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.