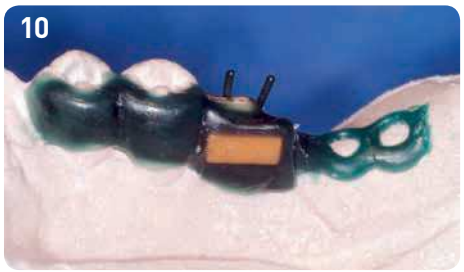
Assembly Instructions Module Swivel Latch

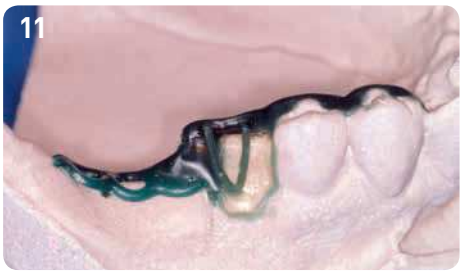
The primary structure made of CoCrMo.

The primary structure is prepared for the duplication.

The duplicate investment model.

Fixing the plastic pattern (Order No. 30-1383).





Modelling the model cast secondary structure.

Fitted model cast made of CoCrMo.

Position the model with the primary-secondary structure. The erosion position is determined by lowering the cut-to-size electrode.

Using the electrode (Order No. 30-1384), the erosion depth is set on the cone of the primary part. The clasp serves to secure the primary part.

Optical control of the electrode position. The electrode should be lowered towards the cone so that the latch nose slots completely into the eroded groove of the tapered cone.

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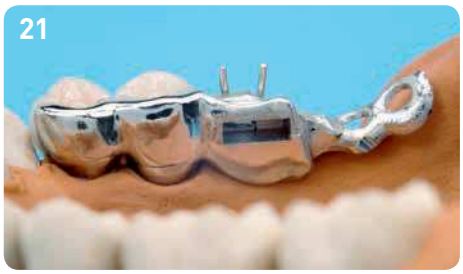
The dielectric hose is put in position.

The spark erosion process begins with flushing through the dielectric fluid.

The spark erosion process is complete when the set depth is reached, erosion time approx. 20 minutes (CoCrMo).



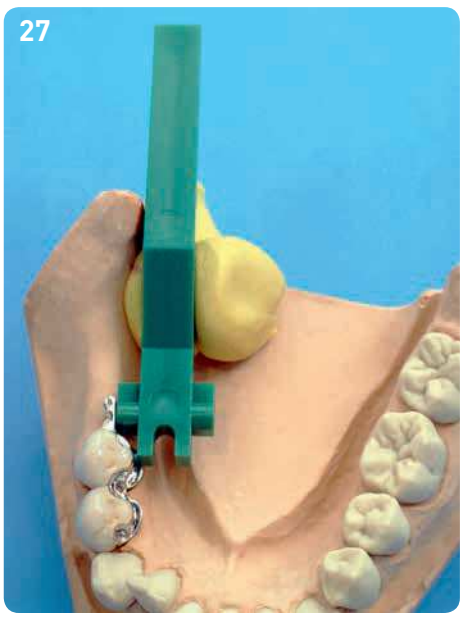
The aligned latch fit in the primary and secondary part.

The eroded fit in the primary part for the latch nose.

The prefabricated compact module latch is glued to the secondary part. A small amount of Vaseline is applied to the area between the primary and secondary part so that the composite does not flow between.

The assembled module latch.

The open module latch shows 2 screws – see instructions enclosed with the complete kit.



The latch gauge (Order No. 30-1246) should be used to correctly position the latch cone on the model.

The secondary part.

The secondary part interlocked with the primary part.