SF classic / Technical Manual

1. Frame system
2. Frame parts
3. Devices / Tools
4. Technical data drilling
5. Mounting instructions for straight temple
6. Mounting instructions for raster temple
7. Disassembly: Temple, nosepad, pin
8. Typical mounting mistakes
9. Basic fitting in Lab
10. Cleaning

1. Frame system

Endpieces

- straight
- curved

Earpieces

- raster standard
- raster kid
- raster strong

Hinge

- standard (72 colors)
- Base 8 (22 colors)

Pad

- 10 sizes
- 5 adapters

Temple

- straight
- raster

Bridge

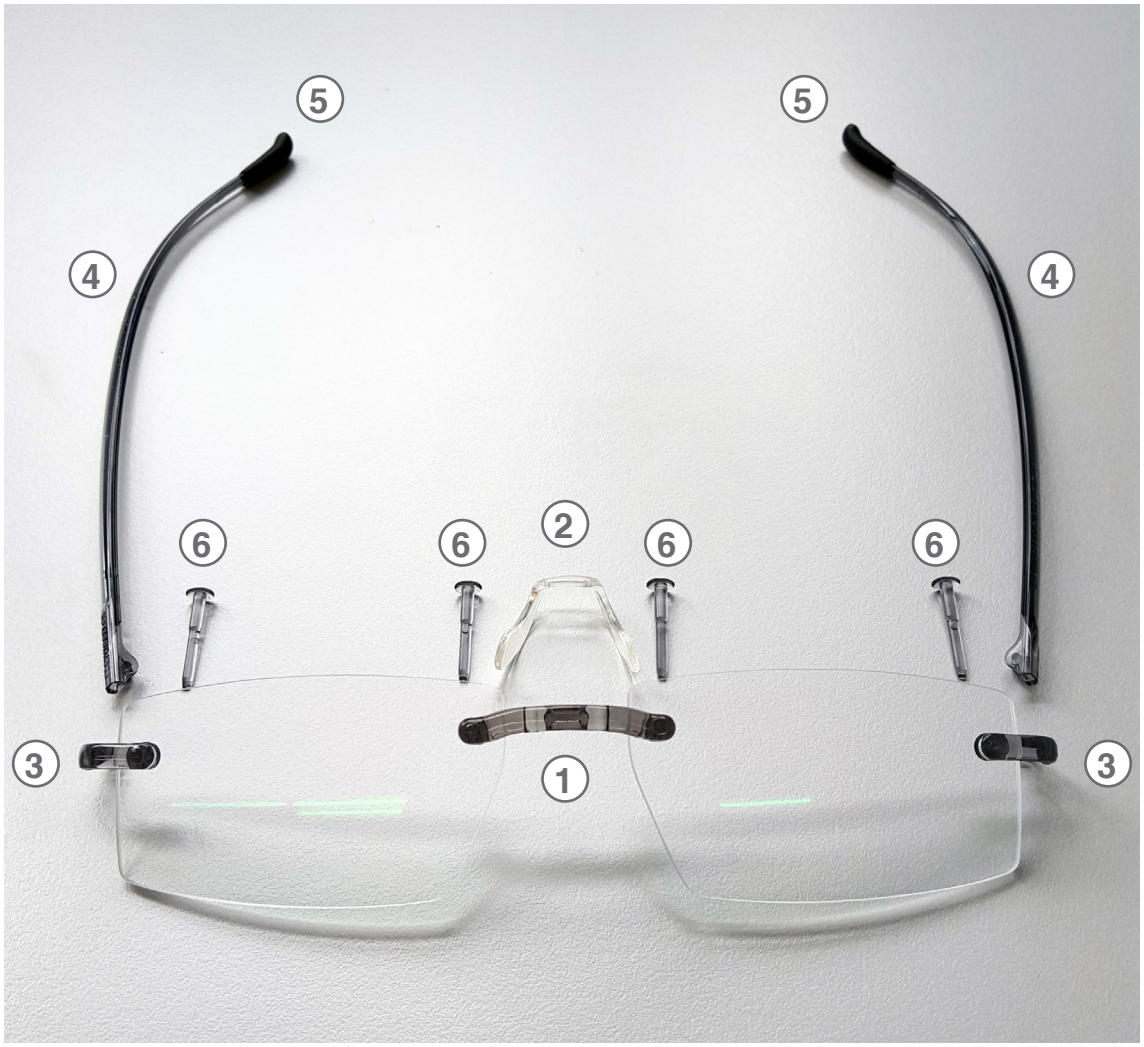
- standard
- small bridge

Colors

• polished	72
• frosty	72
• glitter	8

Pictures of all the elements above are available in the legend and the color overviews of the order forms.

2. Frame parts



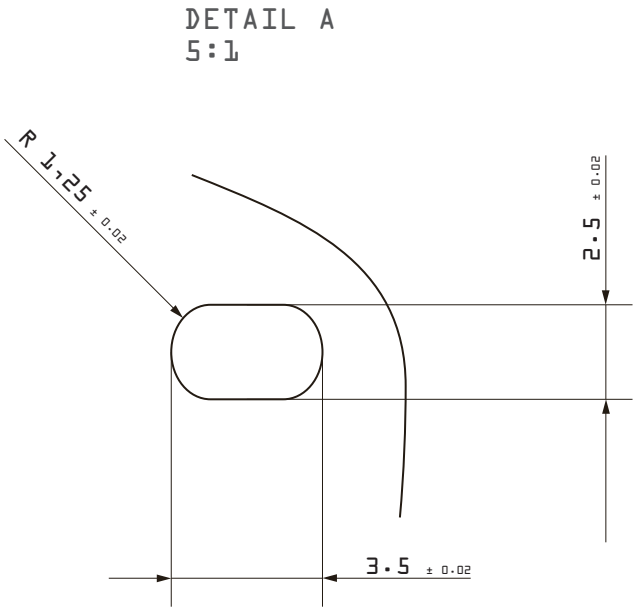
1. Bridge
2. Nose pad
3. Hinge
4. Temple
5. Endpiece
6. Pin

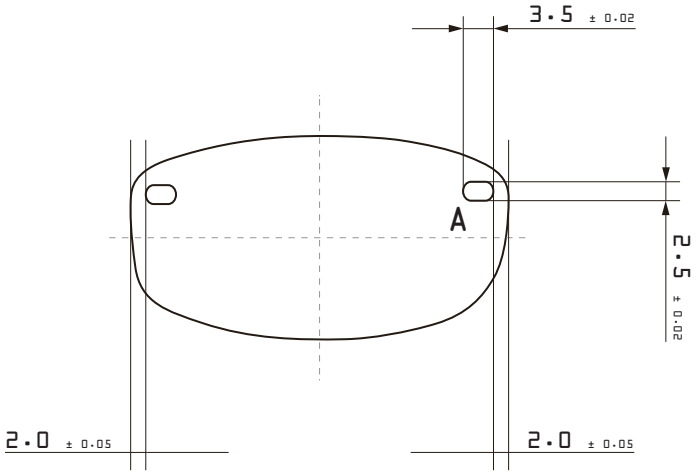
3. Devices / Tools

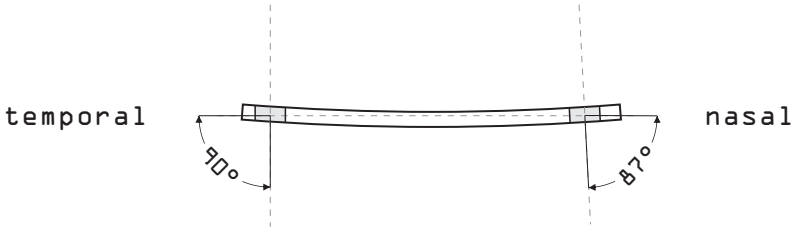
The devices and tools are matched especially for Swissflex and only by using them the optimal mounting quality can be guaranteed.

	Tools	Article code
1	Demounting device	70211042
	Demounting top	70111043
2	Rivet device	70211041
	Rivet top	70111041
	Rivet countereffect	70111042
3	Mounting plier	70111045
4	Metal spacer	70111046
5	Core drill with handle	70003004
6	Diagonal cutting nipper 632N	70003005
7	Diagonal cutting nipper 582N	70003006
8	Mounting tool for pad clip	70003007

4. Technical data drilling



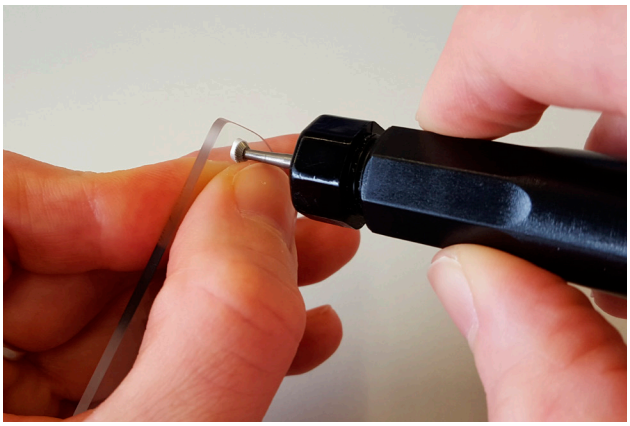




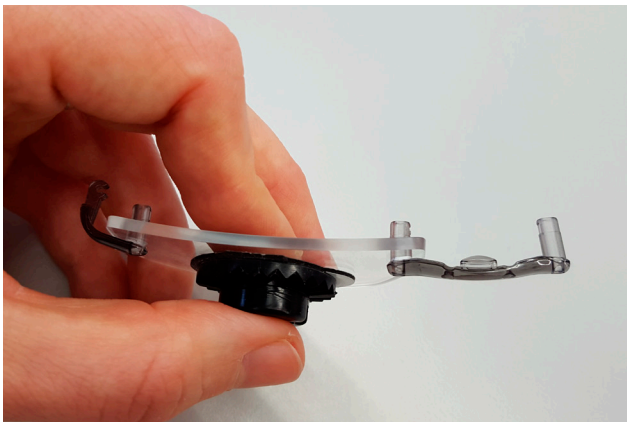
(A minimum glass thickness of 1.8 mm is recommended)

5. Mounting instructions for straight temple

1 Deburring the long holes from the front and back with the sinker.

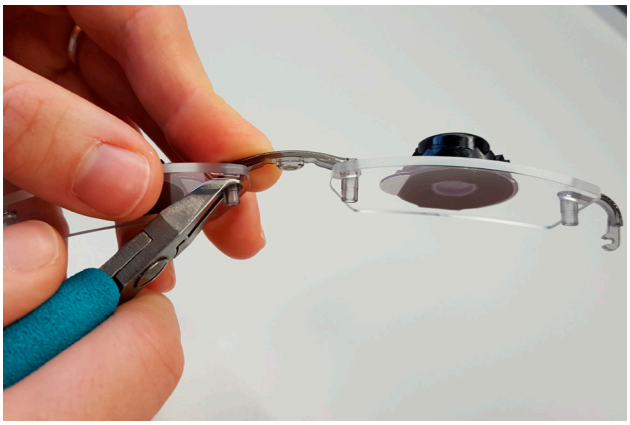


2 Inserting of bridge and hinge in long holes and pressing them up to the lens surface.



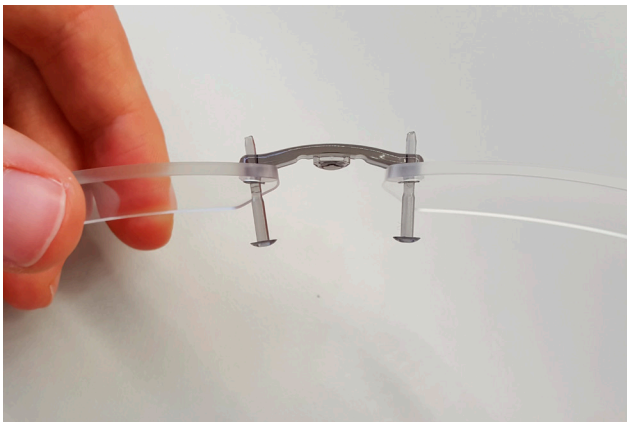
3 Making sure bridge and hinge closes tight against the front surface of the lens. Cutting the remaining part of the pins along the inside of the lens surface.

Use the tool cutter 582N.

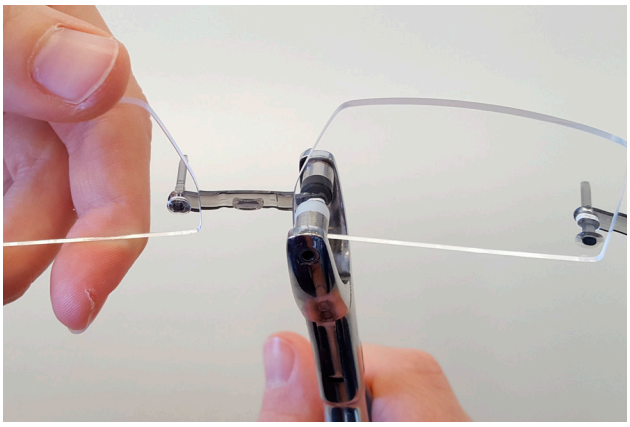


4 Depending on the blocking system it is advisable to remove the blockers before further working steps.

5 Inserting the rivet pins from the inside in the holes of the bridge and hinge.

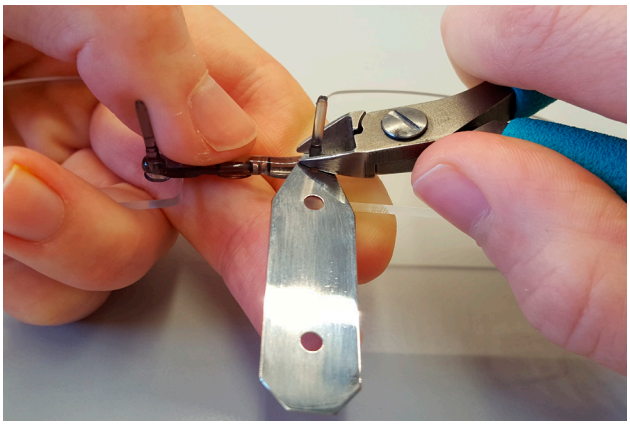


6 Pressing all the pins with the mounting pliers.



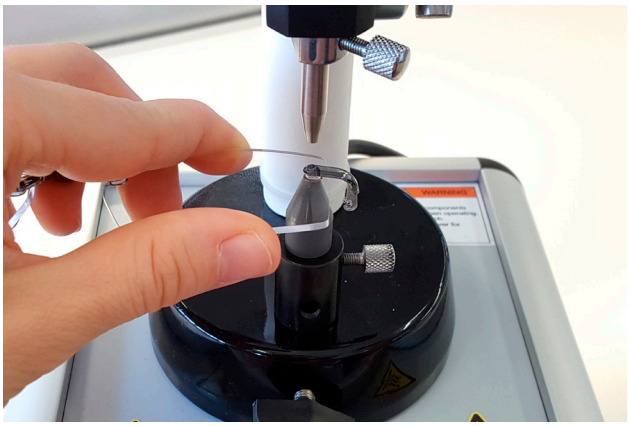
7 Cutting the protruding rivet pin plan at the distance gauge.

Use the tool side cutter 632N.



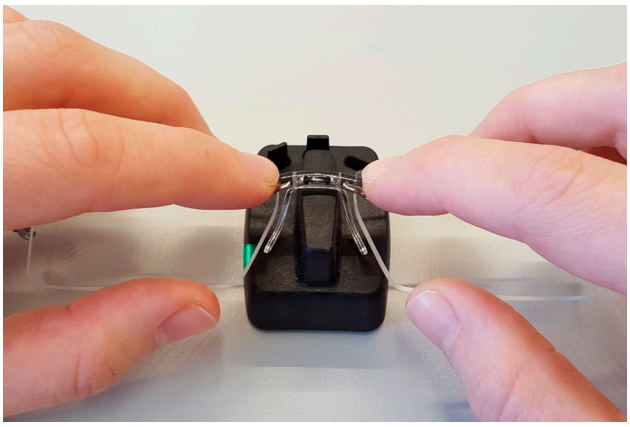
8 Riveting of the shortened rivet pins with a pre-heated rivet tip on the outside of the lens. A temperature of 220° C. +/- 10° C. is recommended.

If the temperature is too high the polymer sticks to the rivet tie and tool and rivet tip get mat and rough and have to be replaced to ensure the proper quality. Good result from more time and less pressure.

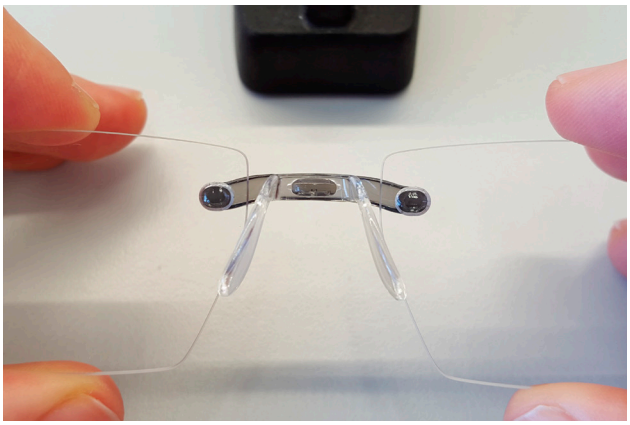


9 Preparations of the pad assembly, inserting the mounting aid in the pad.

10 Placing the bridge with the mushroom downwards vertically on the mounting aid and pushing it down until it clicks into place.

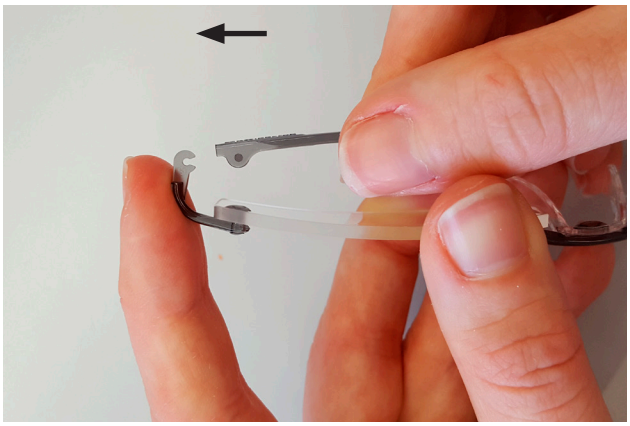


11 Checking the correct fit.



12 Mounting the endpieces with the tip outwards.

13 Fixing the hinge, positioning the temple parallel to the front, inserting the temple in the hinge until it clicks into place.



14 Mounted frame is ready but not pre-fitted.

More information in the fitting chapter.

6. Mounting instructions for raster temple

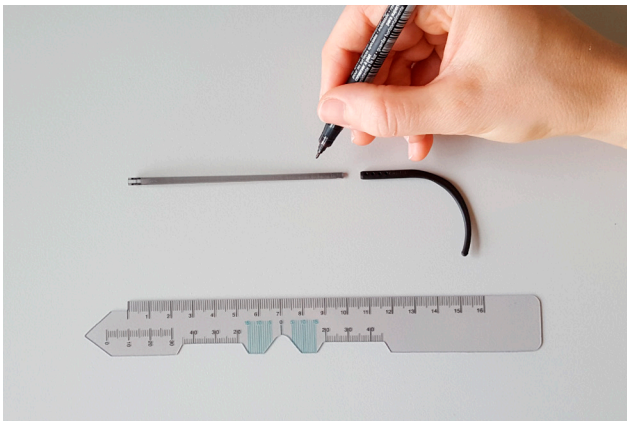
1 Preparation of parts:
- raster temple
- raster earpieces

2 Mounting the temples to place the frame on the head of the consumer.

Putting the earpiece close to the ear, marking the overlay at the temple (determine the length for each side individually).

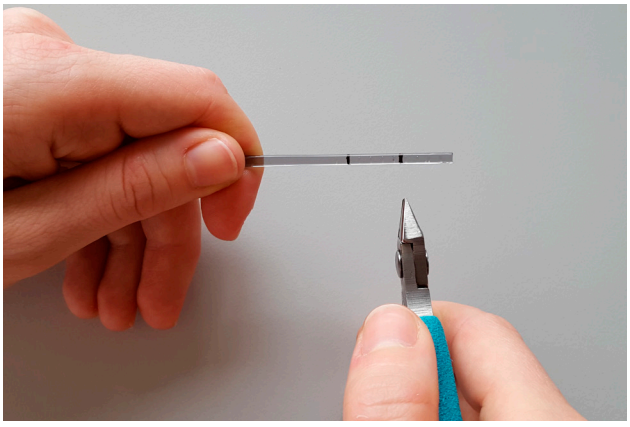
3 Marking the intersection point.

Determination of the necessary allowance and adding it to the length of the temple.



4 Shortening the temple to the desired length.

Use the tool side cutter 632N.



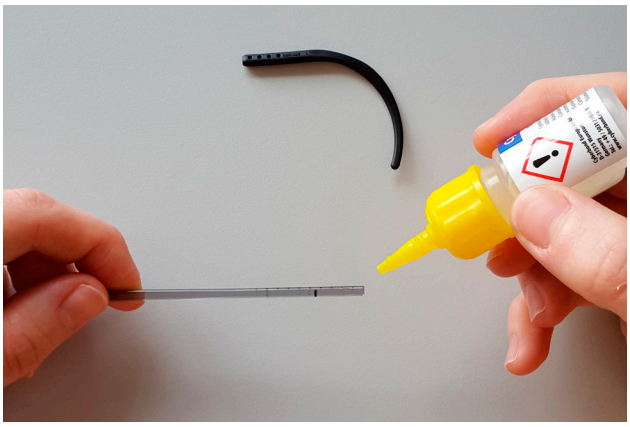
5 Heating the ends of the temple slightly from both sides on order to simplify the installation.

6 If necessary the earpiece can be glued to the temple.

Application of glue (only on cut surface) in small quantity with immediate assembly.

Remove any visible glue immediately.

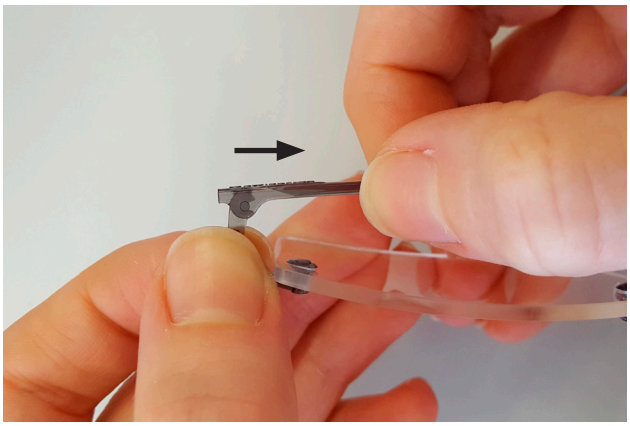
Official product for glueing earpieces is CB 2008.



! Caution!
Observe the safety regulations regarding glues and solvents.

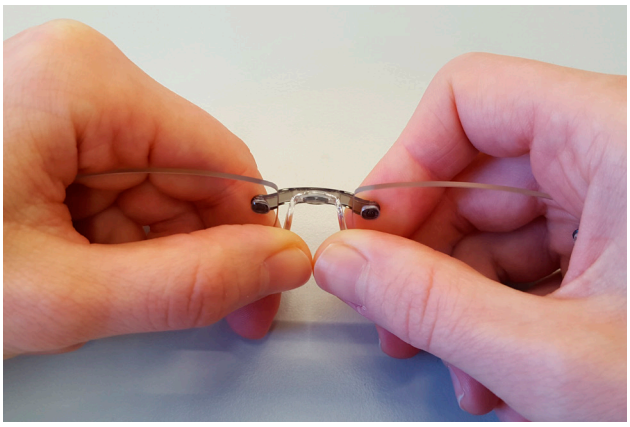
7. Disassembly: Temple, nosepad, pin

1 Closing the temple, fixing the hinge with thumb and fingers, pulling the temple jerking towards the opposite hinge. Check the opening angle of the hinge.



2 Removing the pad.

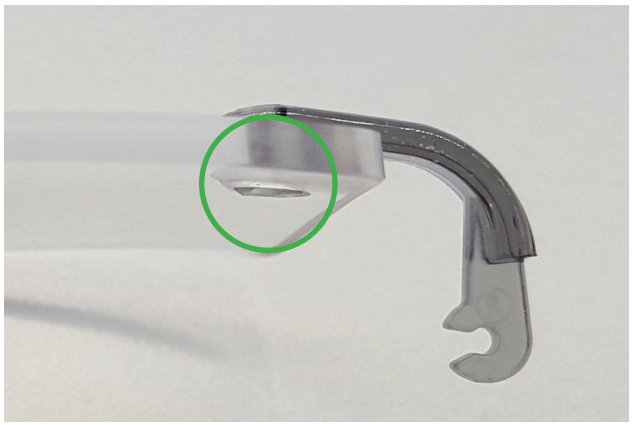
Press the wings with both thumbs downwards until the pad clicks out.



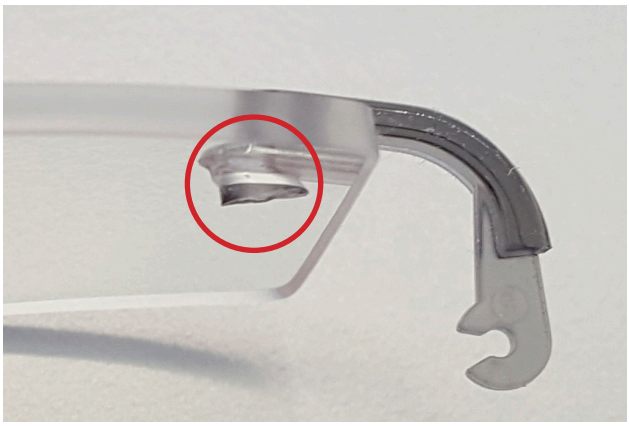
3 Removing the rivet pin.

Placing the pin on the disassembly device. Using the mandrel to fix the rivet head centrally and push it out.

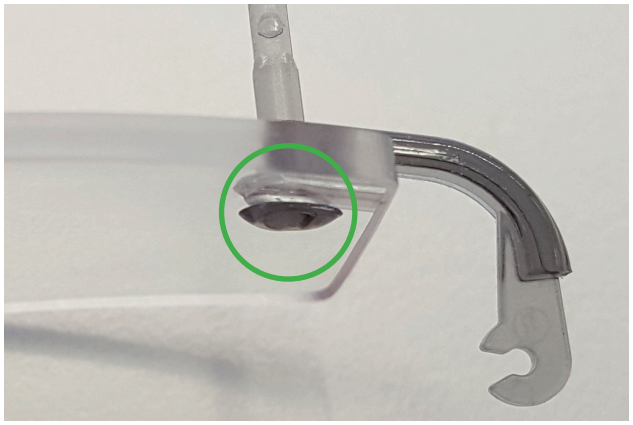
8. Typical mounting mistakes



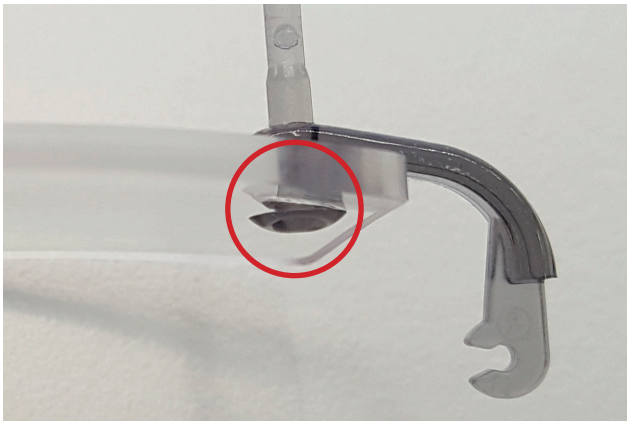
Mounting pin cut plan to lens



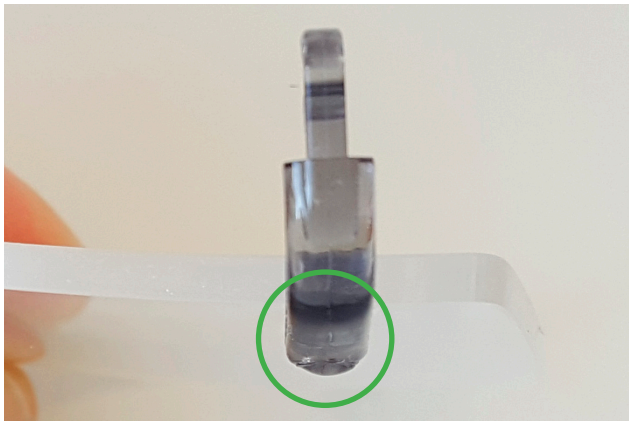
Mounting pin cut at an angle to lens



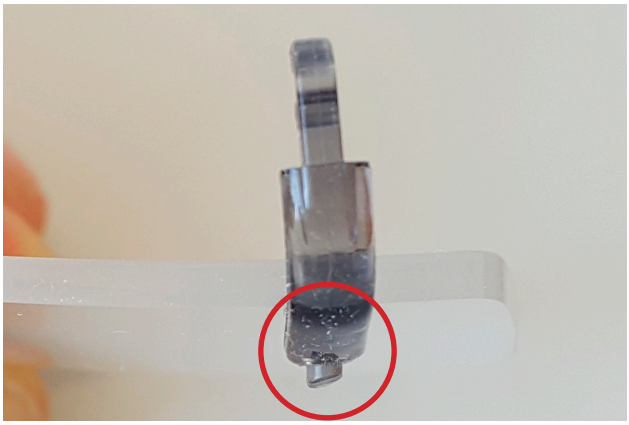
Rivet pin lays flat on lens surface



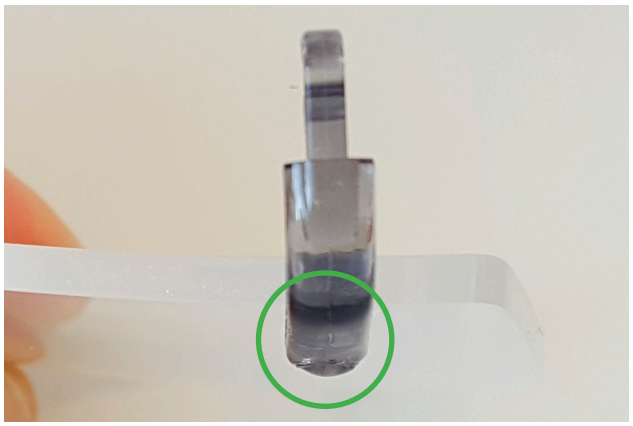
Rivet pin at an angle to lens surface



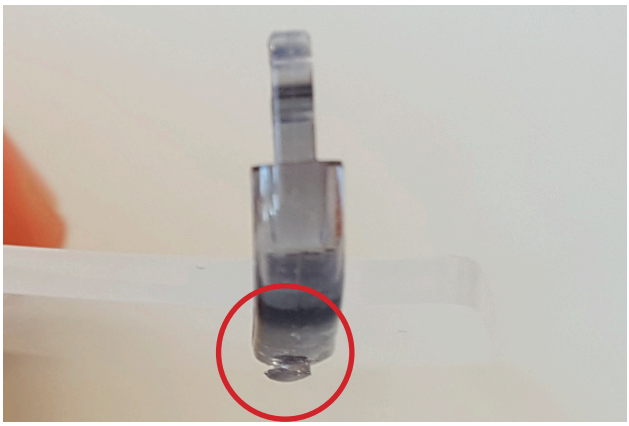
Rivet pin cut correctly (length & angle)



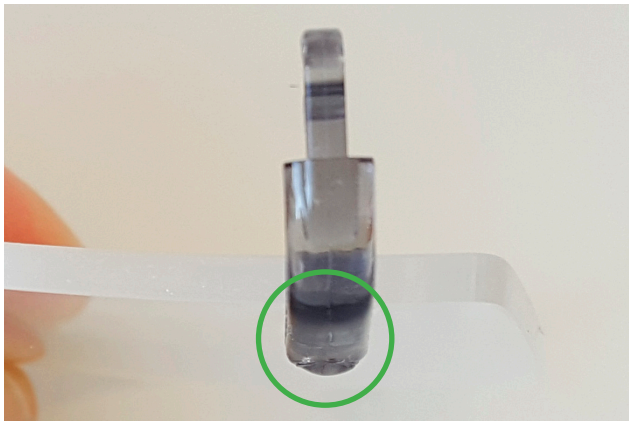
Rivet pin cut too long / too angled



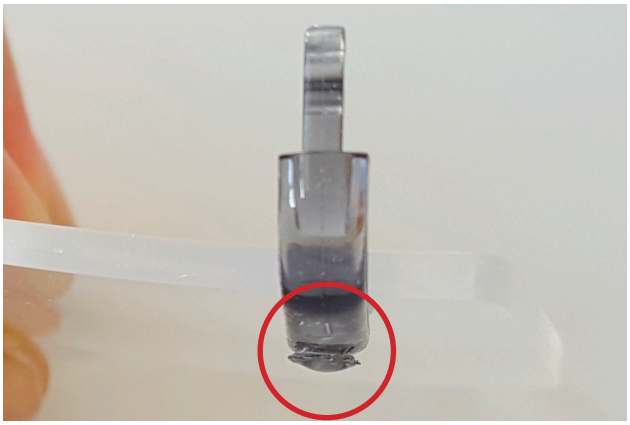
Rivet pin correct



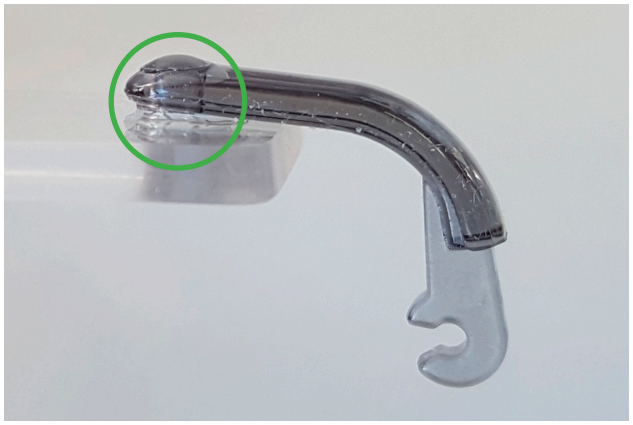
Rivet pin tilts sideways and is too big



Rivet pin correct



Rivet pin too big (not shortened enough)



Rivet pin correct

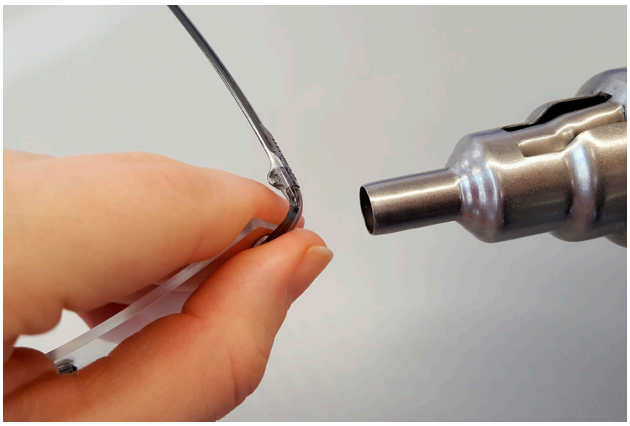
Rivet pin with edge (too much pressure or too much time – part has to be replaced)

Hinge is in its original state

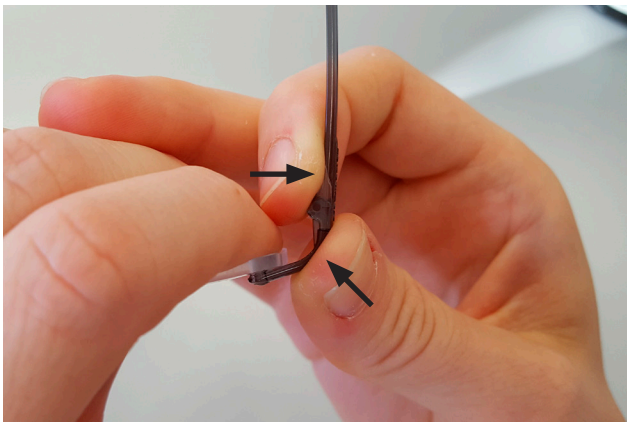
Hinge is widened (incorrect handling)

9. Basic fitting in Lab

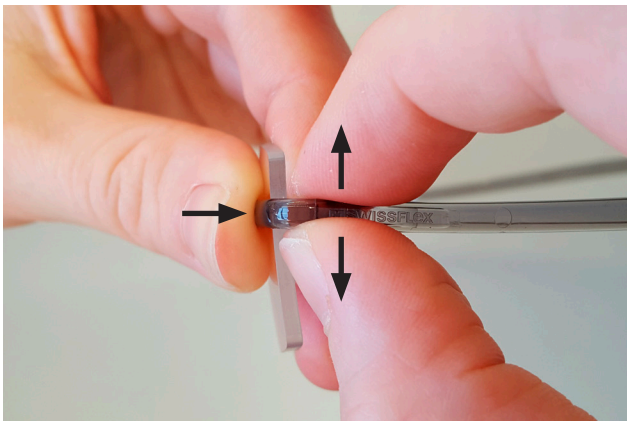
1 Heating the hinge from both sides gradually while protecting the lens.
Adjust the temperature to the clearance.



2 Increasing/Decreasing the opening angle.

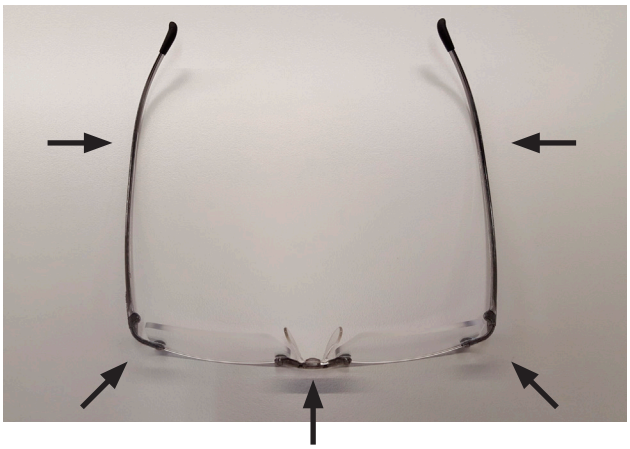


3 Adjusting inclination.



4 Possible points for tuning.
- Bridge (remove pad before)
- Hinge
- Temple (not in the area of the connection of hinge and temple)

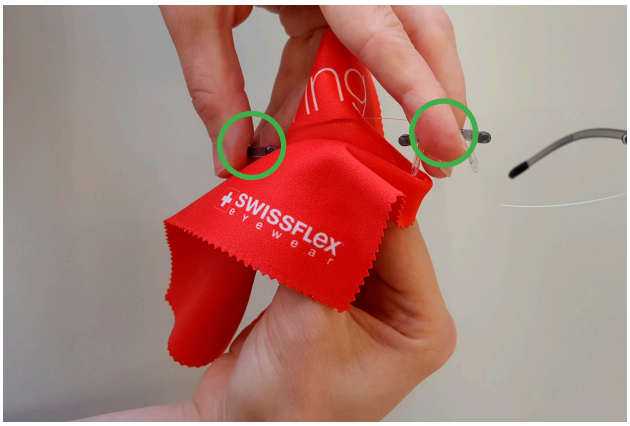
Adjusting the temperature to the respective clearance.



10. Cleaning

1 Correct cleaning.

Fixing the frame at bridge and hinge. It is recommended to clean the glasses with soap and clean water. The removal of glue residues on the frame with acetone. Avoid alcohol (e.g. Isopropanol) and solvents.



2 Incorrect cleaning.

Not fixing the frame properly which results in a torsion between the lens and the frame.