ATC Daily Checklist:

Each Day before cutting:

☐ **Verify that there is proper air supplied to tool**.

☐ **Warm up spindle for 6-9 minutes** with **[C][5]** routine. **Verify spindle speed changes**. **Confirm operation of spindle cooling fan and air.**

☐ **Check bit, collet, collet nut and tool holders** for wear and debris. Collets are good for 400-500 hours *MAXIMUM* use if they are kept clean and no "event" occurs such as a broken bit inside the collet or a plunge that bottoms out on the collet. **Remove corrosion from tool holders** with a Scotchbrite pad. **Verify that pull studs are tight** into tool holders.

☐ **Check rack/pinion/motor/shaft** relationship by rapidly pushing and pulling the carriages near each motor. X1, X2, Y and Z. Adjust motor mount and/or tighten set screws. A slight clicking sound should be heard, but no movement (over a few thousandths) should be present. Adjust if needed.

☐ **Move the machine around the table** in both jog and move speeds, or make a short warm up routine to automate the process.

☐ **Run the [C][3]** file to home the tool (3 axes) using the prox switches.

☐ **Verify that tool in holder and tool# match.**

☐ **Run the [C][2]** file to zero your bit, if material surface zero is required.

☐ **Verify that your bit has been zeroed** properly by using a "**MZ,0**" command over the surface you have zeroed the bit to. Repeat zeroing (**[C][3]** for table, **[C][2]** for material) if not correct.

☐ **Cycle the dustfoot gate [ALT]+[3]** open and closed to verify operation.

☐ **Perform a visual inspection of the machine**, wiring, air and dust collection hoses and table surface. Inspect tool holder forks for damage. Verify proper operation of vacuum pump and dust collector (if present).