

### **Daily check list before cutting:**

- 1.) Reboot computer to install correct defaults (for computers with Deepfreeze software).
- 2.) Turn on control box and check spindle fan. Wait for the fan to come on before you hit the blue reset button. Hold your hand above the fan to confirm air flow.
- 3.) Check bit, collet and collet nut for wear and debris. Collets are good for 400-500 hours of use if they are kept clean and no "event" occurs such as a broken bit inside the collet or a plunge that bottoms out on the collet. Please use good quality, well balanced tooling with the correct feed rate and RPM to achieve good chipload. See ShopBot command, "TC" to confirm chip size. Read chipload help document in the calculator.
- 4.) Warm up spindle for 6-9 minutes with C5 routine or ½ RPM (9000)
- 5.) Check rack/pinion/motor/shaft relationship by rapidly pushing and pulling the carriages near each motor. X1, X2, Y and Z. If you feel and see some movement, contact a TechShop staff.
- 6.) Walk around the machine to make sure all machine movement is clear of debris, hoses, scrap wood, wires etc.
- 7.) Zero X and Y axis with C3.
- 8.) Zero Z axis with C2. Is your file at the table or the top of the material? Is your file no more than .02" below your material? Did you measure the thickness of your material with calipers? Respect the Spoilboard!
- 9.) Air cut your file above the material to check location, speeds and smoothness of motion.
- 10.) Cut your file and have fun.