SHOPBOT CHECK LIST*: PRS Gantry Tools/PRS Buddy Tools or Desktop Tools

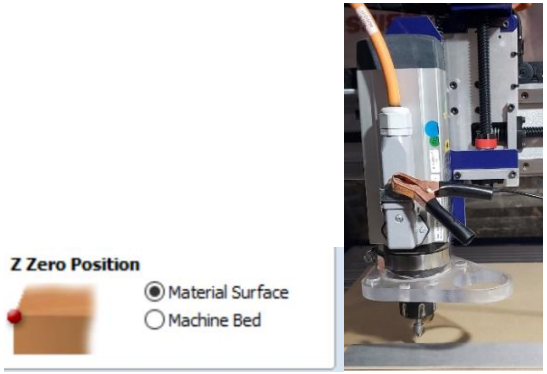
*See **ShopBot Safety and Basic Use** for detailed information about each of these steps

○ **Is the appropriate bit in the spindle/router?**	◦ Does bit have enough length to cut to full depth?
○ **Has the bit been zeroed at Z location set in CAD file?**	◦ Is Design set to Table Surface or Material Bed? ◦ **C2** or icon to run Z Zero routine w/ Z Zero plate
○ **Is the material in the correct location/orientation?** ○ **Is there a plan for Hold Down in place?**	◦ Does the X axis orientation in the CAD file match the X axis on the table?
○ **Are X & Y axes Zeroed at location set in CAD file?** ○ **C3** runs XY zero routine to set 0,0 at lower left corner of table ○ **JH** or **MH** lifts bit to Safe Z above zero and sends the bit back to current 0,0 location (Bit does not travel down to Safe Z)	◦ See other side to set X & Y Zero to location other than lower left corner of table
○ **Is the power to the spindle/router on?**	◦ If PRSalpha/standard: is the key on collet wrench engaged in interlock on Control Box? ◦ If Desktop/PRSstandard : is the interlock key engaged?
○ **Is the correct file loaded?** ○ **FP** button from menu or **Cut Part** button on screen ○ Is ShopBot Control software set to **Move/Cut** mode? ○ **START** button (green) or **ENTER**	**To Preview file before cutting:** ◦ Set ShopBot to **Preview** mode and review toolpath on screen (material size set by tool path) Remember to return ShopBot to **Move/Cut** mode ◦ "Air Cut" by sending bit home (**JH**) and send Z to 2" above regular Zero (**MZ,2)** Run file with a **3D offset** in start screen
○ **Start the spindle or router** ○ **Turn on Dust Collection**	◦ PRS alpha tools: press **START** button on pendant. LISTEN. Is spindle spinning? If not, **Cancel**, check lockout key, and load file again ◦ All other tools: Pressing **OK** at prompt should start spindle. If spindle does not start, stop file, troubleshoot, reload file
If you need to PAUSE or STOP a file: PRESS the SPACE BAR	

Insert Bit in the Collet

- Leave ~1/16 – 1/8” of the shaft out of the collet
- Test that cutting length of bit is long enough to cut through material without rubbing collet
- Tighten bit/collet assemby onto spindle (monkey tight, not gorilla tight)

Zero Z at same location as CAM file

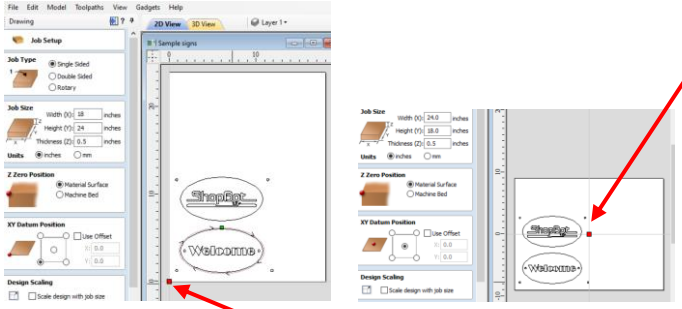


Test for continuity by touching Z-Zero plate to the bit.

If #1 input does not light up, check alligator clip

Zero the Z using the Z icon, or C2

Zero the X and Y at same location at CAD file



If 0,0 is in lower left corner of table, use the **XY Zero** icon or **C3** to run the Automatic Zeroing routine

If 0,0 in CAD/CAM file is not lower left corner

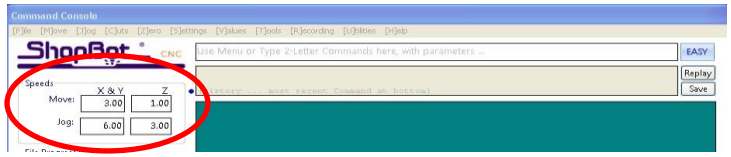
- For reference, Zero the X and Y in lower left corner using icon or C3
- Move the bit to the desired 0,0 location Hint: write down that location from known 0,0 in case you lose the new 0,0
- Zero the X and Y at that location using the **Zero** Command from the Toolbar or the Blue Button on the Keypad Control screen

JH or icon sends tool to current 0,0

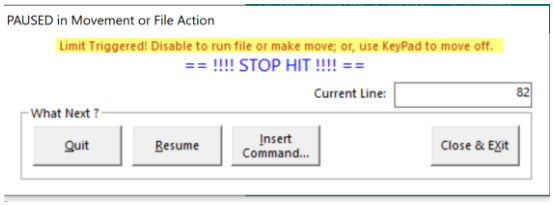
C3 or icon runs Automatic XY Zero routine to set 0,0 at lower left corner

To change the Move Speed in the middle of running a ShopBot Part (.sbp) file

Current Move Speed is displayed on Command Console



Pause the File (hit the space bar), then select **Insert Command**



Type MS in Command Line

- Enter new values on yellow screen **OK**
- **Resume** the File
- ShopBot will stay at that speed until it encounters another MS command