Green Part Seminar

Measuring

* Clean and zero calipers before starting
* Measure on clean, deburred, machined surfaces

General

* Establish your order of operations
* Clean and check for burrs on all precision mating surfaces before clamping/installing
* Peck drill when using center drills and drills
* Do NOT handle chips with your hands
* Clean machines and surrounding area (floor) when done
* Measure tool size and check condition before beginning to machine
* Use proper RPM (Use RPM calculator)
* Use cutting oil
* Use a center drill to start a hole before drilling
* DO NOT touch your work piece or chips while the machine is running

Lathe

* Stock may be extended up to 1.5 times the diameter from chuck jaws and remain rigid
* After a cut, move your tool away from the piece before repositioning
* Maintain clearance between the tool/carriage and chuck

Mill

* Keep work piece as far inside the jaws as practical
* End mills never go in drill chucks
* Do not place the end mill into the collet so the notch or flutes are at the collet surface
* Mill will cut into the jaws if you are not careful
* Climb milling is preferred
* Climb milling applies to side milling, not surface milling
* Raise quill and lock before inserting/removing tooling
* Wait for Z-axis power feed motor to stop before reversing direction
* Do not try to lower the table below the Z-axis power feed shutoff
* When zeroing, compensate for the edge finder radius
* The fixed jaw on the vise is more accurate for indicating and zeroing
* Be gentle with taps
* Always use the quill stop when milling
* NEVER USE “RETURN ABS ZERO”

Ask for Assistance

Machine \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

