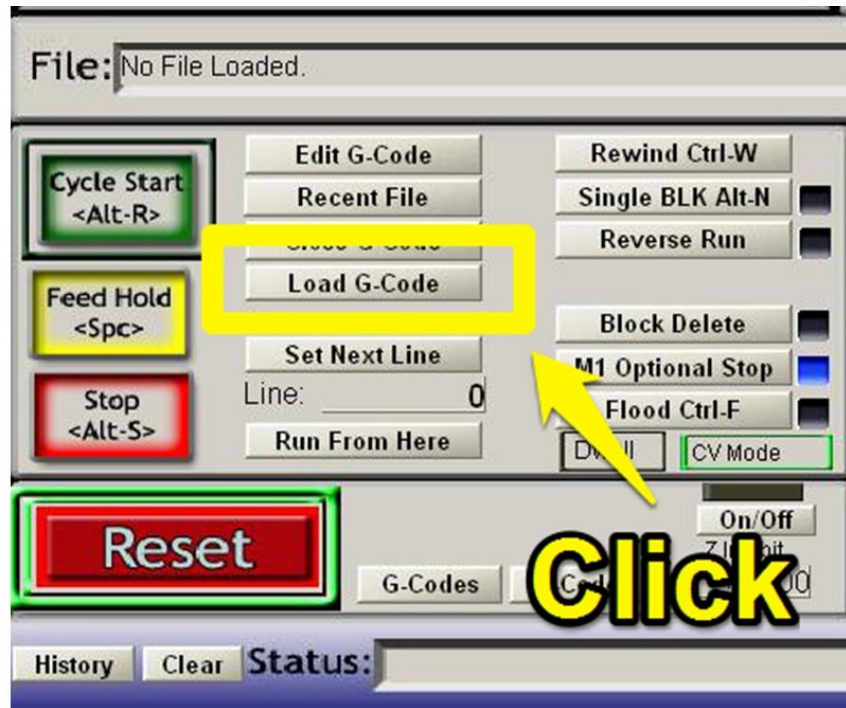
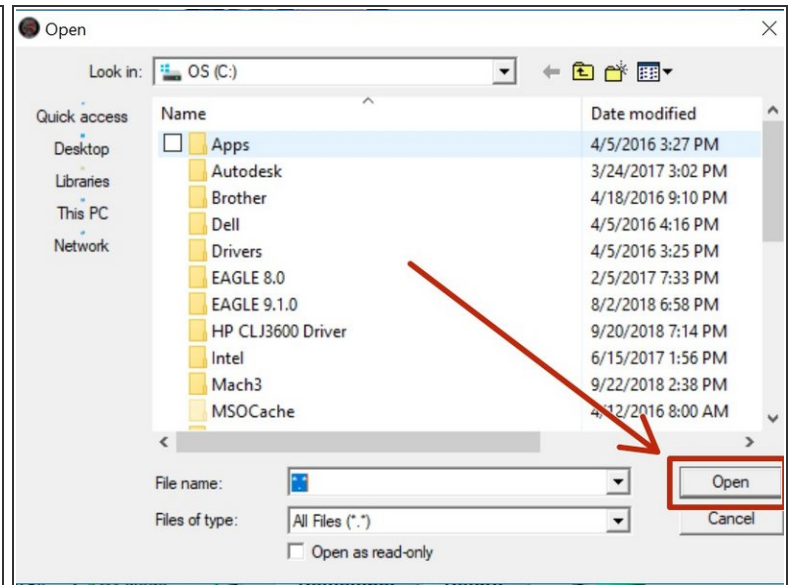
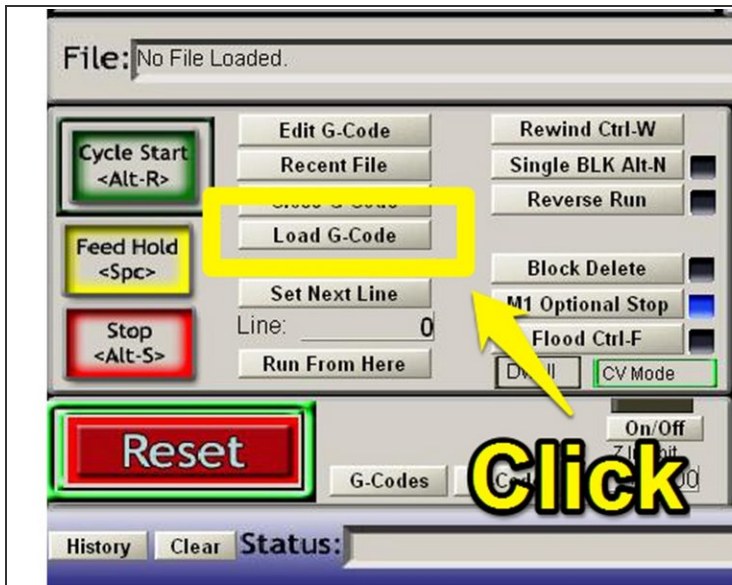


## 04 - Running a Job

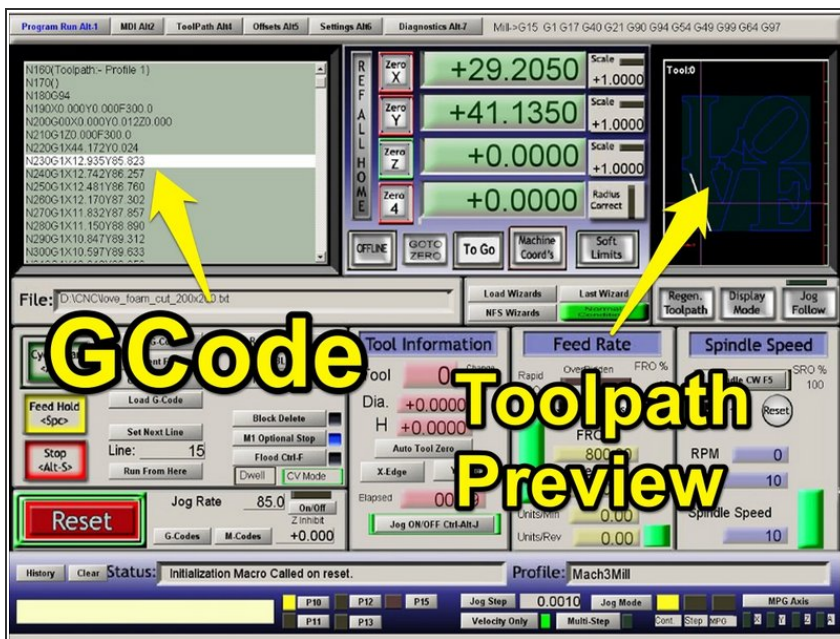


## Step 1 — Load GCode File



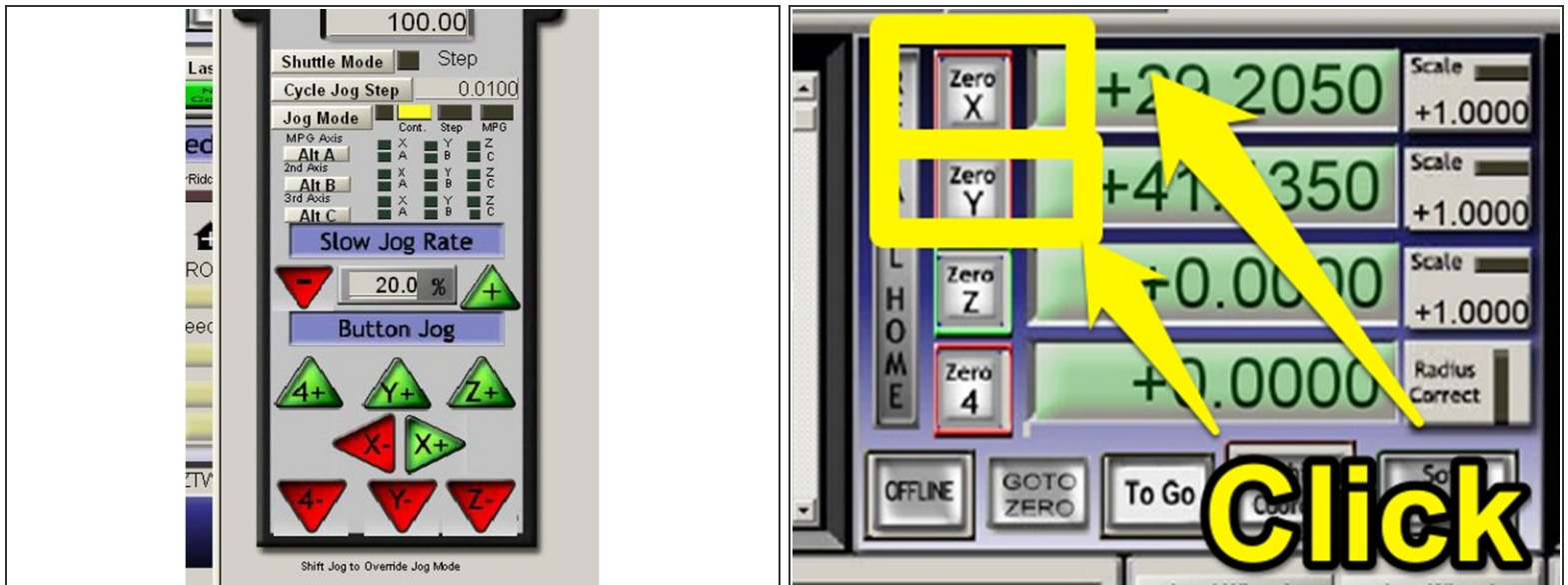
- Click "Load GCode"
- Locate your Gcode / TAP file and click Open

## Step 2 — Preview GCode



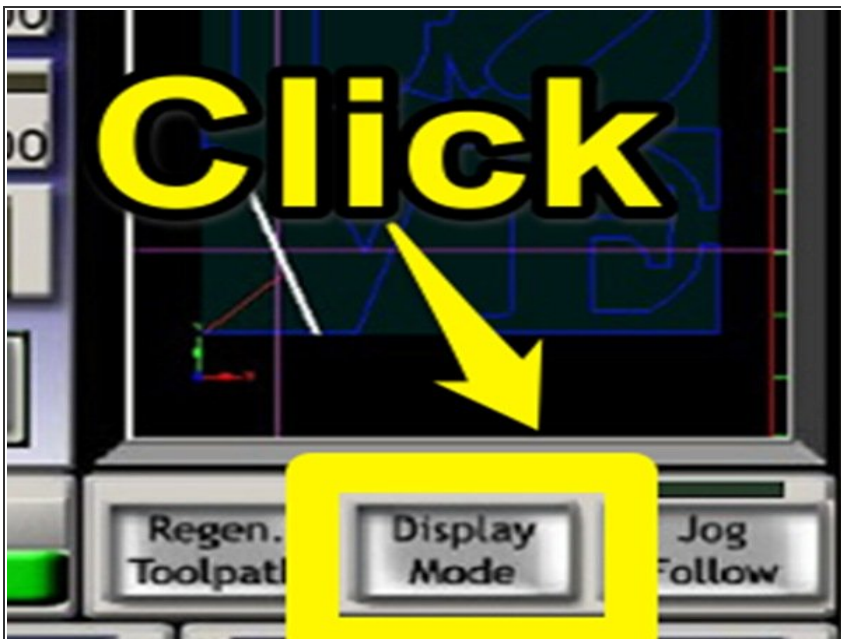
- Verify that your GCode has loaded and the preview looks correct.
- ❗ You may need to double-click in the tool path preview to regenerate the display after loading your gcode.

### Step 3 — Zero X and Y



- Using the JOG controls, move the machine over the desired origin position you choose during the CAM process.
- Once the machine is positioned correctly over your X-Y origin, click the X and Y axis buttons to zero the axis.

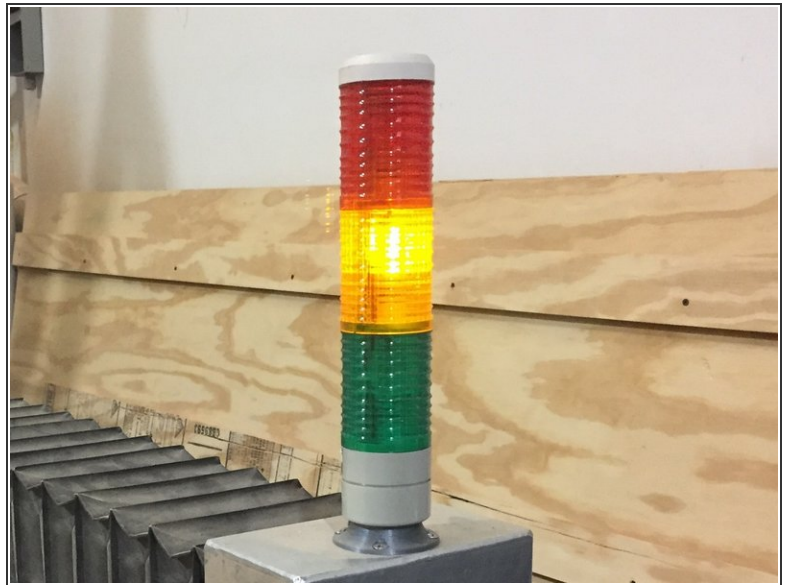
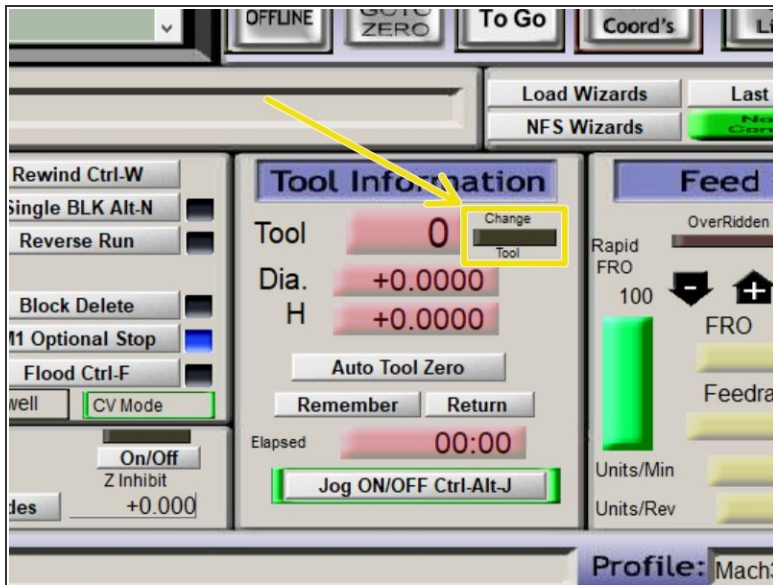
### Step 4 — Inspect Toolpath



- Click "Display Mode" under the toolpath preview window until the display shows the outline of the machine along with the toolpath.
- The crosshair indicates the current position of the tool bit in relation to the toolpath.
- ⓘ You may have to click "Regen Toolpath" after zeroing to update the display.
- ⚠ Make sure the toolpath and its orientation to the machine and material affixed to the bed all seem reasonable before continuing.



## Step 5 — Preparing to Run



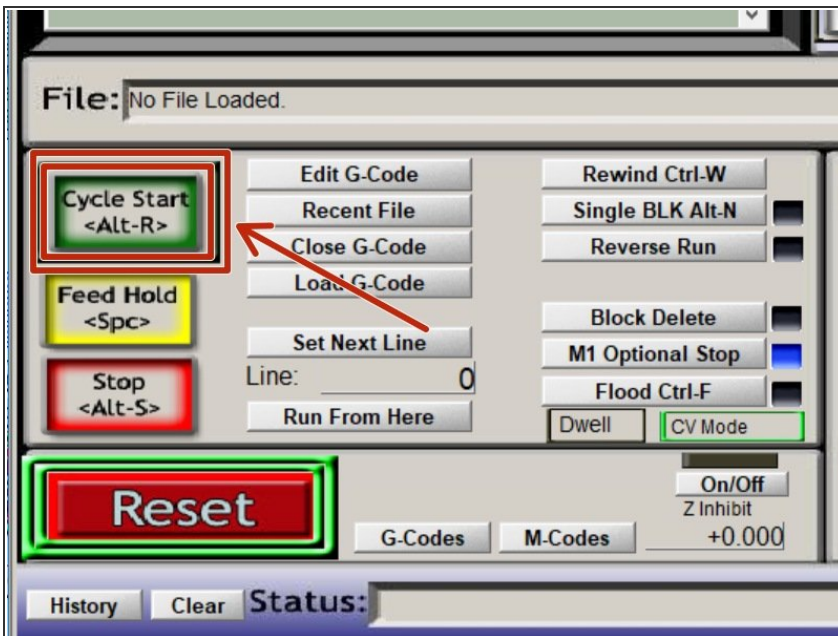
- Follow guide [03 - Changing Tools](#) to install the first bit used in your program.
- As your program runs, when your program indicates a tool change is required the "CHANGE TOOL" LED on the Tool Information panel will blink and the program execution will pause.
- Follow [03 - Changing Tools](#) to change to the next tool in your program. The tool number will be indicated in the "Tool Information" panel.
- Once you complete the changing tools SOP, the spindle should be armed and the Yellow light on the light stalk should be illuminated.

## Step 6 — Turn on dust collector



- When you are ready to run your job, turn on the dust collection system.
- Ensure that the blast gate for the spindle in use is pulled OPEN and all other un-used gates are pushed CLOSED.

## Step 7 — Run your program



- Click "CYCLE START" to start your program running.
- *i* The "CHANGE TOOL" LED will likely illuminate.
- If you have already loaded your first tool, click "CYCLE START" to continue.
- If you have not loaded your first tool, now would be a good time.