Tool Change

Tool Change

Changing of tool is an operation only to be carried out by a Level 2 certified user or the Fabrication Lab Supervisor.

- Move router to over bed (this is so if the bit drops it doesn't hit the ground)
- Pair the right sized collet for the cutting Tool you have selected
- Blow collet out clean with compressed air
- Blow Collet nut out clean with compressed air and inspect (clean collet nut with steel wool if required).
- Inspect Clamping nut surfaces on the Spindle (clean with steel wool if required and blow out clean with compressed air)
- Fit collet in Collet nut with an audible *click*

Tool Change Continued

- Hand tighten collet nut (and collet) onto spindle - *take care not to cross thread*
- Place Bit into clamping hole of collet and hand tighten until collet begins to grip bit.
- Adjust bit so that approx 5mm of bit shank is exposed below collet (ensuring swarf will clear flutes of bit without feeding up into collet.
- Tighten Collet nut using Collet nut Spanner and Spindle Spanner. **Note** not too tight.

  To Tighten - Squeeze the Tools together.

- On CNC Control Console go to TAB 6 and select appropriate tool for the job

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LINKS

[CNC Router Operations](#)

[Other Operations - Staff Only](#)

[Multicam CNC Induction](#)