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# Technical Instructions T086 –T089

**T086 Greta**
**T087 Bill**
**T088 David**
**T089 Erin**

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# Bio-Based frame material

- 100% bio-based **natural3D** frame material derived from the castor oil bean
- Frames produced with 3D printing technology
- Stainless steel hinge elements
- Titanium needle in temple end for lasting temple bend adjustments
- Lacquer layer provides smooth frame finish
- Cut lenses on size and cold insert


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# Glazing - General

- Frame designed with 5.0 base curve
- Other base curves will work and should have bevel profile matching 5.0 base curve
- All lens materials are possible
- OMA shape files available at https://portal.silhouette.com
- Do not heat frame to aid lens insertion!
- If lenses are large, resize to allow cold insert



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# Glazing - Lens bevel and placement

- Frames have a standard V bevel for lens retention
- For best lens fit, the bevel on the lens should follow frame curve of 5.0
- Consult edger instructions for setting bevel curve
- The lens bevel curve matching the frame curve will minimize needing extensive bench alignment of the frame after lens insertion



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# Glazing - Lens insertion

- **natural3D** frames require a cold snap lens insertion
- Lenses should be cut on size.  Large lenses must be resized to allow cold insert
- Frames should be at room temperature for lens insertion
- Frame should not be heated to ease lens insertion!

# Inclination

- Incline the temple at the logo hinge carefully.
- Hinge has special curve to prevent excessive gap with inclination adjustments.



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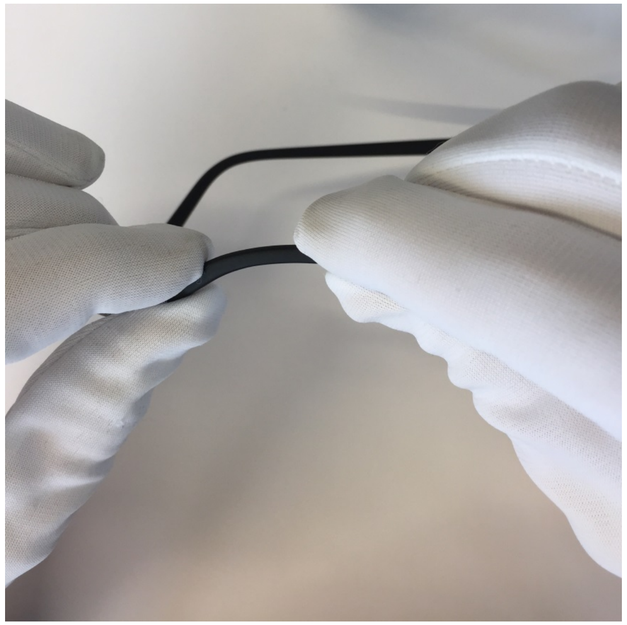
# Temple adjustment



Straighten temple end

Re-adjust temple end using gentle curves

Adjust temple only within the thin area of the titanium insert

**Heating the material up to 70°C for temple end adjustment is permitted**



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