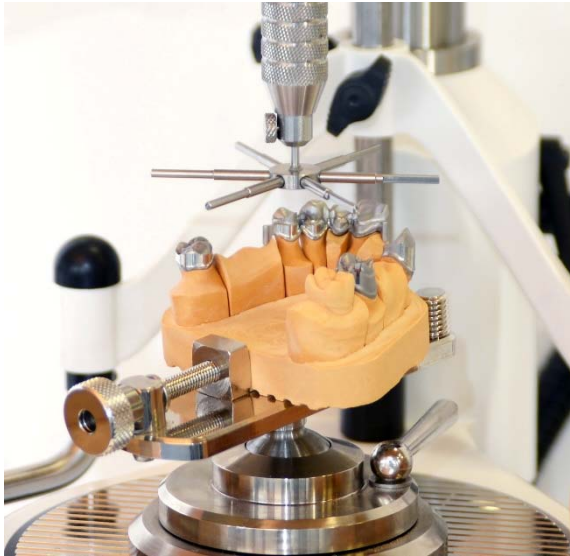


User Manual Transfer Spider

Step 1:

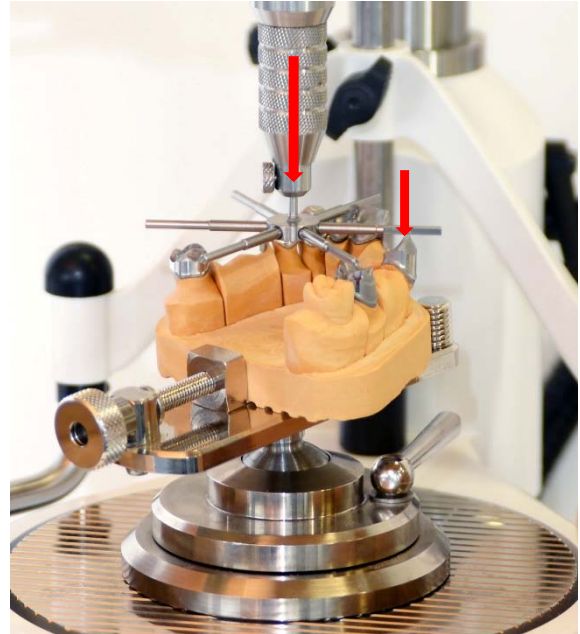
IMPORTANT:

Replace the milling spindle of the milling unit because of safety reasons (starting of the motor accidentally) with the measuring spindle (Art.-No. 2408, 2408/1, 2250 or 2250/1).



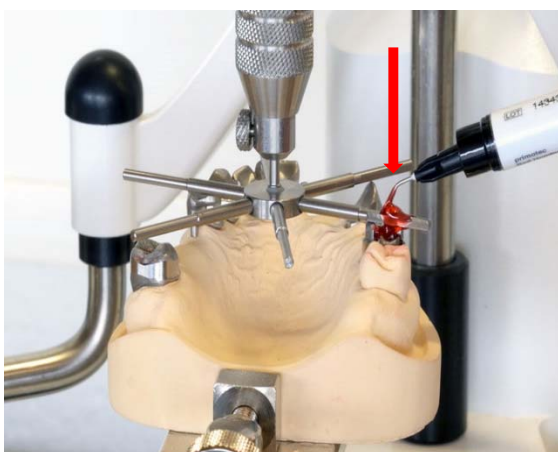
Step 2:

Lower the position of the measuring spindle until it touches the objects.



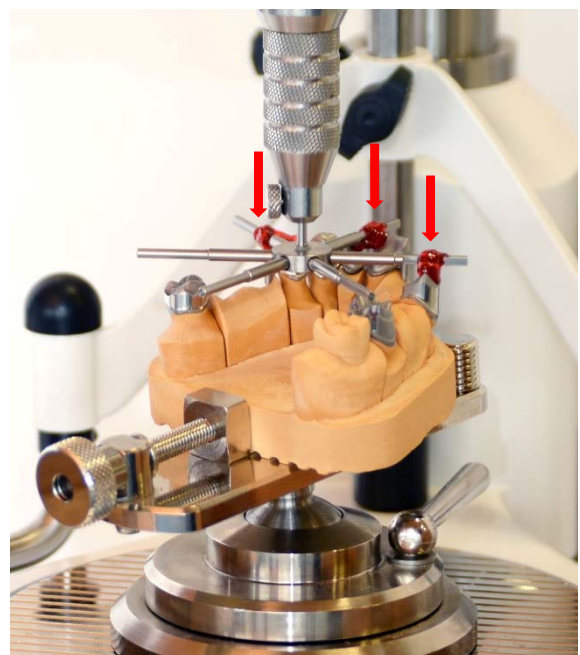
Step 3:

Fixation of the objects with a light curing material.



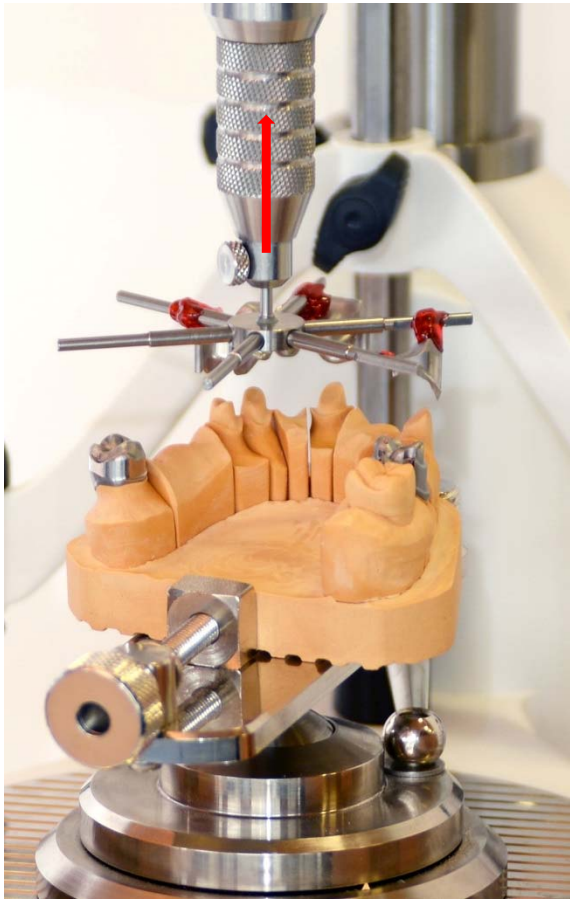
Step 4:

Fixation of all objects.



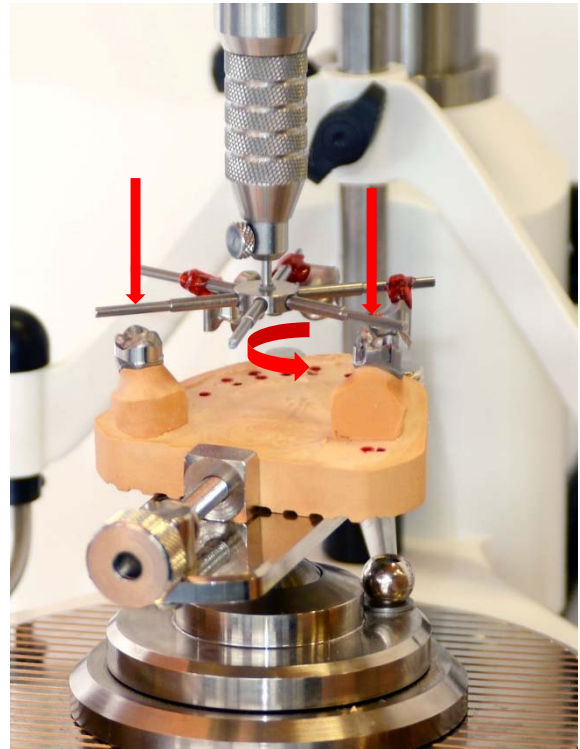
Step 5:

Move the measuring spindle with the fixed objects upwards.



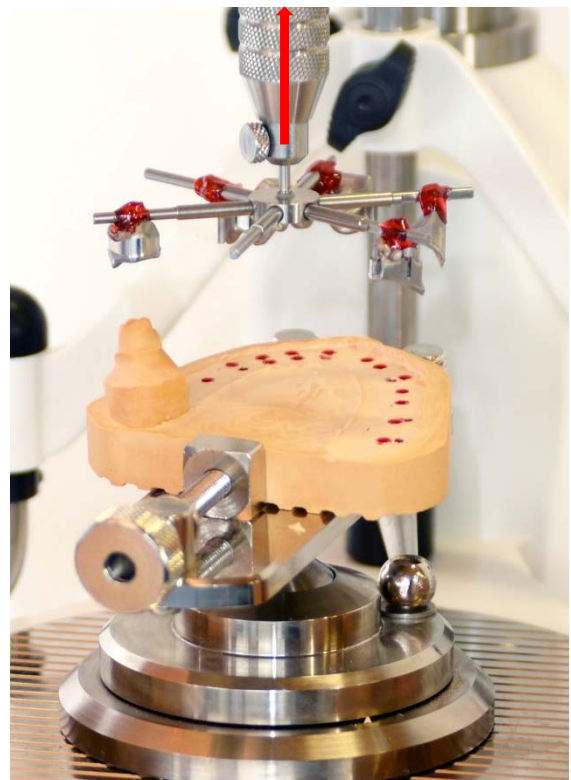
Step 6:

Remove all parts from the model you do not need. Then move the measuring spindle and the transfer spider into position above the non-fixed objects. If needed turn the spider to the left or right to find the best position.



Step 7:

Fix all remaining objects with light curing material, cure it properly and move the measuring spindle upwards.



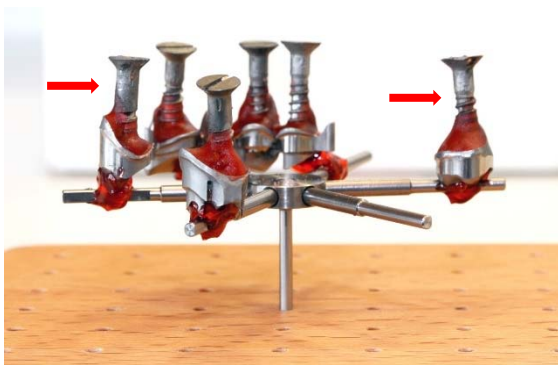
Step 8:

Fix the transfer spider in reverse position as shown in the picture. Fix some screws with light curing material inside the objects (as shown in the picture), cure it properly and fix the transfer spider back again in the measuring spindle.

Hint:

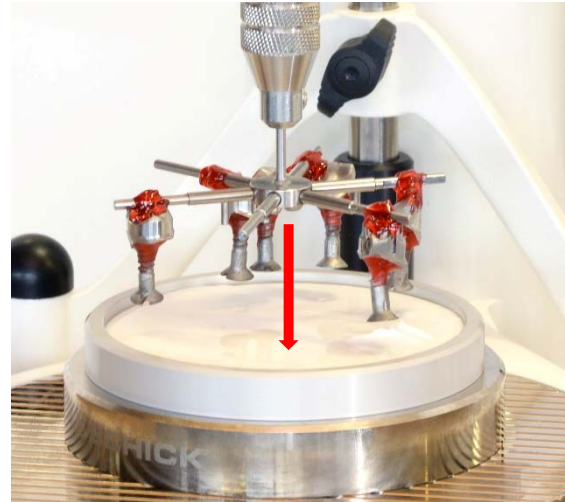
It is highly recommended to block out the inside of the objects with a thin wax layer.

This helps to remove the objects later on.



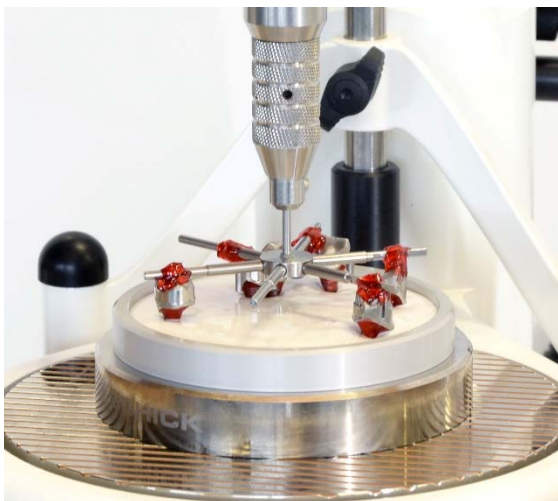
Step 9:

To prepare the milling model you have to place the milling tray (Art.-No. 2507/1) into the holding tray (Art.-No. 2509). Mix some plaster, fill it into the milling tray, lower the measuring spindle with the attached transfer spider into the plaster.



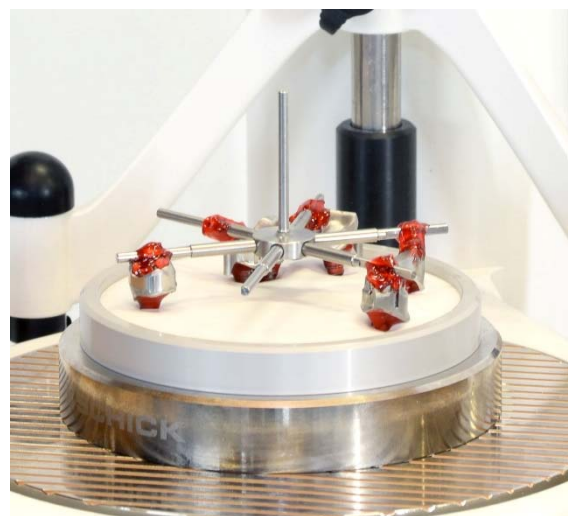
Step 10:

Final position of the transfer spider



Step 11:

Let the plaster dry completely, unloose the screw that is holding the transfer spider in the measuring spindle and move the measuring spindle upwards.



Step 12:

Remove the transfer spider from the objects and remove any remaining material from the surface of the objects.



Step 13:

Milling model ready for milling. All objects are in the same path of insertion, there is enough space for the milling tools, no danger of damaging any nearby objects accidentally, clear and unobstructed view to all objects...

