CNC job guide

1. Run spindle warmup if necessary
2. Fasten the piece properly
3. Set work offsets with the probe
4. Initialize "SAFE MODE" by pressing F3

    This makes the machine to stop if it crashes unexpectedly, hopefully saving it from taking serious damage. Only works when doing transports, not when it is in "FEED MODE"

5. Set tool offsets FOR ALL TOOLS in your job (Except the probe)
6. Double check X and Y 0-coordinates are correct

    Use G0X0Y0 command from MDI when you are in a clearance height well above the work piece (SO THERE IS NO RISK OF CRASH) Checking Z0 coordinate is done when program has started.

7. Activate "Handle feed" and "All positions"
8. Start your program at a **LOW speed**
9. Check Z 0-coordinate are correct

    Use the "Positions" screen to see how far down the tool will move. The Z is correct if the height is correct according to your CAD-file when initializing the first cut. **DO THIS SLOW** so you have time to stop the machine and abort.

Clean the machine after you are done and remove the tools that you have used. Clean the holders and dry off used parallel plates.

OBS! If you are inexperienced have someone with you