

EBF Checklist

- Check the oil in the Vacuum pump. (sight glass on back)
- Make sure the dust collector bags (inside) are not full. Change if necessary.
- Move the control cabinet out to clear the machine and the metal shop door.
- Load cutters into the tool holder as required for your job. (1-8, left to right)
- Adjust dust hood if necessary (Allen head screws on sides)
- Make sure compressed air is supplied to the table (connection front lower left corner near floor – regulator and filter on wall – minimum 70 psi).
- Make sure the Circuit Breaker on the Main Panel is on. (Circuit breaker feeds a transformer that supplies the correct power to the EBF)
- Turn on the local power disconnect.
- Rotary switch on back of the control cabinet should be set to 'Marche' (It stays in this position)
- Power on the control cabinet (black switch on left side - up).
- Open the cabinet and reset the computer.
- Launch WinCNC
- Home machine
- Issue G92 X0 Y0 Z0
- Move spindle towards back of machine, or wherever you need to move it to in order to position your spoil board/fixture.
- Be sure fixtures and spoil boards are clear of pins.
- Select 'Pins Up' button.
- Position base board against side and front pins.
- Position your spoil board/fixture as needed on the table.
- Position your material on your spoil board/fixture
- Load your tool table in WinCNC as required.
- Touch-Off each tool. Place the Touch-Off button on the machine base (aluminum) on the side of the machine. Load Each tool (Tn). Move tool to Touch-Off position (G00 X2 Y17) and use the 'Set Tool' button on the screen.
- Turn on Vacuum. (Button on WinCNC)
- Turn on 4 vacuum zone control switches (front of machine in oval cut out).
- Check security of raw material. (Table vacuum zones can be adjusted – please consult tool steward.)
- With your last tool (after Touch-Off) move Touch-Off button to a suitable place on top of your material.
- Jog the Spindle to over the Touch-Off Button. (or move the button)
- Use the 'Set Material' button to set the Z height.
- Jog the Spindle to where you want your material X and Y Zero.
- Note down the X and Y positions (valuable if you need to restart)
- Issue command G92 X0 Y0 to set work piece zero.
- Turn on Dust Collector (breaker switch on box just inside the wall to the right of the machine)
- Turn on Vacuum (if not already on)
- Load Gcode (File, Open, yourfile) **WAIT !** (Pressing Enter will start the cut !)
Your Gcode may be loaded from a flash drive. USB hub is on left side of machine. Suggest copying your file to the hard drive on the machine.
- Press Enter - Cutting will begin

After Job Completion

- Wait till the spindle stops spinning before doing anything.
- Vacuum off
- Dust collection off
- Jog the machine out of the way of your material as needed
- T0 removes any tool from the Spindle
- Spindle to Parking
- Lower Spindle Z
- Remove your material
- Vacuum top, under and around machine
- Empty dust collection bag if full
- Restore/adjust tools in tool holders and tool order as needed.
- Disconnect air line
- Exit WinCNC
- Shut down Windows
- Turn off cabinet (black switch on side of cabinet down)
- Turn off Power Disconnect
- Turn of EBF Breaker in Breaker Box.
- Clear any custom fixtures and make machine ready for next user

