





Fast Start – ATC Spindle

1. Turn on Power

Locate the power switch, the round knob in the control enclosure, and rotate it to the ON position.
Turn on the air regulator.

2. Find Machine Hard Home


Press **Shift**  and **Go Home**  on the keypad to index the gantry, carriage, and Z assembly.

Press **Shift**  and **Five**  to open the chuck and remove a tool from the Tool Changer.


3. Calibrate New Tools

Press **Menu** .


Press **X-axis Jog Arrows**  until ATC is highlighted in blue.


Press **Enter**  to access the ATC sub-menu.


Press **X-axis Jog Arrows**  until Calibrate Tool is highlighted in blue.

Press **Enter**  to access the Tool Calibration function.

Select the number of the tool to calibrate using the number keypad (e.g., 1).

Press **Enter** . The spindle will move over to the tool carousel, unload the tool if one is currently in place, rotate to the selected tool, and load that tool into the system. The system will then move over the calibration block.

Press the **Z-axis Jog Arrows**  to lower the spindle until it is near the top of the calibration block. Place the grounding magnet on the spindle tool holder.

Press and hold **Zero**  to begin the tool calibration. The Z-axis will move down slowly until it senses the calibration block. It will then lift off the block up to maximum Z height.
Remove the mounting magnet before beginning work.

MultiCam requires that tools be calibrated when a new tool is inserted into the tool holder. The machine will store the Z-axis tool length of the new tool in memory even after the machine is turned off. Only new tools need to be calibrated.

4. Set Home

Press **Jog Speed** to set the speed of the movement to slow, medium, or fast.

Press **Jog Arrows** to place the **center of the bit** over the front right corner of the material.

Press **Set Home** to set the home location for the bit. The system will prompt the operator as to whether the selected position should be set as home, and the display will read “Press Down to set Rotation Point.” See Rotate File for a description of this function.

Press **Enter** to confirm the position.

5. Turn on the Table Vacuum

Locate the power switch on the table vacuum.

Switch the indicator to the ON position.

The Table Vacuum must be on so that the **surface and maximum depth** can be set properly. Failure to turn on the vacuum will allow an incorrect setting to be entered when using these **MultiCam** features.

6. Set Surface

Press **Jog Arrows** to position the tool bit anywhere over the material to be cut. Place the grounding magnet on the spindle tool holder.

Press **Set Surface** and enter the tool number. Place the surface block on top of the material underneath the tool.

Press **Z-axis Jog Arrows** to lower the Z-axis until the end of the tool is just above the surface block.

Press and hold **Zero** to begin the surfacing routine. This will cause the Z-axis to move down slowly until the tool comes in contact with the surface block and then move up above the surface block to the Tool Life Height.

Remove the grounding magnet and surface block before beginning work.

7. Set Maximum Depth (as needed)

Press **Jog Arrows** to position the tool over the spoilboard or sacrifice material. Place the grounding magnet on the spindle tool holder.

Press **Set Max Depth** to set the maximum depth for the bit.

Place the surface block underneath the tool and on top of the tabletop or at the required maximum depth.


Press **Z-axis Jog Arrows** to lower the spindle until the end of the tool is just above the surface block.



Press and hold **Zero** to begin the Maximum Depth routine. This will cause the Z-axis to move down slowly until the tool comes in contact with the surface block and then move up above the surface block to the Tool Lift Height.

Remove the grounding magnet and surface block before beginning work.



8. Adjust Maximum Depth (as needed)

Press **Shift**  and **Set Max Depth** .

Press **Cancel**  to clear the current maximum depth without having to reboot the machine or press

Z-axis Jog Arrows   to adjust maximum depth in one-thousandth increments (e.g., 0.001).


A positive value will increase the range of maximum depth, and a negative value will decrease the range of maximum depth.



Press **Enter**  to accept or **Cancel**  to abort.


9. Turn on Mister or Dust Collection Vacuum



Make sure the manual switch on the mister is switched to the ON position if applicable.

10. DNC

Press **DNC** . The keypad will display a list of job folders and job files, which are located in the C:\Dncfiles directory.


Press **X-axis Jog Arrows**   until the appropriate folder is highlighted in blue.


Press **Enter**  to display the DNC files that are available in that particular folder.


Press **X-axis Jog Arrows**   until the appropriate file is highlighted in blue.

Press **Start**  to begin the file.

11. Start / Cancel / Pause

Press **Start**  to begin the cutting sequence.

Press **Cancel**  to abort the cutting sequence.

Press **Pause**  to yield the cutting sequence.

Operators should never leave the machine unattended during the cutting sequence.