Mach 3 CNC Operations Checklist

Startup Checklist
- ☐ Check Power / Turn On Phase Converter
- ☐ Check Air / Turn On Air Compressor & Dryer
- ☐ Check Squareness / Pull Gantry Against Hard Stops
- ☐ Check Warm Up Tool is Ready
- ☐ Power On the CNC / Turn On Control Software
- ☐ For ATC Machine Check Air Pressure / Moisture in Regulators
- ☐ Check Emergency Stop Switch
- ☐ Home / Reference the Machine
- ☐ Warm Up Spindle

Setup a Horizontal Table Work Offset Checklist
- ☐ Securely Mount the Blank onto the Horizontal Workstation
- ☐ Check Turning is Deactivated
- ☐ Choose a Work Offset #
- ☐ Check MTC Tools Are Ready / Load ATC Tools into Clip Positions
- ☐ If Using The Vacuum Table, Turn-On Vacuum Table
- ☐ Check / Locate & Set Work Offset / Set X & Y with An Edge Finder
- ☐ Check / Locate & Set Z-zero / Use Cutter with Smart Tool Pad
- ☐ Load Tool Path / G-Code File
- ☐ Check Tool #'s Match Tool Path / G-Code File
- ☐ Start the program (Cycle Start)

Setup a Vertical Table Work Offset Checklist
- ☐ Securely Mount the Blank onto the Vertical Workstation
- ☐ Check Turning is Deactivated
- ☐ Choose a Work Offset #
- ☐ Check MTC Tools Are Ready / Load ACT Tools into Clip Positions
- ☐ Check / Locate & Set Work Offset / Set X & Y with An Edge Finder
- ☐ Check / Locate & Set Z-zero / Use Cutter with Smart Tool Pad
- ☐ Load Tool Path / G-Code File
- ☐ Check Tool #'s Match Tool Path / G-Code File
- ☐ Start the program (Cycle Start)

Mach 3 CNC Operations Checklist

Setup a Turning Center Work Offset Checklist
- ☐ Securely Mount the Blank into the Turning Center Workstation
- ☐ Check Turning is Activated
- ☐ Choose a Work Offset #
- ☐ Check MTC Tools Are Ready / Load ATC Tools into Clip Positions
- ☐ Check Work Offset X & Y Location / Set X, Y-Zero if Necessary
- ☐ Check Smart Tool is On / Active
- ☐ Load Tool Path / G-Code File
- ☐ Check Tool #'s Match Tool Path / G-Code File
- ☐ Start the program (Cycle Start)

Shut-Down Checklist
- ☐ MTC Remove Tool / ATC Put Tool Away
- ☐ Park System
- ☐ Close & Save The Controller Software / Power-Off the CNC
- ☐ Check Daily / Weekly Maintenance