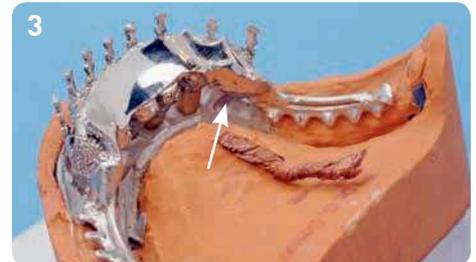


# Assembly Instructions

## Swivel Latch Standard + Standard mini



1 The duplicate model with the plastic patterns in place (SAE Order No. 30-1241) for the erosion of the latch fittings. Position the plastic pattern so that the sloping radius is aligned with the end piece of the primary cone (see arrow) – for the subsequent, optimal positioning of the latch.



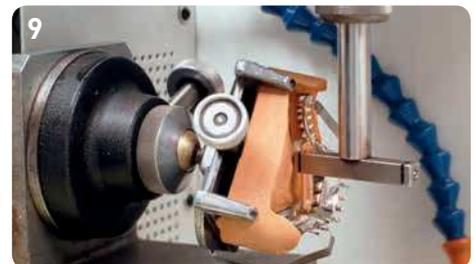
3 Area for the spark erosion fit of the swivel latch (see also figure 4).



5 Position the model with the primary and secondary parts at a 90° angle to the oral surface. Align the erosion position with the aid of a straight, cut-to-length electrode. Set zero points on display for the X and Y axes.



7 Visual 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.



9 The secondary part is mounted onto the primary part.



10 The clasp secures the secondary part on the primary part and thus creates the electrical contact. Allow the electrode to slowly move towards the model cast (beep) and then set the depth on the display (depth: 5.5 – 5.7 mm).



12 The hose for flushing dielectric fluid is positioned at just under 45° to the erosion area.



13 The influx of dielectric fluid is commenced, the tank is filled, the spark erosion process begins. For the erosion parameters, see parameter list EDM 2000.



14 The burnt-down electrode following the spark erosion process.

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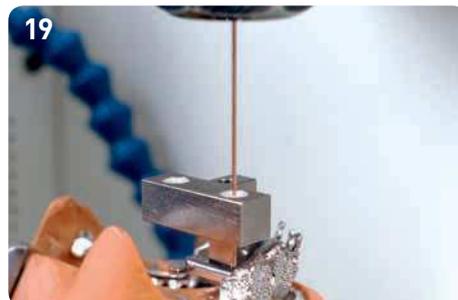
The aligned latch fit on the primary and secondary parts.



For the erosion of the latch axle at a 90° angle to the eroded latch fit, the latch part (Order No. 30-1242) is inserted into the latch fitting and attached to the axle location (Order No. 30-1602). The spirit level (Order No. 82-1201) inserted into the latch area serves to ensure parallel alignment.



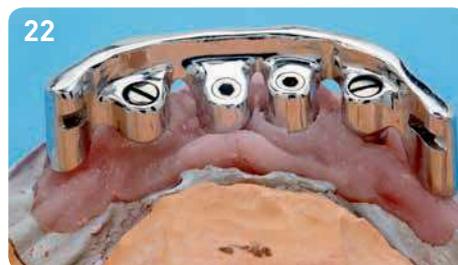
Using forcible control, the electrode (Order No. 30-1004) was lowered into the exact position in the Teflon bushing. The bushing fits an 0.8 mm electrode.



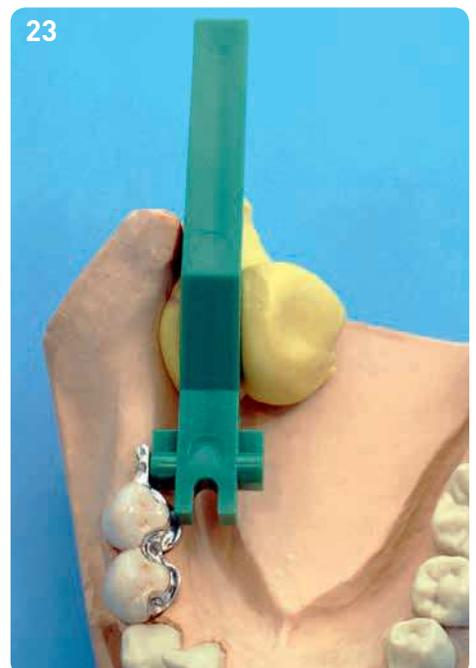
After the influx of dielectric fluid has begun, the erosion process can start – see data sheets for parameters.



The completed, inserted part (swivel latch, Order No. 30-1242) and the pivot pin inserted at a right angle.



Mesostructure with the eroded fits for the latch nose.



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



The two lamella can be seen which press into the latch fit.



The assembly component of the fabricated latch is rounded and cut-to-length. To access with the fingernail, a groove is milled into it.