

## 5-Axis calibration checklist

- ☐ Mount 90 degree calibration plate on PowerStick.
- ☐ Put drill rod in spindle.
- ☐ Manually move machine over top of plate. Spindle should point straight down with B motor pointing in the positive Y-Direction.
- ☐ Make sure input-1 will trigger by touching the alligator clip to the plate.
- ☐ Attach alligator clip to spindle.
- ☐ **FP, C:\SbParts\Five Axis\Calibration Routines\1) 5AX\_AB\_Calibration.sbp**
- ☐ Remove drill rod and collet
- ☐ **FP, C:\SbParts\Five Axis\Calibration Routines\2) 5AX\_Get\_Gauge\_Length.sbp**
- ☐ **FP, C:\SbParts\Five Axis\Calibration Routines\3) 5AX\_Find\_Side\_Plate.sbp**
- ☐ Reattach alligator clip to spindle (if removed)
- ☐ **FP, C:\SbParts\Five Axis\Calibration Routines\4) 5AX\_Get\_Gauge\_Factor.sbp**