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.
- ☐ 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 cabinet. 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.