

F-04: Set Up Machine

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.

EQUIPMENT

- Rotary Index Head, or required holding device
- edge finder indicator, a wiggler (center point), or a dial indicator
- basic Toolmaker measuring devices

RESOURCES

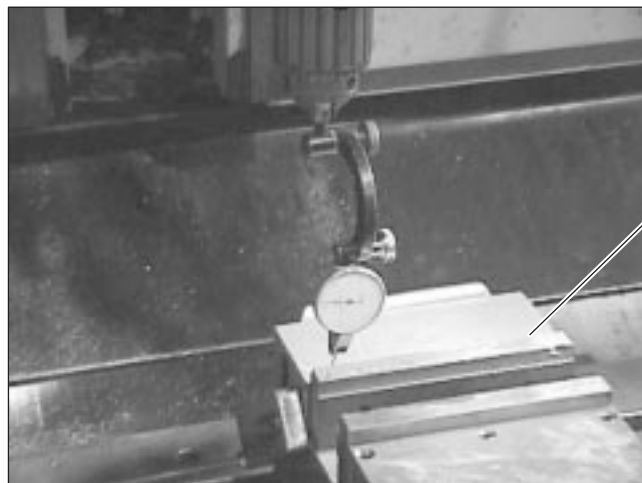
- job process sheet
- print

Set Up Machine

1. Determine piece requirements.

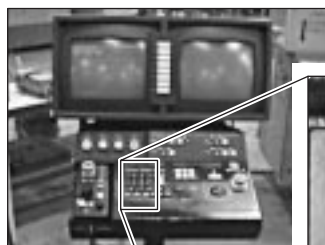
- Read the print and check the job process sheet to determine the piece requirements.

2. Install the required holding devices.



- Install an indicator and verify the holding device is square with the machine.

3. Secure the piece in the holding device.
4. Select the tooling as determined from the print and process sheet.
5. Enter the tool parameters.
 - Press the <Input> key from the Program Entry keypads.



Press Input to Begin Programming

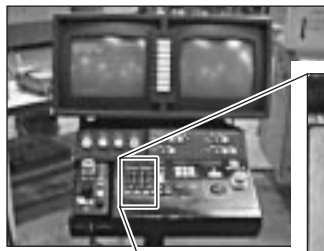


- Press the <F2> key to select Tool Setup.



Function Keys
Correspond to
Options on Screen

- Press the right and left arrow keys to select the tool number.

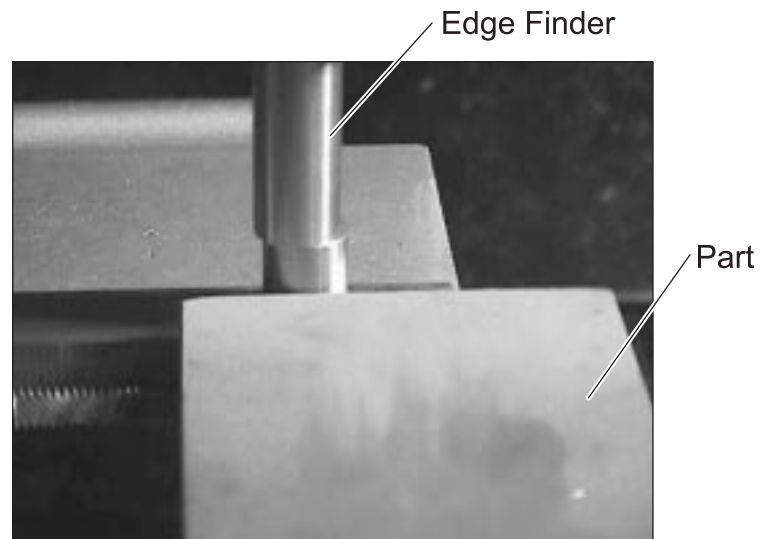


Press to Scroll
Through
Tool Numbers

- Enter the tool diameter, rpm, cutter direction, and coolant, if required.
6. **Set the Z axis zero for the cutter, as determined from the print.**
 7. **Press the Program Entry <Input> key.**
 8. **Press the <F1> key for Part Setup.**

9. Establish the part X axis zero.

- Install a measuring device such as an edge finder indicator, a wiggler (center point), or a dial indicator to locate the X zero.



- Type zero (0) when X is established.

10. Establish the part Y axis zero.

- Follow the procedure in step 9 to locate the Y axis for the part.