



PPE Required: **Safety Glasses**

Prohibited Clothing: gloves, loose clothing, neckties, jewelry

Machine Access Level: **Supervised Only**

Materials Allowed: **Wood, plastic, composites**

Note: For all other materials see the AFL supervisor! No MDF except for fixturing.

Operating Procedure

1. Machine Safety Inspection and Work Area Check-Out

- A. **PPE:** make sure you are wearing the proper PPE and not wearing any equipment listed on the first page that could create a hazard.
- B. **Machine Warning Signs:** Make sure you read and follow the machine warning signs that are attached to the machine. If you have any questions, ASK!!
- C. **Work Area:** Make sure the work area is clean and the work area around the machine is free and clear of debris and personnel.

2. Work Supervision

- A. This machine requires supervision by an AFL employee. A supervisor or TA will assist you in the set-up and operation of the machine. **You may not operate this machine without supervision.**

3. Machine Adjustment

- A. **Note:** The electronic safety eye must be in position, in order to make adjustments on this machine.
- B. **Check and Select router bit(s):** Make sure the bit is in good condition. A TA will assist you in the selection and proper set up of your tools.
- C. **Identify the machine controls:** Identify the red emergency stop button. This will stop the machine in case of an emergency. Identify the Green Cycle Start button; this will start the program to cycle the machine.
- D. **Secure the part to work surface:** The part **MUST** be clamped correctly so it will not move during operation. **You may NOT use your hand to hold the part to the work surface!** The TA will assist you with this step.
- E. **Adjust barrier guarding:** Barrier guarding **MUST** be moved into place before you can begin cutting.
- F. **Adjust speeds and feeds:** Speed and feed adjustments are the main adjustments on the machine. The TA will assist you with this step.
- G. **Adjust the air blast:** Make sure to utilize air blast when needed. The TA will assist you with this step.

4. Machine Operation

- A. **Dust collection system check:** **The dust collection system and ambient air cleaners MUST be on before cutting can be performed.**
- B. **Set up and operation:** The TA will assist you with setting up and operating the machine.
- C. **Safely run the part:** Safely run the part. The TA will assist you with this step.
- D. **Turn the machine off:** When finished, push the red stop button to shut the machine off. Let the bit come to a stop before removing the part. **Never touch a moving bit.**

5. Clean Up

- A. **Disassemble work set-up:** Disassemble any clamps or bits. Return all parts to their proper location and the appearance of the CNC Router to how it looked when you started.
- B. **Clean up the area:** Clean up all messes (For example: Use a shop vacuum to clean up any additional dust), return all tools, etc. The TA will check that the area is clean before you can sign-out of the AFL.