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

\_\_\_\_\_ Part must be drawn in FeatureCAM (CNC 2 only).

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

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

\_\_\_\_\_ Check settings for **grooves**, “SIMPLE ENGRAVE” should **NOT** be checked.

\_\_\_\_\_ 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.

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

\_\_\_\_\_ Under “Strategy”, do **NOT** use “Finish Bottom”.

\_\_\_\_\_ The entire piece of stock must be machined square before machining the part.

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

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

\_\_\_\_\_ Tool lengths are properly entered in the tool table (DPM & Tormach only).

\_\_\_\_\_ Correct post was used (machine specific).

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

**Additional checks for CNC 3**

\_\_\_\_\_ Part must be drawn in Solidworks, and imported.

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

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