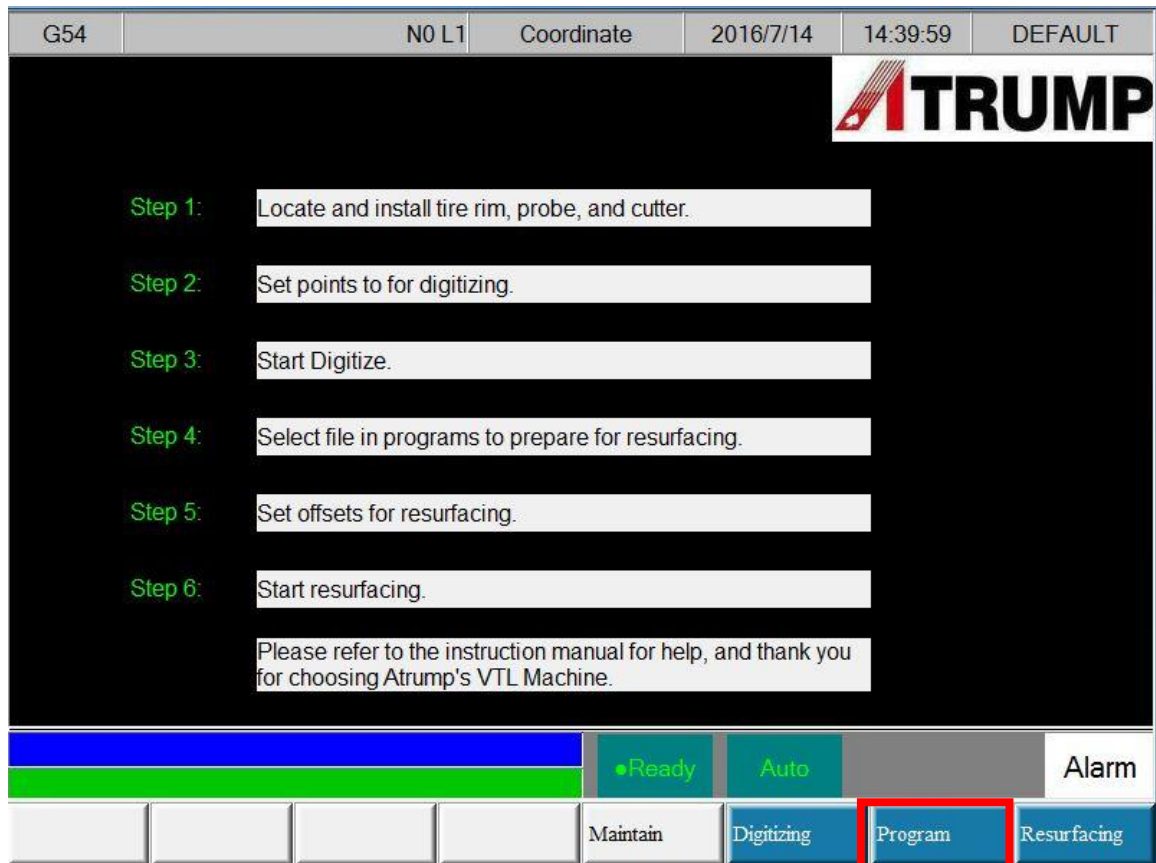
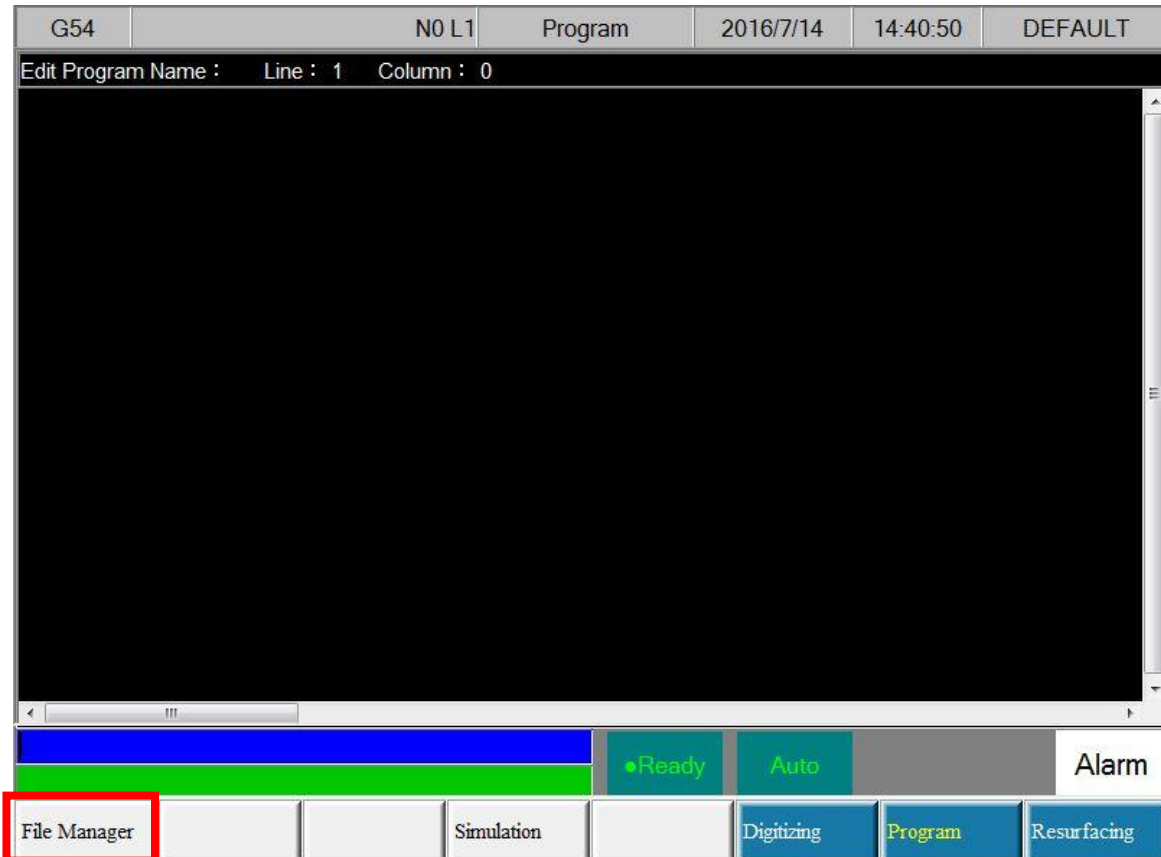


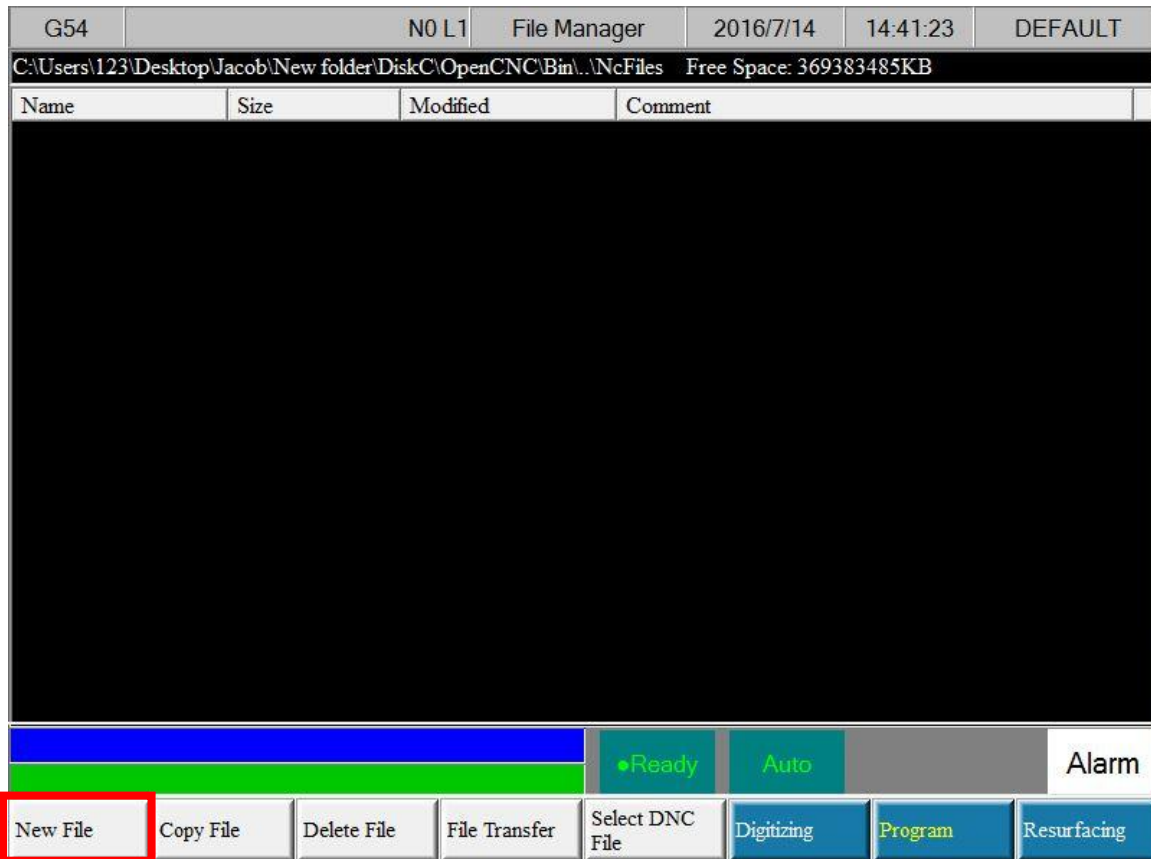
Step 1: Start at the main page and press **Programs**.



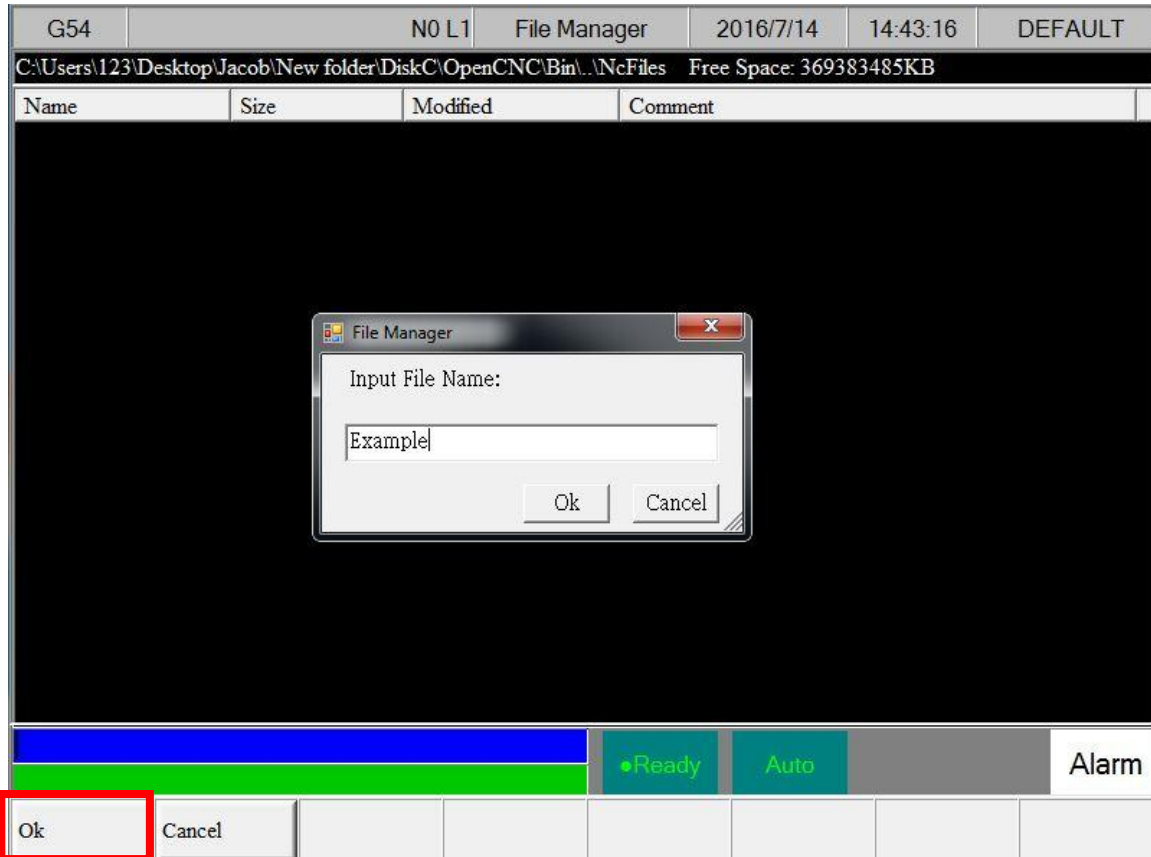
Step 2: Locate the **File Manager**.



Step 3: Create a New File.

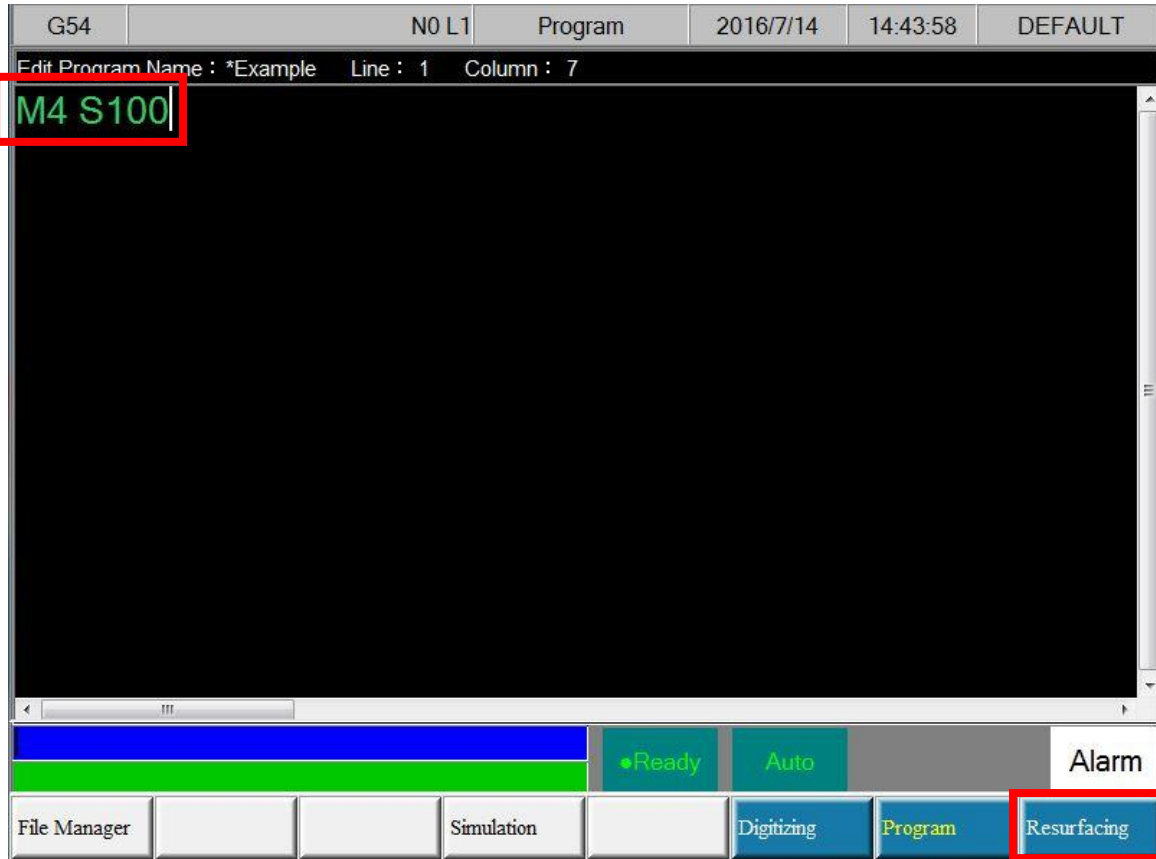


Step 4: Input File Name and Press OK.

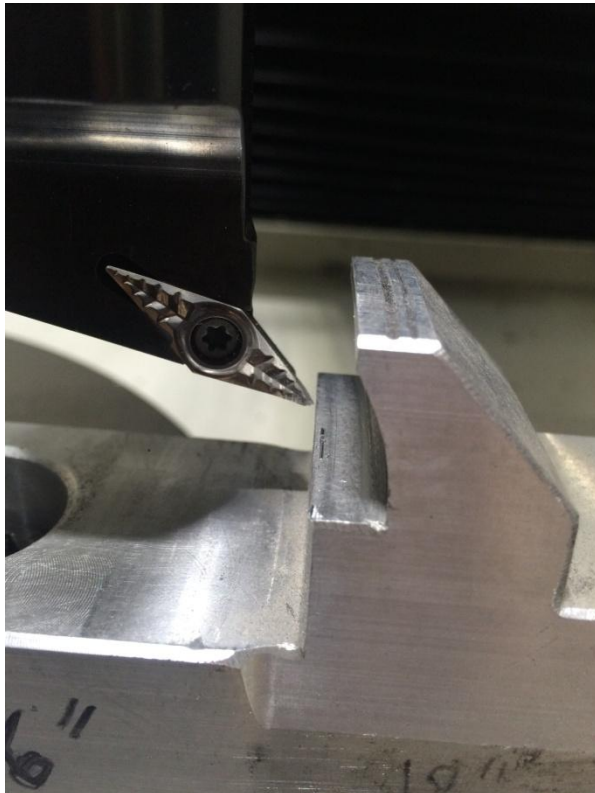


Step 5: In the file, type in (recommended) M4 S100. In this example, this is the code to set the spindle speed to 100 RPM.

Step 6: Press **Resurfacing**.



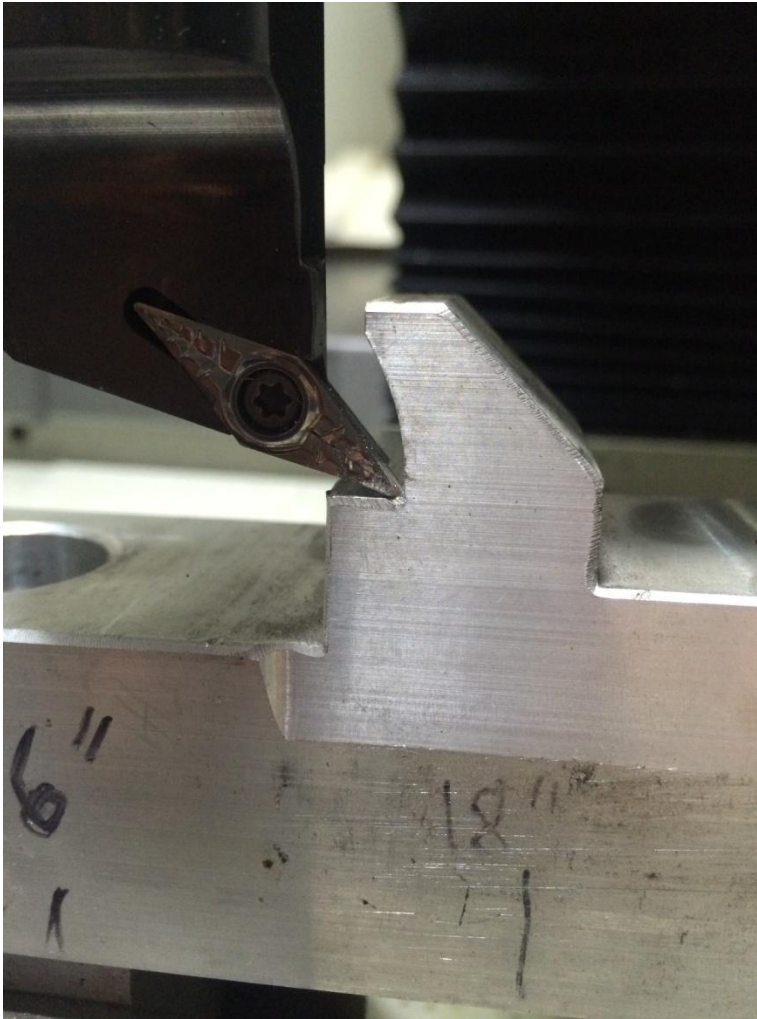
Step 7: Align the cutting tool against the edge of the individual jaw that you wish to cut



Step 8: Once the cutting tool is aligned make sure to keep track of the absolute X-axis value

Absolute	
X	0.000
Y	0.000
Z	0.000

Step 9: After recording the X-axis value at the edge of the jaw, move the cutting tool inwards without changing the Z-axis until you are close to the wall of the jaw.



Step 10: Record the X-value when the cutting tool is closest to the wall of the jaw.

Step 11: Return the cutting tool to the X-value recorded at the edge of the jaw and lower the cutting tool by 0.005.

Step 12: After lowering the cutting tool press "Cycle Start" (Green Button on Control Panel) and begin moving the cutting tool towards the recorded X-value near the wall of the jaw slowly.

Step 13: Slowly move the cutting tool back to the recorded X-axis at the edge of the jaw.

Step 14: If there are uneven shiny and cloudy areas across all three jaws, lower the Z- axis and repeat steps 11-13.

This is result of the soft jaw repair.

