



05

CNC

5.2 CNC Nested Machining

5.2.1 Routing, Grooving And Boring

Candidate Name: _____ Date/Time: _____

Evaluator Name: _____ Location: _____

Completed test successfully: Yes No (If no, reason:) _____

Pre-Operation Checklist

Level 1

PERFORMANCE STANDARD:

- ▶ Inspects spoil board.
- ▶ Activates vacuum system and assures stock is properly secured.
- ▶ Verifies machine is properly guarded and safety mechanisms are in place and operating.
- ▶ Demonstrates knowledge of and proper use of all machine specific controls.
- ▶ Verifies vacuum pod gaskets or table surface gaskets are free of cuts, tears and defects.
- ▶ Inspects material for nails, staples or foreign materials before processing.
- ▶ Verifies scrap and offal is removed from the machine prior to processing material.

Level 2

PERFORMANCE STANDARD:

- ▶ Replaces/resurfaces spoil board when necessary.
- ▶ Selects machine operation functions and options.
- ▶ Selects and installs tooling to meet machining specifications.
- ▶ Enters tool values into the tool database.
- ▶ Inspects tooling apparatus for proper function.
- ▶ Inspects and positions vacuum apparatus and support beams.
- ▶ Meets Level 1 performance standard.

Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
- ▶ Tool/Machine Manufacturer's safety rules and guidelines are followed.
- ▶ Panel support rails (if present) are used to assist with large panel movement and placement.
- ▶ Tooling requirements are reviewed and appropriate tooling on the machine verified.
- ▶ Operator does not reach into the machine processing area while the machine is in operation.
- ▶ Stock is held securely.
- ▶ Operator clears machine and cleans work area after use.
- ▶ Required OSHA approved personal protective equipment is worn.
- ▶ Lock-out/Tag-out procedure is in place and followed by everyone.
- ▶ Process is completed in a timely manner.

Please use back side for additional notes

Operation Checklist

Level 1:

Given a CNC nested base machine that is properly set up and adjusted, calibrated with the correct CNC tooling, and stock present, machine part(s).

Performance standard:

- Dimension tolerance is within ± 0.1 mm [0.004"].

Level 2:

Given the CNC nested base machine, set up the machine and tooling, and machine part(s) to specifications.

Performance standard:

- Verifies finished product measurements to design specifications.
- Verifies tooling is processing within ± 0.1 mm [0.004"].
- Analyzes and corrects machining defects (quality of edges, holes).
- Meets Level 1 performance standard.