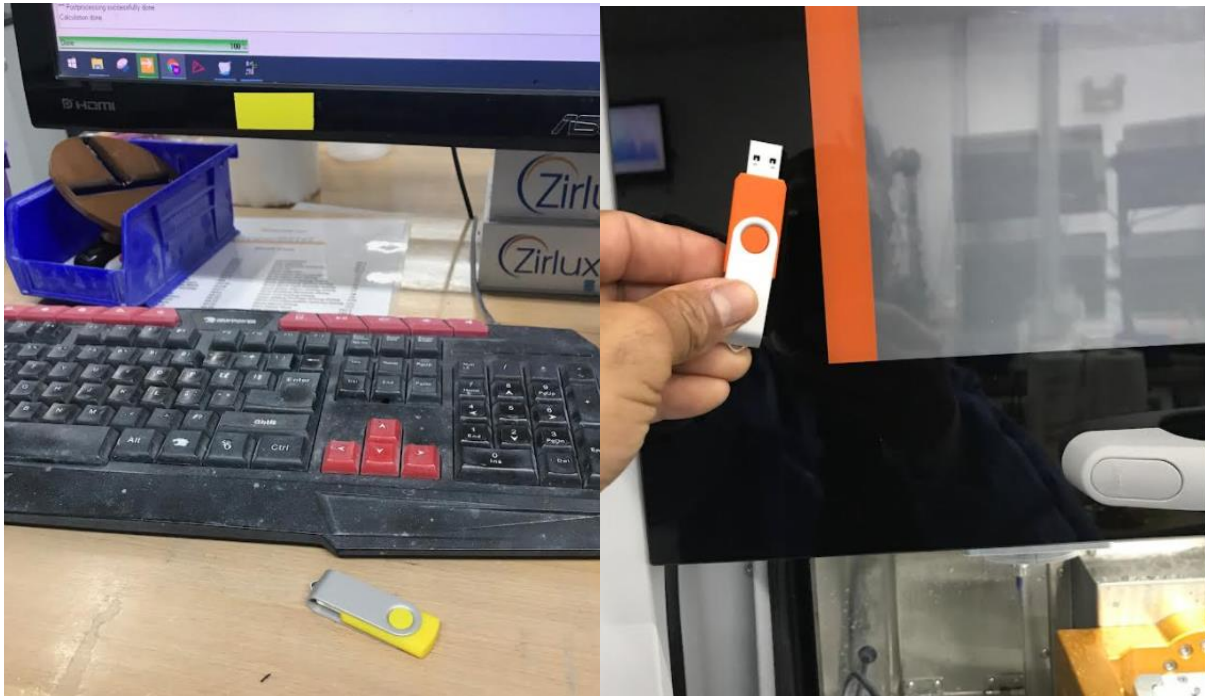


# Versamill **Basic** File Transfer Procedure

This process is meant to replace the file transfer method usually completed online via the network. This method may be used when the network is compromised or when trying to isolate root cause for mill failures.

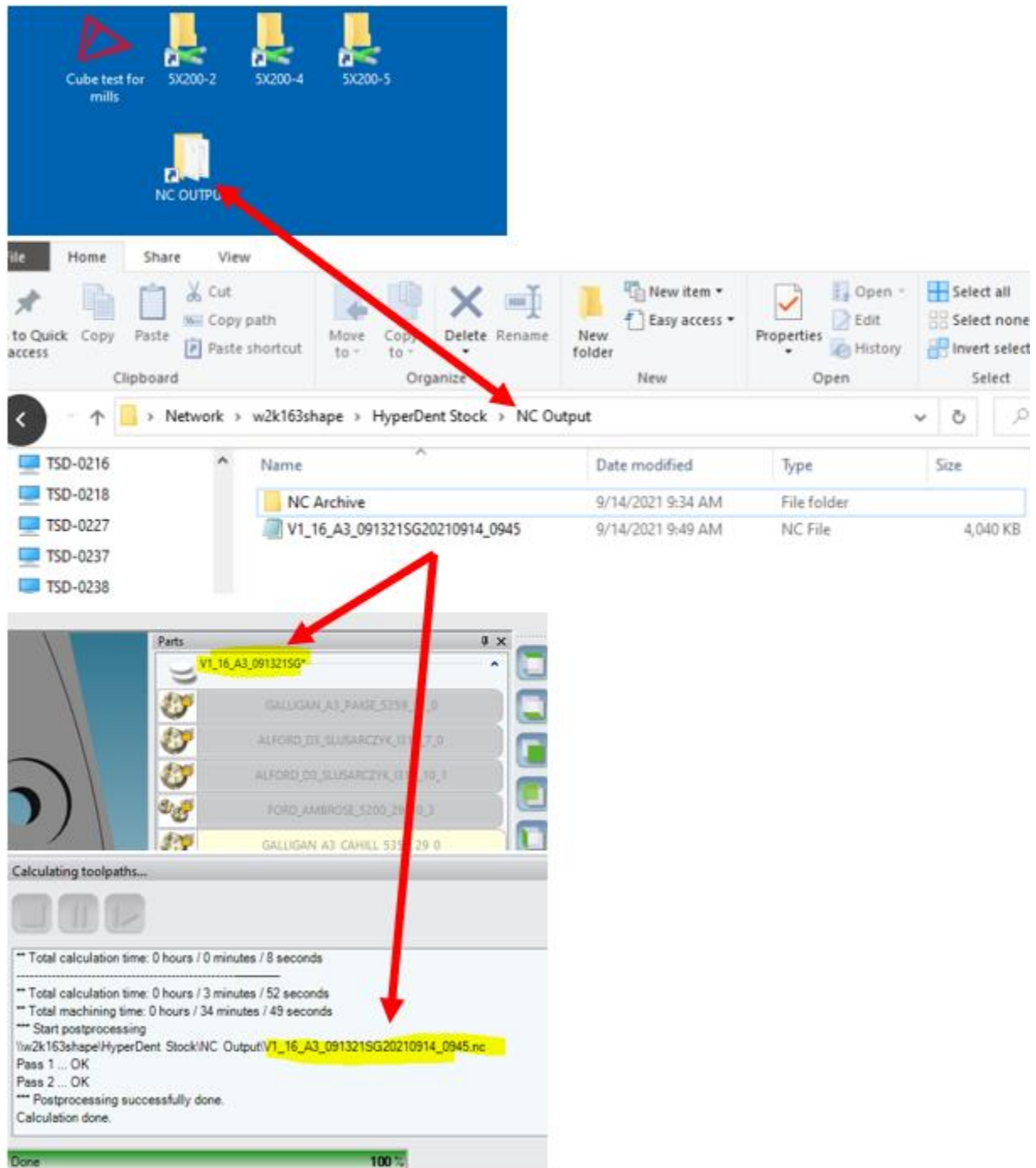
Step 1. Follow your normal procedure and calculate the job. Upon reaching the point at which you must transfer the .nc file using the network folders, utilize the specific thumb drive either for the 5x200 (orange) mills or the 5x400 mills (yellow). The monitor for the Nesting PC for the 5x400s have been marked with yellow tape to prevent confusion. The 5x400 mills have also been marked with yellow tape.

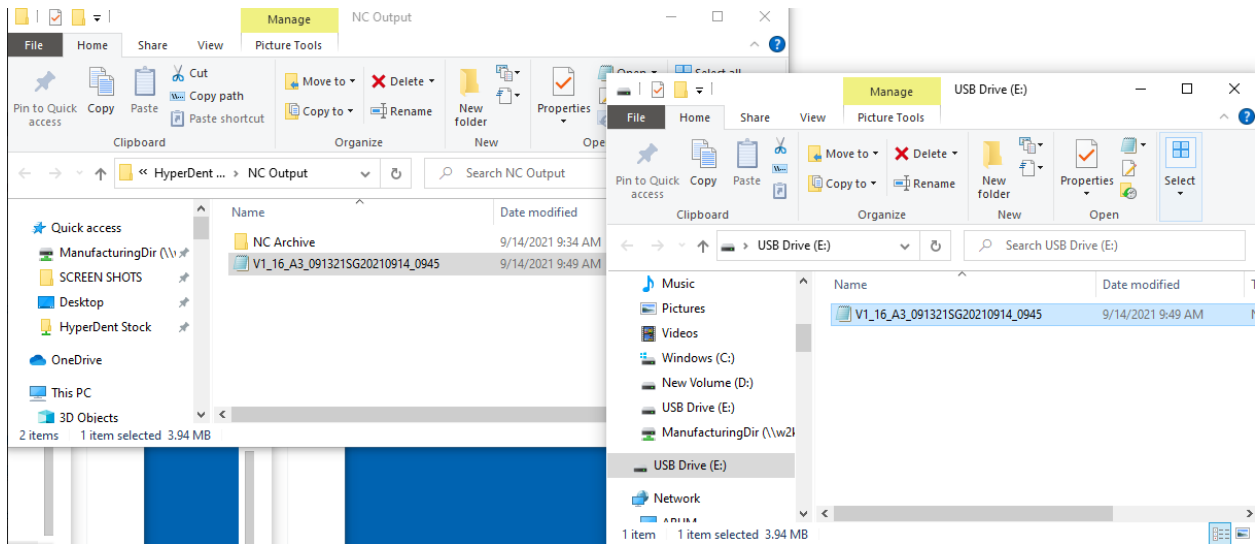


The orange thumb drive matches the trim of the 5x200s.

The importance of this distinction is meant to prevent cross contamination of the 5x200 coolant and DI water tanks which causes massive failures on batches of crowns due to discoloration. The G code calls for coolant on the 5x200 is the same as the call for DI water on the 5x400s. Avoiding running a 5x400 program on the 5x200 is of the utmost importance to maintain high first pass yield in fabrication.

To complete this step, simply drag and drop the .nc file meant for transfer on the correct thumb drive. Be sure you pick the correct file by verifying the name against the calculated file in Hyperdent. **Be sure to properly eject the thumb drive to avoid corruption.**





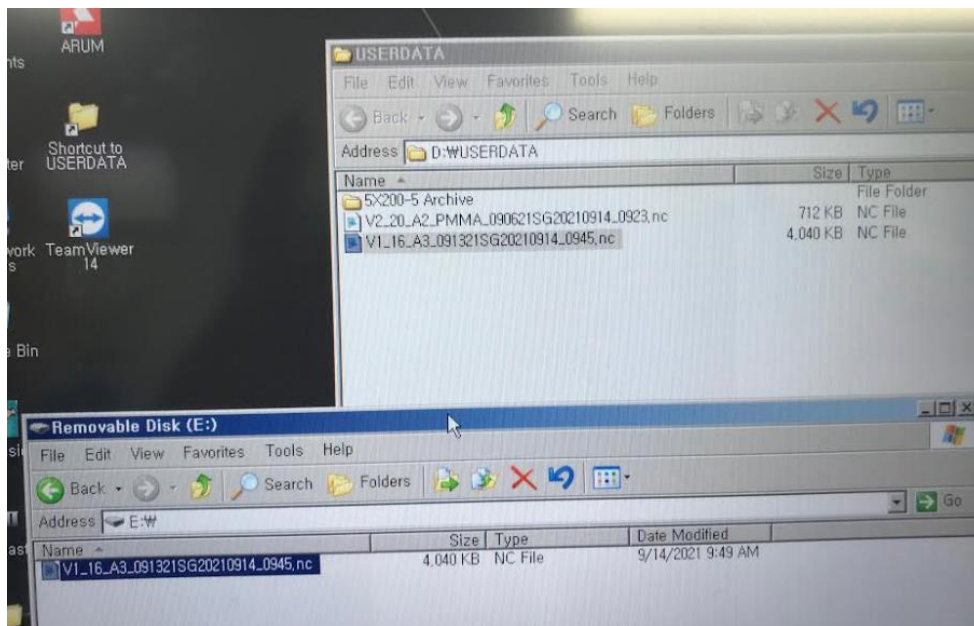
Step 2.

Transfer the .nc file to the mill via the thumb drive. Insert the thumb drive into the controller USB port.



Any available port will suffice. You will note the USB flashing.

Minimize the Arum controller software and open the USERDATA folder. Open the MY DOCUMENTS folder and click the thumb drive. Drag and drop the .nc file to be run from the thumb drive folder to the USERDATA folder.



Click on the green arrow icon on the bottom left of the screen to properly eject the thumb drive.



Remove the thumb drive to allow it to be used for another transfer.

Deleting old files must be done prior to next use and there will be minor differences between the 5x200 and 5x400 mills. Please direct specific questions to your supervisor or system experts.