

CNC-STEP MILLING MACHINE

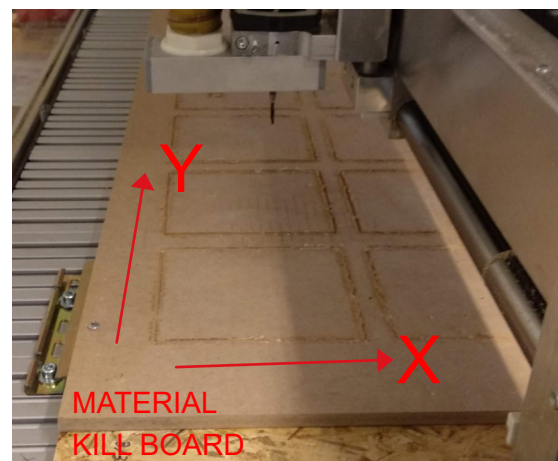
1 Visual check the machine;

- the machine should be clean
- there should be no obstacles
- check the drill diameter and status according to the requirements

“DO NOT CHANGE THE TOOL YET!”

2 Load the material

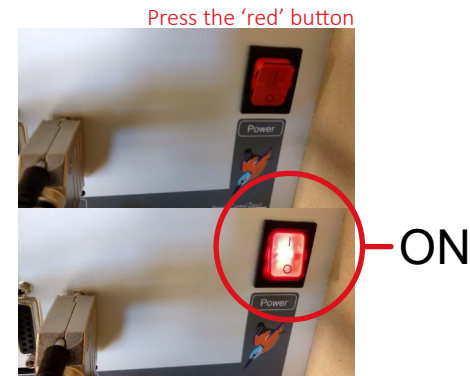
- by screwing (using electric screwdriver) and check the screws height to not damage the supporting aluminium board



The view is from the large operation window!!

- by double side sticky tape. Make sure that the material is firmly connected to the platform

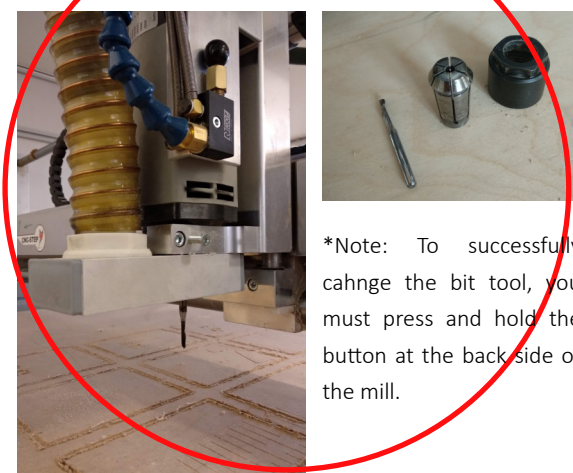
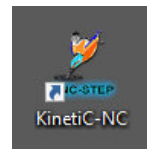
3 Turn the machine ON



4 Open the software KinetiC-NC (as Admin)

KinetiC-NC

- use the 'reference' icon to set all the values to machine 'ZERO position'
- by using the On-Screen (point 5) or the remote control you can move the machine through X, Y & Z
- check the drill bit number and status. If needed make the bit change by using wrench to loose and later on tight the tip.

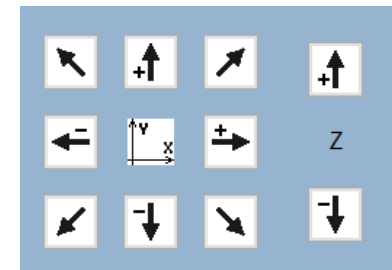



*Note: To successfully change the bit tool, you must press and hold the button at the back side of the mill.

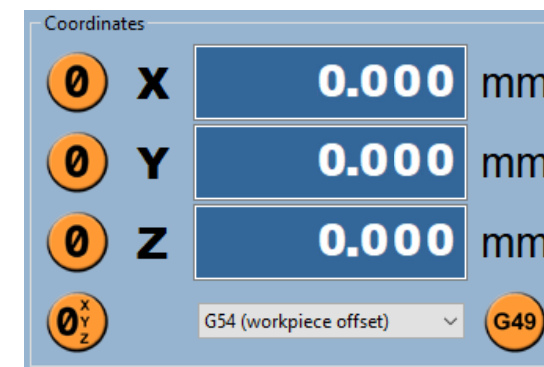
Beschreibung passt nicht! hier muss mit einem zweiten Schlüssel gegengehalten werden. Bitte ein extra Foto ergänzen. Ebenso muß der Absaugadapter demontiert werden!

5 Keep it Set the 'ORIGIN' point (bottom-left)

- to set the origin point, navigate with the arrow keys. Use the - X - Y - Z- and by clicking to reset the Origin values
- **Be very careful!**
- there should be no collision with the screws
- while setting the Z values, use the 'JOG' command. Slowly move the bit down till it touches the surface of the working material!



- Now you have to press the values as below  icon to set X - 0.000; Y - 0.000; Z - 0.000;



6 Upload the Code to the program

- use the 'LOAD' button to upload the extracted code.



- check the Frame to make sure that the desired mill is inside the working area, free of obstacles and possible collisions

7 Start the Milling Job

- turn ON the vacuum cleaner and make sure that the nozzle is connected in the right way to the machine
- you can use F4 anything to 'pause' the Job. Use this break to vacuum-clean the machine interior from excessive rubbish
- check the Frame to make sure that the desired mill is inside the working area, free of obstacles and possible collisions
- after making sure that all is good, START the job by pressing F4 or the 'Start' icon
- The Machine opening has magnetic sensors and the job will not start if the doors are still opened.



8 Keep it clean

- after finishing the milling, write down the working time and inform a tutor
- move the machine to initial home position (right/front/up)
- take the material out
- bring anything and any tool to their place