Ballscrew Alignment

1) Install the ballscrew and align it from end to end.
2) With a clamp-on ammeter, clamp to the brown wire connected to the axis amplifier. If an AC amplifier, attach your ammeter to one of the output wires R, S or T.
3) Jog the axis to the + limit.
4) Enter one of the following into MDI, adjusting values to reflect the total travel of the axis. As an example, a VMC 4020 will have the following travels. X40, Y20 and Z20/28
    a. GI F25. G91 X-_. M49
    b. GI F25. G91 Y- _. M49
    c. GI F25. G91 Z-_. M49
5) Monitor the ammeter display while traversing along the axis. The readings should not vary more than 2 amps for MM screws and 1 amp for inch ballscrews.
6) Watch for variations at either end when being approached. If higher than normal values, check and adjust alignment.
7) If the ballscrew is realigned, adjust backlash again and retest.