.</p> <p><b>Hard-wired systems:</b> 2 × Ø3.0 mm (0.12 in) air pipe.</p>	
<b>Air blast pneumatic supply</b>	Air supply to the air blast must conform to BS ISO 8573-1 Class 2.9.4. Ø6.0 mm (0.24 in) air pipe × 5.0 m (16.40 ft), 6.0 bar (87.02 psi) maximum.	
<b>Laser type</b>	<p>Class 2 laser product:</p> <p>1 mW maximum output emitted wavelength 405 nm.</p> <p><b>WARNING:</b> Laser radiation. Do not stare into the beam.</p>	
<b>Laser beam alignment</b>	The unit is supplied with an adjustable mounting plate on the underside.	

## NC4+ Blue specification (continued)

<b>Weight</b> (including 12.5 m (41.01 ft) of cable)	1.1 kg (2.43 lb) to 2.0 kg (4.4 lb) depending on configuration.	
<b>Mounting</b>	<p><b>For F100 and F100-10 systems:</b> Use M4 (x 3) or M10 (3/8 in) bolts for mounting via the adjuster plate.</p> <p><b>For F115, F145, F230, and F300 systems:</b> Use M4 (x 3), M10 (3/8 in), or M12 (1/2 in) bolts for mounting via the adjuster plate.</p> <p>Bolts are not supplied. Other fixing arrangements are available on request.</p>	
<b>Environment</b>	IP rating	IPX5, IPX6, IPX8. BS EN 60529:1992+A2:2013
	Storage temperature	–25 °C to +70 °C (–13 °F to +158 °F)
	Operating temperature	+5 °C to +55 °C (+41 °F to +131 °F)

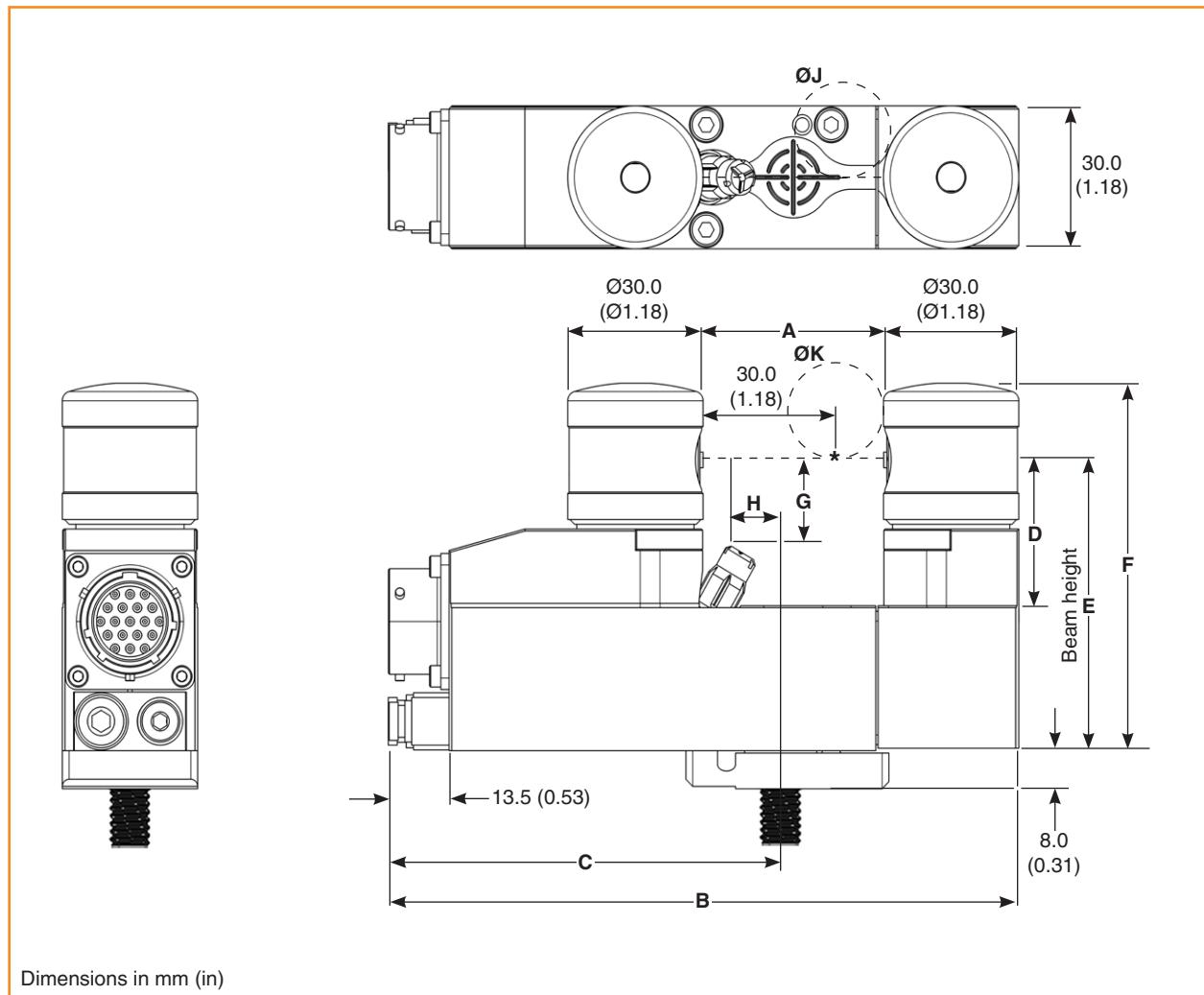
## Dimensions of NC4+ Blue units with connector



Model	Dimensions									
	A	B	C	D	E	F	G	H	ØJ	ØK
F100C	40.0 (1.57)	140.0 (5.51)	87.0 (3.43)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	18.0 (0.71)	10.9 (0.43)	66.0 (2.60)	44.0 (1.73)
F115C	55.0 (2.17)	155.0 (6.10)	97.3 (3.83)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	18.0 (0.71)	13.8 (0.54)	105.0 (4.13)	70.0 (2.76)
F115C-R	55.0 (2.17)	155.0 (6.10)	97.3 (3.83)	50.0 (1.97)	80.0 (3.15)	96.0 (3.78)	35.1 (1.38)	12.3 (0.48)	105.0 (4.13)	70.0 (2.76)
F145C	85.0 (3.35)	185.0 (7.28)	112.3 (4.42)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	21.3 (0.84)	25.3 (1.00)	205.0 (8.07)	147.0 (5.79)
F145C-R	85.0 (3.35)	185.0 (7.28)	112.3 (4.42)	50.0 (1.97)	80.0 (3.15)	96.0 (3.78)	37.1 (1.46)	24.7 (0.97)	205.0 (8.07)	147.0 (5.79)
F230C	170.0 (6.69)	270.0 (10.63)	155.0 (6.10)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	21.3 (0.84)	25.3 (1.00)	652.0 (25.67)	535.0 (21.06)
F230C-R	170.0 (6.69)	270.0 (10.63)	155.0 (6.10)	50.0 (1.97)	80.0 (3.15)	96.0 (3.78)	40.3 (1.59)	44.3 (1.74)	652.0 (25.67)	535.0 (21.06)
F300C	240.0 (9.45)	340.0 (13.39)	190.0 (7.48)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	21.3 (0.84)	25.3 (1.00)	1200.0 (47.24)	1043.0 (41.06)
F300C-R	240.0 (9.45)	340.0 (13.39)	190.0 (7.48)	50.0 (1.97)	80.0 (3.15)	96.0 (3.78)	40.3 (1.59)	44.3 (1.74)	1200.0 (47.24)	1043.0 (41.06)

Dimensions in mm (in)

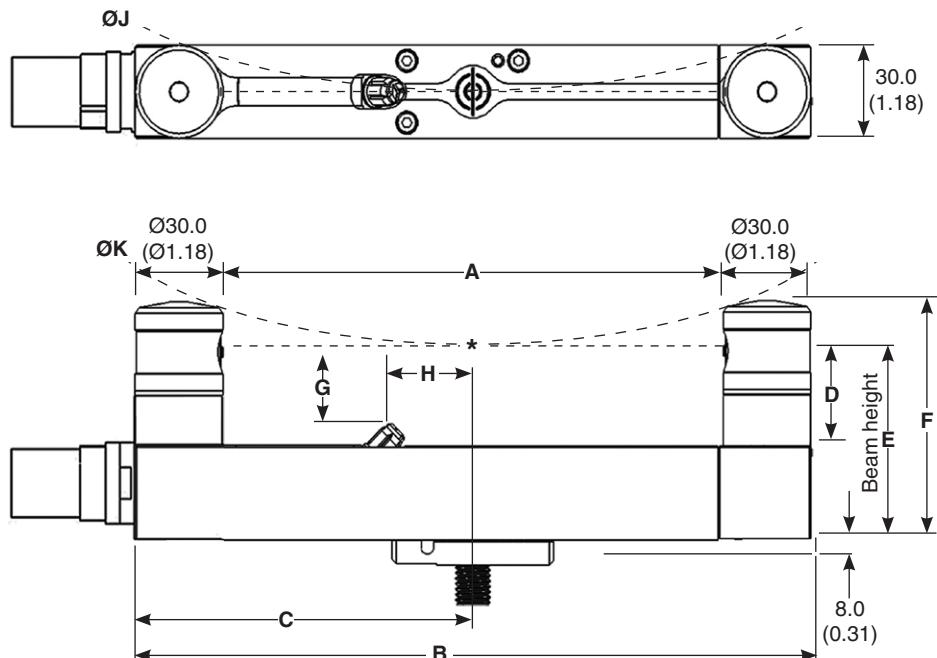
## Dimensions of NC4+ Blue F100-10C units with connector



Model	Dimensions										
	A	B	C	D	E	F	G	H	ØJ	ØK	
F100-10C	40.0 (1.57)	140.0 (5.51)	87.0 (3.43)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	18.0 (0.71)	10.9 (0.43)	25.0 (0.98)	19.5 (0.77)	

Dimensions in mm (in)

## Dimensions of hard-wired NC4+ Blue units

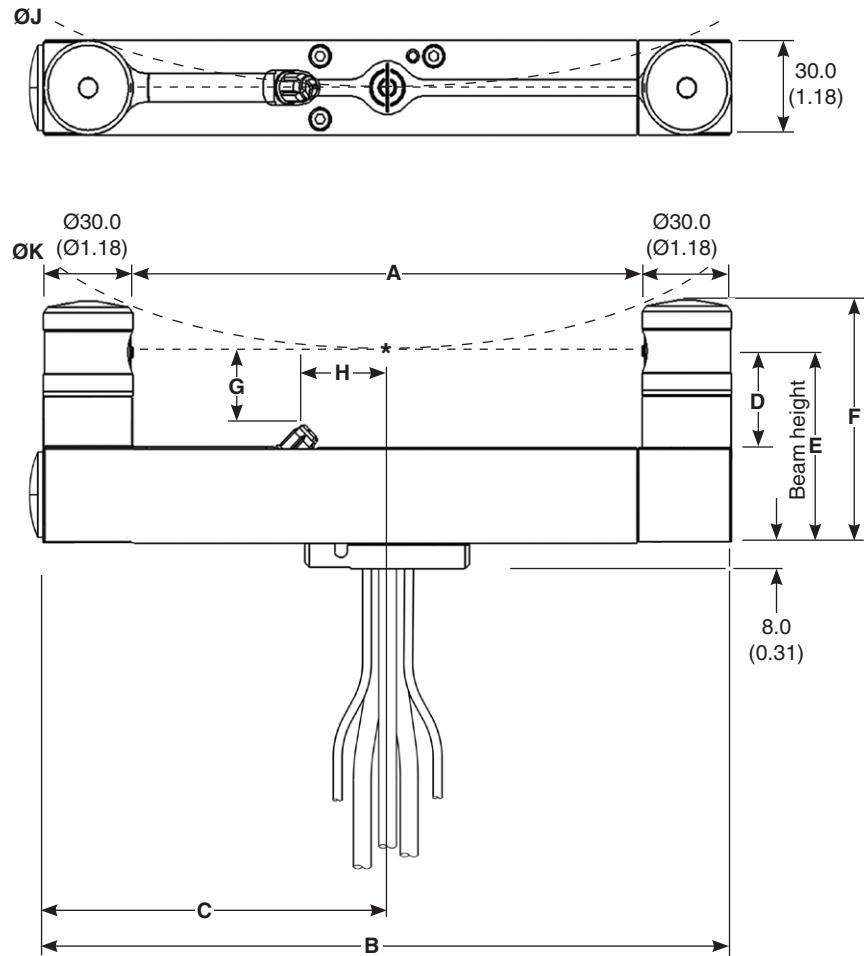


Dimensions in mm (in)

Model	Dimensions										
	A	B	C	D	E	F	G	H	ØJ	ØK	
<b>F145</b>	85.0 (3.35)	145.0 (5.71)	72.5 (2.85)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	20.4 (0.80)	24.5 (0.96)	205.0 (8.07)	147.0 (5.79)	
<b>F230</b>	170.0 (6.69)	230.0 (9.06)	115.0 (4.53)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	21.3 (0.84)	25.3 (1.00)	652.0 (25.67)	535.0 (21.06)	

Dimensions in mm (in)

## Dimensions of bottom exit NC4+ Blue units



Dimensions in mm (in)

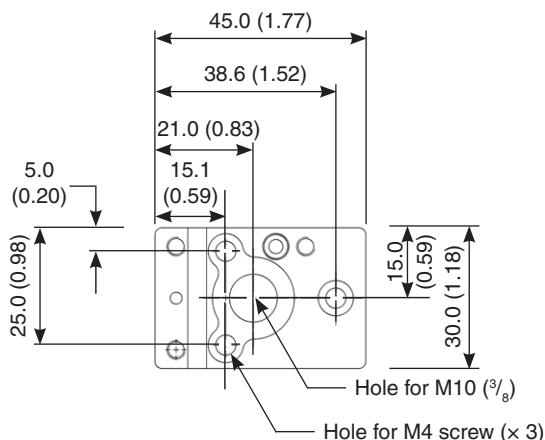
Model	Dimensions										
	A	B	C	D	E	F	G	H	ØJ	ØK	
F145	85.0 (3.35)	145.0 (5.71)	72.5 (2.85)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	20.4 (0.80)	24.5 (0.96)	205.0 (8.07)	147.0 (5.79)	
F230	170.0 (6.69)	230.0 (9.06)	115.0 (4.53)	31.0 (1.22)	61.0 (2.40)	77.0 (3.03)	21.3 (0.84)	25.3 (1.00)	652.0 (25.67)	535.0 (21.06)	

Dimensions in mm (in)

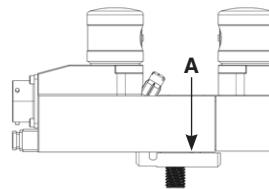
## Mounting adjuster plate dimensions

Mounting plate for F100 systems only

Mounting/adjuster plate

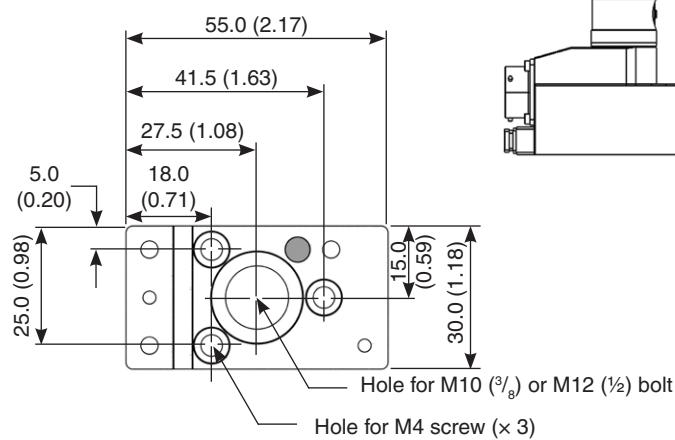


View on A

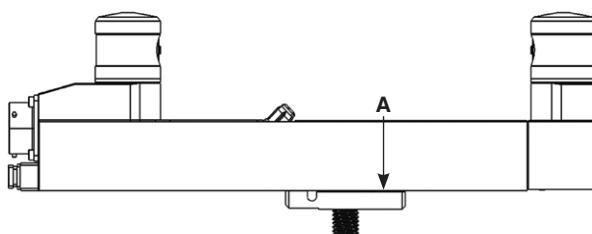


Mounting plate for F115, F145, F230 and F300 systems

Mounting/adjuster plate



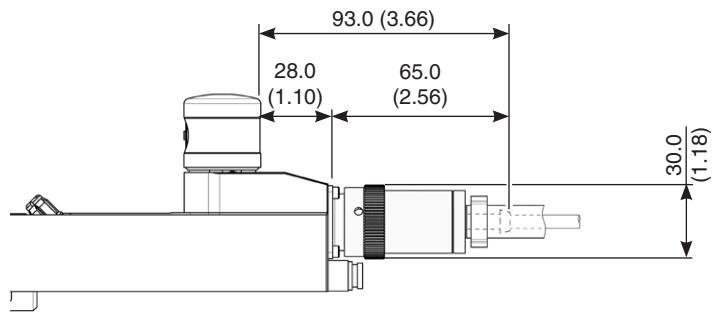
View on A



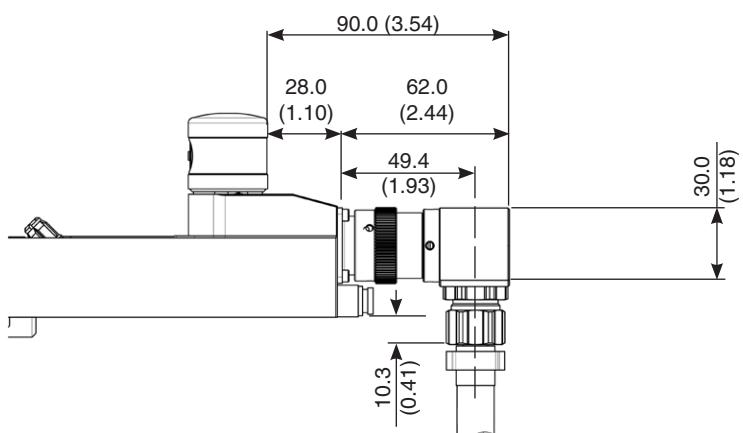
Dimensions given in mm (in)

## Cable with connector dimensions

Straight connector

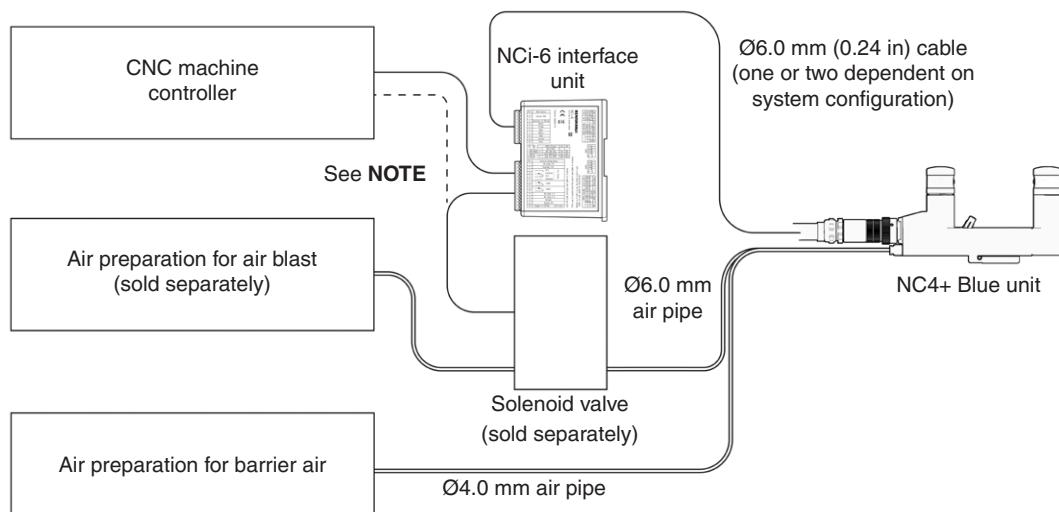


90° connector



Dimensions given in mm (in)

# System installation



**NOTE:** The solenoid valve can be controlled by an M-code connected using the auxiliary relay on NCi-6, CN2 pins 3, 4, 5 and 6. Alternatively, the M-code can be connected directly to the solenoid valve.

## How to install and configure the NC4+ Blue system

Install and configure the NC4+ Blue system in the sequence described below:

1. Install the air preparation pack (see [page 3-3](#), “Installing the air preparation pack”, for further information). Do not switch on the air supply or set the air pressure at this stage.
2. Install the NC4+ Blue system (see [page 3-4](#), “Installing the NC4+ Blue system”, for further information).
3. Install the NCi-6 interface unit (see [page 3-8](#), “Installing the NCi-6 interface unit”, for further information).
4. Switch on electrical power to the NCi-6 interface unit (see [page 3-9](#), “Supplying electrical power to the NCi-6 interface unit”, for further information).
5. Switch on the barrier air supply to the NC4+ Blue unit and set the air pressure (see [page 3-10](#), “Setting the NC4+ Blue barrier air pressure”, for further information).
6. Align the NC4+ Blue unit (see [page 3-13](#), “Aligning the NC4+ Blue unit to the machine axes”, for further information).
7. Finally, calibrate the system as described in the appropriate non-contact tool setting software programming guide.
8. If problems occur, or for more information, see [page 5-1](#), “Fault-finding”.

## Air supply information

The barrier air supply to the NC4+ Blue unit must conform to BS ISO 8573-1 air quality of Class 1.4.2 and be moisture-free. If the air quality cannot be guaranteed, an air preparation pack is available from Renishaw; see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

The NC4+ Blue unit requires a continuous regulated air supply of up to 0.6 MPa (87.02 psi) maximum.

Failure of the air supply causes a PassiveSeal™ inside each NC4+ Blue unit to activate, protecting the unit from the ingress of contaminants. This causes the unit to enter a trigger state. The laser beam will not be seen exiting the transmitter head.

The cause of the air failure should be determined and rectified.

When supply air to NC4+ Blue F100 and F100-10 systems is routinely isolated, install a Ø0.2 mm orifice to vent the barrier air supply line to extend PassiveSeal service life.

The NC4+ Blue air blast requires an air supply of up to 0.6 MPa (87.02 psi) maximum. The air supply to the air blast must conform to BS ISO 8573-1 air quality of Class 2.9.4. A solenoid valve is required to control the air blast. Both the air preparation pack for the air blast and the solenoid valve are available from Renishaw; see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

## Best practices

- Where possible, tap into the air supply that exits the machine air supply filter/regulator unit. Do not connect the NC4+ Blue unit to an oiled air supply.
- When cutting air pipe, ensure it is cut straight, as a tapered cut could compromise sealing.
- Use blanking caps, supplied with the air preparation pack, when feeding air pipe through the conduit/machine.
- Before connecting the air pipes to the inlet of the NC4+ Blue unit or air blast, briefly switch on the air supply to clear out any debris from the pipe. When no more debris is emitted, switch off the air supply and connect to the NC4+ Blue unit.
- When installing the air pipes to the NC4+ Blue unit, keep runs as short as possible to minimise pressure drop.
- If the temperature of the air supply is greater than 5 °C (41 °F) above ambient and is humid, an air dryer will be required. NC4+ Blue installation packs are supplied with an air preparation pack including dryer (Renishaw part number A-6435-4000).

### Minimum bend radius

Component	Outer diameter	Minimum static bend radius
GP 9 conduit	14 (0.55)	40.0 (1.57)
GP 18 conduit	24 (0.94)	75.2 (2.96)
Air pipe	3 (0.12)	6 (0.24)
	4 (0.16)	25 (0.98)
	6 (0.24)	30 (1.18)
NC4 cable	6 (0.24)	10 (0.39)

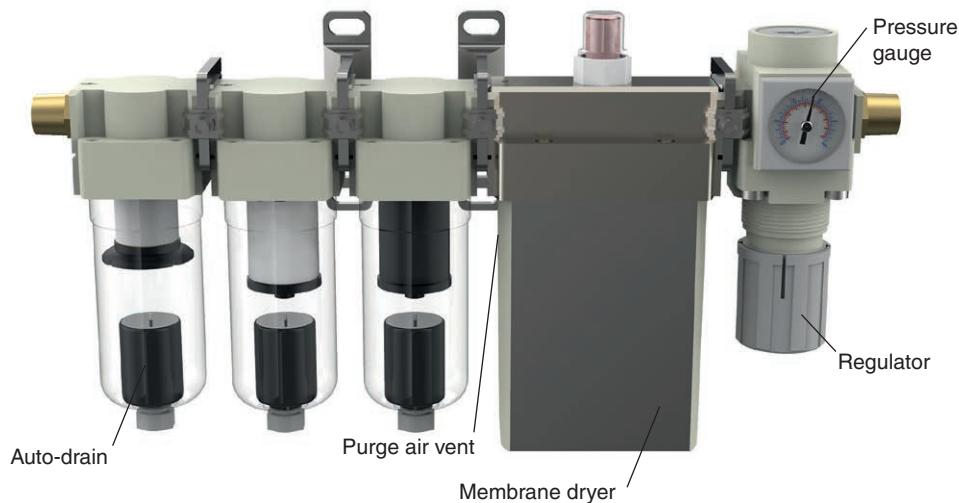
Dimensions given in mm (in)

## Installing the air preparation pack

The air preparation pack (see the figure below) features an auto-drain to remove accumulated liquid from the filter bowls. Once the liquid has reached the float within each filter bowl, the liquid will be drained. The drain ports are threaded M5 x 0.8 to facilitate connection to a suitable waste.

If the incoming air supply is grossly contaminated, a suitable pre-filter may be required to maximise the service life of the air preparation pack.

**WARNING:** Before starting to install the air preparation pack, ensure that the machine is safe to work on.



Secure the air preparation pack, vertically upright, to a suitable surface using the mounting brackets. This must be within 25 m (82.02 ft) of the NC4+ Blue unit.

**NOTE:** The membrane dryer features a small vent from which humid air is purged. Air can be heard venting from this port during operation. It is essential that this port is kept unobstructed.

## What to do next

After you have finished installing the air preparation pack, install the NC4+ Blue system (see [page 3-4](#), “Installing the NC4+ Blue system”, for further information).

Do not switch on the air supply or set the air pressure until the NC4+ Blue unit and NCi-6 interface unit have been installed and electrical power has been supplied.

## Installing the NC4+ Blue system

This section describes how to install NC4+ Blue systems. Refer to the figures on [pages 3-6 and 3-7](#).

---

**WARNING:** Before starting to install the NC4+ Blue system, ensure that the machine is safe to work on. Switch off machine power when working in the controller cabinet.

---

1. Find a suitable position to mount the NC4+ Blue unit. Ensure air will be able to exit freely from the MicroHole™ in the access panels.

---

**NOTE:** Do not mount the system in a position where excessive quantities of swarf can build up.

---

2. Secure the mounting/adjuster plate in a suitable location inside the machine, using one of the options shown in the figure on [page 3-6](#). Align the plate so it is approximately parallel to one of the machines linear axes.
3. Use a dial test indicator to determine the squareness of the adjuster plate relative to the machine axis. The top and sides of the plate should be within 1.0 mm (0.039 in) over the length of the plate.
4. Lay the conduit (and spring covers for systems with connector) in the machine to check the length. Cut to length if necessary.

---

**NOTE:** The internal diameter of the spring covers increases at the end that will be fitted to the NC4+ Blue unit air fittings. When cutting to length, ensure that the length is measured from this end.

---

5. **Hard-wired system:** Feed the two cables and air pipes through the conduit. Do not apply excessive force to the cables or air pipes. Apply an appropriate lubricant if necessary. For more information, refer to the figure on [page 3-6](#).

**System with connector:** Feed the cable through the conduit and feed the two air pipes through the spring covers. For more information, refer to the figure on [page 3-7](#).

6. Push the conduit onto the barbed fitting and fit the securing O-clip.
7. **System with connector:** Fit the cable to the NC4+ Blue unit by pushing the connector into the socket. Rotate the knurled collar until it locks into place.
8. Place the NC4+ Blue unit on the mounting/adjuster plate and secure with the two X/Y axis locking screws and single Z-axis locking screw.

9. Route the conduit (and spring covers for systems with connector) through the machine (for minimum bend radius values, refer to the table on **page 3-3**). A range of accessories are available for neat installation; see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

---

**NOTE:** Before routing conduit and air pipes through the machine, ensure straight adaptors and blanking caps are fitted to the free ends of each pipe (refer to the figure on **page 3-6**). This prevents the ingress of debris into the air pipes.

---

10. Route the cables to the electrical cabinet, taking care to avoid situating them next to sources of electrical noise such as motors or power cables.
11. Route the barrier air pipe to the air preparation pack and air blast air pipe to the solenoid valve (sold separately); see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

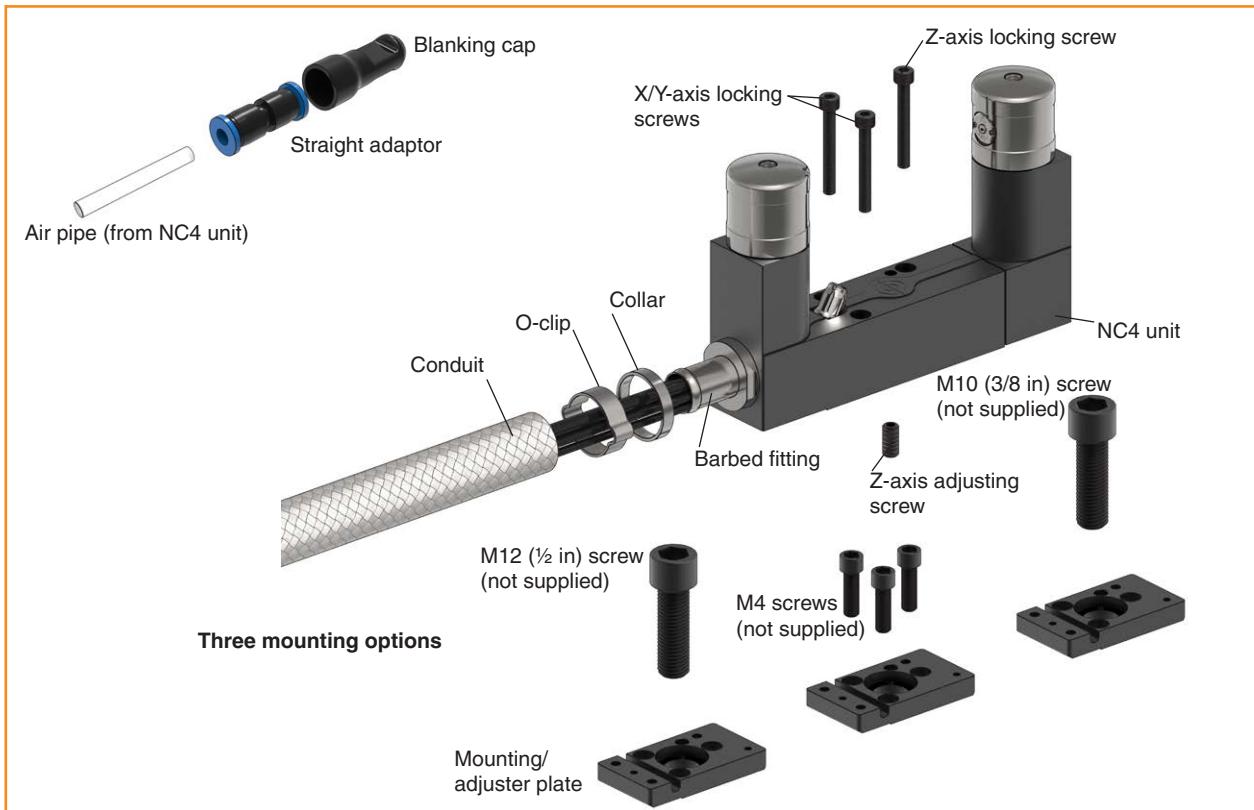
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**NOTE:** 20 m (65.62 ft) of 6 mm (0.23 in) diameter pipe is supplied with the NC4+ Blue installation pack. When routing the barrier air supply, it is recommended that this pipe is used as far as possible (typically to the machine bulkhead) then reduced in diameter closer to the NC4+ Blue unit.

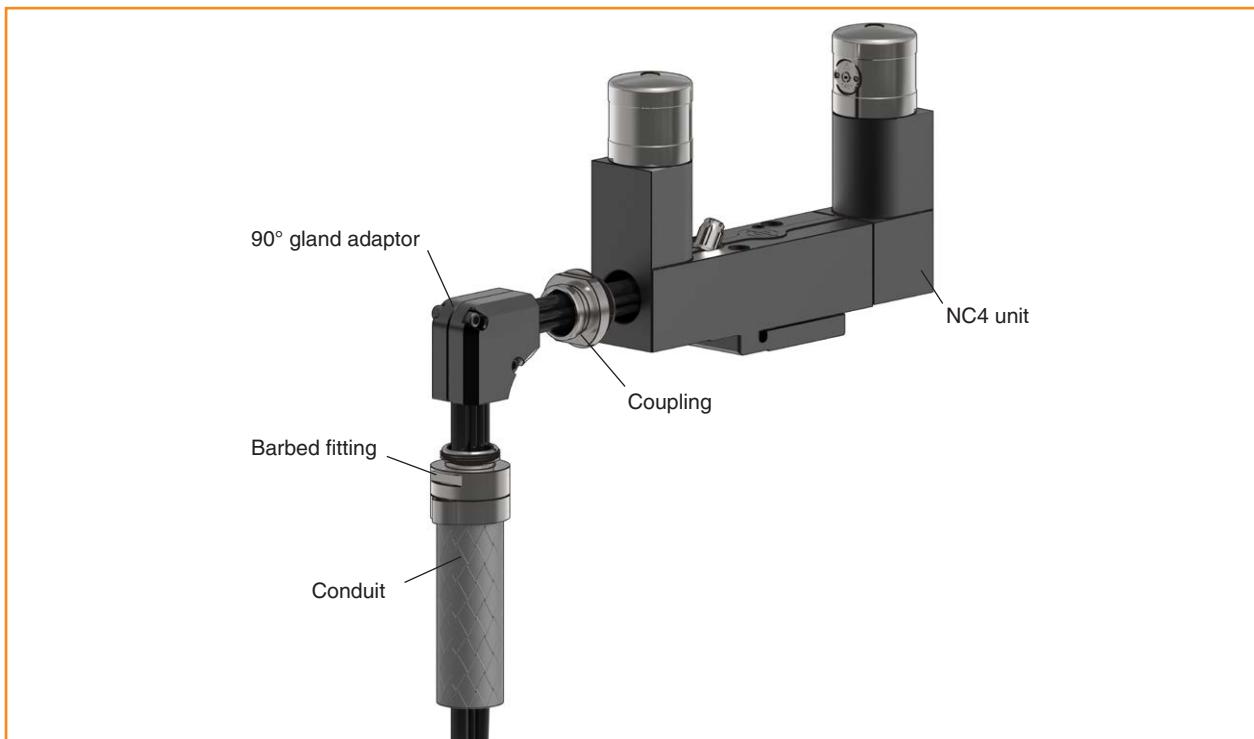
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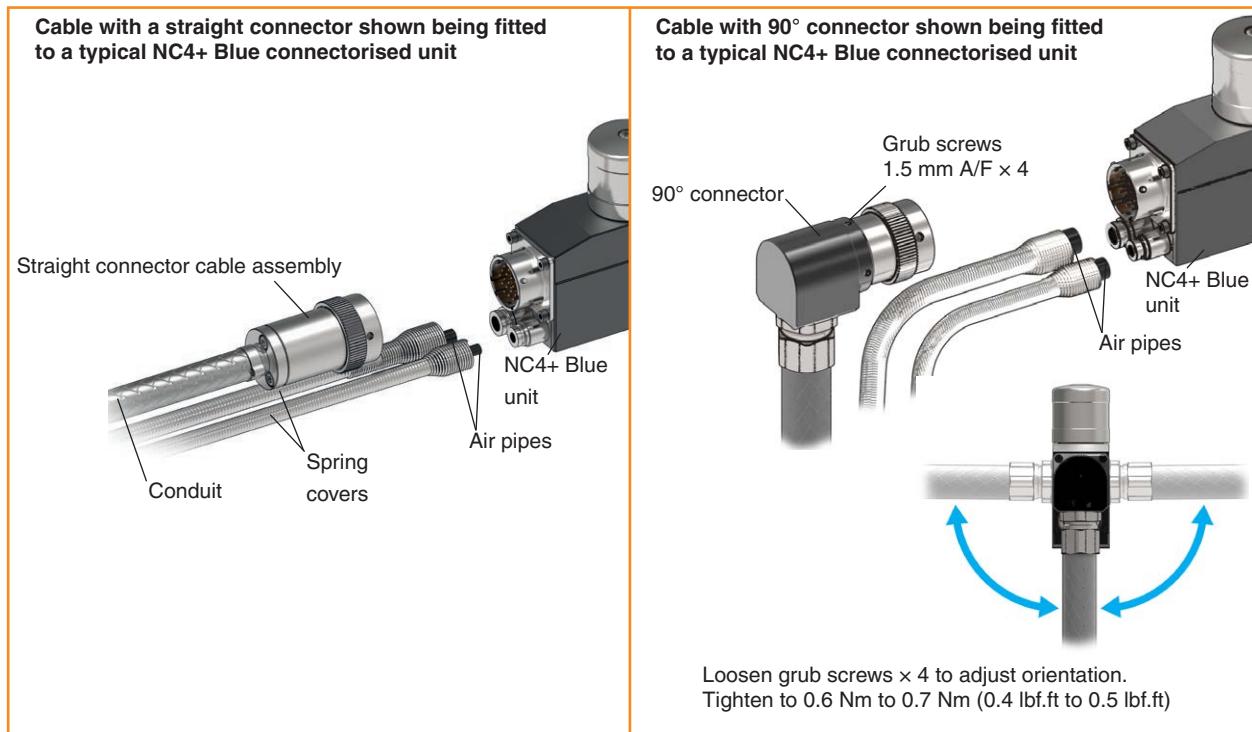
12. Remove the straight adaptors and blanking caps from the end of the air pipes.
13. Before connecting any pipe to the NC4+ Blue unit, use the air regulator to purge the pipe and remove any debris.

## Straight conduit gland shown fitted to a typical hard-wired unit (fitted as standard)



## Optional 90° gland adaptor shown fitted to a typical hard-wired unit

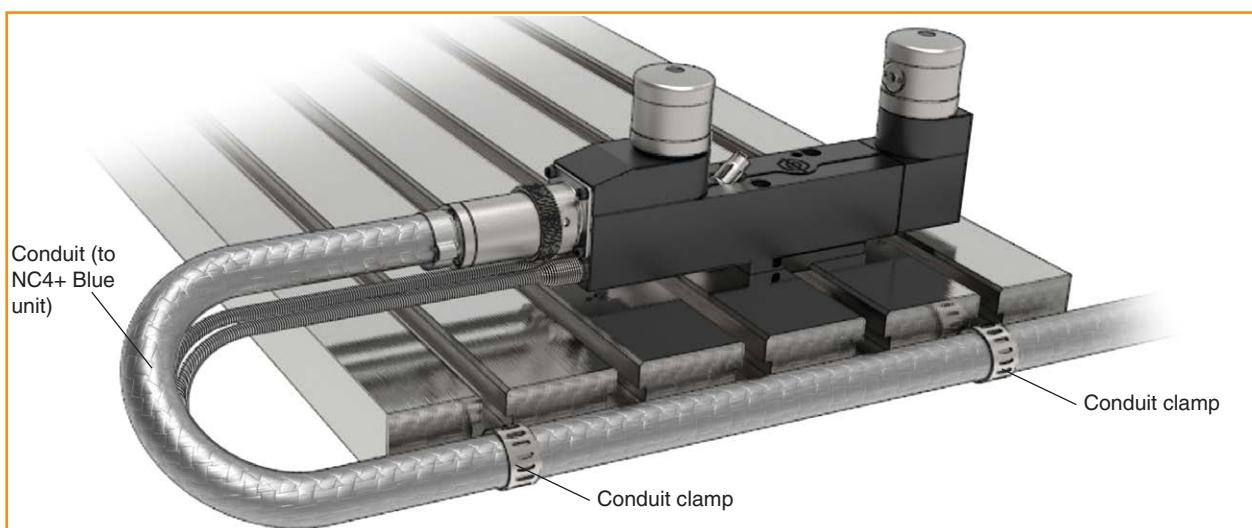




14. **Hard-wired system:** Connect the barrier air pipes to the outlet of the air preparation pack using the T-fittings and pneumatic adaptor fittings as appropriate. Also connect the air blast supply to the solenoid valve (sold separately).

**System with connector:** Connect the barrier and air blast supply pipes to the NC4+ Blue unit and slide spring covers over the air fittings.

15. Fit conduit clamps to secure the conduit in position on the table of the machine (refer to the figure on **page 3-7**). This will ensure that loads are not transferred to the NC4+ Blue unit when the machine operates.
16. **System with connector:** Secure the spring covers to the conduit.



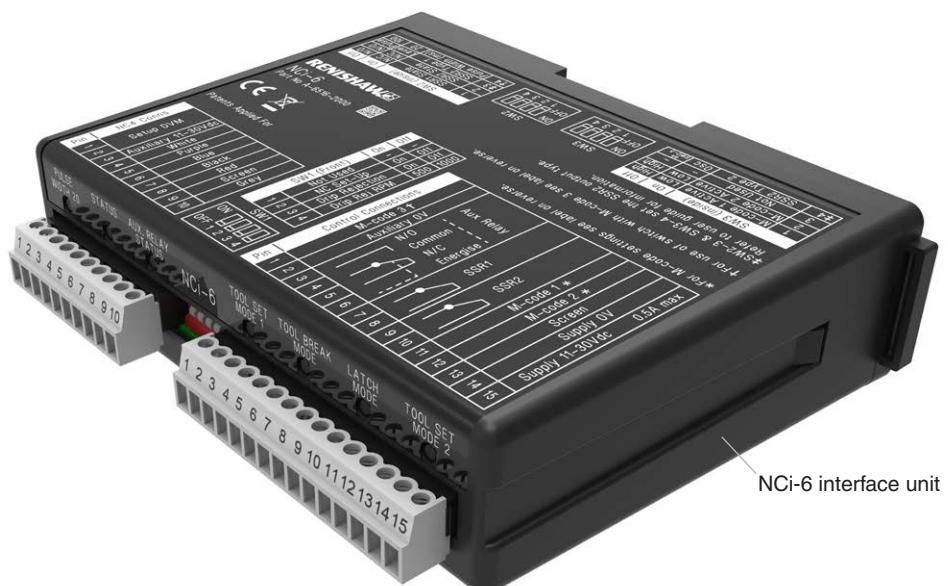
## Installing the NCi-6 interface unit

**WARNING:** Before installing the NCi-6 interface unit, ensure that the machine is safe to work on. Switch off machine power when working in the controller cabinet.

The NCi-6 interface unit should be installed in the CNC controller cabinet. Where possible, locate the unit away from potential sources of interference such as transformers and motor controllers.

The NCi-6 interface unit processes signals from the NC4+ Blue unit and converts them into a voltage-free solid state relay (SSR) output. This is transmitted to the CNC machine controller.

Install and configure the NCi-6 interface unit as described in the *NCi-6 non-contact tool setting interface* installation and user's guide (Renishaw part no. H-6516-8500).



## NC4+ Blue system wiring details

The colour and intended function of each of the wires from the NC4+ Blue unit transmitter and receiver heads are described below.

### Wiring details for hard-wired NC4+ Blue systems

NC4+ Blue transmitter head		NC4+ Blue receiver head	
Wire colour	Function	Wire colour	Function
Green	Screen	Green	Screen
Black	0 V	Black	0 V
Red	12 V	Red	12 V
White	Not used*	White	Analogue output 1
Blue	Not used*	Blue	Analogue output 2
Purple	Not used*	Purple	Set-up
Grey	Status	Grey	Status

\* As this wire is not used, ensure that the free end is correctly insulated.

### Wiring details for connectorised NC4+ Blue systems

Wire colour	Function
Green	Screen
Black	0 V
Red	12 V
White	Analogue output 1
Blue	Analogue output 2
Purple	Set-up
Grey	Status

## Supplying electrical power to the NCi-6 interface unit

**WARNING:** Before switching on electrical power, ensure that the machine is safe to work on.

1. Ensure that the NCi-6 interface unit and air supplies have been connected correctly (see the table above for further information).
2. Switch on electrical power to the NCi-6 interface unit.
3. Check that the status LEDs on the NC4+ Blue transmitter and receiver heads are lit.

### What to do next

When the NCi-6 interface unit is powered up, switch on the air supply and set the correct air pressure (see page 3-10, “Setting the NC4+ Blue barrier air pressure”, for further information).

## Power loss and restoration

If electrical power to the NCi-6 interface unit is lost and subsequently restored when the NC4+ Blue system is in a normal operating mode, the NC4+ Blue system powers down and then powers up again without loss of the original gain settings.

# Setting the NC4+ Blue barrier air pressure

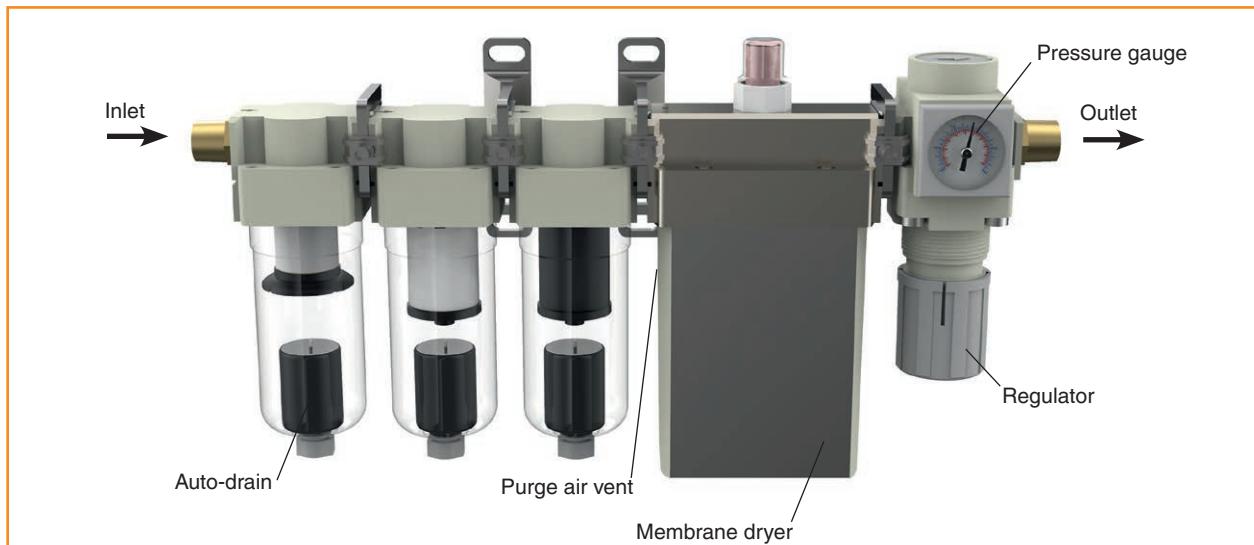
**WARNING:** Before setting the air pressure, ensure that the machine is safe to work on.

1. Ensure that electrical power is applied to the NCi-6 interface unit.
2. Monitor the set-up voltage as shown on **pages 4-10 and 4-12**.
3. Switch on the air supply.
4. Gradually increase the air pressure until a well defined laser beam is emitted from the transmitter and the set-up voltage is near its peak.
5. Note the pressure on the gauge and then increase it slightly to account for pressure fluctuations:
  - NC4+ Blue systems (excluding F100 and F100-10): +0.01 MPa (1.45 psi) to +0.05 MPa (7.25 psi)
  - F100 and F100-10 models:
    - IPX5: +0.01 MPa (1.45 psi) to +0.05 MPa (7.25 psi)
    - IPX6: +0.12 MPa (17.40 psi)

## NOTES:

If the air supply pressure varies while the machine is operating, the air pressure to the NC4+ Blue unit may need to be increased to allow for this pressure fluctuation.

For illustration of this set-up procedure, view the “Check air pressure” video guide in the NC4 mobile app.



Conversion table

MPa	Bar	PSI
0.2	2	29
0.4	4	58
0.6	6	87
0.8	8	116
1	10	145

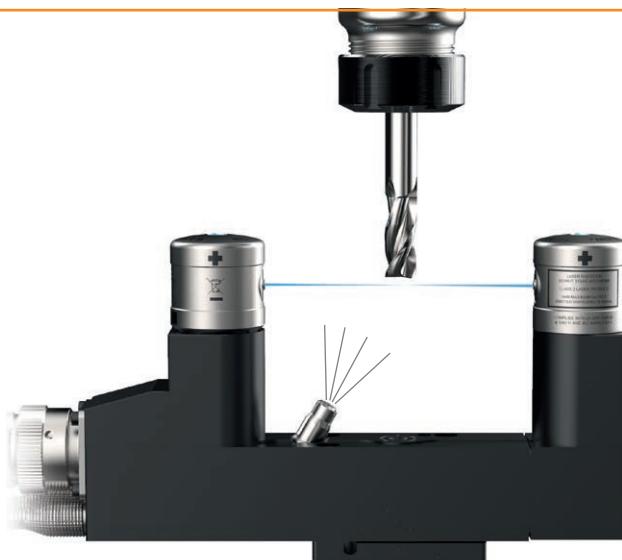
## Setting the NC4+ Blue air blast pressure

**WARNING:** Before setting the air pressure, ensure that the machine is safe to work on.

1. Switch on the air supply (air preparation pack for air blast sold separately) see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).
2. Activate the solenoid valve (sold separately) see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).
3. Increase the air pressure until sufficient to remove the swarf and coolant contamination typical for the application and the tools used.

The air blast pressure should be set between 0.3 MPa (43.5 psi) and 0.6 MPa (87.0 psi). Typically 0.6 MPa (87.0 psi) is most effective.

For very small tools, reduce the pressure in order to prevent damage to the tools.



## Macro programming software

**NOTE:** Before installing the non-contact tool setting macro programming software, read the guidelines contained in the Readme file on the software media.

Software routines for tool setting using various machine controllers and available software packages are described in the *Probe software for machine tools – programs and features* data sheet (Renishaw part no. H-2000-2298, available at [www.renishaw.com](http://www.renishaw.com)).

For detailed instructions on how to use Renishaw's non-contact tool setting software, refer to the relevant programming guide for your machine tool controller type.

## Software and user information

For available software, see the *Probe software for machine tools – programs and features* data sheet (Renishaw part no. H-2000-2298, available at [www.renishaw.com](http://www.renishaw.com)).

### Machine tool apps

Smartphone apps provide information at a user's fingertips in a simple, convenient format. Available globally in a wide range of languages, our free-of-charge apps give users the following information:

- NC4 app Configuration (including wiring), maintenance, troubleshooting of NC4 systems.
- GoProbe app Programming of Renishaw probing systems (including NC4).



Renishaw apps are available in China via Baidu, Huawei and Tencent.

On-machine apps can be seamlessly integrated with a wide range of CNC controllers. Apps are installed onto a Microsoft® Windows®-based CNC controller or a Windows tablet connected to the controller via Ethernet.

With touch interaction and intuitive design, smartphone and on-machine apps provide significant benefits to machine tool probe users.

For more information, visit [www.renishaw.com/machinetoolapps](http://www.renishaw.com/machinetoolapps)



## Aligning the NC4+ Blue unit to the machine axes

**WARNING:** Before aligning and setting up an NC4+ Blue system, ensure that the machine is safe to work on.

This procedure involves moving the NC4+ Blue unit so that the laser beam is parallel/perpendicular to the machine's axes. The alignment should be adjusted so that it is within the recommended tolerances (see [page 3-14](#), "Alignment tolerances", for further information).

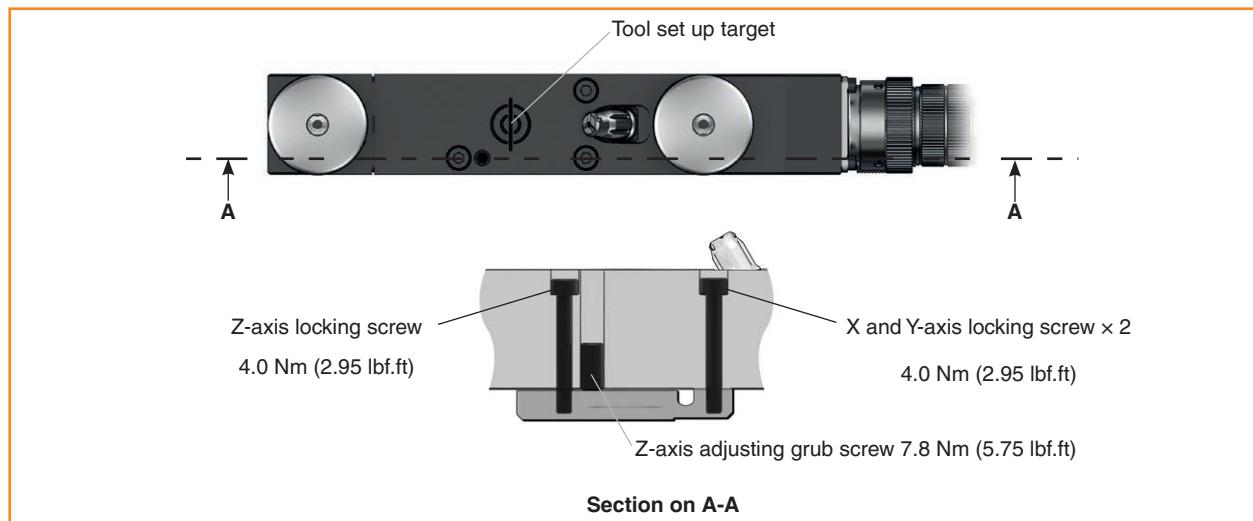
The beam alignment macro described in the relevant non-contact tool setting software programming guide is used for this process. The macro indicates how well the unit is aligned to the machine axes. You can then use this information to make adjustments to the NC4+ Blue unit.

### To align an NC4+ Blue unit

1. Run the beam alignment macro (for further information, see the relevant non-contact tool setting software programming guide).
2. If alignment is outside the values described in "Alignment tolerances" on [page 3-14](#), make the appropriate adjustments to the NC4+ Blue unit.

#### Aligning to the X and Y axes

- a. Slacken the X and Y-axis locking screws.
- b. Align the unit to the X and Y axes by hand.
- c. Carefully tighten the X and Y-axis locking screws, taking care not to move the NC4+ Blue unit.



## Aligning to the Z-axis

- a. Slacken the Z-axis locking screw(s).
- b. Adjust the Z-axis adjusting screw(s).
- c. Carefully tighten the Z-axis locking screw(s), taking care not to move the unit.

3. After aligning the NC4+ Blue unit, run the beam alignment macro again.

## Alignment tolerances

The tolerances to which a tool can be set are dependent on the parallelism of the laser beam to the machine axes.

### Tool setting applications

Over a span of 100 mm (3.94 in), the following alignment accuracies are recommended:

**Spindle axis (P2 – P1):**  $\leq 10 \mu\text{m}$  (0.39  $\mu\text{in}$ )

**Radial axis (P2 – P1):**  $\leq 1 \text{ mm}$  (0.039 in)

These values are sufficient for the majority of tool setting applications.

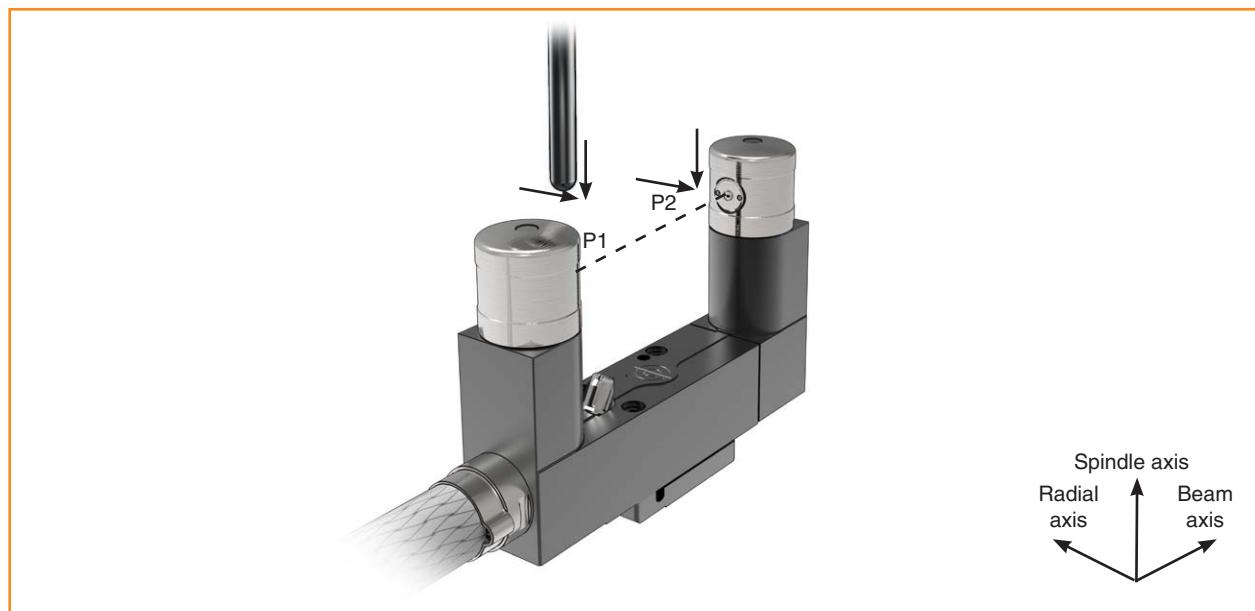
### Tool breakage detection applications

Over a span of 100 mm (3.94 in), the following alignment accuracies are recommended:

**Spindle axis (P2 – P1):**  $\leq 0.2 \text{ mm}$  (0.008 in)

**Radial axis (P2 – P1):**  $\leq 1 \text{ mm}$  (0.039 in)

These values are sufficient for the majority of tool breakage applications.



**NOTE:** For best measurement performance, Renishaw recommends aligning NC4+ Blue units using a ball-nosed cylinder-type calibration tool. A mobile app (NC4+ Blue app) is available for step-by-step instructions on NC4+ Blue unit alignment (for more information, see [page 3-12 "Machine tool apps"](#)).

# Maintenance

## Introduction

The NC4+ Blue unit requires minimal maintenance as it has been designed to operate as a permanent fixture on all sizes of vertical and horizontal machining centres, multi-tasking machines and gantry machining centres where it is subject to an environment of hot metal chips and coolant.

You may undertake the maintenance routines described in these instructions.

Further dismantling and repair of Renishaw equipment is a highly specialised operation, which must be carried out at an authorised Renishaw Service Centre.

Equipment requiring repair, overhaul or attention under warranty should be returned to your supplier.

---

**WARNING:** Before carrying out any maintenance operations, ensure that the machine is safe to work on and electrical power to the NCi-6 interface unit is switched off.

---

## Removing and refitting the air preparation filter elements

For the following instructions, refer to the figure on [page 4-4](#).

Regularly inspect the filter elements (A). They should be replaced when dirty or wet and at least once each year:

1. Switch off the air supply.
2. Unscrew the filter bowl by hand.
3. Remove the O-ring from the recess in the filter bowl. Discard the O-ring.
4. Unscrew and remove the filter elements from filter body.
5. Fit the replacement filters.
6. Fit a new O-ring into the recess in the filter bowl.
7. Refit the filter bowl and screw hand-tight.
8. Switch on the air supply and set the pressure as described in “Setting the NC4+ Blue barrier air pressure” on [page 3-10](#).

---

**NOTE:** Items shown within dotted box (A) are included in the air filter service pack obtainable from Renishaw see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

---

## Removal and replacement of membrane dryer module

Regularly inspect the dew point indicator (B) on the membrane dryer (C). The membrane dryer should be replaced according to the table below or at least once every four years.

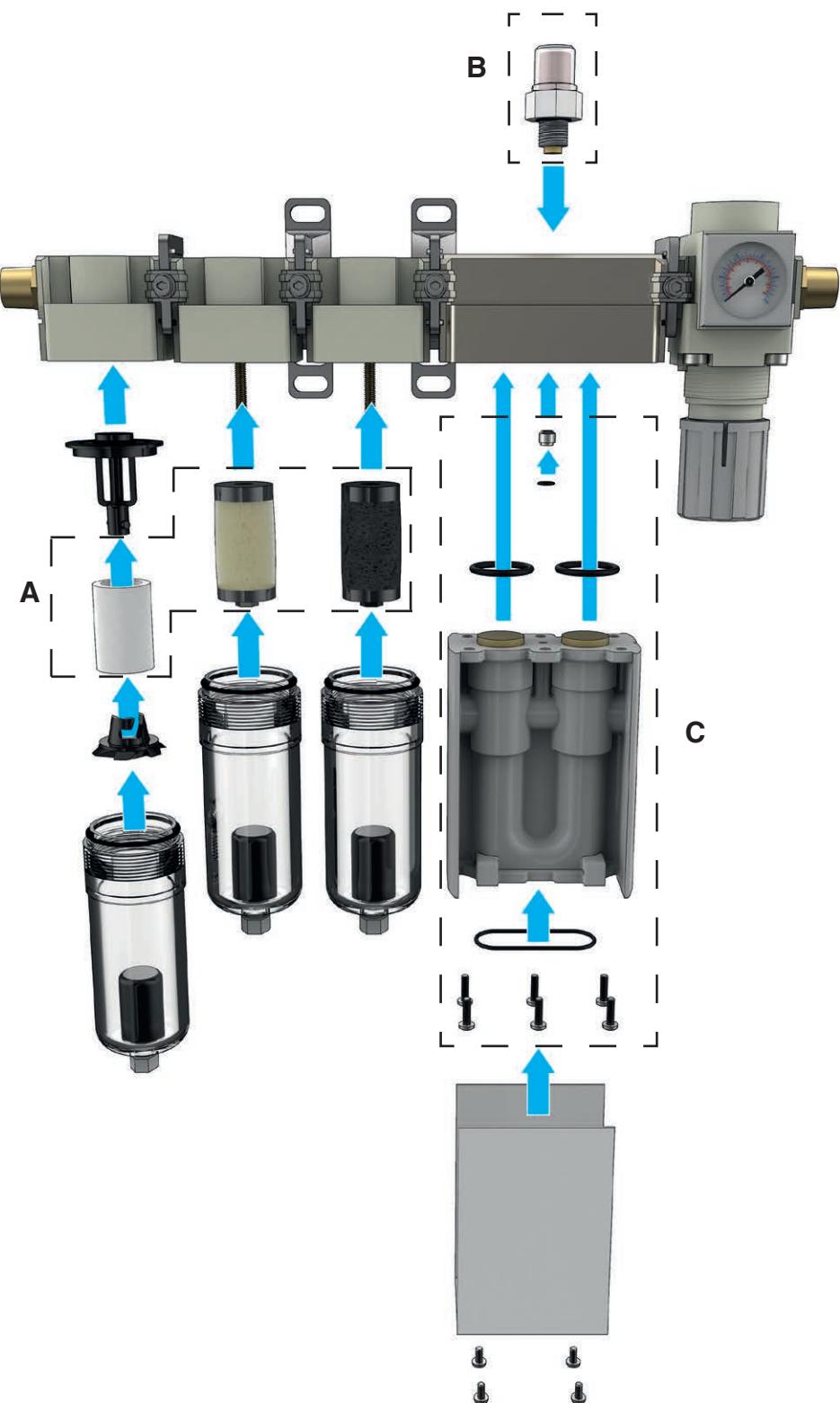
### Dew point indications

Grain colour	Causes	Solutions
Green/amber	Dryer functioning correctly.	No action required.
Yellow	Initial state.	Allow a minimum of 10 minutes from start of air flow for the dew point indicator to turn green.
	Water flow into membrane drier.	Check and replace filters if necessary. Check condition of inlet air for excess oil or water. Ensure outlet of purge air port is free of obstructions. Lower input air temperature. Install in-line air coolers if necessary.
Brown/black	Membrane contaminated / oil carryover.	Check condition of inlet air for excess oil or water. Replace membrane and dew point indicator.

---

**NOTE:** Items shown within dotted boxes (B) and (C) are included in the membrane dryer service pack obtainable from Renishaw see the *NC4 non-contact tool setting accessories* data sheet (Renishaw part number H-2000-2223).

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4-4 NC4+ Blue non-contact tool setting system: Maintenance

## Cleaning the optics

Cleaning the optics should only be carried out by personnel who have received training in the use and operation of laser products. Special tools, such as the cleaning tool and pin spanner, should only be used by service personnel.

### Cleaning the NC4+ Blue unit

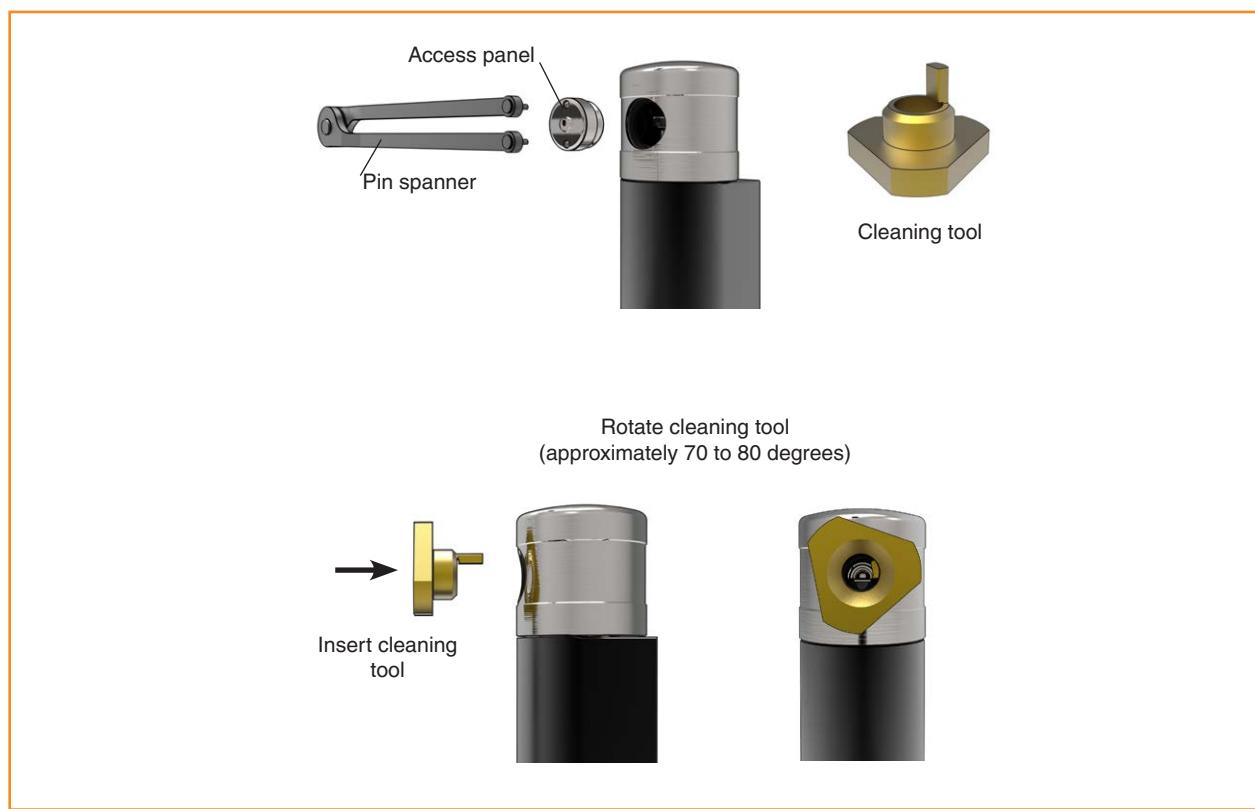
If the air to the NC4+ Blue unit becomes contaminated, the transmitter and receiver heads may require cleaning.

Contamination will cause the system to stay in a triggered state. If contamination is suspected, identify the cause and rectify the problem (for more information, see “Fault-finding” on **page 5-1**), before cleaning the NC4+ Blue unit. If necessary, change the air pipe.

Clean the units one at a time to reduce the risk of mixing up the access panels.

#### Equipment required

- Pin spanner or access panel tool.
- Cleaning tool.
- Precision cleaning solvent, lens cleaner or isopropyl alcohol.
- Dust remover clean air spray.
- Cleaning swabs (x 2).

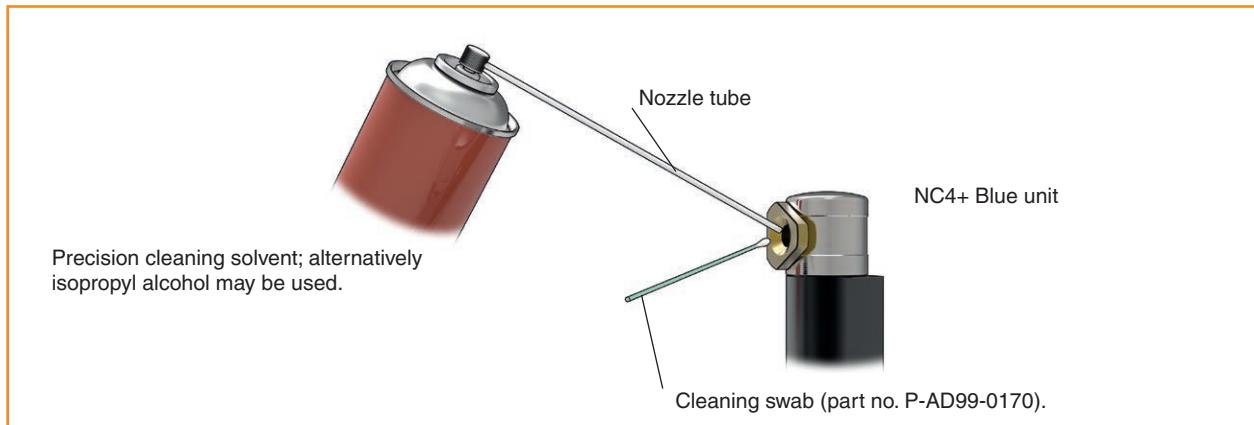


## To clean the optics



### CAUTION – LASER SAFETY

The access panel of an NC4+ Blue transmitter head is removed to allow access to the optics. Before removing the panel, switch off electrical power to the NC4+ Blue unit to avoid exposure to the laser beam.



1. Switch off electrical power to the NCi-6 interface unit. Isolate power by disconnecting from connector on NC4+ Blue unit or from the NCi-6 interface unit.
2. Remove the air supply from the NC4+ Blue unit by setting the pressure regulator to 0 MPa (0 psi).
3. If an air pipe is damaged, replace the pipe.
4. Using the pin spanner, remove the access panel (unscrew anticlockwise) from the front of the NC4+ Blue unit.
5. Visually inspect for debris around the surfaces where the access panel fits into the NC4+ Blue unit and remove if applicable. Take care not to accidentally introduce debris into the housing.
6. Insert the cleaning tool into the housing and rotate through 70 to 80 degrees until the PassiveSeal is clear of the optic glass.
7. Purge the air supply for approximately 1 minute.
8. Access to the lens is through the centre of the cleaning tool. Spray the solvent cleaner through the nozzle tube, onto the lens.
9. Wipe the lens with the swab, using quarter-turn movements.

**CAUTION:** Take care not to apply excessive force to the lens or PassiveSeal as this may damage the optical surfaces.

10. Spray the clean air spray into the housing to remove all traces of solvent.
11. Using solvent cleaner and a clean, dry compressed air supply, blow all debris out of the MicroHole in the access panel.

12. Remove the cleaning tool. Refit the access panel using the pin spanner. Tighten to 2.0 Nm (1.48 lbf.ft).
13. Repeat the cleaning procedure for the other NC4+ Blue head (ensure both Tx and Rx heads are clean).

## After cleaning the NC4+ Blue unit

1. Reconnect and switch on electrical power to the NCi-6 interface unit (for more information, see “Supplying electrical power to the NCi-6 interface unit” on [page 3-9](#)).
2. Restore the air supply to the NC4+ Blue unit and adjust the pressure (for more information, see “Setting the NC4+ Blue barrier air pressure” on [page 3-10](#)).
3. If realignment is not necessary, set switch SW1-2 (NC set-up) on the NCi-6 interface unit to ‘On’. After approximately 5 seconds, set the switch to ‘Off’.
4. Check that the system triggers. To do this, pass an object through the laser beam and check that the NC4+ Blue unit’s status LED changes from blue to red and back to blue.

---

**NOTE:** A mobile app (NC4 app) is available for step by step instructions on the cleaning process (for more information, see [page 3-12](#) “Machine tool apps”).

---

# Replacing the air blast nozzle

The air blast nozzle can be replaced if it becomes damaged.

Identify the cause of the damage and rectify the problem before replacing the air blast nozzle.

## Equipment required

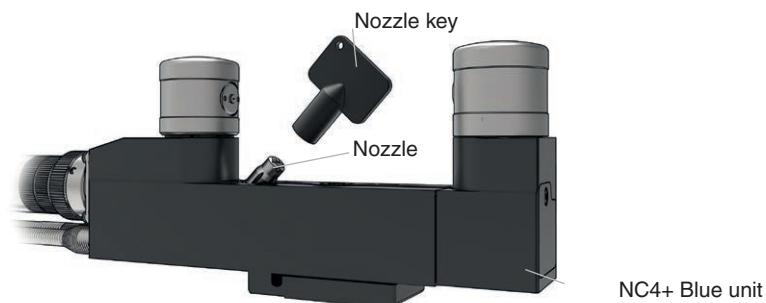
- Nozzle replacement pack. Supplied with:
  - Nozzle key
  - Nozzle assembly
  - Washer

## To replace the air blast nozzle

1. Switch off electrical power to the NCi-6 interface unit.
2. Remove the air supply to the NC4+ Blue unit by setting the pressure regulator to 0 MPa (0 psi).
3. Isolate the air supply to the air blast system.
4. Using the nozzle key, remove the nozzle from the NC4+ Blue unit (unscrew anticlockwise).
5. Fit the new nozzle to the NC4+ Blue unit (for further information, see the figure below). Tighten to 2.0 Nm (1.47 lbf.ft.).

## After replacing the air blast nozzle

6. Switch on electrical power to the NCi-6 interface unit (see “Supplying electrical power to the NCi-6 interface unit” on [page 3-9](#)).
7. Restore the air supply to the NC4+ Blue unit and air blast and adjust the pressure (see “Setting the NC4+ Blue barrier air pressure” on [page 3-10](#) and “Setting the NC4+ Blue air blast pressure” on [page 3-11](#)).



## Head alignment of the NC4+ Blue unit

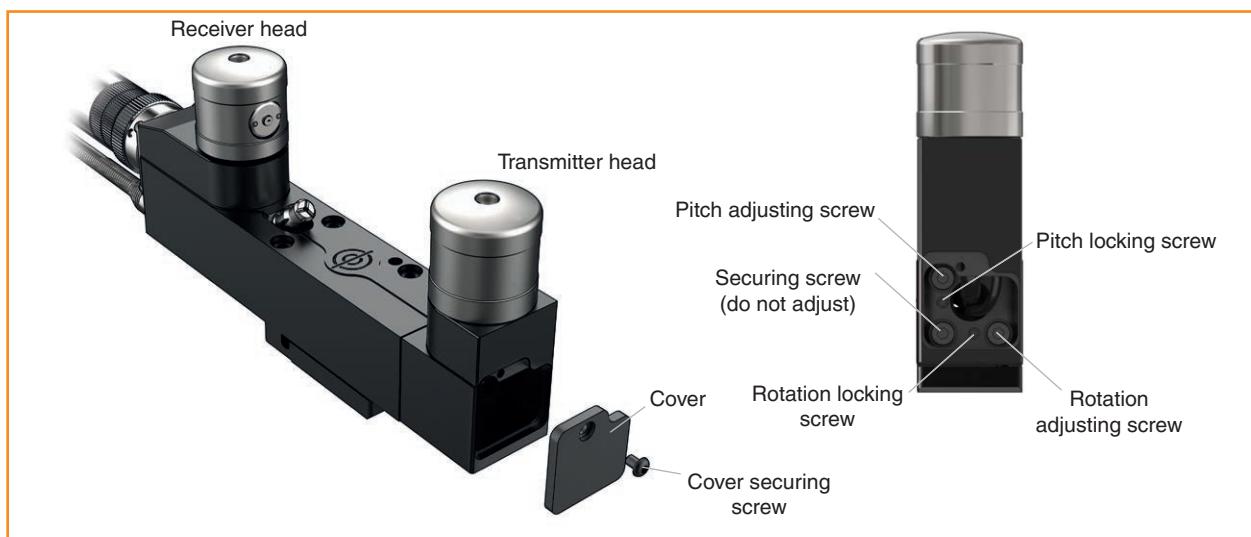
**NOTE:** NC4+ Blue units are supplied with the transmitter and receiver heads correctly aligned. Only use the head alignment procedure if it is suspected that the transmitter and receiver heads have become misaligned.

Head alignment of the NC4+ Blue unit involves adjusting the relative positions of the transmitter and receiver heads to maximise a test signal obtained at the receiver head. Do this with the NCi-6 interface unit in set-up mode.

Either a voltmeter or an NC4 set-up tool can be used to provide an indication of the signal strength received at the receiver head.

Refer to the figure below.

1. Either connect the digital voltmeter as described in “Using a voltmeter” on **page 4-10** or fit the NC4 set-up tool as described in “Using the set-up tool” on **page 4-12**.
2. Switch on electrical power to the NCi-6 interface unit.
3. Ensure that air is supplied to the NC4+ Blue unit and is at the correct pressure.
4. At the transmitter head, unscrew the cover securing screw and remove the cover.



5. At the transmitter head, slacken the pitch and rotation locking screws.
6. On the NCi-6 interface unit, set switch SW1-2 (NC set-up) to ‘On’.
7. Adjust the rotation and pitch of the transmitter head so that the laser beam shines on the centre of the receiver MicroHole and the maximum signal is obtained on the voltmeter or set-up tool.

Check that either:

- the voltmeter reading is between 1.0 V and 7.0 V, or
- the set-up tool reading is between 1.0 and 7.0.

8. At the transmitter head, tighten the pitch and rotation locking screws to 2 Nm (1.48 lbf.ft).
9. Check that the reading is still between 1.0 V and 7.0 V using the same device (voltmeter or set-up tool) used in step 7.
10. At the transmitter head, refit the cover then refit and tighten the cover securing screw.
11. Check that the laser beam is not obstructed.

On the NCi-6 interface unit, set switch SW1-2 (NC set-up) to 'Off'.

Check that:

- the NCi-6 interface unit status LED is blue, and
- the voltmeter reading is between 4.7 V and 5.4 V.

---

**NOTE:** If the set-up tool is used, ignore the reading on the display. A false reading is shown when the NC set-up mode is switched off.

---

12. If the beam is blocked when the switch is set to 'Off', the system will be unable to set itself correctly. If this occurs, remove the obstruction then set switch SW1-2 (NC set-up) to 'On' then back to 'Off'.

## Using a voltmeter

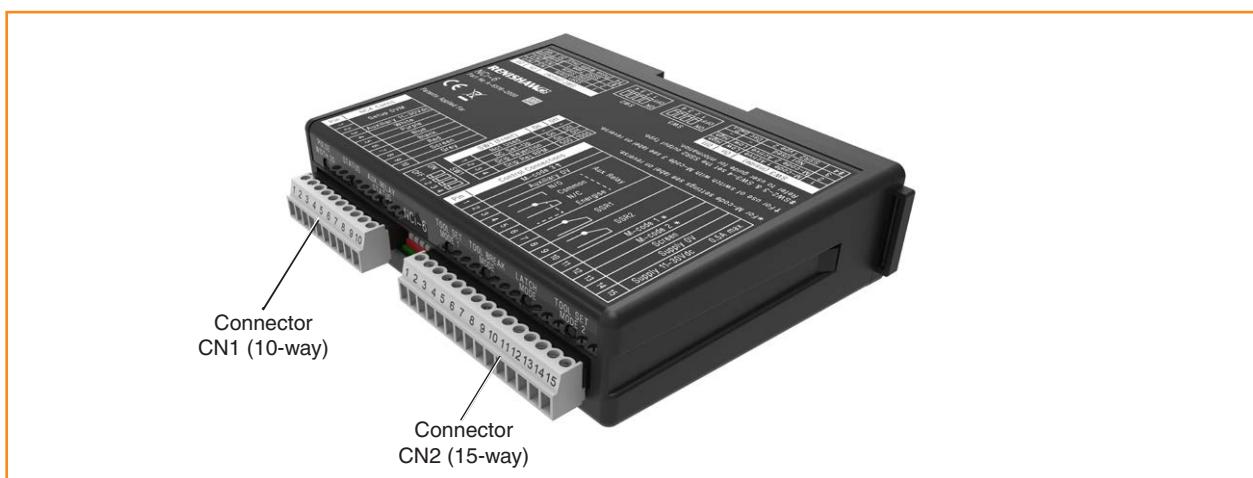
A standard voltmeter, that is within calibration, may be used for setting up and aligning the NC4+ Blue transmitter and receiver heads.

1. Position the voltmeter next to the receiver head. Connect a wire between terminal CN1-1 on the NCi-6 interface unit and one of the voltmeter probes. Connect a second wire between terminal CN1-2 and the other voltmeter probe.
2. On the NCi-6 interface unit, set switch SW1-2 (NC set-up) to 'On'.

---

**NOTE:** If a negative reading is obtained when you use the voltmeter, swap over the voltmeter probe connections.

---



## NC4 set-up tool

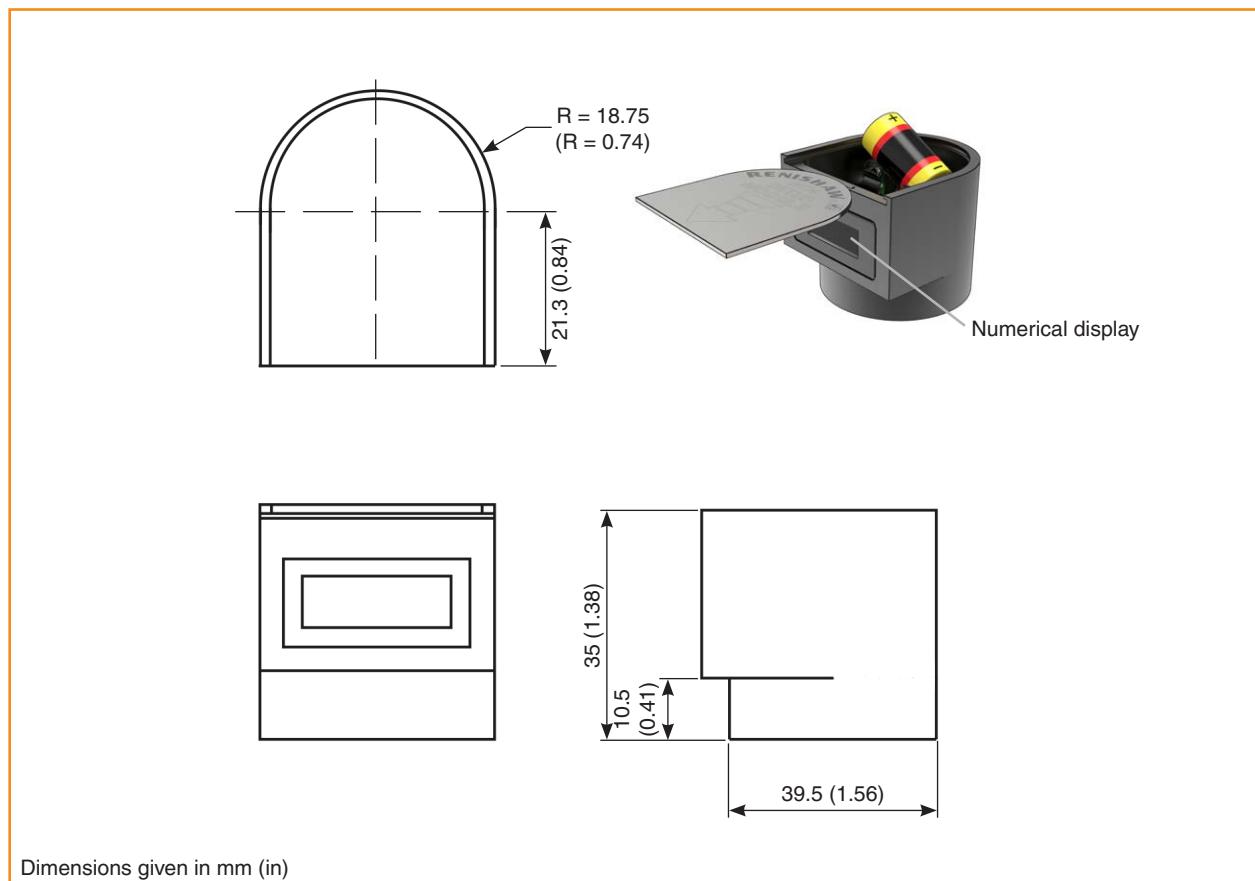
### Introduction

The NC4 set-up tool (Renishaw part no. A-4114-8000, sold separately) is a battery-operated device that is used to provide a visual indication of the signal strength at the NC4+ Blue unit receiver head. The signal strength is shown on a numerical display. The higher the number, the greater the signal received at the receiver head.

The set-up tool is placed over the receiver head and is rotated so that the display can be easily viewed. Placing the tool over an NC4+ Blue unit activates the numerical display. Removing the tool causes the display to power off (for more information, see **page 4-12**, "Using the set-up tool").

**NOTE:** The numerical display provides only an indication of the signal strength. If a true reading of signal strength is required, a voltmeter must be connected to the appropriate connector pins on the NCi-6 interface unit.

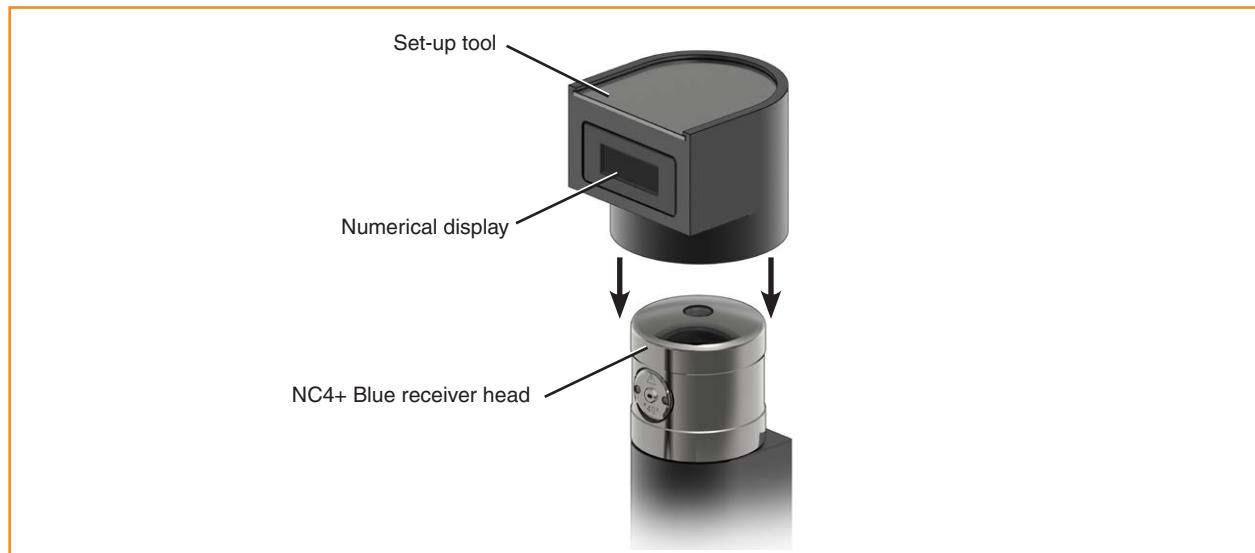
### Dimensions



## Using the set-up tool

The set-up tool numerical display provides a correct reading only when the NCi-6 interface unit is in the set-up mode – that is, when the NC set-up switch (SW1-2) is set to 'On'.

1. Check that the NC4+ Blue receiver head is clean and free of swarf. Push the set-up tool onto the top of the receiver head and rotate it so that the display is facing you.
2. On the NCi-6 interface unit, set switch SW1-2 (NC set-up) to 'On'.



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**NOTE:** Excessive cutting fluid deposits on the NC4+ Blue receiver may prevent the set-up tool from switching on. It may be necessary to clean the top of the NC4+ Blue receiver to ensure good electrical contact to the set-up tool.

---

## Replacing the set-up tool battery

The set-up tool requires a ½ AA size battery that is rated at 3.6 V (for more information, see the, “Battery specification” in the table below).

1. Lift the top cover and slide forward by hand to expose the battery.
2. Remove the battery.
3. Carefully fit a new battery. Refer to the markings on the circuit board for correct orientation.
4. Refit the top cover.



## Battery specification

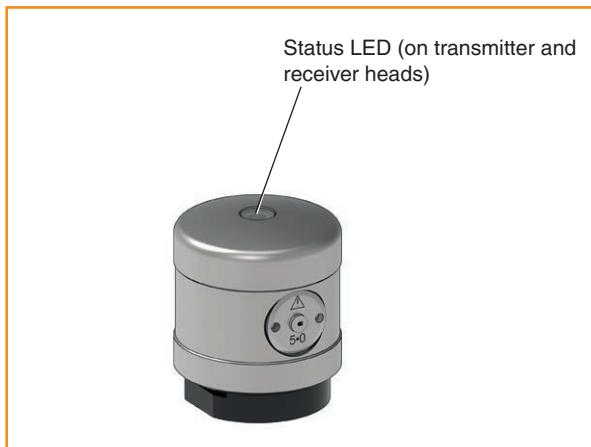
The set-up tool requires one ½ AA size battery, rated at 3.6 V. It is important to ensure that the battery is supplied in standard form. Batteries that are described as tagged have additional connection tag features fitted to the terminal and are not suitable.

Typically, this specification can be provided by a cell containing Lithium-thionyl chloride (3.6 V). This is recommended for maximum battery life. A Lithium-thionyl chloride (3.6 V) battery will last the equivalent of 700 hours' continuous operation.

Battery manufacturer	Part number
Saft	LS 14250
Tadiran	SL-750
Xeno	XL-050F

## Status LED function

The status LEDs on the NC4+ Blue transmitter and receiver heads indicate to the user the status of the unit. The LEDs mimic each other.



Colours shown by the LEDs vary depending upon the mode of operation of the NCi-6 interface unit.

When the NCi-6 NC set-up switch SW1-2 is set to 'On', the status LEDs will rapidly flash code which is used by the NC4 set-up tool. The colours of the LEDs will vary between red, violet and blue.

When the NCi-6 NC set-up switch SW1-2 set to 'Off', the status LEDs will operate according to the tables on [page 4-15](#).

LED colour	Signal voltage	Tool set mode 1		Tool set mode 2	
		Description			
Blue/violet	> 6.0 V	Flashing at 1 Hz.  The system operating voltage is too high.  The system will continue to function, but for optimum performance repeat the set-up and alignment procedures.  The system is untriggered.		Flashing at 1 Hz.  The system operating voltage is too high.  The system will continue to function, but for optimum performance repeat the set-up and alignment procedures.  The system is triggered.	
Blue	6.0 V to 4.0 V	The beam is clear.  The system is untriggered.		The beam is clear.  The system is triggered.	
Violet	4.0 V to 2.5 V	The beam is partially blocked.  The system is untriggered.		The beam is partially blocked.  The system is triggered.	
Red	2.5 V to 0.0 V	The beam is blocked.  The system is triggered.		The beam is blocked.  The system is untriggered.	
No light	0.0 V	No power to the unit.			

LED colour	High speed broken tool detection mode	Latch mode
Blue/violet	Not applicable.	Flashing at 1 Hz.  The output is not latched.  The system operating voltage is too high.  The system will continue to function, but for optimum performance repeat the set-up and alignment procedures.
Blue	Not applicable.	The beam is clear.  The system is not latched.
Violet		The output is not latched.  The beam is blocked.
Red	The output is latched.  The tool is broken.	The output is latched.
No light		No power to the unit.

The status LEDs can be used for diagnostic purposes, as the NC4+ Blue system constantly checks for signal and indicates the state of the system by the colours of the LEDs. If the laser beam is clear and the LEDs are either violet or flashing blue/violet, this indicates that servicing is required. The system will continue to function as normal. For more information, see [page 5-1](#), “Fault-finding”.

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# Fault-finding

Symptom	Cause	Action
<b>NC4+ Blue fails to turn on (Tx and Rx status LEDs are not lit).</b>	Faulty connections.	Check that the wiring connections are correct.
	Wrong supply voltage.	Check the supply voltage to the NCi-6 interface unit.
	Blown fuse.	Check the connections for a short circuit.
	Damaged cable.	Replace the cable.
<b>No laser beam is exiting the transmitter (Tx and Rx status LEDs are lit).</b>	The PassiveSeal is protecting the device.	Check that the air supply to the NC4+ Blue system is switched on (for more information, see <b>page 3-10</b> , "Setting the NC4+ Blue barrier air pressure").
	Damaged air pipe.	Check the air pipe for damage or kinks.
	Access panel could be blocked.	Turn off NC4+ Blue system, remove access panel from Tx head, clean debris from access panel before refitting.
<b>Poor repeatability/spurious readings.</b>	Coolant or swarf on the tool.	Clean the tool with an air blast or high-speed spin. Optimise air pressure to the air blast. Check the air blast nozzle is not damaged or blocked. Replace if necessary.
	Feedrate is too high.	Set the correct feedrate – 2.0 µm (78.74 µin) per revolution is the recommended value.
	Electrical interference.	Ensure that the NC4+ Blue cables are not routed alongside cables carrying high current. Ensure that the screen wire is connected to the NCi-6 interface unit.
	Thermal growth of the machine and the workpiece.	Minimise temperature changes. Increase the frequency of calibration.
	Excessive machine vibration.	Eliminate vibration.
	NC4+ Blue air pressure is set incorrectly.	Reset the air pressure (for more information, see <b>page 3-10</b> , "Setting the NC4+ Blue barrier air pressure").
	Calibration and updating of the offset is not occurring.	Check the software.
	Measuring speed is different from the calibration speed.	Review the software program.
	Measuring occurring during the machine acceleration and deceleration zones.	Review the software program.
	Poor machine repeatability due to worn slides, for example accident damage, loose encoders.	Perform a health check on the machine.
	Loose brackets.	Check and tighten the brackets as appropriate.

Symptom	Cause	Action
<b>Poor repeatability/ spurious readings (continued).</b>	Poor tool change repeatability.	Check repeatability of the NC4+ Blue without performing a tool change.
	Poorly regulated power supply.	Ensure that the power supply is correctly regulated.
	Coolant drips or mist.	Select tool set mode 2. If no M-codes are available or tool set mode 2 cannot be implemented, use tool set mode 1 and select the drip-rejection mode using the switch on the NCi-6 interface unit and the NC software. Wait until the mist has cleared before measuring.
	Contaminated optics.	Follow cleaning procedure, (for more information, see <a href="#">page 4-5</a> , "Cleaning the optics").
<b>Voltage is outside the range 1.0 V to 7.0 V when in set-up mode (NCi-6 interface unit set-up switch SW1-2 is set to 'On').</b>	Incorrect access panel for separation.	Ensure that the NC4+ Blue unit has the correct access panels installed (for more information, see the <i>NC-4 non-contact tool setting system accessories</i> data sheet (Renishaw part no.H-2000-2223)).
	Poor connection.	Check that the voltmeter is operating correctly and is correctly connected to the NCi-6 interface unit.
	NC4+ Blue air pressure is set incorrectly.	Reset the air pressure (for more information, see <a href="#">page 3-10</a> , "Setting the NC4+ Blue barrier air pressure").
	An object is blocking the beam.	Ensure that the laser beam is unobstructed.
<b>NC4+ Blue status LED is violet (this is a fault only in certain conditions for more information, see the tables on page 4-15).</b>	System is not set for optimum performance.	<p>The system operating voltage has decreased since it was last set up. This may occur if:</p> <ul style="list-style-type: none"> <li>• The optics are contaminated (for more information, see <a href="#">page 4-5</a>, "Cleaning the optics").</li> <li>• The air pressure is incorrect (for more information, see <a href="#">page 3-10</a>, "Setting the NC4+ Blue barrier air pressure").</li> <li>• The system is out of alignment (for more information, see <a href="#">page 3-13</a>, "Aligning the NC4+ Blue unit to the machine axes").</li> </ul>

Symptom	Cause	Action
<b>NC4+ Blue status LED is flashing violet/blue.</b>	Flashing at 1 Hz. System is not set for optimum performance.	The system operating voltage has increased since it was last set up. This may occur if the system was not set up and aligned correctly (for more information, see <a href="#">page 4-9</a> , "Head alignment of the NC4+ Blue unit").
	Violet/blue flickering. NO FAULT.	If in tool set mode 2 or latch mode, violet/blue flickering indicates the tool is rotating in the laser beam revealing the laser between tool teeth. The unit is untriggered. This is not a fault.
<b>NC4+ Blue status LED is red.</b>	No air supply to the NC4+ Blue.	Check the air supply.
	Damaged air pipes.	Ensure that the air pipes are not damaged or kinked.
	Misalignment between the receiver and transmitter heads.	Realign the transmitter and receiver heads.
	Laser beam is obstructed.	Clear the obstruction.
	Lens is dirty or the air hole is blocked.	Refer to the servicing section of this guide for cleaning instructions. (See the fault, "Tx or Rx lens is dirty or the air hole is blocked", for more information).
	NC4+ Blue system is not wired correctly to NCi-6 interface unit.	Ensure that all wires are correctly connected to the NCi-6 interface unit (for more information, see <a href="#">page 3-9</a> , "NC4+ Blue system wiring details").
<b>Tx or Rx lens is dirty or the air hole is blocked.</b>	Air supply to NC4+ Blue does not conform to BS ISO 8573-1 Class 1.4.2.	Connect the air supply upstream of the oil mist lubricator.  Ensure that the machine shop air supply is to the required air quality.  If the temperature of the air supply is 5 °C (41 °F) or more greater than ambient and is humid, fit an air dryer (supplied as standard with NC4+ Blue packs).
	Non-Renishaw air filter is being used.	The air filter must conform to BS ISO 8573-1 Class 1.4.2.
	Auto drain failed.	Replace filter/dryer/regulator unit.
	Air pipe is full of coolant or oil.	Purge or replace the air pipe.

Symptom	Cause	Action
<b>NC4 set-up tool does not power up.</b>	Faulty connection.	<p>Check that the NC4 set-up tool is clean and free from swarf.</p> <p>Check that the spring-loaded contact springs on the underside of the tool are clean and are not damaged.</p>
	Coolant build up/deposits on NC4+ Blue cover.	Clean the top of the NC4+ Blue outer cover to ensure good electrical contact to the set-up tool.
	Battery fitted incorrectly.	<p>Fit the battery correctly.</p> <p>Check that the correct battery is fitted.</p>
	Flat battery.	Replace the battery.
<b>NC4 set-up tool gives incorrect reading.</b>	Incorrect reading.	<p>The numerical display of the setup tool provides an indication only. This may differ from the reading obtained on a voltmeter that is connected to the NCi-6 interface unit. The reading may also vary when the set-up tool is swapped between the transmitter and receiver heads. This variation in voltage is not greater than <math>\pm 0.2</math> V.</p> <p>Check that the set-up switch is on.</p> <p>An incorrect reading is obtained when the NC set-up mode is switched off.</p>
	Dirty optics.	Ensure that the NC4+ Blue status LED and the optical filter on the setup tool are clean and are not damaged.
<b>Air blast problems.</b>	Air blast nozzle makes a squealing noise.	Air pressure is too low. Increase air pressure until noise stops. Do not exceed 0.6 MPa (87.02 psi) maximum.
	Jet of coolant from nozzle when air blast activated.	Check the nozzle is not damaged and is correctly fitted. Replace nozzle.
	No air from air blast.	<p>Check nozzle is fitted correctly and is not damaged.</p> <p>Check that the air supply is switched on.</p>

## Parts list

### NC4+ Blue hard-wired unit pack, supplied with:

- NC4+ Blue non-contact tool setter
- Ø6.0 mm (0.24 in) × 12.5 m (41.01 ft) electrical cable (× 2)
- Ø6.0 mm (0.24 in) × 5.0 m (16.40 ft) air tube installation pack
- Ø3.0 mm (0.12 in) × 5.0 m (16.40 ft) air tube installation pack (× 2)
- Mounting and adjuster plate
- Machine tool support card
- Laser warning sign

Item	Part number	Description
NC4+ Blue F145 hard-wired unit pack	A-6435-2200	NC4+ Blue F145 pack with hard-wired cable.
NC4+ Blue F230 hard-wired unit pack	A-6435-2400	NC4+ Blue F230 pack with hard-wired cable.

## NC4+ Blue hard-wired 90°unit pack, supplied with:

- NC4+ Blue non-contact tool setter
- Ø6.0 mm (0.24 in) × 12.5 m (41.01 ft) electrical cable (× 2)
- Ø6.0 mm (0.24 in) × 5.0 m (16.40 ft) air tube installation pack
- Ø3.0 mm (0.12 in) × 5.0 m (16.40 ft) air tube installation pack (× 2)
- 90° cable fitting
- Mounting and adjuster plate
- Machine tool support card
- Laser warning sign

Item	Part number	Description
NC4+ Blue F145 90° hard-wired unit pack	A-6435-2220	NC4+ Blue F145 pack with 90° fitting and hard-wired cable.
NC4+ Blue F230 90° hard-wired unit pack	A-6435-2420	NC4+ Blue F230 pack with 90° fitting and hard-wired cable.

## NC4+ Blue hard-wired full installation pack, supplied with:

- NC4+ Blue hard-wired unit pack
- NCi-6 interface unit
- Air filter/regulator
- Ø4.0 mm (0.16 in) × 5.0 m (16.40 ft) air tube installation pack
- Ø6.0 mm (0.24 in) × 20 m (65.62 ft) air tube
- Pneumatic fittings
- 4.0 m (13.12 ft) GP18 steel braided conduit pack
- NC4 tools

Item	Part number	Description
NC4+ Blue F145 pack	A-6435-3200	NC4+ Blue F145 pack with hard-wired cable.
NC4+ Blue F230 pack	A-6435-3400	NC4+ Blue F230 pack with hard-wired cable.

## NC4+ Blue hard-wired 90° full installation pack, supplied with:

- NC4+ Blue hard-wired 90° unit pack
- NCi-6 interface unit
- Air filter/regulator
- Ø4.0 mm (0.16 in) × 5.0 m (16.40 ft) air tube installation pack
- Ø6.0 mm (0.24 in) × 20 m (65.62 ft) air tube
- Pneumatic fittings
- 4.0 m (13.12 ft) GP18 steel braided conduit pack
- NC4 tools

Item	Part number	Description
NC4+ Blue F145 90° pack	A-6435-3220	NC4+ Blue F145 pack with 90° fitting and hard-wired cable.
NC4+ Blue F230 90° pack	A-6435-3420	NC4+ Blue F230 pack with 90° fitting and hard-wired cable.

## NC4+ Blue unit pack with connector socket, supplied with:

- NC4+ Blue non-contact tool setter with connector socket
- Ø4.0 mm (0.16 in) × 5.0 m (16.40 ft) air tube installation pack
- Ø6.0 mm (0.24 in) × 5.0 m (16.40 ft) air tube installation pack
- Mounting and adjuster plate
- Machine tool support card
- Laser warning sign

Item	Part number	Description
NC4+ Blue F115C unit pack	A-6435-2010	NC4+ Blue F115C pack with connector socket.
NC4+ Blue F115C-R unit pack	A-6435-2110	NC4+ Blue F115C-R pack with raised columns and connector socket.
NC4+ Blue F145C unit pack	A-6435-2210	NC4+ Blue F145C pack with connector socket.
NC4+ Blue F145C-R unit pack	A-6435-2310	NC4+ Blue F145C-R pack with raised columns and connector socket.
NC4+ Blue F230C unit pack	A-6435-2410	NC4+ Blue F230C pack with connector socket.
NC4+ Blue F230C-R unit pack	A-6435-2510	NC4+ Blue F230C-R pack with raised columns and connector socket.
NC4+ Blue F300C unit pack	A-6435-2610	NC4+ Blue F300C pack with connector socket.
NC4+ Blue F300C-R unit pack	A-6435-2710	NC4+ Blue F300C-R pack with raised columns and connector socket.

## NC4+ Blue with connector socket full installation pack, supplied with:

- NC4+ Blue unit pack with connector socket
- Ø6.0 mm (0.24 in) × 12.5 m (41.01 ft) cable with straight connector
- NCi-6 interface unit
- Air filter/regulator
- 4.0 m (13.12 ft) spring cover for Ø4mm (0.16 in) air tube
- 4.0 m (13.12 ft) spring cover for Ø6mm (0.24 in) air tube
- Ø6.0 mm (0.24 in) × 20 m (65.62 ft) air tube
- Pneumatic fittings
- NC4 tools

Item	Part number	Description
NC4+ Blue F115C pack	A-6435-3010	NC4+ Blue F115C pack and cable with straight connector.
NC4+ Blue F115C-R pack	A-6435-3110	NC4+ Blue F115C-R pack with raised columns and cable with straight connector.
NC4+ Blue F145C pack	A-6435-3210	NC4+ Blue F145C pack and cable with straight connector.
NC4+ Blue F145C-R pack	A-6435-3310	NC4+ Blue F145C-R pack with raised columns and cable with straight connector.
NC4+ Blue F230C pack	A-6435-3410	NC4+ Blue F230C pack and cable with straight connector.
NC4+ Blue F230C-R pack	A-6435-3510	NC4+ Blue F230C-R pack with raised columns and cable with straight connector.
NC4+ Blue F300C pack	A-6435-3610	NC4+ Blue F300C pack and cable with straight connector.
NC4+ Blue F300C-R pack	A-6435-3710	NC4+ Blue F300C-R pack with raised columns and cable with straight connector.

## NC4+ Blue with connector socket 90° full installation pack, supplied with:

- NC4+ Blue unit pack with connector socket
- Ø6.0 mm (0.24 in) × 12.5 m (41.01 ft) cable with 90° connector
- NCi-6 interface unit
- Air filter/regulator
- 4.0 m (13.12 ft) spring cover for Ø4mm (0.16 in) air tube
- 4.0 m (13.12 ft) spring cover for Ø6mm (0.24 in) air tube
- Ø6.0 mm (0.24 in) × 20 m (65.62 ft) air tube
- Pneumatic fittings
- NC4 tools

Item	Part number	Description
NC4+ Blue F115C 90° pack	A-6435-3030	NC4+ Blue F115C pack and cable with 90° connector.
NC4+ Blue F115C-R 90° pack	A-6435-3130	NC4+ Blue F115C-R pack with raised columns and cable with 90° connector.
NC4+ Blue F145C 90° pack	A-6435-3230	NC4+ Blue F145C pack and cable with 90° connector.
NC4+ Blue F145C-R 90° pack	A-6435-3330	NC4+ Blue F145C-R pack with raised columns and cable with 90° connector.
NC4+ Blue F230C 90° pack	A-6435-3430	NC4+ Blue F230C pack and cable with 90° connector.
NC4+ Blue F230C-R 90° pack	A-6435-3530	NC4+ Blue F230C-R pack with raised columns and cable with 90° connector.
NC4+ Blue F300C 90° pack	A-6435-3630	NC4+ Blue F300C pack and cable with 90° connector.
NC4+ Blue F300C-R 90° pack	A-6435-3730	NC4+ Blue F300C-R pack with raised columns and cable with 90° connector.

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