






















CNC MILL TROUBLESHOOTING

PROBLEM/ISSUE	TROUBLESHOOTING STEPS
Machine won't turn on	 Did you turn on the main breaker?  Are you pressing the cycle start instead of power on?
Program won't load	 Check (file type, percent signs (top and bottom of the program), and correct O number for program number.)  Is your program in a subfolder on your USB drive?
Error - bad code	 Make sure that your code is G01 (number 0) not GO1 (letter O).  Check other number and letter assignments in each code to make sure they are correct.  Check G01, G02, and G03 to make sure you are doing the correct motion (either line or arc).
Machine motion stops for "no reason"	 Check your feed rate. F3 is not the same as F3.0.
Spindle is too fast or slow	 Do you have the correct spindle speed? If you have the incorrect speed, did you adjust to the correct speed?
Bad surface finish or chatter	 Is your tool hanging out more than it should be?  Is your tool sharp? If your tool is dull, index insert or reshape.  Is your feed rate too fast or too slow? Adjust RPM and/or feed rate.  Is the part clamped correctly in the vise?
Chips are wrong shape/color	 Is your spindle speed too fast? Change RPM to lower speed.  Is your feed rate too fast? Slow down feed rate.  Is the DOC too much? Reduce the depth of the cut.  Is your tool step over set to the correct amount?
Part too big or too small	 Did you have a bad tool touch-off? Retouch-off your tool and check for discrepancies.  Are you using the correct tool diameter offset?  Is the cutter compensation set to the correct side (left or right?)  Are you using the correct tool height offset?  Is the part clamped correctly in the vise?