



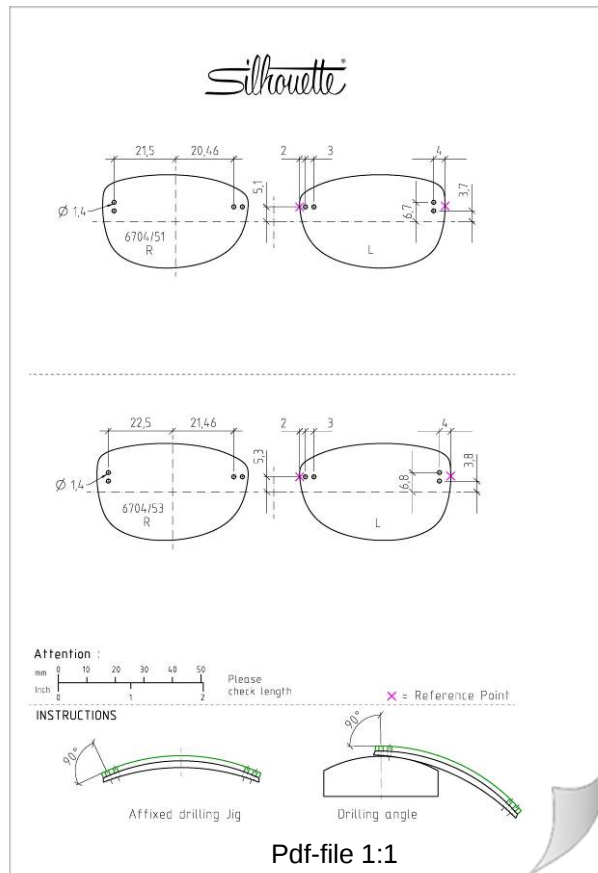
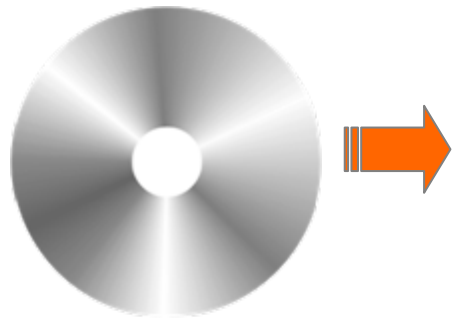
GLAZING INSTRUCTIONS with DRILLING PATTERN

LEATHERDROPS



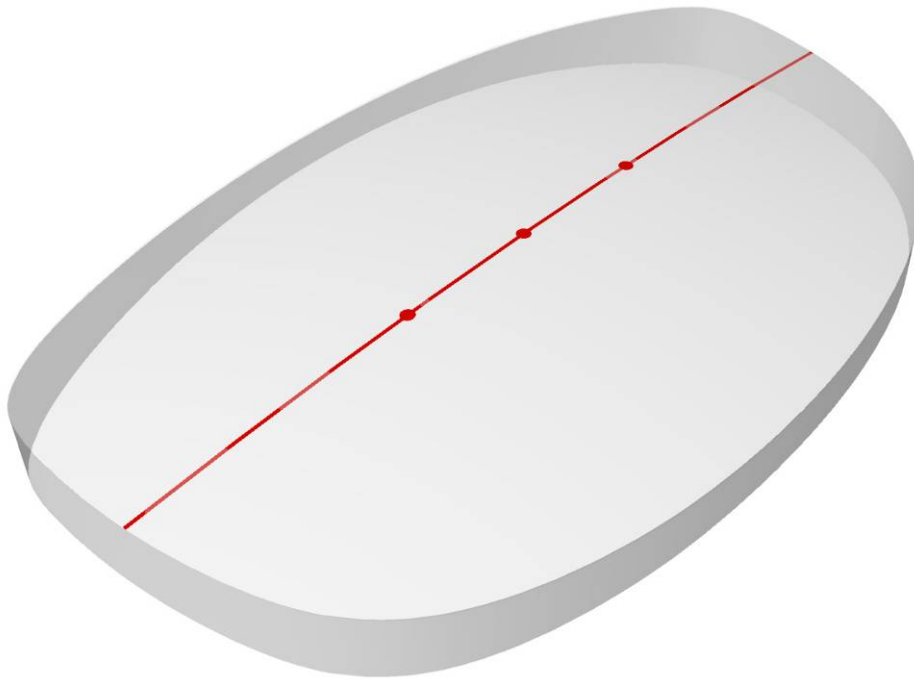


1. Download Drilling Coordinates



- Print drilling coordinates in size 1:1. (In print window set your page scaling „none“.)
- **Alternative A:** Drilling with an Edger and Automatic Drilling Machine. Drill at a 90° angle to the front surface of the lens.
- **Alternative B:** Drilling by hand with drilling pattern and tools from mounting box P0027.

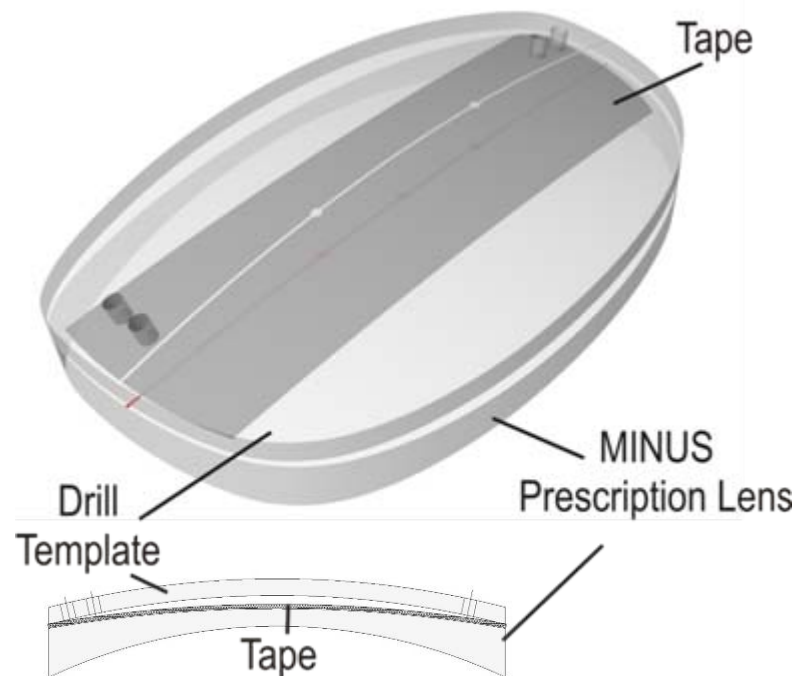
2. Cutting



- Measure lenses in the focimeter. Mark the central axis with a waterproof pen. Cut the lenses using a flat edge at a 1:1 scale.
- Polish edges as desired.
- Maximum lens thickness at fixing position = 6 mm (= length of BLS)



3.1. Alternative B: Drilling by Hand Sticking of Drilling Pattern on MINUS Lenses



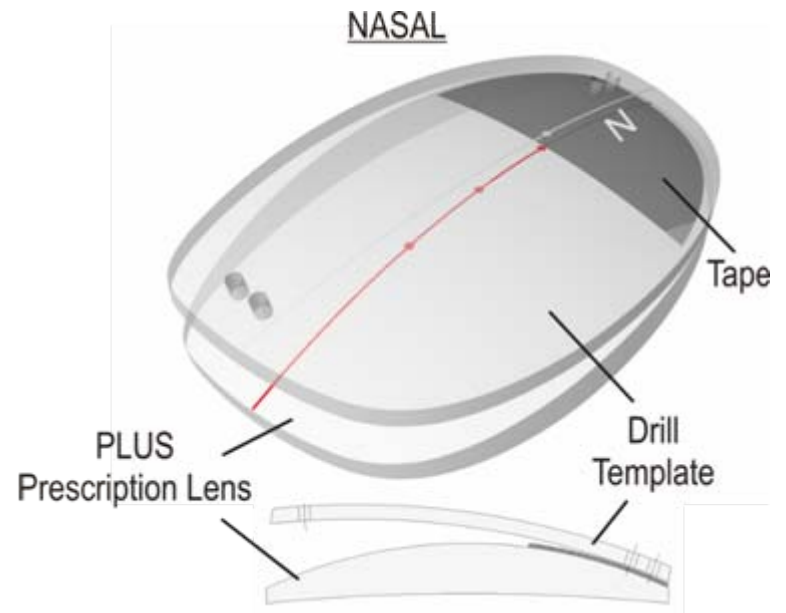
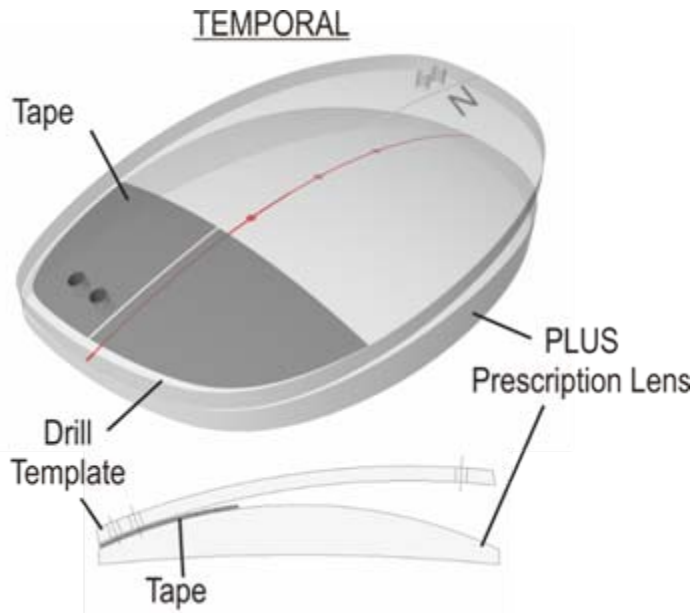
Alternative B:

Use enclosed demo-lens as drilling pattern. Affix the demo-lens with double-adhesive tape accurate to contour and axially parallel to the optical lens.

Please note direction for fixing!



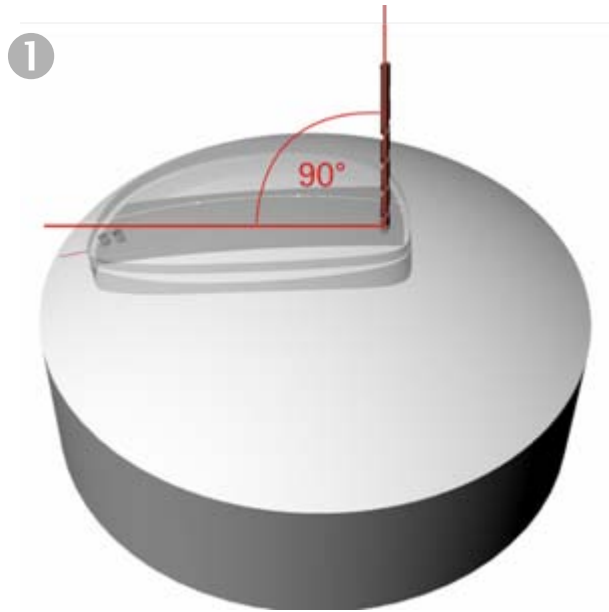
3.2. Alternative B: Drilling by Hand Sticking of Drilling Pattern on PLUS Lenses



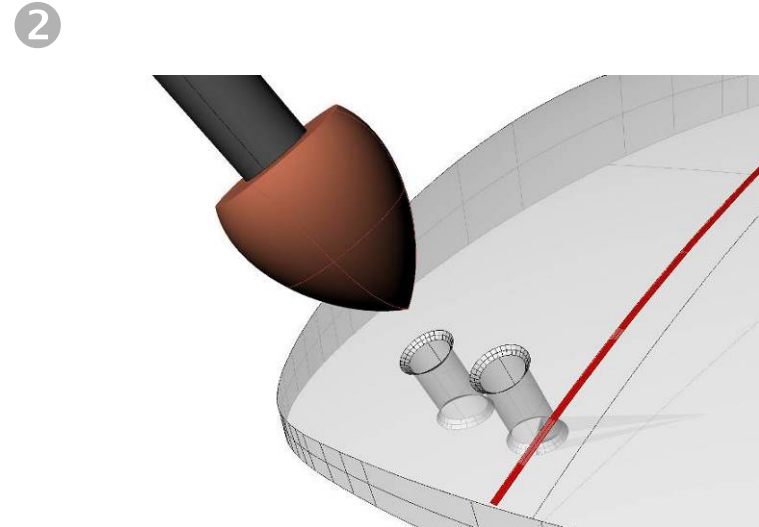
Alternative B:

Use enclosed demo-lens as drilling pattern. Affix the demo-lens with double-adhesive tape accurate to contour and axially parallel to the optical lens.
Please note direction for fixing!

3.3. Alternative B: Drilling by Hand Drilling and Deburring

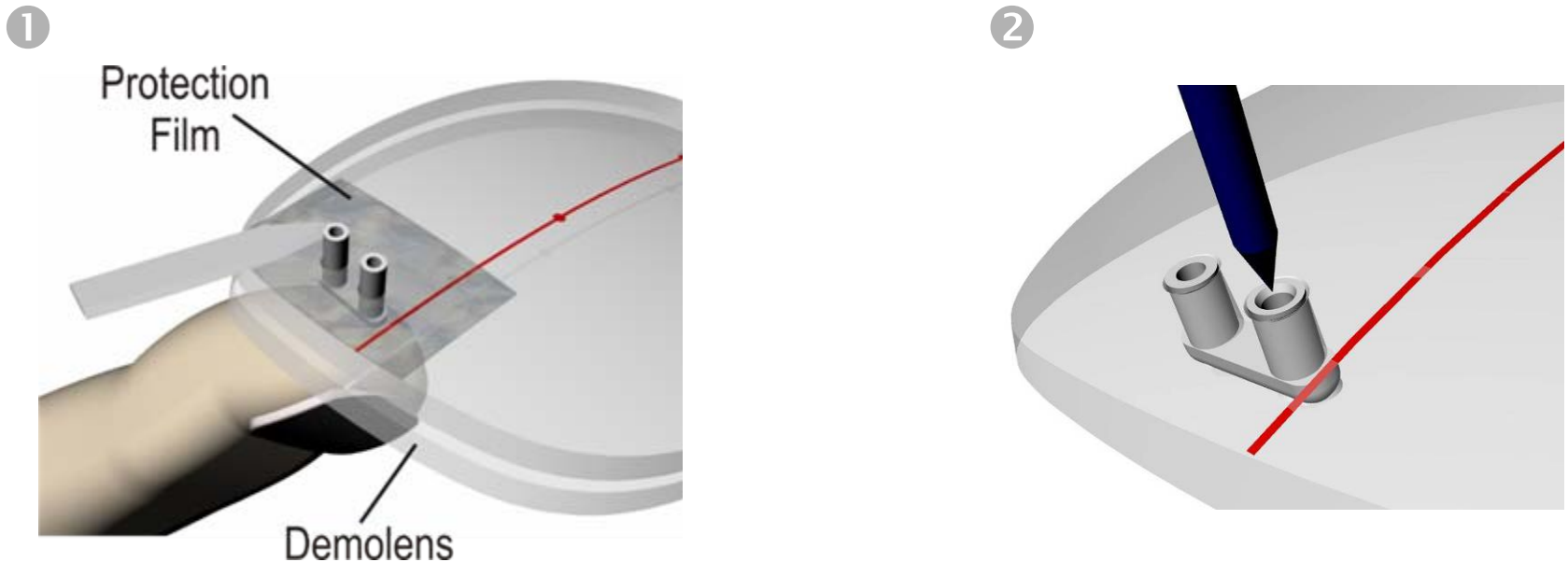


1. Place the correction lens on a curved pad for drilling. Drill the holes at 90° to the lens front. Drilling diameter is $\varnothing 1,4$ mm.



2. Deburr the holes carefully on both sides.

4. Insert BLS – Cut to Size – Expand

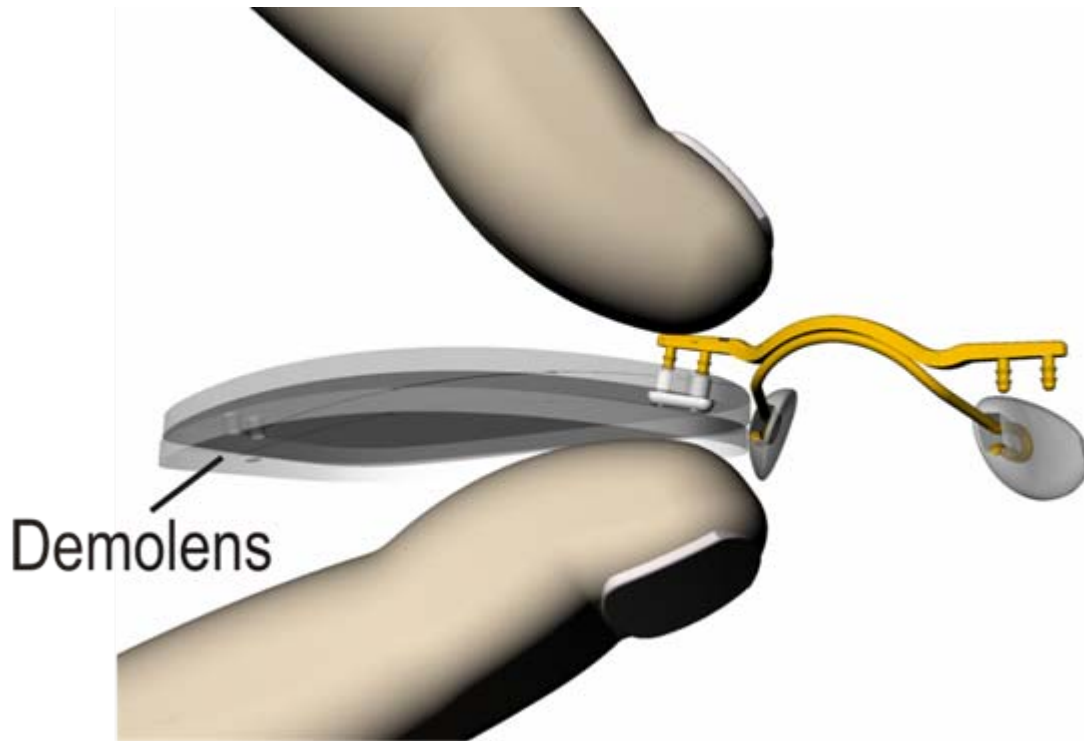


1. Apply protection film to avoid damage while cutting. Insert BLS into drilled holes (use a demo lens to get best fit). Cut to size, depending on the lens-thickness. Place blade parallel to the lens.

2. Expand open end of sleeves with a conical pin. This will make it easier to press in frame parts.



5. Press Frame Parts into Sleeves

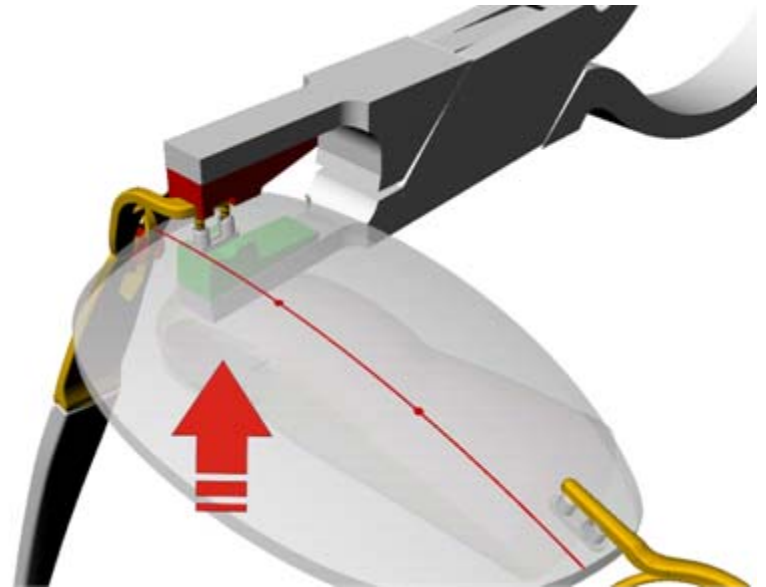
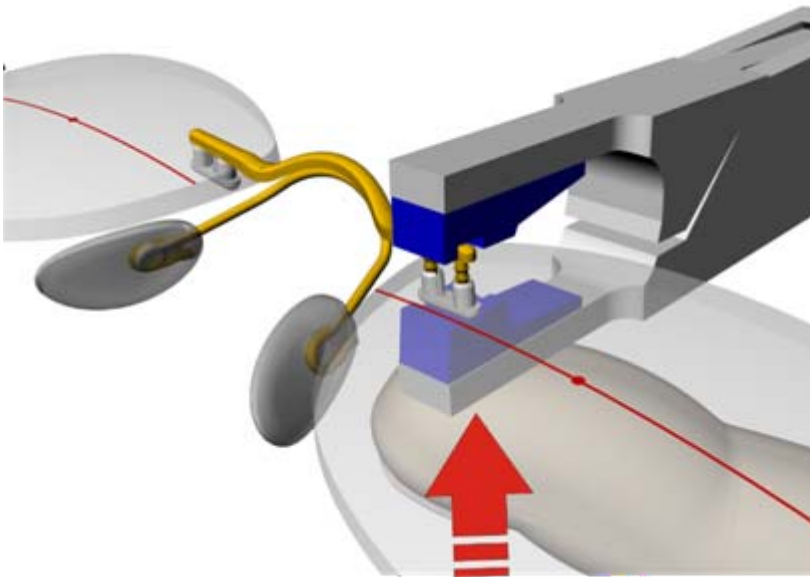


Press frame parts into sleeves by hand.

Use some counter-pressure at the top of the BLS, use a demo lens as a support.



6. Fixing of Frame Parts



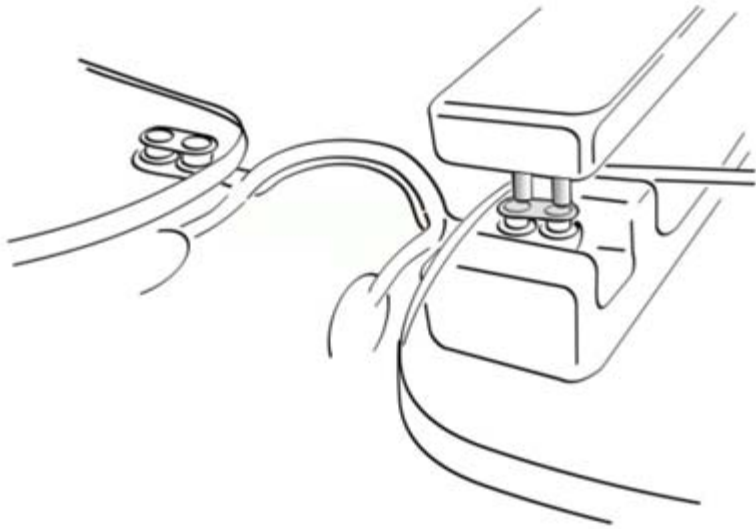
NOTE: Focus some counter-pressure with the pliers on the inside of the lens. Then close pliers and gently ease components together.

Use universal mounting pliers P0023 for the bridge, pliers P0026 for the sideparts (mount red sideparts AC 329 to the pliers)

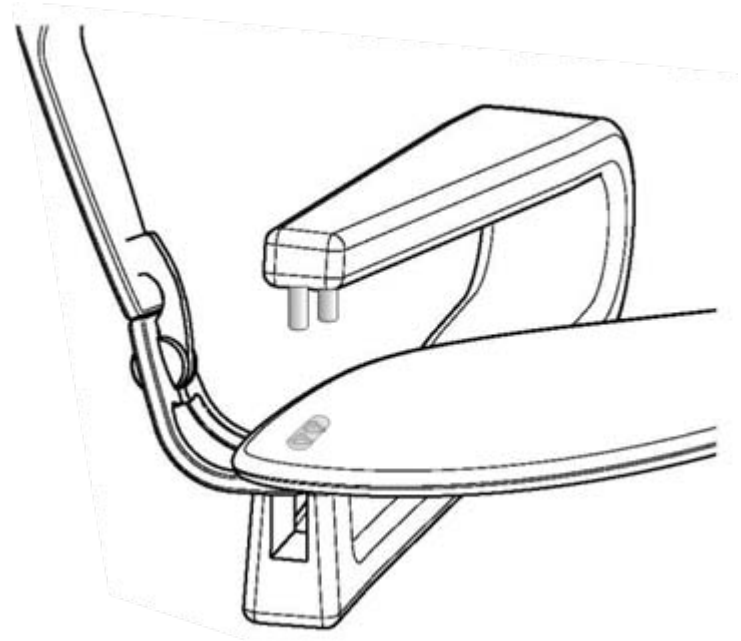
TIP: Always place moveable sideparts at the top of the BLS!



7. Disassembly of the Demo Lenses



Remove demo-lens nasally by using the transparent disassembly pliers AC 212-2.



Remove demo-lens temporally by using the green disassembly pliers AC 268.