

Skills USA  
Michigan Automated Manufacturing Competition - 2006

NOTES

- A. Do not begin filling in your notebook before the competition officially starts.
- B. Tooling may not be installed in the machine or tool holders until the competition officially starts.
- C. Work holding devices may not be mounted on the machine until the competition officially starts.
- D. Only two computers may be used at any time. You may have more than two computers as long as the extra computers have their screens covered so it is obvious that they are not being used.
- E. Do not write your name or school name on any document. Identify your team with your team letter that was given to you by SkillsUSA.
- F. If any team has a **catastrophic** equipment failure that is **beyond your control**, your team leader may request that the competition clock be stopped for your individual team. This will allow you time to attempt to make equipment repairs and get your team back in the competition. A judge will make the determination if your request is valid. While your team clock is stopped, **ALL** work must cease on any competition related activity and you should focus your efforts on getting your equipment repaired. When you are satisfied that you have corrected the problem, notify a judge who will re-start your teams clock. The maximum time allowance for this provision will be 60 minutes total for each team.
- G. Individual bathroom or food breaks may be taken at the team's discretion. Only one team member may leave at a time.
- H. Safety glasses must be worn when your CNC machine is running. There will be a 25 point penalty for each violation of this rule. The only (optional) exception is for team members who are actively engaged in using the computer for CAD or CAM purposes. These individuals must be seated and directly facing the computer monitor. If they leave the computer to work on a running CNC machine then they must wear safety glasses.
- I. REMINDER: Turning in your first prototype part and your first production part is a timed event for which you will earn points. Mark the part with your team letter and turn it into a judge as soon as you are satisfied that it is ready. The judge will mark the hand in time on the part.
- J. The prototyping material is RenShape 450. Its cutting specifications are .004" per tooth and 300ft. per minute surface speed. Material chipping will be judged as surface finish errors. Control your speeds and feeds accordingly.