

TB001 (Rev1) - Out of Round Circles and Arcs

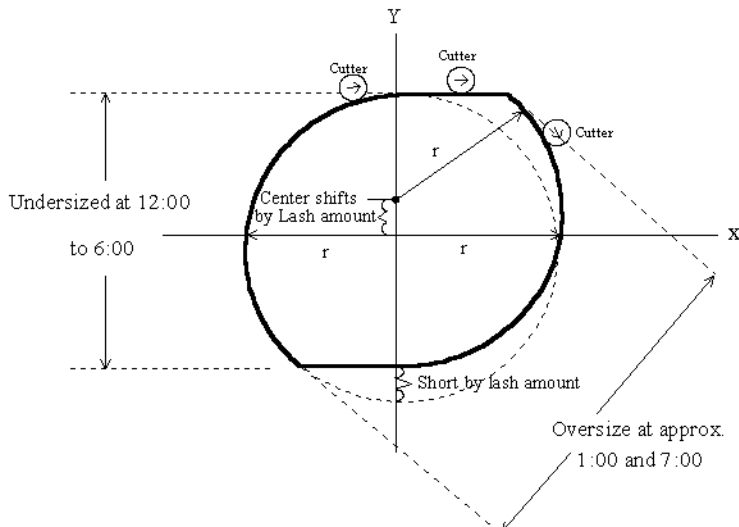
Question: *What is causing an inconsistent radius after milling a circle or arc?*

Answer: *Mechanical lash in the machine or improper backlash compensation setting.*

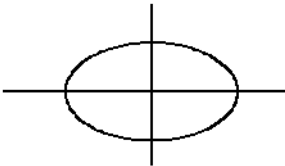
Solutions:

- Adjust software lash if less than 0.001". See TB037 - measuring machine lash
- Repair mechanical if lash is over 0.001". Contact your dealer.

Drawing shows: Exaggerated example of Mechanical lash in the Y axis, with a CW cutter path.
Note: This example has no lash in the X axis.

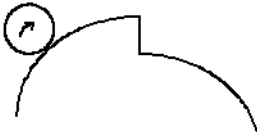


Problem: Elliptical Shape
Cure: Adjust Pitch (turns/inch)



See TB036 - Measuring Motor Revs/inch

Problem: Steps at 0,90,180,270
Cure: Reduce Lash Compensation



See TB037 - Measuring Backlash

Document History

Rev1 Created on 1997-10-01 by #001