Ballscrew Troubleshooting Inspection Report

Technician		Cell#	
Serial Number		Date	
Model			

Ballscrew

What Axis is the ballscrew?			
What is the brand of the ballscrew?			
What type of bearing pack do they have?	Bearing pack (old)		Cartridge Bearing (new)
What type of coupler is insalled?	Flex Coupling	Solid Coupling	Spider Coupling

Why is the Ballscrew being replaced?

1a. What alarms are generated?		**1b.** Does the alarm reset?	Yes No
1c. When does the alarm occur?		**1d.** Have you submitted a video of the original issue to service?	Yes No
1e. Have you submitted an error report?	Yes No		
2a. Is the ballscrew physically damaged?	Yes No	**2b.** Are the support or motor housing bearings damaged? Bearings should feel smooth by hand.	Yes No
2c. Do the support or motor bearings need to be replaced**?**	Yes No		

3. Other - Describe the issue:

Mandatory Troubleshooting

4. Did you check the ballscrew for correct lubrication?		Yes No		
5. Is the correct lubrication being used?	Yes No	Lubcrication Used:		
6. Did you check the ballscrew and ballnut for damage? Has it been crashed?	Yes No	Yes No		
8. Observe Axis Servo load while Jogging axis in question through full travel. A properly aligned Ball Screw will exhibit consistent servo loads throughout its travel.	Load % Range:			
	Please describe the behavior:			
9. Can you physically feel the ballscrew binding (turning by hand)?	Yes No			

10. If this machine is a GM-2 with dual ballscrews and you expirience high loads while jogging the X -axis. Did you complete an **inspection report** and submit an **error report** to service? **DO NOT** make geometry adjustments before consulting with service. What is the Load range for both the F1 and X axis	Inspection Report			Error Report:		
	Ye	No	N/A	Yes	No	N/A
	X:			F1:		

10a. Verify the breakaway torque value (this value will be in in-lbs) at the motor end, middle of travel and support end for both X and F1 axis **(GM-2 dual ballscrew only).** Check N/A box if this does not apply to your machine.	N/A	Motor	Middle	Support
	X:			
	F1:			

11. Are there LSC files active on the machine? (Parameter X.319)	Yes No	
12. Have you verified ballscrew backlash?	Yes No	Backlash value:
13. Has a ballbar plot been taken and submitted to service?	Yes No	
14. Is there humming present?	Yes No	
15. For axis humming have you visited the axis humming troubleshooting guide? Have you visited the ballscrew troubleshooting guide	Yes No	Yes No
16. Did you download and install the latest configuration files for the machine?	Yes No	

Notes/ Observations:

Attach this report, an error report, and any relevent documentation to a service notification in the Haas Service App.