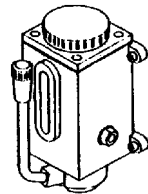


MILLMASTER STARTUP/SHUTDOWN INSTRUCTIONS

Startup Instructions

1. Obtain from the shop manager the key to the lock on the machine's On/Off switch.
2. Check the oil level in the following reservoirs and refill if necessary:

Hand pump reservoir below the table on the left side.
(Refill with Vactra oil No. 2 Way Oil; ISO VG 68.)



Air line lubricator on pneumatic tool changer. Air pressure must be off and pressure released. Unscrew the bowl, fill to below maximum mark and screw bowl back into lubricator head.
(Refill with Air lube 10W/NR oil.)



3. Turn on the air-line ball valve near the ceiling. (Rotate the green handle upward to a vertical position.)
4. Ensure that the protruding handles on the table hand wheels are folded in. (Pull and fold, if necessary.)
5. Lower the table so that the bottom of the spindle clears the highest object on the table. (Use the large silver handle to turn the screw on the upper left side of the knee.)
6. Turn the JOG knob to continuous mode ($\wedge\wedge$).
7. Turn the "FEED $\wedge\wedge$ %" knob to 50.
8. Add SAE 10W (ISO 32) multipurpose machine oil in the spindle oil caps. There are 3 of them, silver in color, around the spindle body, just below the head.

