SHOPBOT OPERATION GUIDE

1. Power machine ON
2. Secure stock to spoilboard
    1. Run a pre-drill operation and secure stock to spoilboard with screws [or]
    2. Block stock in [secure scrap blocking boards to spoilboard holding stock in with pressure from the sides
    3. DO NOT start job if you can move the stock with your hands
3. Insert flash drive and locate .sbp mill file
4. Insert START and STOP code
    1. Open .sbp file with Notebook application
    2. Add line C6 directly after the JS [Jog Start] line of code
    3. Add line C7 directly before the JH [Jog Home] line of code
5. Load correct tool [specified on CNC form] with wrenches
6. Make sure air handler skirt is secured and in correct position
7. Zero Tool Z
    1. This operation must be performed each time a tool is changed
    2. Place zeroing plate flat on a clear area of the spoilboard [this may need to be done prior to securing stock to spoilboard if the stock is 48” x 48”]
    3. Clip lead to the endmill bit
    4. Initiate the zeroing operation on the digital interface
    5. Return zeroing plate / lead to holder
8. Zero X + Y
    1. X + Y will be zeroed to the corner of your stock
    2. Use hand jog function on the digital interface to get endmill bit at corner of stock closest to the origin
    3. Press ZERO SET button and make sure that only X + Y are selected
    4. Press ZERO SET
    5. MAKE SURE tool is above stock while jogging in X + Y directions
9. Turn the air handler on
10. Take a last visual check to make sure mill area is clear of debris / tools
11. MAKE SURE student knows how to stop mill in case of emergency / problem
12. MAKE SURE student knows that it is their responsibility to clean out bay completely after job
13. MAKE SURE student has eye / ear / respiratory protection
14. INITIATE JOB