**\*\*HAVE STAFF SIGN-OFF CHECKLIST BEFORE RUNNING PROGRAMS\*\***

\_\_\_\_\_ All RPMs must be less than 5000 for the DPM mills, less than 2000 for the Eisen mills.

\_\_\_\_\_ Feed rates for wax can be 30” per minute.

\_\_\_\_\_ Check settings for grooves, they should not be checked SIMPLE ENGRAVE.

\_\_\_\_\_ Use the proper tooling for CNC 2, Part 1:

Tool 1 - 5/16” 2 Flute end mill

Tool 2 - #2 center drill

Tool 3 – 1/8” drill

Tool 4 - #7 drill

Tool 5 – 3/32” 2 Flute end mill

\_\_\_\_\_ When in FRONT and RIGHT view, there are to be no zigzag downward moves for CNC 2 Part 1 & 2.

\_\_\_\_\_ CNC 3 Part 1 MUST have zigzag moves when entering material.

\_\_\_\_\_ Programs should not be longer than 30 minutes of run time.

\_\_\_\_\_ Curved 3d shapes must be cut with a ball end mill.

\_\_\_\_\_ Top of the stock has been machined flat before setting Z zero.

\_\_\_\_\_ Set up of the stock is correct/adequate (stock not hanging out of vise excessively).

\_\_\_\_\_ Tooling is set up properly (not hanging out too far).

\_\_\_\_\_ Correct post was used.

\_\_\_\_\_ Correct tool library was used (COE Student Shop).