

Cutout

- [Doweler Instruction Procedures](#)
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Doweler Instruction Procedures

Powering on Machine

IMAGE1.jpg

1. Turn switch located on the bottom left.

IMG_0012.jpg

2. Press "Control Power" button (see *image 2*)

3. Enter Password "Weeke"

Image 3.jpg

4. Click "Production"

Image 4.jpg

5. Click "Automatic" icon located at the bottom of the screen

Image 5.jpg

6. Click “Start/Stop” icon located at the bottom of the screen

Have the employee run through the steps while your explaining to help better understand where exactly everything is.

Set up Pathways

Image 6.jpg

1. Click Select icon located in the bottom toolbar

Image 7.jpg

2. Open path "HMI_DATA(D:)"

Image 8.jpg

3. Open folder "ww4"

Image 9.jpg

4. Open folder "a1"

Image 10.jpg

5. Open folder “mp4”

Image 11.jpgImage 12.jpg

6. Select “37mm front dowel folder” and/or “small lock dowel drawer folder”

7. Dowel parts will have dowels in all drilled holes

8. Standard parts will have a dowel in the front drilled hole and all other holes will be pre-drilled for screws

9. Find the file that matches the part label

10. Open file by double clicking

11. Verify the file opened matches the production label on the production part

Be sure to show the employee were to find the information that will be needed to ensure the right file is selected and if other steps are needed.

Running parts through Doweler

1. Match file selected with part label

2. Adjust clamps if needed

[Image 14.jpg](#)

3. Place the front edge of the part against the fence with the cabinet interior up

[Image 15.jpg](#)

4. Push part forward slowly till it stops

[Image 16.jpg](#)

5. Step on the foot pedal according to the side you are on

6. Repeat till work cart is complete

7. When the cart is complete take it to the next department. Wood finish parts without dowels to go to the paint bay

Explain to the employee that it is very important for to verify the label on every part ensuring the right file is selected before running each part. If part is a face 6, that part need to go through the BHX first.

End of Day Power Down

1. Use the air compressor to blow off the outside for the machine only. (do not use compressor under the hood)

[Image 17.jpg](#)

2. Click the "Back" icon located on the bottom right hand of the computer screen

[Image 18.jpg](#)

3. Click "MDR" icon

Image 19.jpg

4. Click the oil can and gear icon

Image 20.jpg

5. Check the maintenance report for any weekly maintenance needed

(check with supervisor before doing any maintenance)

Image 20.jpg

6. If maintenance is required and/or completed click the windows icon at the lower left of the computer screen

7. Click “Shutdown” and wait for the computer to power off

Image 22.jpg

8. Turn power switch off (see *image 22*)

CNC Instruction Procedure

Starting and Resurfacing

The CNC table should be resurfaced at the beginning of each shift.

[Image 1.jpg](#)

1. To start the machine simply turn the switch to the on position

[Image 2.jpg](#)

2. Click the "F11" icon located at the bottom right of the screen

Image 3.jpg

3. Click the "**Assignment**" icon located at the bottom of the screen

Image 4.jpg

4. Click the "**Select**" icon located at the top right of the screen

Image 5.jpg

5. Click the "**Parent Directory**" up arrow to go back to the beginning

Image 6.jpg

6. Open the "**Weeke (D:)**" drive

Image 7.jpg

7. Open the "ww4" folder

Image 8.jpg

8. Open the "a1" folder

Image 9.jpg

9. Open the "mp4" folder

Image 10.jpg

10. Click the "____**spoil.mpr**" file

Image 11.jpg

11. When the file loads click the "Accept" icon located at top right of the screen

Image 12.jpg

12. Click the "Softkeys" icon located at bottom left of the screen

Image 13.jpg

13. Click both the Push off icons and the Front fence icon to turn them off

Image 14.jpg

14. Step on the foot pedal located under the CNC table

Image 15.jpg

15. Click the left Resurfacing icon and the right icon will turn yellow

This icon is only clicked when resurfacing the table. Do not click icon for any other reason!

Image 16.jpg

16. Press the "Cycle Start" button