## Test Case # 1: CNC Confirmation Test

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| **Test Writers:** Cameron Tribe | | | | | | | | | |
| **Test Case Name:** | | CNC Confirmation Test #1 | | | | **Test ID #:** | | 3MP-Wire-01 | |
| **Description:** | | Measures the actual wire speed in correlation with the wire speed encoder. This test will allow for the construction of the lookup table to be used with the main program. | | | | **Type:** | |  | |
| **Tester Information** | | | | | | | | | |
|  | **Name of Tester:** |  | | | | | **Date:** | |  |
| **Hardware Ver:** | | Display V1.0, Main Board V1.5, Sensor V1.0 | | | | | **Time:** | |  |
| **Setup:** | | Only Welder will be used, not CNC. Remove Cover of welder to ensure wire feed is properly set up. Welding will not be taking place, so be sure ground wire is not connected. | | | | | | | |
| **Step** | **Action** | **Expected Result** | **Pass** | **Fail** | **N/A** | | **Comments** | | |
| 1 | Open wire feed program | Program should open |  |  |  | |  | | |
| 2 | Set program to run for one second | program should only run for one second |  |  |  | |  | | |
| 3 | Cut wire extruded from nozzle as short as possible | Very little wire should be showing |  |  |  | |  | | |
| 4 | Set wire feed speed nozzle to home setting | Wire feed should be at lowest setting |  |  |  | |  | | |
| 5 | Turn on welder | Welder should turn on |  |  |  | |  | | |
| 6 | Run test program | Welder should feed wire for exactly one second |  |  |  | |  | | |
| 7 | Turn off welder | Welder should turn off |  |  |  | |  | | |
| 8 | Cut wire extruded from nozzle as short as possible | Very little wire should be showing |  |  |  | |  | | |
| 9 | Measure length of cut wire and record value | Value determined for specified wire feed setting |  |  |  | |  | | |
| 10 | Repeat steps 1-9 for various values of wire speed | Determine if wire feed is linear. If so, interpolate for all wire feed speeds |  |  |  | |  | | |
| **Overall Test Result:** | | |  |  |  | |  | | |