

# EBF Checklist - Short

## Prior to Turning On the EBF

- Check the oil in the vacuum pump.
- Check dust collector bags.
- Move the control cabinet into the red taped area.
- Turn on air compressor.
- Check that compressed air is supplied to the table - at least 70 psi.
- Load cutters/endmills into the tool holders and tool holders into the correct slots.
- Check and clean any debris out of the collet and tool holder before loading tools.
- Adjust the dust hood if necessary.
- Check that the blast gate to the EBF is open and others are closed.
- Move rubber gasket material to the correct positions for your piece.

## Turning Machines On

- Turn on the EBF at main circuit breaker.
- Turn on the local power disconnect via the big red lever to the left of the machine.
- Turn the rotary switch on back of the control cabinet is to 'Marche'
- Turn on the control cabinet power on left side of the control cabinet.
- Open the cabinet and push the power button on the computer.

## Setting Up To Cut

- Launch WinCNC
- Press "Home" on WinCNC
- Type "G90" to set the machine to absolute coordinates
- Press the "Set X0 Y0 Z0" button
- Position your spoil board/fixture and work material.
- Load your tool table in WinCNC if needed (not frequently used).
- Touch-off each tool - Set Tool Z
- Cover any unused holes in the vacuum table.
- Turn on the vacuum by pressing the "Vacuum" button on WinCNC.
- Check the security of your spoilboard, fixture, and/or work piece.
- Touch off the tool on the top of your workpiece - Set Material Z. Make sure vacuum is on.
- Jog the spindle to where you want your material X and Y zero to be.
- Press the "Set Work X0 Y0" button.

## Loading the GCode and Cutting

- Save your GCode file from your flash drive to the computer.
- Drop the machine pins if you raised the pins for aligning your work piece.
- Open the GCode file in WinCNC.
- Use the preview "Eye" button to make sure that your project is going to cut in the right location.
- Press Enter. This will pickup the correct tool and start the spindle.
- Turn on the dust collector.
- Once you hear the spindle spinning, press Enter again to start cutting.

## Post Cut

- Turn dust collection off
- Press the "Go To Parking" button.
- Lower the spindle Z height to just over the pad in the parking position.
- Exit WinCNC
- Remove your material
- Vacuum top, under and around machine
- Empty dust collection bag(s) if full
- Remove endmills from tool holders and replace all Makersmiths parts inside the drawer.
- Clean dust and debris out of all collets and tool holders used.
- Shut down Windows
- Turn off cabinet (black switch on left side of cabinet)
- Turn switch on the back of the cabinet to "Arrete".
- Turn off power at the local breaker box behind the cabinet - big red lever.
- Turn off EBF breaker in the breaker box in the metal shop.
- Put the tarp back on top of the machine.
- Move the PC cabinet back out of the way and so that the metal shop door can be opened.