Load & Go DC/RC Series Pre-installation Checklist

The following list is designed to prepare you for a successful installation and startup.

Being prepared prior to the arrival of the Load & Go installer will help the installation take as few as 4 hours. Minimizing installation time allows for several days of running time, testing, and end-user training. If the pre-installation steps are not completed upon arrival of the AWR service tech, an additional $4,000 installation charge will occur and the install will be rescheduled.

CNC Compatibility:

HAAS

	Complete
8 Spare M Functions	
#33-0404 M-Fin wiring harness	
#25-10626 Left hand switch bracket, 1 piece	
#25-10627 Right hand switch bracket, 1 piece	
#25-10636 Nut plate holding bracket to coolant collector, 2 pieces	
#25-10637 Nut plate to hold proximity sensor to bracket, 2 pieces	
#32-2250A (proximity sensors), 2 pieces	

OKUMA

	Complete
Robot interface Ethernet Internet Protocol option operational, Anybus X EIP	

OTHERS

CNC integration is possible with many brands, including Hardinge, Doosan, Mazak, and DMG Mori.
Please contact us at info@automationwithinreach.com

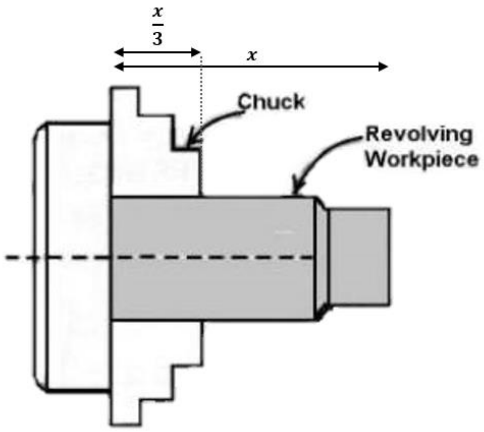
CNC Machine Tool Related:

	Complete
Automatic Door	
Chuck air blow operational and hard plumbed in the CNC	
Spindle orientation - electric (usually standard)	
Machine Home Position setup with turret in corner of workspace	

Load & Go Related:

	Complete
240VAC / 20A / 60HZ / 3PHASE dedicated power	
80~100 PSI air pressure at 1 cfm^3	
Ethernet drop (CAT 5/6) to Load & Go for Ewon remote support. (Guest network is acceptable).	
Ethernet drop tested with Ewon Connection Checker. (Provided separately by AWR).	
Proper anchoring conditions with >6” deep concrete.	
Communicate any customer preferences on Load & Go placement. Verify if a filler panel is needed.	
Customer has parts available to run and test during installation	

Cutting Process Related:

	Complete
At least one (preferably several) cutting program(s) written and proven (machine goes to Home at end of program).	
Workholding has a hard stop for robot to load against.	
Workholding has approximately 0.030" minimum load clearance and appropriate 0.030" plus a bullet-nose lead-in radius.	
Tool life management is setup and operational for all cutting tools.	
Cutting tool life is predictable and broken or chipped tools either do not happen or happen rarely.	
Chips from cutting process do not build up on workholding or cutting tools.	
Coolant wash and blow off M-Codes are programmed into the cutting process to ensure part is free of chips at completion of cycle.	
Chuck air blow-off is programmed into the cutting process to ensure part is relatively free of coolant at the completion of the cycle.	
Verify machine is actually cutting good parts and ready to run full auto with robot	
The ratio of the workpiece length in the chuck to total workpiece length should be at least 1:3. 	

Updated 01/12/2021

Signature:_____ Date: _____