



Measurements

Production



Step 1: Odoo/Files

- With your Order Label, navigate to the Sales order
- Download the photos inside the Loupes Profile.
- Save them to a new Cx profile (we use a google drive file explorer)

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e	s) / Shared drives / MAKE learn / CAPTOINE		v 0	>> search cxprome	Customer	Claire Kim 3517 Ridgemill Cir Dacula	Order Date	01/18/2023 09:25:29	Yaoyue Wang - an hour ago @Ana Gomez Please make the loupes in XL thank you very much
^	Name	 Date modified 	Type Size	^		Dacula GA 30019	Pricelist	EDU Price ×15%-20% off (USD)	 gena domez Prease make the toupes in AL mank you very much
🖈 Quick access	🛃 Thu Doan	1/9/2023 11:04 AM	File folder			United States	Payment Terms	Immediate Payment	January 23, 2023
🐴 CxProfile 🛷	🛃 Thu Pham 59mm	10/14/2022 11:21 AM	File folder		Customer Email	Boykim@usc.edu	Salesperson	Yaoyue Wang	Ana Gomez - 2 days ago
Frame 🖈	😞 Thuy Anh Luu (Teresa Luu) 59.53mm	12/22/2021 3:26 PM	File folder		Invoice Address	Claire Kim	Tags		Ana Gomez - 2 days ago @Ysoyue Wang Claire Kim - Photos for Cx are in the XL, but the S0 indicates petite. There is a
IPD Pictures 📌	😞 Thuy Anh Luu (Teresa Luu) 59.53mm Service	2/12/2022 5:51 PM	File folder		Delivery Address	Claire Kim	Event		difference in frame size. Do you have photos of Cx in the Carbon Petite frame? Please advise.
192.168.1.168 *	😞 Thuy anh nguyen 54mm	10/7/2022 7:17 AM	File folder		Student ID	-	School	University of Southern California Herman Ostrow School of Dentistry - USC	Jacob Soto - 2 deys ago
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EP #	SThuy Nguyen Carbon 59.01mm		File folder				MO Exception	Fread and to do to hope do cor Print	 IPD: 0.00 → 57.00
EP	S Thuy Nguyen 60.06mm		File folder		Source	Direct			January 19, 2023
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👌 Abigail Gavers 58mm 🛛 🖈	S Thy Nguyen 61.76mm		File folder		Order Lines Hel	pdesk Details Other Info Shipstation Shipping Charges	Loupes Profile MPnoto		graoyue Wang guAna Gomez order is now ventied and pushed to production.
🕳 Google Drive (G:) 💉	🛃 Tia Dunagan 60.66mm		File folder		Priority		Name Plate	Bo Yeon Kim DDS	
Aimee Zopf 3D Service	🔁 Tia Lucas 58mm		File folder		EP Angle		Ocular Buttons	Blank Buttons	Gladys Cleofas - 6 degr ago
EP 3D	Tia Rinzel 59.24mm		File folder				Cx Using	None	Carrier Rx: → None Case Type: → Large
EP 3D	Tiarybelle Alexander 59.71mm		File folder	No preview available.	EP Height		Carrier Rx	None	 EP WD: → 22'
Junn Nguyen Service	Tierney Pettinato 53.29 mm		File folder		Std WD		Add Power		 Maker Notes: → Cx is using regular nosepiece. Name Plate: → Bo Yeon Kim DDS
and heaven	Tiffany Boren 54.06mm		File folder		EP WD	22"	Lens Upg Progressive		Name Hate: → bo from Kim bbs Cx Using: → None
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🛄 This PC	Tiffany Chen 56.33mm		File folder		PD Left	0.00	Lens Upgrade		January 18, 2023
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Contraction of the second s	Tiffany Chung 55.43mm		File folder		Case Type	Large	Maker Notes	Cx is using regular nosepiece.	The transaction with reference (j256p3g for \$ 2,975.00 has been confirmed (Credit Card via
Desktop	Tiffany Crocker 55mm		File folder		IPD Photo		Rx Photo		Braintree).
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🖶 Downloads	Tiffeny Giang 57 mm Tiffeny Leverock 55mm		File folder					\rightarrow	Public user - 7 days ago
Music	Tiffany Min S4mm		File folder		Std Photo		Rx to Lab Image		Invoice INV/2023/00882 paid
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Shared Folders	Tiffany Munk 52 mm		File folder			(\mathbf{A})	SW Image		Subject: LumaDent Inc Order (Ref S148715) Helio,
Wideos	Tiffany Nguyenfa 58mm	9/ 19/2022 Sto3 PM	File folder				QC1	_	
Local Disk (C:)	Tiffany Saba		File folder		EP Photo	- - - - - - - - - - -			Your order \$148715 amounting in \$ 2,975.00 has been confirmed. Thank you for your trust!
7,879 items 1 item selected	<u> </u>	12 Key Kerke, K. (9 1 H)							Do not hesitate to contact us if you have any questions.

Step 2: Manufacturing Timer

- Inside the Sales order, we have a Manufacturing Order.
- Within the Manufacturing Order, we have Work Orders.
- Please use the Measurements Timer to track when you start, and when you are complete.

Quotations / S	S148715/W	/H/M0/06358								
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☆ WH	/MO/0	6358							 Jacob Soto -2 days ago MO Readiness: Ready → Waiting 	
Product Custom Descrip	tion ErgoF weari	rism TTL Loupes (5.0x EP, Carbon 3, Black, Petite) rism Working Distance: 22' What eyeglasses are you ng?: None. I have perfect 20/20 vision For peripheral through the Carrier lens, I need to have: Please select	Scheduled Date Component Status Responsible	01/19/2023 20:1 Not Available	1:09				January 19, 2023 Gladys Cleofas -6 days ago • State: Confirmed In Progress	
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Bill of Material	2022.	Jun07: ErgoPrism TTL Loupes							January 18, 2023	
Components	Work Orders	Miscellaneous							OdooBot - 7 days ago	
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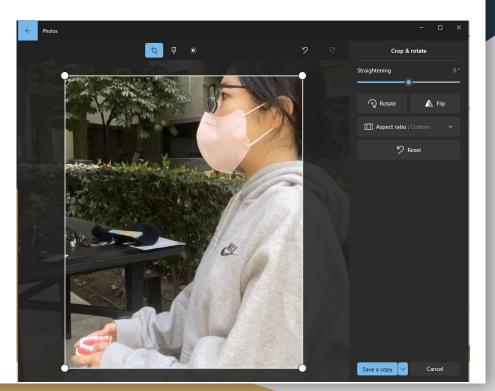
Step 3: Edit the Photos

- With each photo we edit them to get a closer IPD and EP ANGLE
- Double click and use the Photo application to crop them.



EP Angle Example

The main components needed are the customers target, and the temple arm



Step 4: Prepping Solid works

- We are going to use Solid Works to Save three different Files.
 - 1 Frame Cut
 - 2- Tubes x Frame
 - 3- Tubes All
- Working from the bottom up is the best way to think of this. We are going to open each part, then Save it as a custom file for the customer.
- Example, start with the Tubes All.
- Save as Jerry Carter Tubes All
- Then Replace it, and do the same for Tubes x Frame, next Frame Cut.

Step 4: Examples

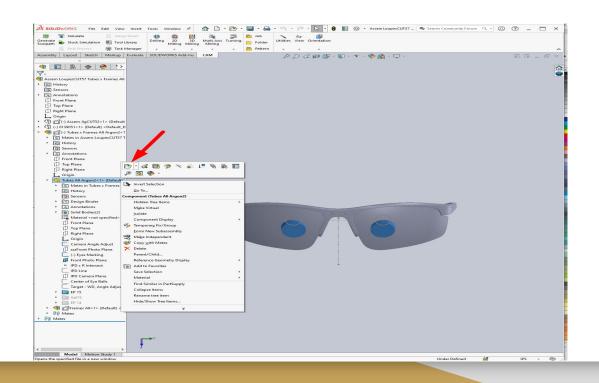
- Start by opening the template assembly of the frame and magnification you need.
 - EP15 = 15mm oculars. Or the 3.3x, 4.3x, 5.0x
 - EP14 = 14mm oculars. 6.0x

File, Open, Tubes x Frames All is the file explorer path

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000.00	 Name 	^		Date modified	Type	Size	^		
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Frame 🖈	4: Argon2 3D			7/6/2022 9:33 AM	SOLIDWORKS Part	5.473 KB			
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192.168.1.168 #	Assem Loupe	sCUT57 Tubes x Frames All Argon2 EP1	5	1/20/2023 3:19 PM	SOLIDWORKS Ass	15,038 KB		•	
LUMADENTSERVER #	Assem Loupe	sCUT57 Tubes x Frames All Argon2 Gal	15	1/5/2023 2:09 PM	SOLIDWORKS Ass	15,026 KB			
EP #	Assem Loupe	sCUT57 Tubes x Frames All Carbon3P 8	P14	1/17/2023 2:35 PM	SOLIDWORKS Ass	15,047 KB			
EP #	Assem Loupe	sCUT57 Tubes x Frames All Carbon3P 8	P15	1/18/2023 9:09 AM	SOLIDWORKS Ass	15,047 KB			
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EP 3D		sCUT57 Tubes x Frames All ClariTi2 Gal		11/16/2022 8:48 AM	SOLIDWORKS Ass	15,009 KB			
Lynn Nguyen Service		sCUT57 Tubes x Frames All Classic EP1		1/18/2023 10:36 AM	SOLIDWORKS Ass	15,030 KB			
		sCUT57 Tubes x Frames All Classic EP1		1/18/2023 12:47 PM	SOLIDWORKS Ass	15,047 KB			
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3D Objects		sCUT57 Tubes x Frames All InfiniTi2 EP		1/20/2023 9:45 AM	SOLIDWORKS Ass	15,026 KB			
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		sCUT57 Tubes x Frames All SporTi EP15		1/20/2023 7:38 AM	SOLIDWORKS Ass	15,022 KB			
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File name: Assem	LoupesCUT57 Tubes x Fra	smes All Argon2 EP15						~	Custom (".prt;".asm;".drw;"

Step 5: Saving Files

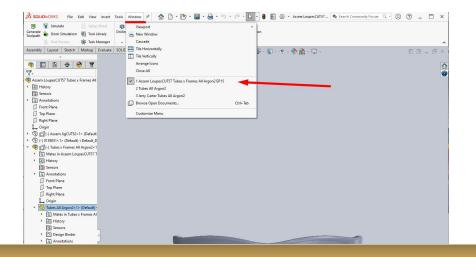
- First, Right click on the Tubes All.
- Select Open Part



Step 5: Continued

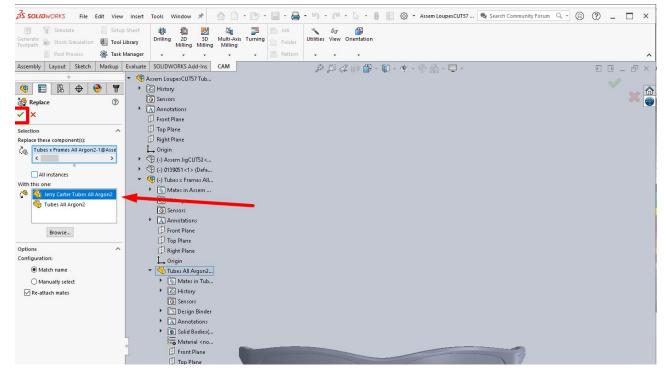
- Select, File, Save As.
- Save it as a "Save as copy and open"

Use the Windows tab to go back to the Orignal Assembly file with the entire component.



Step 5: Cont.

- Replace the component with your Customers File!
- Right click, then replace components.



Step 6 : Tubes x Frames

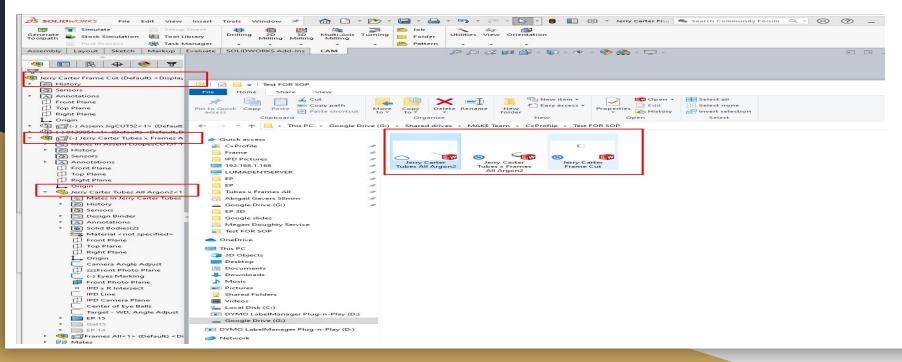
• Repeat Steps 5 but for the Tubes x Frames

- Open Part
- Save as "Cx Name" + "Tubes x Frames"
- Replace components

Tip : Using the Window tab at the top allows you to see multiple files you have open

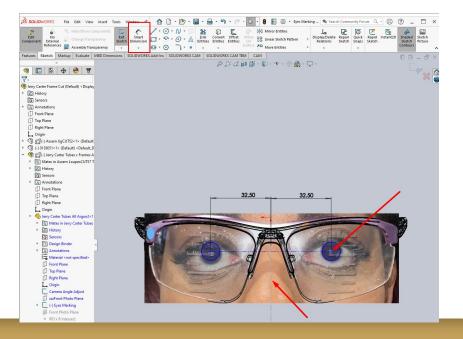
Step 7: Save the Assembly as the Cx name

- Now that the Tubes x Frame, and the Tubes all is saved as the customers name.
- Please Use the Save as, then name it the Customers "Name" + Frame Cut
- When you are all complete, the customer profile folder will look like this below!



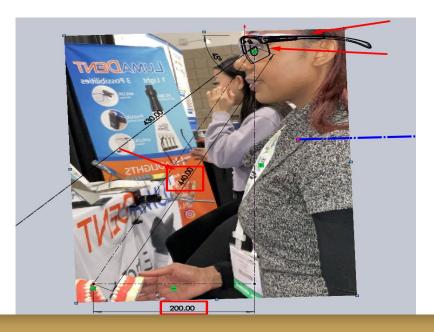
Step 8: Using Photos, IPD

- Right click the Eye marking, and the Target- WD, Angle Adjust, "Edit Sketch" to start moving the photos to the correct postion.
- With the Eye Marking, please make sure the top of the frame and the temple arms are aligned.
- Drag and click the middle dot on each eye marking to get your IPD.
- Use the Smart Dimension to measure from the middle dot, to the middle grey line.



Step 9: EP angle Photo

- We want the temple arm to be parallel to the temple arm in the solidworks template.
- Next make sure the center of the eye is where the green dot is.
- Change the "440" to reflect he customers working distance in millimeters
- Finally, change the "200" number, to reflect where the customer is targeting



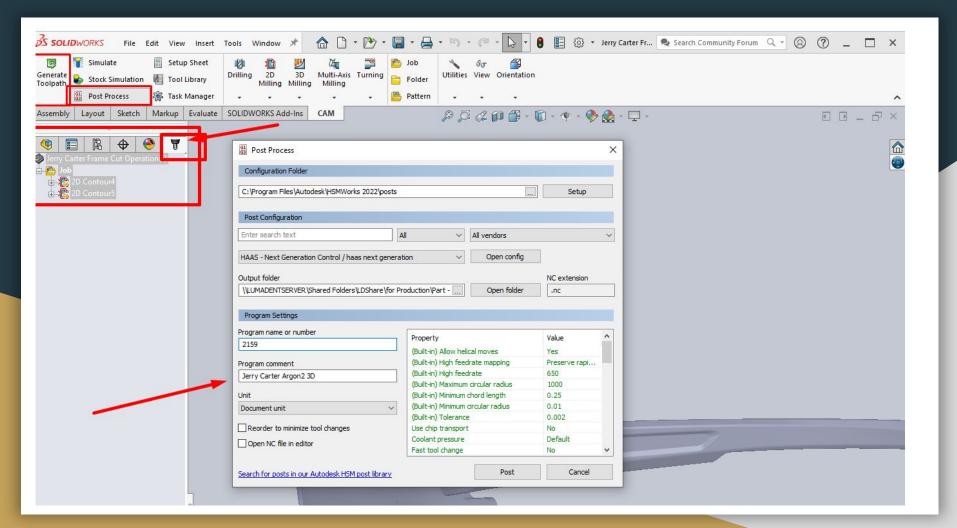
Step 10: Height

- Our last step is to verify that the height looks accurate.
 - The height meaning where the oculars will cut through the lens to match where the customer eyes are with the frame.
- If you need to, raise the eye markings to raise the height of the oculars.
 - Customers may be looking up in the IPD photo, but level in the EP angle. This can throw the Height off.



Step 10: Generate toolpath/Post Process

- In order for our CNC to cut the frame it needs instructions. Think of the next part as the machine code.
- With the CAMManager tab, highlight both contours and Frame cut name.
- Once highlighted, click on the Generate Toolpath button.
- Then, click on the Post Process.
- Post Process is how we save the machine code to the machine.
- Use the Program Comment to Name the File.
- The file name system is "Name" + "Frame" + "3D"
- We save the post process in two locations
 - 1 Server Files
 - 2- Machine Folder



UMC500 Programs = Server Files

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	B Post Process				
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	Organize - New folder		3D		
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	This PC		1/2 Rx button		52 KB 51 KB
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	Desktop	Megan Jacobsen SporTi 3D	1/26/2023 12:02 PM	NC File	39 KB
	Desktop Desktop Desktop	Mychal Chandler Carbon 3P 3D	1/26/2023 10:07 AM	NC File	39 KB
		Megan Doughty Service 3D	1/26/2023 9:53 AM	NC File	47 KB
	- Downloads	Myra Gaucin Argon2 3D	1/26/2023 9:51 AM	NC File	52 KB
	h Music	🖏 Sarah Bahn Argon2 3D	1/26/2023 9:40 AM	NC File	52 KB
	Pictures	Alicia Gillespie Argon2 3D	1/26/2023 9:14 AM	NC File	53 KB
	Shared Folders	Thuy Le Argon2 3D	1/26/2023 9:02 AM	NC File	54 KB
	Videos	Alexis Holt Classic 3D	1/25/2023 4:25 PM	NC File	37 KB
	Local Disk (C:)	Shelbi Robinett ClariTi2 3D	1/25/2023 4:14 PM	NC File	25 KB
	DYMO LabelManager Plug-n-Play (D:)	Allegra Guerrettaz ClariTi2 3D	1/25/2023 4:03 PM	NC File	25 KB
	Google Drive (G:)	Abigail hacker ClariTi2 3D	1/25/2023 3:45 PM	NC File	24 KB
		Fiona Nguyen Argon2 3D	1/25/2023 3:33 PM	NC File	53 KB
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	📥 Network	Michelle Leon Argon2 3D	1/25/2023 2:54 PM	NC File	54 KB
		Gerald Favre SporTi 3D	1/25/2023 2:48 PM	NC File	44 KB
	File name: Jerry Carter Argon2 3D				
	Save as type: All (*.*)				

192.168.1.168 = I.P. Address for CNC

• Drag and drop from the UMC500 Server folder, to the CNC machine's Folder!

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	Nguyen SporTi 3D	1/25/2023 3:07 PM	NC File	40 KB		Desktop	Lisa Katach Argon2 3D	1/25/2023 2:36 PM	NC File		
This PC	elle Leon Argon2 3D	1/25/2023 2:54 PM	NC File	54 KB		Documents	Michelle Leon Argon2 3D	1/25/2023 2:54 PM	NC File		
3D Objects	ld Favre SporTi 3D	1/25/2023 2:48 PM	NC File	44 KB		🖶 Downloads	Linh Nguyen SporTi 3D	1/25/2023 3:07 PM	NC File		
Desktop	Katach Argon2 3D	1/25/2023 2:36 PM	NC File	54 KB		h Music	Fiona Nguyen Argon2 3D	1/25/2023 3:33 PM			
Documents	a Hadi Argon2 3D	1/25/2023 2:19 PM	NC File	52 KB		Pictures	Abigail hacker ClariTi2 3D	1/25/2023 3:45 PM	NC File		
- Downloads	he Hellman Argon2 3D	1/25/2023 2:07 PM	NC File	52 KB		Shared Folders	Allegra Guerrettaz ClariTi2 3D Allegra Guerrettaz ClariTi2 3D	1/25/2023 4:03 PM	NC File		
Music	Morency Argon2 3D	1/25/2023 1:55 PM	NC File	51 KB		· · · · · · · · · · · · · · · · · · ·	Shelbi Robinett ClariTi2 3D	1/25/2023 4:14 PM	NC File		
Pictures	ony Baird Argon2 3D	1/25/2023 12:39 PM	NC File	47 KB		Videos 🖉	Alexis Holt Classic 3D	1/25/2023 4:25 PM	NC File		
	hpreet Kaila InfiniTi2 3D	1/25/2023 12:26 PM	NC File	25 KB		Local Disk (C:)	Megan Doughty Service 3D	1/26/2023 9:53 AM	NC File		
shared Folders	/ Mitchell ClariTi2 3D	1/25/2023 11:12 AM	NC File	24 KB		DYMO LabelManager Plug-n-Play (D:)	Megan Jacobsen SporTi 3D	1/26/2023 12:02 PM	NC File		
fideos	ucopia Innovation Corporation (San	1/25/2023 10:14 AM	NC File	25 KB		Google Drive (G:)	Eric Chatterley Argon2 3D	1/26/2023 12:15 PM	NC File		
ocal Disk (C:)	am E Wyatt Jr TEST 15	1/25/2023 9:15 AM	NC File	49 KB			Karla Rios Argon2 3D	1/26/2023 1:01 PM	NC File		
YMO LabelManager Plug-n-Play (I		1/25/2023 9:12 AM	NC File	48 KB		DYMO LabelManager Plug-n-Play (D:)	Kirsten Kennedy Argon2 3D	1/26/2023 1:12 PM	NC File		
Google Drive (G:)	am E Wyatt Jr TEST 22	1/25/2023 9:05 AM	NC File	50 KB		I Network	Karri Bausch Carbon 3P 3D	1/26/2023 2:07 PM	NC File		
	IT D IC TOD	1/25/2023 0 10 111	North	2010			Ben Vanek InfiniTi2 3D	1/26/2023 2:18 PM	NC File	Y	

COMPLETE!

- Be sure to note the IPD and any other notes needed physically on your order form!
- Plus note it on the Customer Profile!

Vuick access		01273017		265
	-	Shelbi Robinett 50mm	1/25/2023 3:21 PM	File folder
💑 CxProfile	A	😞 Allegra Guerrettaz 53mm	1/25/2023 3:21 PM	File folder
Frame	*	😞 Abigail hacker 54mm	1/25/2023 3:20 PM	File folder
IPD Pictures	*	🛃 Fiona Nguyen 54mm	1/25/2023 3:20 PM	File folder
192.168.1.168	#	🔄 Linh Nguyen 56mm	1/25/2023 3:20 PM	File folder
LUMADENTSERVER	#	🛃 Michelle Leon 58mm	1/25/2023 3:20 PM	File folder
EP	*	🌅 Lisa Katach 60mm	1/25/2023 3:20 PM	File folder
EP	*	🌅 Elisha Hadi 57mm	1/25/2023 3:20 PM	File folder
Contraction of the second second		🌅 Moshe Hellman 58mm	1/25/2023 3:20 PM	File folder
Tubes x Frames All	×.	🔜 Ava Morency 64mm	1/25/2023 3:19 PM	File folder
Abigail Gavers 58mm	*	S Gerald Favre 59mm	1/25/2023 2:48 PM	File folder
🕳 Google Drive (G:)	#	S Gerald Favre (Leah Schultz) 58mm	Date created: 1/25/2023 11:34/2AM/23 2:46 PM	File folder
EP 3D		🔁 Claire Kim 57mm	Size: 30.4 MB 1/25/2023 2:40 PM	File folder
Google slides		Anthony Baird 61mm	Size: 30.4 MB 1/25/2023 2:40 PM Files: Gerald Favre frame cut, 1/25/2023 11:49 AM	File folder
Megan Doughty Service		🌅 Prabhpreet Kaila 65mm	1/25/2023 11:48 AM	File folder
Test FOR SOP		🛃 Lindy Mitchell 52mm	1/25/2023 11:48 AM	File folder
est for sor		Srooklin Byrd 57mm	1/25/2023 11:48 AM	File folder