V CNC Router	
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Introduction	
The information contained in this SOP is general in nature. It is advised that operators are referred to the relevant manufacturer's manual for specific operating information.	
A CNC router is a computer controlled shaping machine used for cutting various hard materials, such as wood, composites, aluminum, acrylics, wax, plastics, and foams. It is one of many kinds of tools that have CNC variants. A CNC router is	



very similar in concept to a CNC milling machine.

As with CNC milling machines, CNC routers can be controlled directly by manual programming, and CAD/CAM opens up wider possibilities for contouring, speeding up the programming process and in some cases creating programs whose manual programming would be, if not truly impossible, certainly commercially impractical.

CNC router operators often have two software applications—one program to make designs (CAD) and another to translate those designs into a 'G-Code' program of instructions for the machine (CAM).



Denford Router 2600 Pro video demo >>>

The Denford Router 2600 Pro is a full three axes CNC router with a large work area, allowing machining of materials approaching 600 x 400mm in size. Together with rapid traverse rates of up to 5000 mm/min this router is the ideal partner for intensive 3D applications, such as the F1 in Schools Formula One Technology Challenge.

A CNC router can be used in the production of many different items, such as door carvings, interior and exterior decorations, wood panels, sign boards, wooden frames, moldings, musical instruments, furniture, and so on. In addition, the CNC router helps in the thermoforming of plastics by automating the trimming process.

# **Identified Risks and Hazards**

Hazards that may arise when operating a CNC router include:

- inhalation of dust from the machining process
- burns from hot materials or cutting tools
- exposure to the laser beam (if fitted)
- electrocution from power faults, faulty equipment or incorrect use

Failure to fit and enable a suitable dust extraction system when machining known hazardous materials, and failure to adhere to the material safety data sheets, could lead to the following health problems which are among the potential effects associated with exposure to certain dust particles:

- Skin disorders
- Obstruction to the nose

Safe Operating Procedures

- Rhinitis
- Asthma
- Nasal cancer



### **General Workshop Hazard Control**

All workplace hazards can be controlled to a certain degree using a variety of methods. The goal of controlling hazards is to prevent workers from being exposed to occupational hazards. Some methods of hazard control are more efficient than others, but a combination of methods usually provides a safer workplace than relying on only one method.

There are five general categories of control measures:

- elimination (removal or exclusion)
- **substitution** (replacement or exchange)
- engineering controls (isolation or enclosure)
- administrative controls (organisation or management)
- personal protective equipment (least effective)

The following control measures should be included as part of the Safe Operating Procedures at your workplace.



# **Personal Protective Equipment**



When used jointly with the machine in a machining environment, the combined sound levels emitted may require that Personal Protection Equipment, such as ear muffs, be used. Other factors, such as high ambient noise levels and nearby machinery and equipment can also increase the sound levels.

# **Pre-operational Safety**

The following safety checks and precautions should be carried out when preparing to set up and use the CNC router:

· Electrical equipment must be isolated from the main electricity supply

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when not in use.

- The operator should seek permission from the supervisor before using this equipment.
- Always check that the CNC router is in good working order.
- Check all settings carefully before commencing any CNC router operation.
- Load and position the material on the table.
- Check that any external exhaust system is turned on.
- Ensure the access door is closed before starting the CNC router.
- The work area should be clean and free of equipment, rubbish and other obstacles.
- Ensure you have had instruction and training in the use the equipment.



#### **Operating Safety**

The benchtop CNC Router is designed for machining hard and soft woods, certain ceramics, plastics and non-ferrous metals. In each case, the appropriate tooling, speeds and feeds should be used as recommended by the material supplier. Always use the machine coupled to a dust extraction system. Benchtop CNC Routers ordinarily are not intended for use with ferrous metals. eg mild steel

Do not remove the router head and attempt to use it independently of the machine.

Do not machine any toxic, radio-active or volatile materials.

Use of the machine for any purpose other than those for which it is designed may result in injury, and may also invalidate the warranty.

The CNC Router should only be used under constant supervision, to help guard against, and respond to, any unforeseen hazard such as fire or explosion.

First aid and firefighting equipment (CO2 Extinguisher) should be located nearby in a clearly signed and prominent position.



A circular, red emergency stop button is located on the front panel of the CNC Router. When pressed, it has the effect of stopping all axes and spindle movements immediately.

The guard interlock switch will also close. When the safety guard door is in its closed position, this will prevent access to the working area of the CNC machine.

To activate an emergency stop, press the button in until it clicks. The emergency stop button will continue to cut all power to the machine drives and continue to keep the interlock switch closed, until the release sequence is performed. To release a closed emergency stop button, push in and turn the button clockwise until it

springs back out.

After releasing an emergency stop, you may need to reset any CNC control software messages and home the CNC machines axes. Check the emergency stop button is released before attempting to power up the CNC Router.

An interlock guard switch is fitted to the front machine door. A closed safety guard

door cannot be opened when:

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- The machine is switched off (ie, not in use). To release the interlock guard switch, supply power to the machine.
- The emergency stop button is fully pressed in. To release the lock, push in and turn the emergency stop button counter-clockwise until it
- springs back out to its ready position.
- Machining is taking place. The interlock guard switch will release when
- the machining operations have been completed and the machine controlling software is operating in Jog Mode.

If cutting known hazardous materials, the machine must be used with a suitable dust extraction system fitted and enabled. The CNC Router is designed to run with a dust extraction system, used to remove any potentially harmful airborne dust particles from within the working area of the machine.

Have a 'material safety data sheet' on hand and follow the recommended precautions. Be aware that certain hardwood and other material dust particles, such as oak and MDF, could contain known carcinogens.

Dust particles that remain inside the working area of the CNC Router after a part has been machined, should be removed using a vacuum cleaner. Never use a compressed airline for this purpose.

Dust particles on the floor can cause slipping. This should be monitored by the operator and cleaned away before becoming a hazard.

It is not advised to manually lift this type of machine, however if no other suitable alternatives are available, the machine only could be lifted by at least 4 people, one at each corner.

Do not place any objects so that they interfere with the guards or the operation of the machine. Always secure the work on the table or in a fixture or vice.

Observe caution when handling machine tooling, particularly with regard to hot and/or sharp cutters. Consider wearing protective gloves when handling cutters.

If laser scanner is fitted to the CNC Router, do not stare directly into laser beam. Eye damage can occur.

Visually check door and window for signs of cracks or chips. Any damage should be reported immediately to your supervisor and a suitable replacement obtained without delay.

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#### Maintenance

Always make sure that the CNC Router is powered off and is unplugged before performing any cleaning or maintenance procedure. Depending on ancillary equipment supplied with the machine there may be more than one power supply to the machine. Post a notice informing others not to use the machine since it is undergoing maintenance.

Hazardous voltages can still exist immediately after switching the machine off. Always wait at least 5 minutes before accessing the CNC Router electronics.

Never try to clean the CNC Router if any part of it is rotating or in motion.

Observe caution when cleaning down the machine, particularly with regard to hot and/or sharp cutters. Consider wearing protective gloves.

Vacuum all loose debris from the inside of the CNC Router. Extra care must be exercised when changing from machining MDF, hardwood, foam etc. to machining metal, to avoid any risk of fire or explosion from ignition of dust particles by hot metal chips. Also after machining metal, thoroughly clean areas

around leadscrews and guide rails to minimise risk of contamination from chips.

The frequency of cleaning will depend entirely on the type of material being processed, the performance of your exhaust system, the operating environment, and the amount of CNC Router system usage.

When emptying the dust extraction system or cleaning down the machine, wear suitable respiratory protective equipment such as a dust mask. Other personal protective equipment, such as eye protection, overalls and gloves should also be considered.

Occasionally cleaning the grill of the cooling fan with a soft brush or vacuum (never use compressed air) and removing any objects blocking the air ways.

Using a soft bristled brush, carefully clean dust and debris away from the microswitches, to an area where it can be removed using a vacuum cleaner.

Use only the appropriate chemical to clean specific parts of the system otherwise cosmetic or operational damage may occur. Pay strict attention to the cleaning procedures outlined in the user manual. When using any chemical, be sure to follow the safe handling procedure printed on its label.

## **Isolating and Lockout Switches**

Electrically operated machines should be fitted with a flush green on or start switch and a red stop switch that has a raised mushroom shaped head for fast emergency contact.

As well as start and stop switches, all machines must have an **isolating switch**, which enables the main power supply to be switched off when the machine is being set up, adjusted or when maintenance is being carried out.



### Safe Work Zones

The following Safe Work Zones for this machine are derived from a state government education authority guide. <u>Click here for a description</u> of the zone requirements described in this diagram.



### **Operating Procedures**

Always obtain permission from the supervisor before using the CNC Router.

Check the following clothing for safety hazards and take appropriate action:

- Fasten any loose clothing and tie apron cords or straps at the back
- Remove any jacket or coat and any school uniform tie
- Roll up shirt sleeves above the elbows or fasten them securely at the wrists
- Wear appropriate Personal Protective Equipment such as dust mask.

The CNC Router should only be used in a supervised location and under the direct supervision of teaching or support staff. In general, supervision should only be undertaken by teaching and support staff who are fully conversant with the machine safety, and any relevant risk assessments.

The CNC Router is to be situated in a well ventilated room. If the CNC Router is supplied for bench mounting it should be sited on a bench of sturdy construction to take the weight of the machine and of a height which enables comfortable operating and programming to take place.

The operator will operate the CNC Router when standing at its front, with a clear view of both the machine working area (through the transparent guard window) and the personal computer being used as the controller unit.

Sufficient room should also be provided for effective maintenance to be carried out around the machine itself. Do not place the machine in a position which allows any of the cabinet vents to be covered. Positioning the PC on a movable workstation may allow easier access to the various vents, connectors and switches on the machine cabinet, when required.

All cables, pipes and flexes are to be positioned to avoid the possibility of users tripping over them.

With every daily start, ALWAYS PREHEAT THE SPINDLE MOTOR following the indicated times:

- 2 minutes at 50% of the max. speed
- 2 minutes at 80% of the max. speed
- 1 minute at 100% of the max. speed

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