

## SINGLE PLANE (FORCE) BALANCING PROCEDURE

1. Place part to be balanced on machine.
2. Measure the correction radius of the part. See Figure 1.
3. Enter this measurement into the Left Radius dimension window.
4. Enter the following dimensions; A=0, B=10, C=0, and Right Radius any thing larger than 1.
5. Ensure the FORCE button is lit.
6. Check the “Static” unbalance of the part. The “Static” unbalance will cause a natural movement of the part to which the heavy spot will go to 6:00 due to gravity. If a quick movement is noticed, make a correction; Add at 12:00 or remove at 6:00. Using clay will estimate amount of correction.
7. If you notice a slight static unbalance, spin the part up to a slower than normal balance RPM. Normal balance RPM is within 50 RPM of the calibration speed. i.e. if normal balance speed is 600 RPM, run the part at 200 to 300 RPM. Being sure to take part up to speed slowly.
8. Make correction by adding or removing weight as directed in the Left Amount and Angle window.
9. Spin part up to normal balance speed slowly. Make correction by adding or removing weight as directed in the Left Amount and Angle window. Repeat until desired tolerance is met.

