The background of the page features a pair of hands holding a pair of sunglasses. The hands are positioned as if presenting the sunglasses, with one hand supporting the frame from below and the other hand holding the temples. The sunglasses have a dark frame and light-colored lenses. The entire scene is rendered in a soft, grayscale, slightly blurred style, giving it a professional and elegant appearance. The Silhouette logo is centered at the top of the page.

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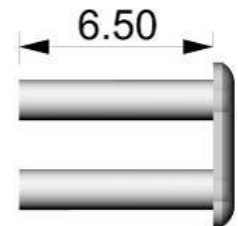
GLAZING INSTRUCTIONS

OPTICAL SUNGLASSES

SUN 2012

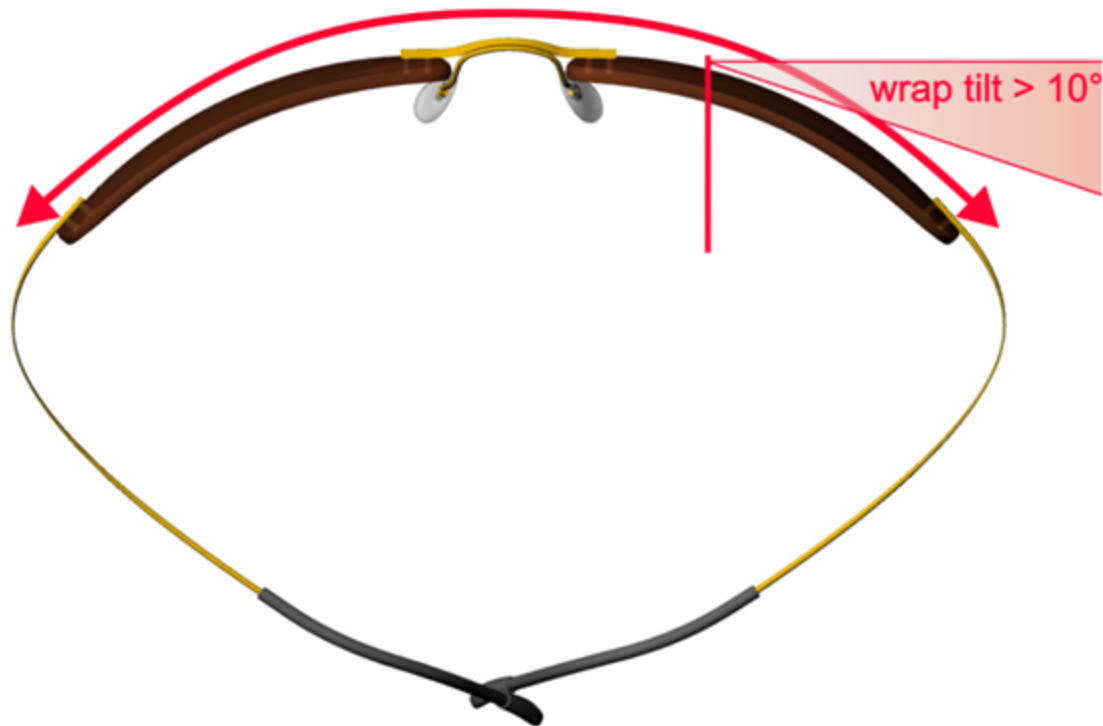
1. Glazing Possibilities

- Max. lens thickness at the drill hole = 6,5 mm depending on the length of the BLS
- Min. lens thickness at the drill hole = 2,0 mm depending on the length of the fixation pins
- Lenses recommendation as of HIX 1,6



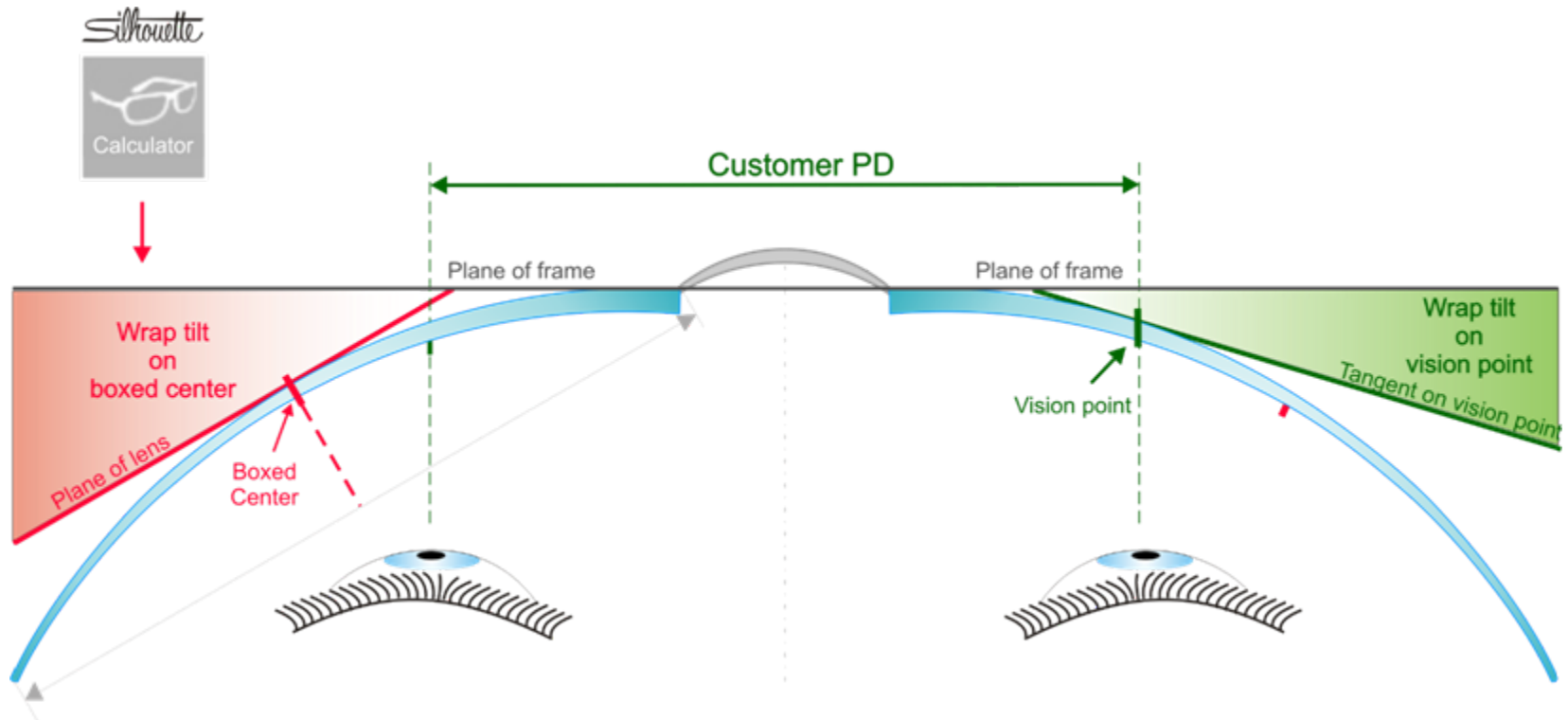
2. WRAP-AROUND FRAME - Definition

Wrap around frame



- Wrap tilt larger than 10° and
- Strong curved lenses with predefined base curve > 6

3. WRAP TILT - Definition



Wrap tilt = angle between plane of frame and plane of lens


To differentiate between:

- Wrap tilt at the **geometrical lens centre** (Silhouette calculator!)
- Wrap tilt at the **customer specific vision point**

4. WRAP-COMPENSATION and ORDERING OF LENSES

1. Wrap Compensation (= Calculation of customer prescription)

- Necessary to avoid incompatibilities
- 2 possibilities:
 - a) Silhouette WRAP-AROUND calculator
 - b) Lens producer
- NOTE: depending on the calculation method, make sure which kind of Wrap Tilt is necessary! (either at the boxed centre or at the vision point)
- Silhouette WRAP-AROUND Calculator on <http://b2b.silhouette.com>

	username	atcalculator1	atcalculator2	atcalculator3	atcalculator4	atcalculator5
	password	english	french	italian	spanish	german

2. Ordering of Lenses:

- Order 8 Base-front curve from the lens producer
- We recommend HIX-lenses as of 1,6 in Freeform-plane design
- For aesthetical reasons take note of the lens edge thickness!
Details on b2b.silhouette.com - Button „Calculator“ – „Glazing Chart“

5. Mounting Box and Pliers



P0027 Universal-Mounting Box
(P 0027 00 0000 0000)



P0031 Pliers Box
(P 0031 00 0000 0000)



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6. MOUNTING
of
OPTICAL SUNGLASS LENSES

6.1. Dismount Sun Protection Lenses

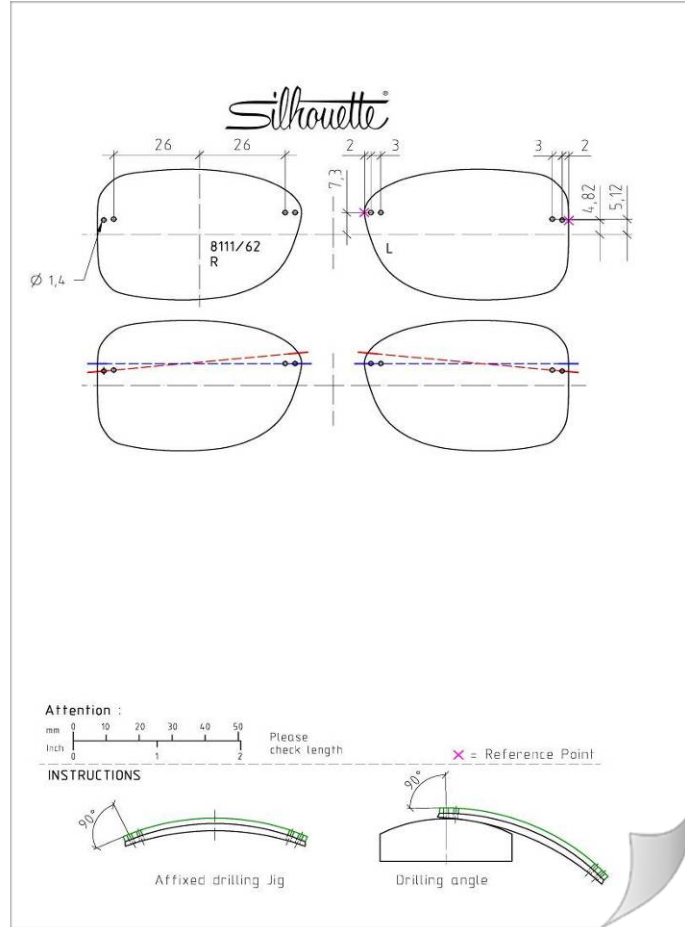


1. Cut the head of the plastic sleeves with the disassembly pliers P0004

3. Press the frame parts out of the drill with the disassembly tool.
4. Carefully remove remaining plastic parts from the BLS.

NOTE: Fixation pins, barbed hooks and surfaces must NOT be damaged. Cuttings and grooves might cause breakages!

6.2. Download Drilling Coordinates and print in Colour



1:1-print

NOTE!
no page scaling




Drilling coordinates on the enclosed CD or from customer service upon request!

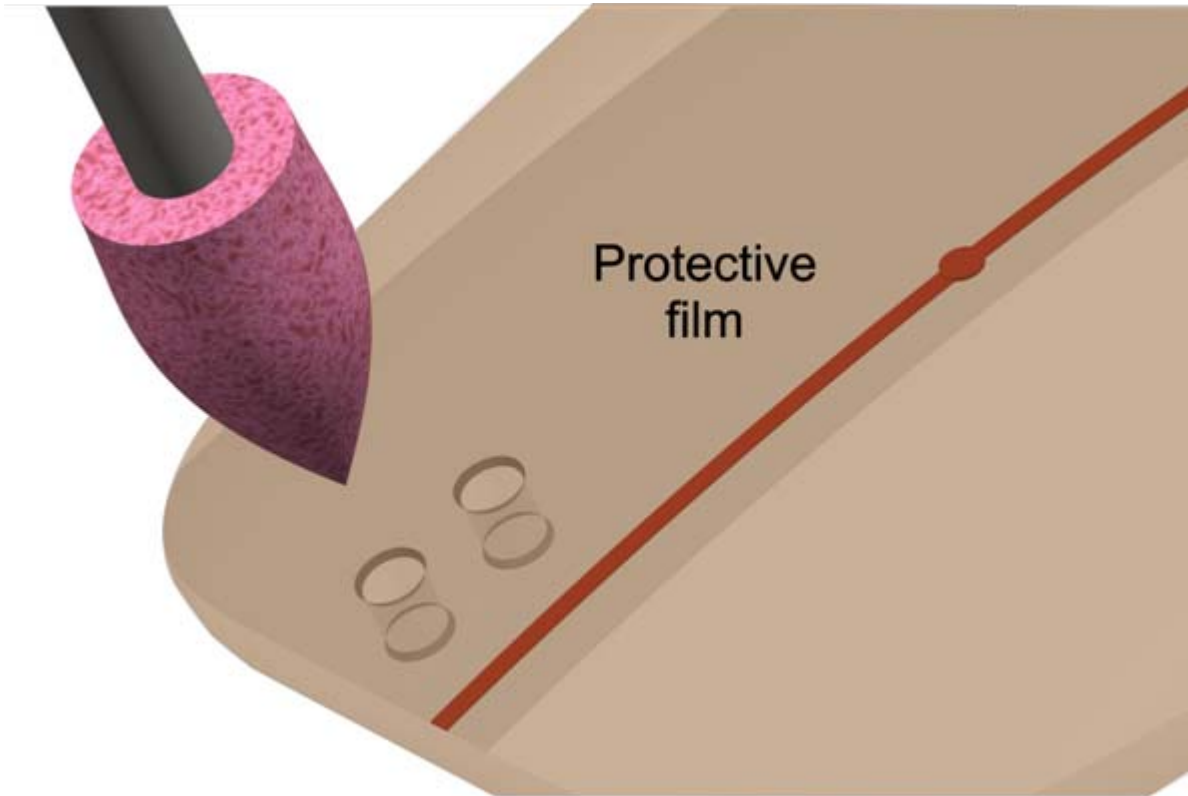
6.3. Cutting and Drilling



- Measure lenses in the focimeter. Mark the central axis with a waterproof pen. For 8-Base-front curves the enclosed 8-Base-axis lineal AC 344 is useful.
- Cut the lenses using a flat edge at a 1:1 scale.
- Polish edges as desired.
- Afterwards drill
 - a) **automatically** with lens cutting and drilling automate or
 - b) **manually** (see "Manual Drilling Method")

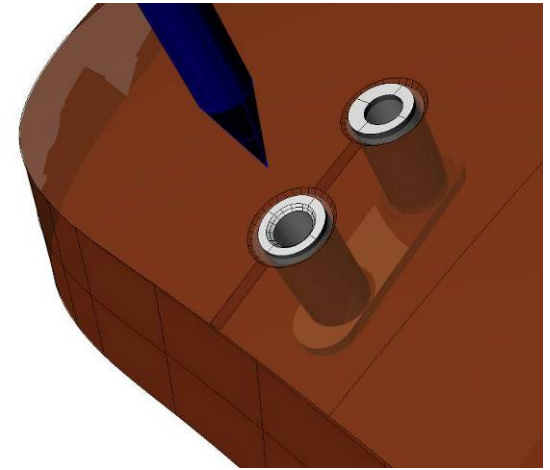
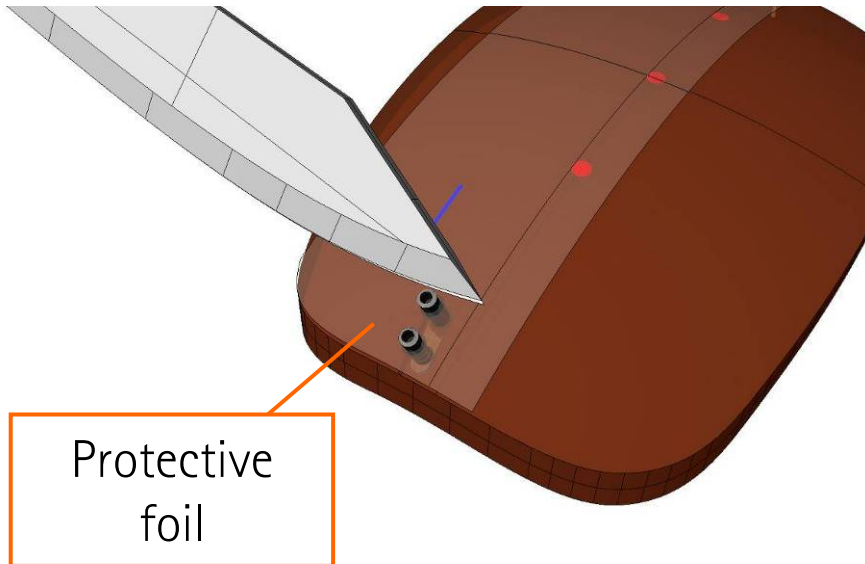
- 1) Model 8128: to achieve a well aesthetically result use an edger that is able to grind a facet with specified angle backwards.
- 

6.4. Deburring



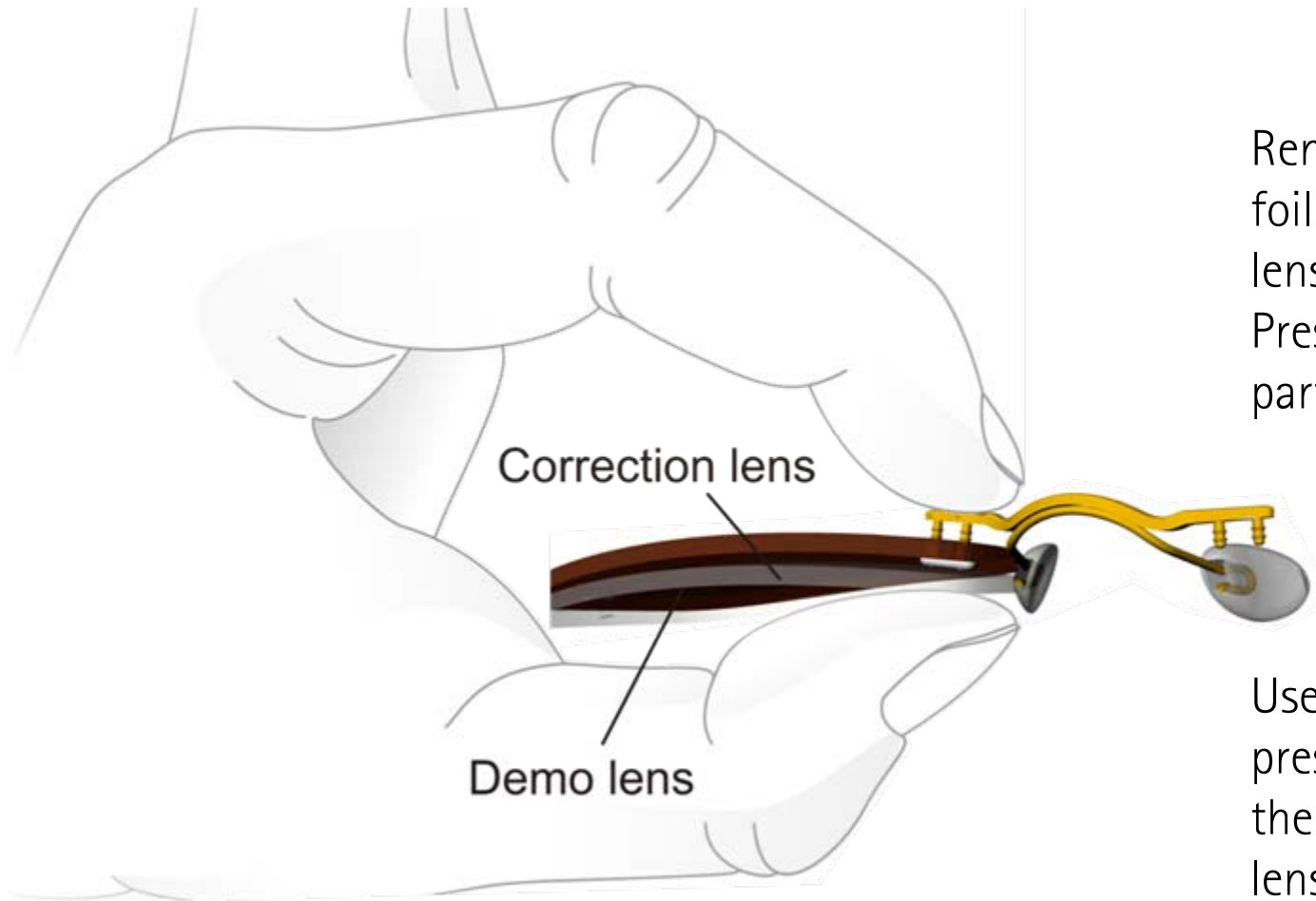
Fix protective foil on the lens front.
Deburr drilling holes carefully on both sides.

6.5. Press in Plastic Sleeves – Cut to Length – Expand



1. Insert plastic sleeves into the drilled holes to the stop.
2. Use BLS 58 for double drills, BLS 44 for single drills.
3. Only afterwards cut to the length, depending on the lens thickness, on the front. Place the blade parallel to the lens.
4. Expand the plastic sleeves with a conical pin, to make it easier to press in the frame parts.
5. Remove protective foil only after this.

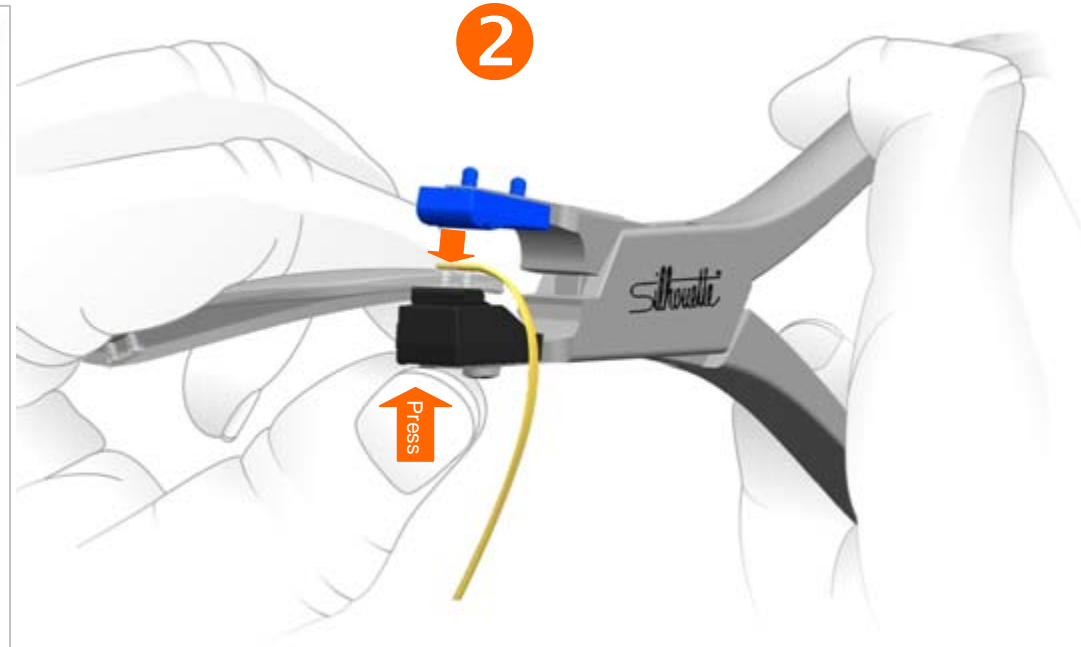
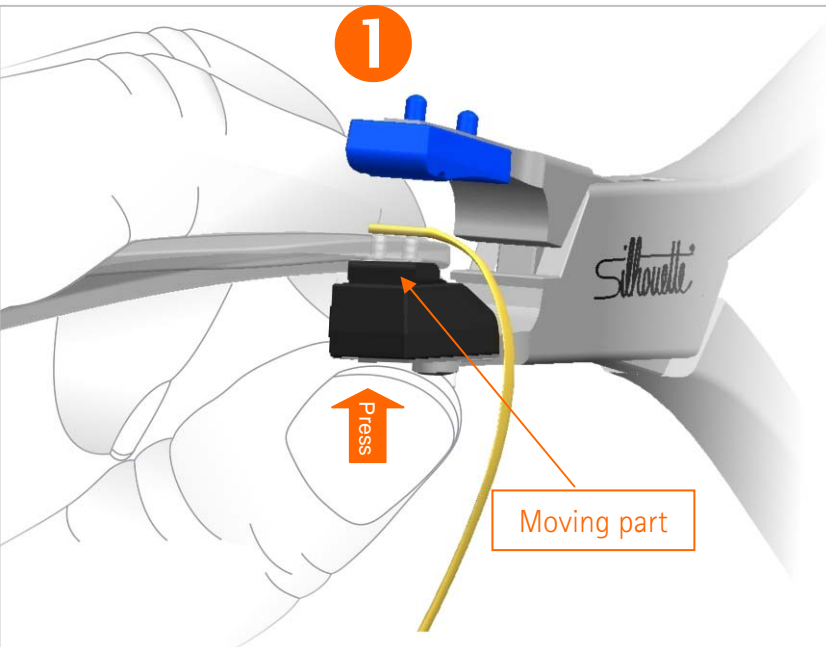
6.6. Press in the Frame Parts



Remove protective foil and marks. The lens must be clean! Press in the frame parts by hand.

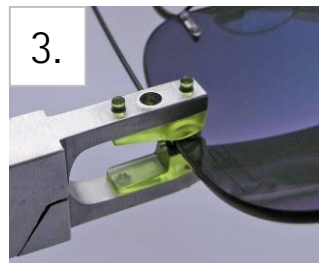
Use some counter pressure at the top of the BLS with a demo lens.

6.7. Fix Frame Parts in 2 Steps



1. Place the BLS moving part at the head of the BLS **precisely fitting** and press to the lens.

2. Hold counter-pressure against the BLS moving part. Only then close pliers and press in the frame parts completely - soft and in one go.



SH Adventurer Aviator: for single drills use the green, vertical sideparts AC 265 + AC 266.

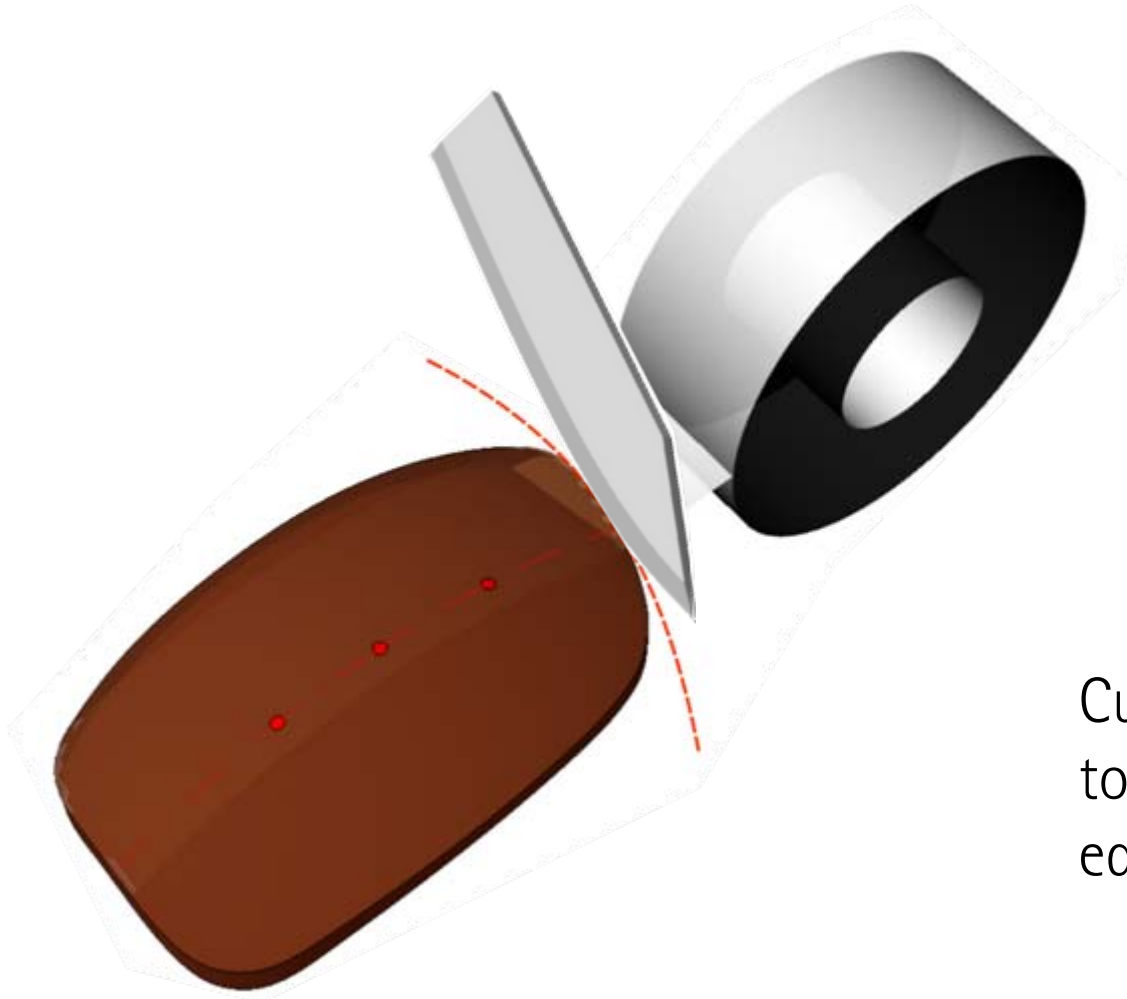
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7. MANUAL DRILLING METHOD
with
DRILLING TEMPLATE



7. Manual Drilling Method with Drilling Template

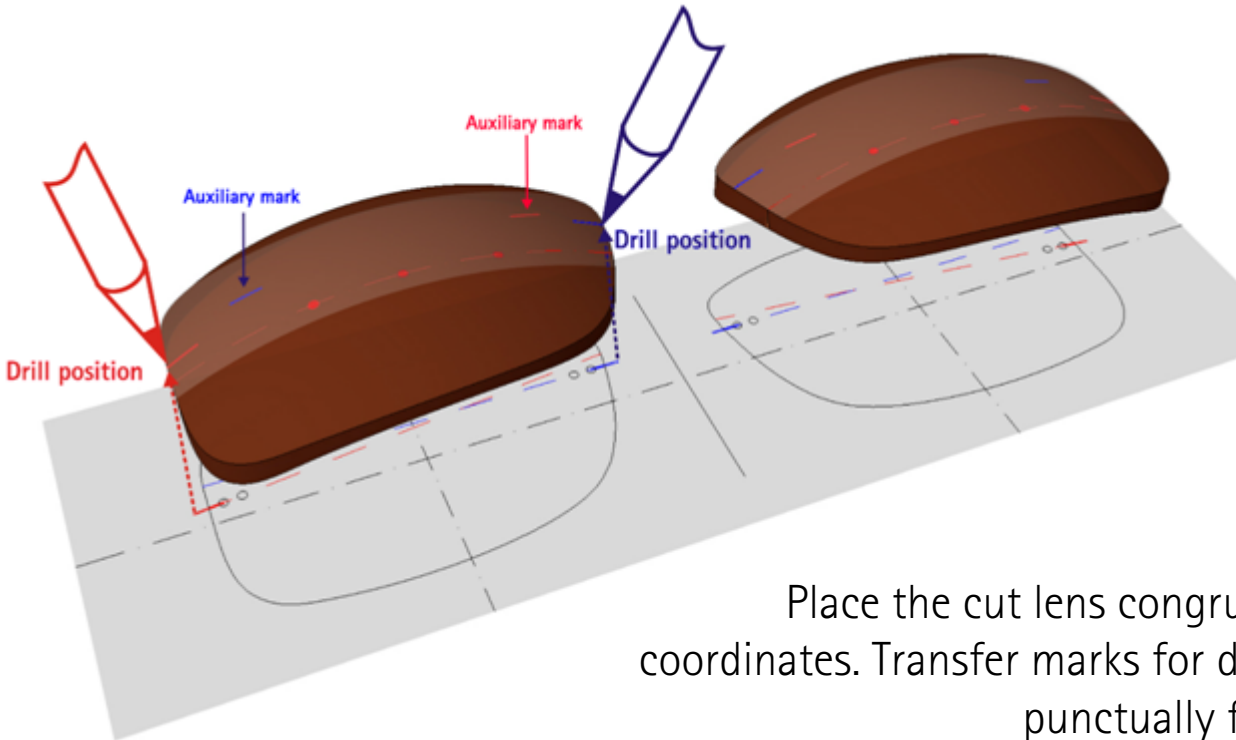
7.1. Fix protective foil on the lens front



Cut protective foil exactly to size following the lens edge!

7. Manual Drilling Method with Drilling Template

7.2. Transfer drilling position to prescription lens in colour



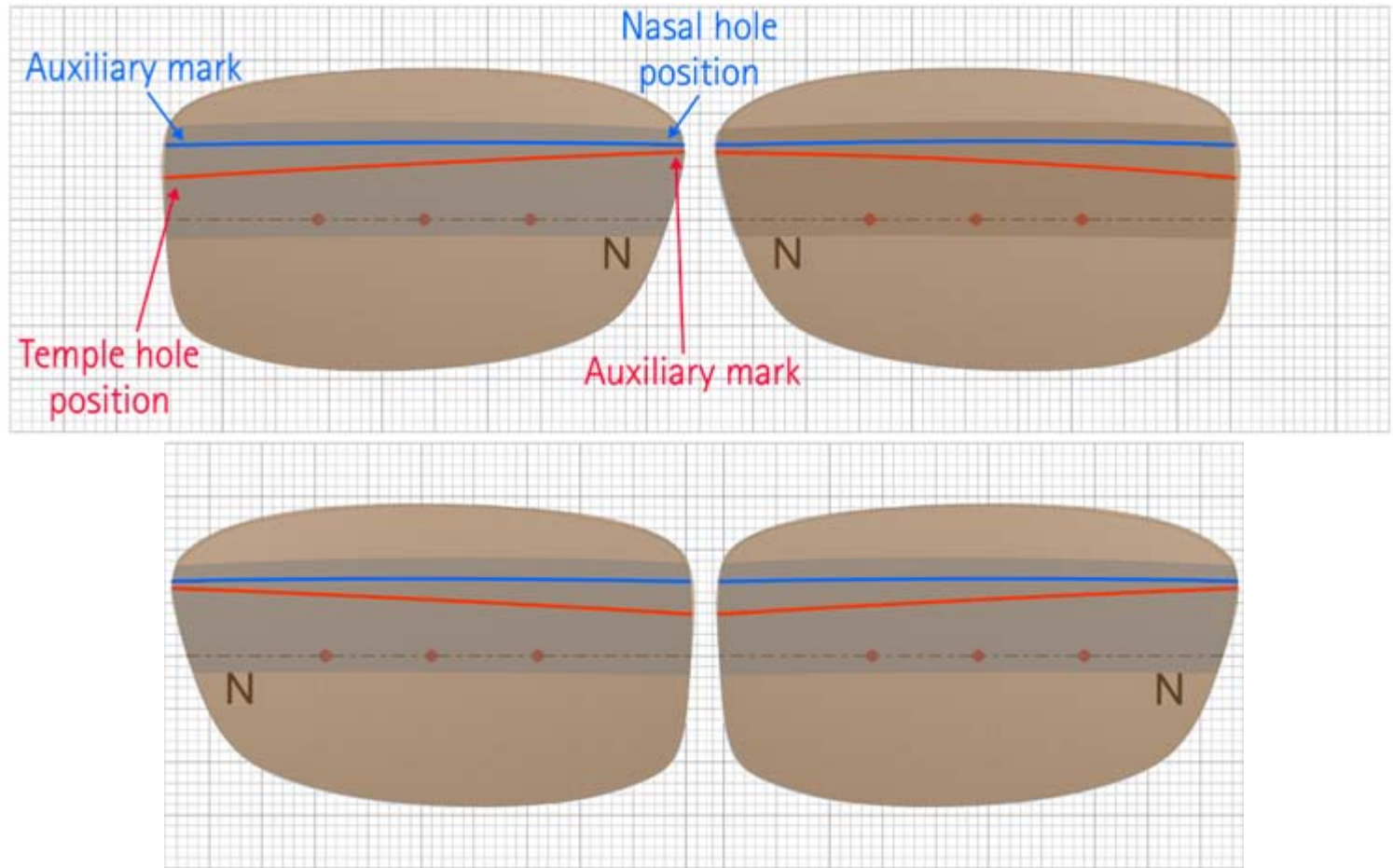
Place the cut lens congruently on the drawing of the drilling coordinates. Transfer marks for drilling positions and auxiliary marks punctually from the lens edge to the lens front. Use different coloured pens for the marks on bridge and side parts. Connect punctual marks according to the colour (Nasal = blue / Temporal = red).



Use the 8-Base-axis lineal!

7. Manual Drilling Method with Drilling Template

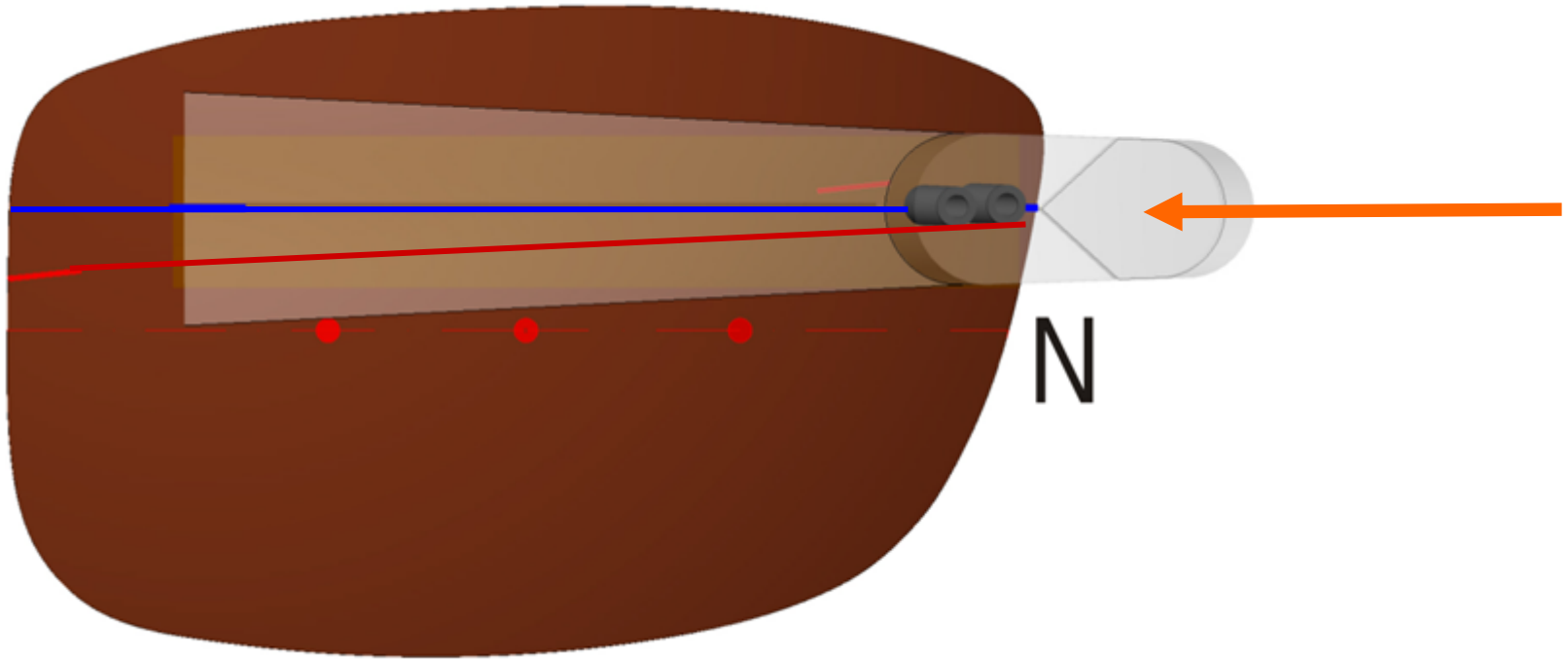
7.3. Control marks



Marks must be at the same level on both lenses.
A chequered pad is helpful for this purpose.

7. Manual Drilling Method with Drilling Template

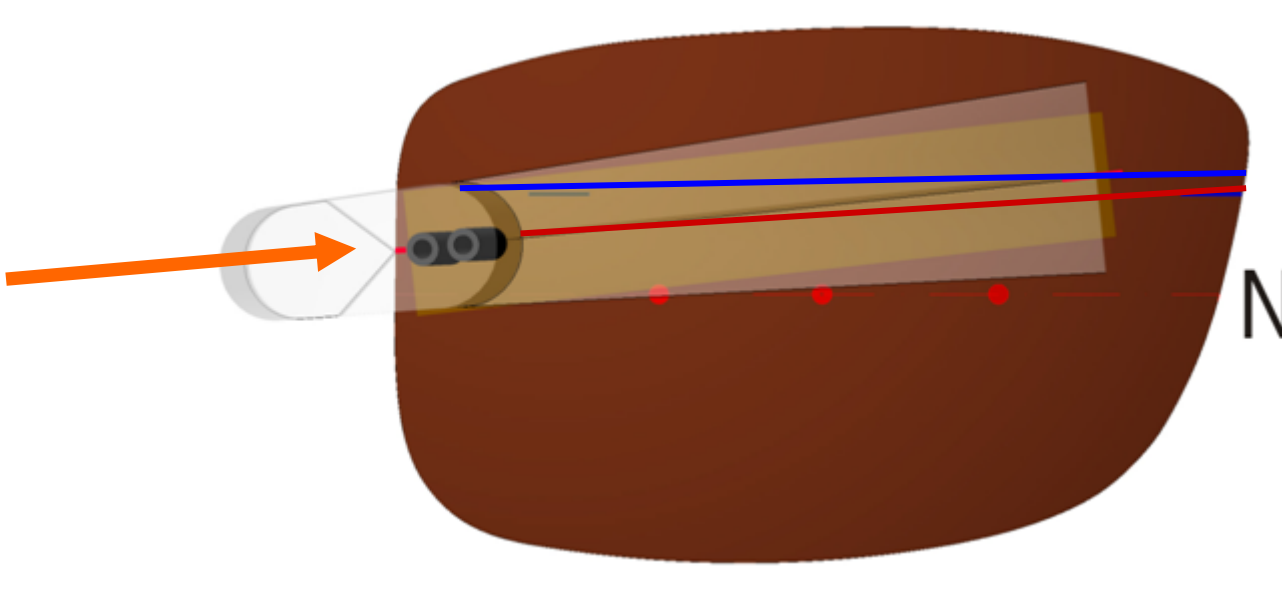
7.4. Nasal drill for bridge



1. Fix the drilling template on the lens front with a double adhesive tape. Place the adhesive tape up to the central peak of the drilling template.
2. Place the central peak of the drilling template at the **nasal blue** mark. Align the central line of the drilling template at the **blue** auxiliary mark.

7. Manual Drilling Method with Drilling Template

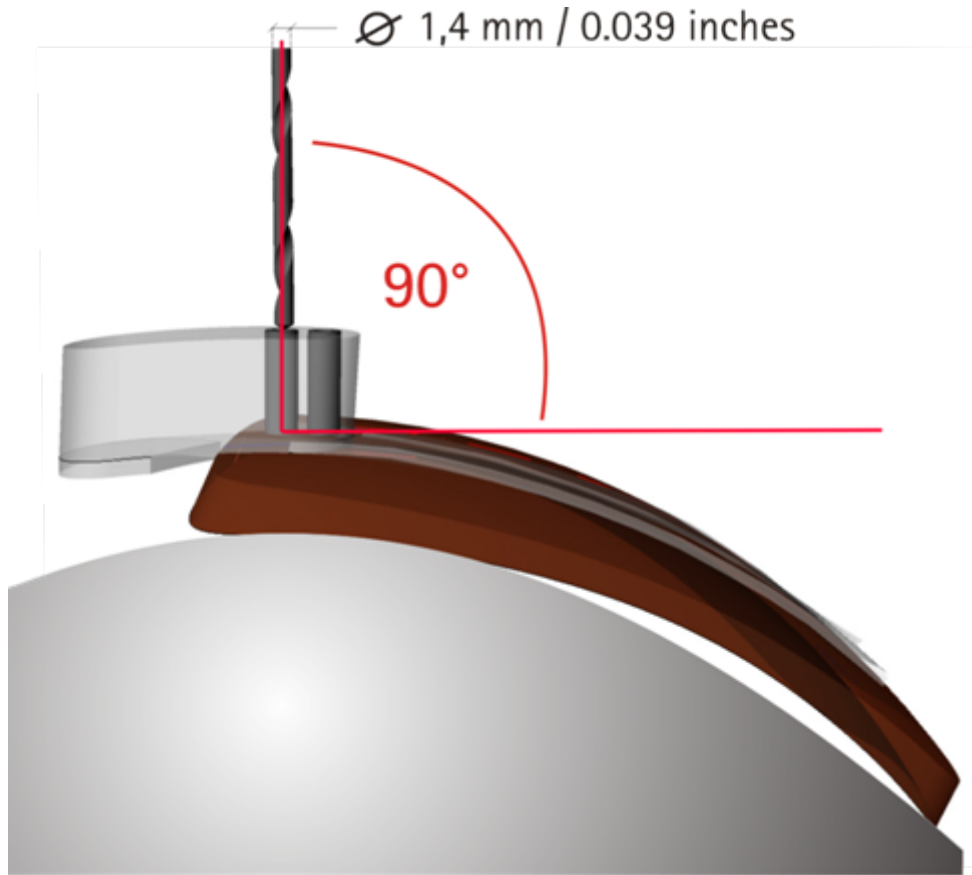
7.5. Temporal drill of side parts



Place the central peak of the drilling template at the **temporal red** mark. Align the central line of the drilling template at the opposite, **red** auxiliary mark.

7. Manual Drilling Method with Drilling Template

7.6. Drilling



Place prescription lens on a curved drilling pad. Drill holes 90° to the lens front.

NOTE: Keep the drilling diameter exactly! Too large drills will reduce the durability.