

# Dental Milling Machine

## Performing Manual Correction

---

---

### CAUTION

Be sure to perform operations as specified by these instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury or burns.

### CAUTION

Be careful around the milling tool.

The milling tool is sharp. Broken milling tools are also dangerous. To avoid injury, exercise caution.

### CAUTION

Do not touch the spindle unit or the surrounding areas immediately after milling has ended.

Doing so may result in burns.

For the latest information regarding this machine (including manuals), see the DGSHAPE Corporation website (<http://www.dgshape.com/>).

# Contents

---

- Contents ..... 2
- Getting Started ..... 3
  - Manual Correction..... 3
  - Perform automatic correction ..... 3
- Required items ..... 4
- How to Perform Manual Correction ..... 5

# Getting Started

## Manual Correction

Use this section to mill material for correction and manually measure the milling results. Then, correct the milling position according to the measured results. This operation is called "manual correction." Performing manual correction may reduce variations in milling accuracy. If you need milling results with higher accuracy, we recommend that you perform manual correction.

## Perform automatic correction

Before performing manual correction, be sure to complete automatic correction. If you perform automatic correction after manual correction, the correction value of manual correction will be initialized.

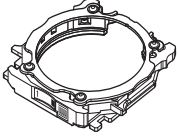
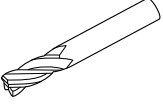

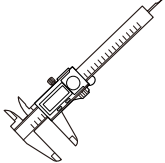
For more information on automatic correction, refer to the User's Manual of the model you are using, available from the following website.

**<https://downloadcenter.rolanddg.com>**



- \* Other manuals are also available to view and download from the website.
- \* You can also view this website from a smartphone.

# Required items

Included items	Items to prepare yourself		
 Adapter *1	 4 mm (0.16 in.) square end mill *2	 Disc workpiece (wax material) *3	 Slide caliper *4

\*1 If using the specified resin, there is no need to change the settings.

\*2 You can also use the ZRB-200D genuine DGSHAPE 4 mm (0.16 in.) radius end mill.

\*3 Prepare a disc workpiece that meets the following specifications.

- Thickness: 14 mm (0.55 in.)

\*4 Prepare a slide caliper that meets the following specifications.

- Measurement range: 0 to 20 mm (0 to 0.79 in.) or more
- Measurement surface dimensions: About 4 mm
- Minimum readable value: 0.01 mm

## Important

**When performing manual correction, give attention to the following two points.**

- Use wax material.

Manual correction has been designed assuming that it will be performed with wax material. You may not obtain correct correction results if you use other material.

- Measure in a short period of time, continuously, and fully.

Wax material is affected by temperature, which makes the dimensions of this material change easily. This can lead to incorrect correction results, so we recommend that you wear gloves when handling this material.

# How to Perform Manual Correction

1 Show VPanel.

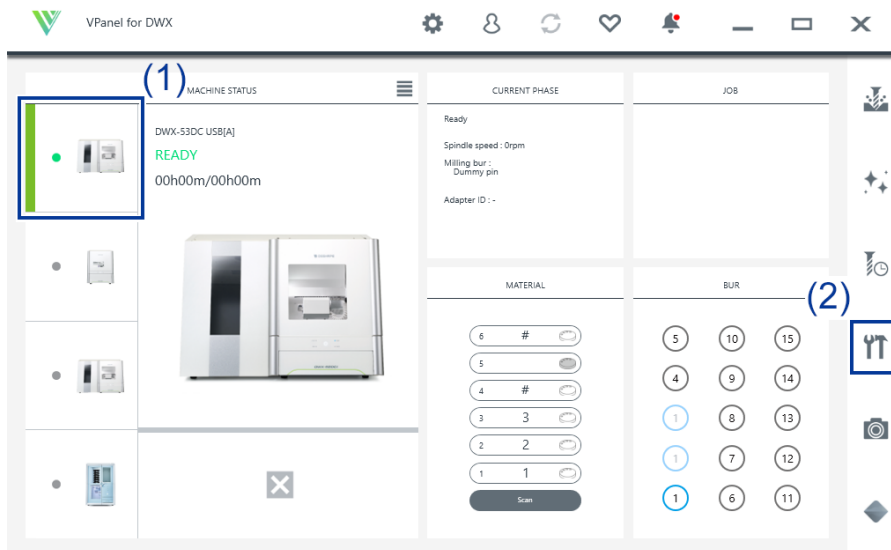
2 Open the [Machine settings] window.

① In the top window of VPanel, select the machine to operate.

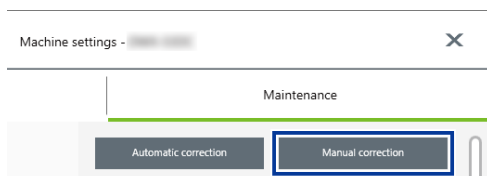
When you have connected multiple machines, you can switch to a different machine to operate by clicking its image under [MACHINE STATUS].

② Click .

The [Machine settings] window is displayed.



3 On the [Maintenance] tab, click [Manual correction].



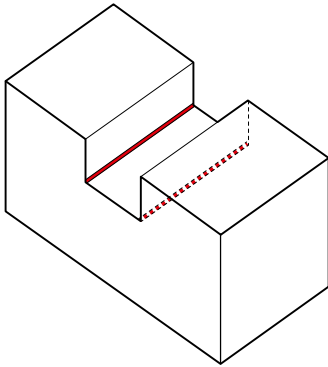
### 4 Follow the on-screen instructions to perform manual correction.

Use a slide caliper to accurately measure the thickness of the milled locations. The machine automatically performs correction on the basis of the measured values entered into VPanel. For information on how to use the slide caliper, refer to the documentation for the device you're using.

#### **Important**

If you are milling using the ZRB-200D (4 mm [0.16 in.] radius end mill), avoid the sections indicated with red in the following figure when measuring the thickness.

The shape of the end mill tip results in 0.2 mm (0.01 in.) curved surfaces in the sections indicated with red. To accurately correct the milling position, enter in VPanel the thickness measured while avoiding these curved surfaces.



### 5 When manual correction is finished, click [Complete].

The [Manual correction] window closes. Perform actual milling and check its results.

