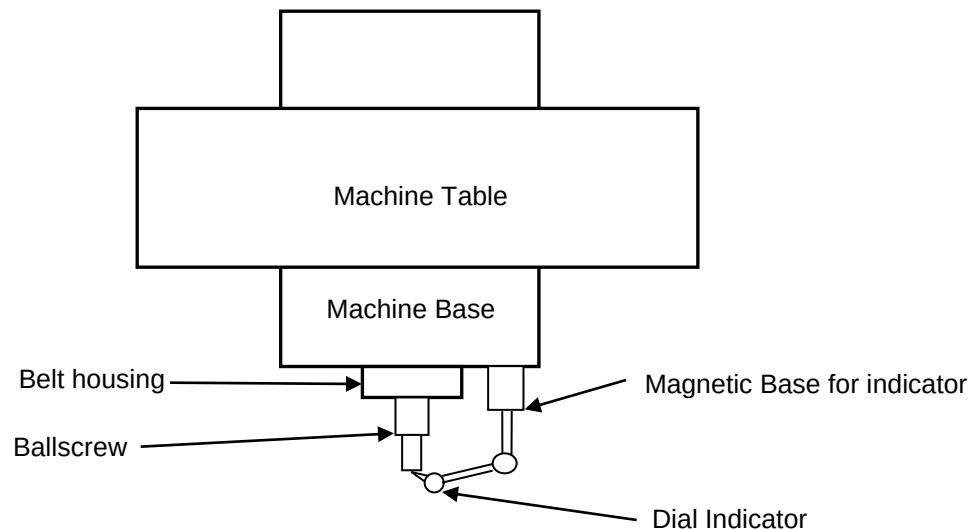


Check for ballscrew endplay

(This refers to the Y axis on an MB20 but is fairly generic to MB/VK.RH machines)

1. Position the Y-axis to approximately the center of its travel.
2. Remove the axis hand crank (if equipped) by removing the white plastic center piece. Then remove the nut and slide the handle off from the ballscrew shaft.
3. Mount a magnetic base to the machine base as shown in the drawing below.
4. Mount a dial indicator onto the magnetic base so that the end surface of the ballscrew shaft can be measured for in / out play. Rest the tip of the dial indicator against the end surface of the ballscrew.



5. Using Jog mode or MDI traverse the Y axis -1" (-25.4mm) in the negative direction.
6. Set the dial on the indicator dial to "0". This is the reference point.
7. Traverse the Y axis +1" (+25.4mm) in the positive direction.
8. The indicator should now read between .0002" - .0005" (.005mm - .0127mm). This amount is the "end play".
9. If the end play amount is greater than the upper limit specified, it suggests something is loose. Possibly the bearing nut, bearing retainer ring, etc.
10. Tighten any loose retaining hardware. If the bearing nut is loose adjust it until the endplay falls within the specified amount then ensure the lock washer is set.