

# Precision Rolled Ball Screws

## Reloading the Ball Nut

To reload the ball bearings into a Helix ball nut, follow these simple steps:

1. Remove the return tube(s).
2. Position the ball nut on the ball screw shaft with the ball return holes facing up.
3. Center the ball nut grooves with the shaft grooves by inserting plastic dowels into each of the ball nut return circuit holes. Use dowels that have a similar outside diameter to that of the ball bearings.
4. Remove the dowel from one end on the circuit and load with ball bearings.
  - Turning the screw as you load the bearings will help fill the groove more easily.
  - The balls will begin to lift the remaining dowel as the circuit fills up.
  - To ensure the circuit is full, lightly tap the top ball bearing and check to see if the remaining dowel moves.
5. Load ball bearings into the return tube(s) until there is a 4 or 5 ball space in each return tube.
6. Reattach the return tube(s) to the ball nut and fasten securely.



Contact [sales@helixlinear.com](mailto:sales@helixlinear.com) today!



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