**DF-1 Procedures**

# Startup & Operation

Each morning and at the beginning of every shift:

1. Check die bolts under RAM for tightening
2. Turn on machine
3. Move top switch into Manual Mode (right position)
4. Move bottom switch into Hold Down Up
5. Move RAM level with the die to check alignment
   1. Inform maintenance if X or Y-axis need re-alignment
6. Move RAM back until machine stops moving
7. Move RAM up until machine stops moving
8. Move RAM away from both switches until X and Y values are displayed on screen
9. Move top switch back into Automatic Mode (left position)
10. Load appropriate setting
    1. 02REG: .105 & larger wire diameter
    2. 03DUB: .092 & smaller wire diameter
11. With both operator and assistant operator watching movement:
    1. Home & cycle machine with one hand on magnetic E-Stop
12. If motion is safe, begin operation
13. Repeat Steps 3-12 each time settings are changed.

\*\*\*ALWAYS WATCH FOLDS WITH HAND ON E-STOP TO ENSURE USUAL OPERATION\*\*\*