

# 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*)**

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