

<b>TITLE:</b>	<b>SABRE™ 408 Y-Axis Lead Screw Replacement Procedure</b>
<b>Gerber FastFact #:</b>	2018
<b>Supplied by:</b>	Gerber Hardware Support
<b>Last Modified:</b>	Updated on December 8, 2009 (June 19, 2007)
<b>Summary:</b>	The following procedure explains how to replace the Y-Axis lead screw on a Sabre 408 Router.
<b>Tools used:</b>	<ul style="list-style-type: none"> <li>• Metric Allen Wrench set – “Long-L” type</li> <li>• Metric Allen Wrench set – “T handle” type</li> <li>• Torque Wrench – (INCH POUND)</li> <li>• Socket for Torque Wrench – 15mm for Lead screw bolts, 3/4” for Chapman bits</li> <li>• Metric Chapman Drive set</li> <li>• Light duty thread locking compound, Loctite 222 or equivalent and Loctite 245 or equivalent</li> <li>• Medium duty thread locking compound, Loctite 242 or equivalent</li> <li>• Isopropyl alcohol for clean-up</li> </ul>

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## Referencing 0,0 position

The encoder pulse must be set to its original position after a new lead screw is installed. Before removing the old lead screw, it is advised to use the pen tool to draw a line in the X direction on the table top. You can then use this in setting the new lead screw's 0 position.



*Note: In the case of an inoperable lead screw, see fast fact #2041, “Establishing the Y-Axis encoder pulse position.”*



### To Reference 0,0 position

1. Turn the Sabre on at the controller.
2. Orient system.
3. Place pen tool in spindle motor (without moving beam from position it stopped at when it finished orienting).
4. Lower Pen tool to Table top to depress spring in pen so it can draw on table top.

# Gerber Sabre Manual

**Yi-Tong Ma**



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