

Course 1: Legacy CNC 101
Module 1: Preparing Your Shop For CNC
1.2: Installing Your CNC
Lesson 5: 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)

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