

User manual

Calibration of the single unit DESS holder for CORiTEC one+/150iPRO

CAM-Software

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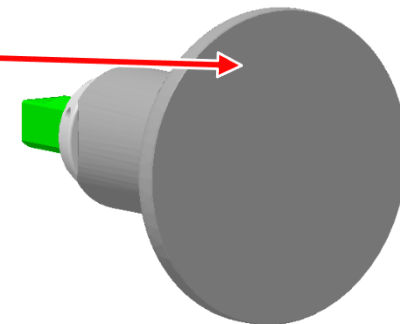
1 General cleanliness and handling

The holder has to be calibrated in the CORiTEC machine before the first use to ensure an optimal positioning of the DESS system. Therefore the following aspects must be considered:

- Cleanliness of the DESS holder and its reception in the machine
 - General cleanliness
 - No damages in the bearing surface
- The machine and its zero-point must be set correctly
- Screw connections
 - The screws should always be tightened in the same order for a reproducible positioning

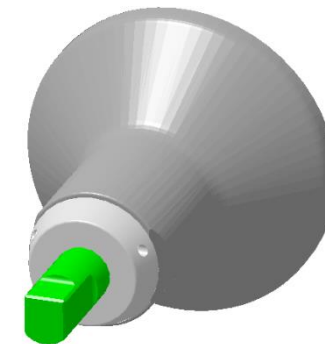
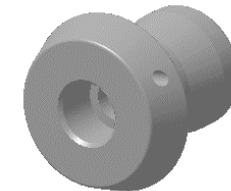
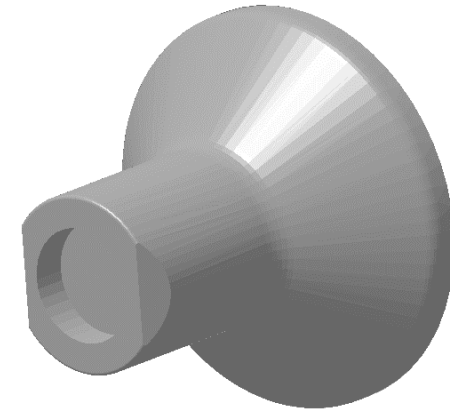


have to
be clean



2 Holder preparation for test milling

- Please follow the directions on general cleanliness and handling!!
- The imes icore® pre holder one is inserted into the clean machine reception and screwed tightly. The 2 screws should be screwed in loosely at first and tightened afterwards. The DESS adapter is then inserted into it and also secured. (It is not necessary to disassemble the holder!)
- The calibration body is inserted into the position hole until the stop and tightly fixed by a clamping screw (please pay attention to the rotation lock).
- The calibration body is milled directly on the machine with the scripted test program. A 2mm metal tool (T2) is required for the milling process.



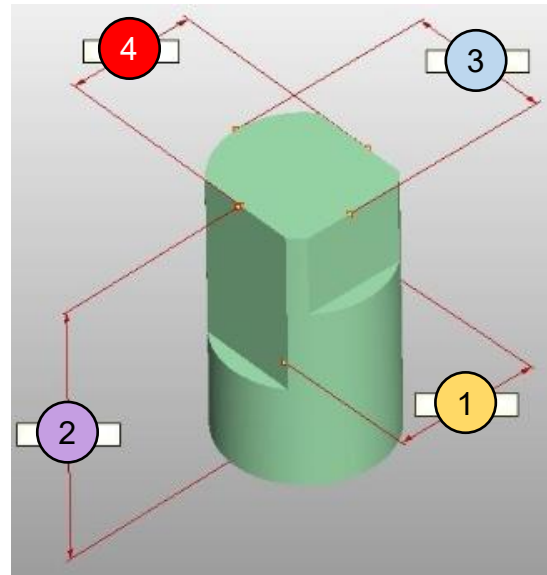
3 Measurement

- The milled calibration body is unscrewed from the holder
- The calibration body has to be clean and free of burrs for measuring



3.1 Measurement

- width (X-axis) 1
- length (Y- axis) 2
- height (Z- axis) 3
- width (X-axis control measurement) 4



customer:

machine type:

SN machine:

Insert your measurements here and send this table to the service for your CAM-software.

1

2

3

4

Ø blank

4 Calculation and data transfer

- Please transfer the completely filled in page 6 to service@imes-icore.de for calculating the offset values.
- Please contact the service of your CAM system to implement the offset data.



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