

Hermle C22 Standard Operating Procedure (SOP)

Do not use the machine if there is a part inside! Ask the PIT crew about the machine status.

Starting the machine:

1. Check the coolant level, empty the waste tray, and perform a visual inspection of the machine
2. Turn both Potentiometers to 0%
3. Start the machine
4. Check A and C axis for rotation, check for 3D-rotation
5. "Home" the mill by verifying the A- and C-axes are set to L A0 C0 M91 F2500. If they are not, set them to these positions by using the potentiometers
6. Reset the A/C display and 3D rotation to zero
7. Verify Preset is set to #0
8. Run warm-up program

Working with the machine:

1. Always double check your presets, potentiometers and axis rotation
2. Manually probe your preset before starting a post-processed job
3. If you need to pause your job, hit the e-stop and turn both potentiometers to 0%
4. When resuming your job, check again for preset, axis rotation and machine status

Shutting down the machine:

1. Clean the cabin and remove fixtures if needed (always remove at the end of the workweek)
2. Change the Preset to 0, move axis to A/C=0 M91, reset A/C-axis to zero, reset 3D-rotation.
3. Put the tool back into the magazine. Manually move the machine to "park" position, and let all coolant drop from the trunnion
4. Turn down both potentiometers to 0%.
5. Initiate restart or shut down the machine (weekends)
6. Remove all tools, stock material and so on, from the tool cart/control console/surrounding area and store away.

Whenever it is needed, clean the waste tray!