



Glazing instructions for Daniel Swarovski Crystal Eyewear

1. *Cut and edge lens to shape.
Edge thickness must be greater than or equal to 2 mm or less than 7 mm.*
2. *Cover plus side of lens with transparent tape to protect the lens.*
3. *Mark 180 axis on taped lens surface.*
4. *Mark drilling positions from pattern to lens.*
5. *Hold lens back to back, check that drill marks on both lenses match one another.*
6. *Using double-sided tape, affix drilling gauge to lens.
For plus, begin with temporal hole.
For minus, begin with nasal hole.*
7. *When drilling nasal holes:
The center line on the gauge must be parallel to the 180 axis.*

When drilling temporal holes:

*The bottom of the gauge must be parallel to the 180 axis.
2 holes per side per lens = 4 holes per lens.*

Use 1 mm drill bit for pocket hole.

Use 1.6 mm drill bit for screw hole.

**The pocket hole is always the inner hole. A steel pin is inserted into it to act as a stabilizer for fixing lens into position. Washers are not used on the stabilizing pin.*

8. *Chamfer the holes. (very important!)
Chamfering creates a safety bevel on the drill to minimize chipping. You must chamfer both sides.*
9. *Slide the washer #46 (the longer of the two washers) on the screw.
(over both threaded and unthreaded portions)*
10. *Insert screw with washer and stabilizer pin onto the lens.*
11. *From the minus, slide the washer #47 (the flat washer) onto the screw.*
12. *Place nut on the screw and tighten.
Be careful not to flatten washer!*
13. *Cut screw flush with the nut and carefully file to remove rough edges.*

Re-glazing Note: Spare Part HM 86 is available for re-glazing.