

TB070 (Rev1) - Laser and Ball Bar Procedures

1. Run the laser on the X-axis. Take readings every 10mm. This is the uncompensated data.
2. After the control has accepted the data from floppy and made adjustments, run the laser on the axis again. This is the compensated laser run.
3. Complete steps (1) and (2) for the other two axes, Y and Z.
4. Run the ball bar once for the XY plane. Use a feedrate of 1000mm/min and 150mm ball bar length.
5. If ball bar analysis shows lash exceeding .005 mm for either axis, take an average between the forward and reverse lash values for that axis and readjust in the Machine configuration. Run the ball bar ball again to verify that lash measurements are near zero.
6. Repeat steps 5 and 6 for the XZ and YZ planes. There should be no need to adjust X or Y lash based upon data from these runs. However, it may be necessary to re-adjust the Z lash based upon an average of values.

Document History

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