

## SF motion / Technical Manual



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## 1. Frame system

### Earpieces

- skull 2 regular
- skull 2 heavy

### Endpieces

- straight
- skull 2
- curved skull 2

### Hinge

- standard
- Base 8

### Nose pad

- 10 sizes
- 5 adapters

### Temple

- straight
- skull 2

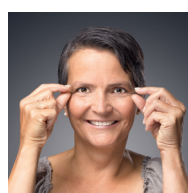
### Bridge

- standard

### Colors

- polished 31
- matt 15
- decor (temple) 6

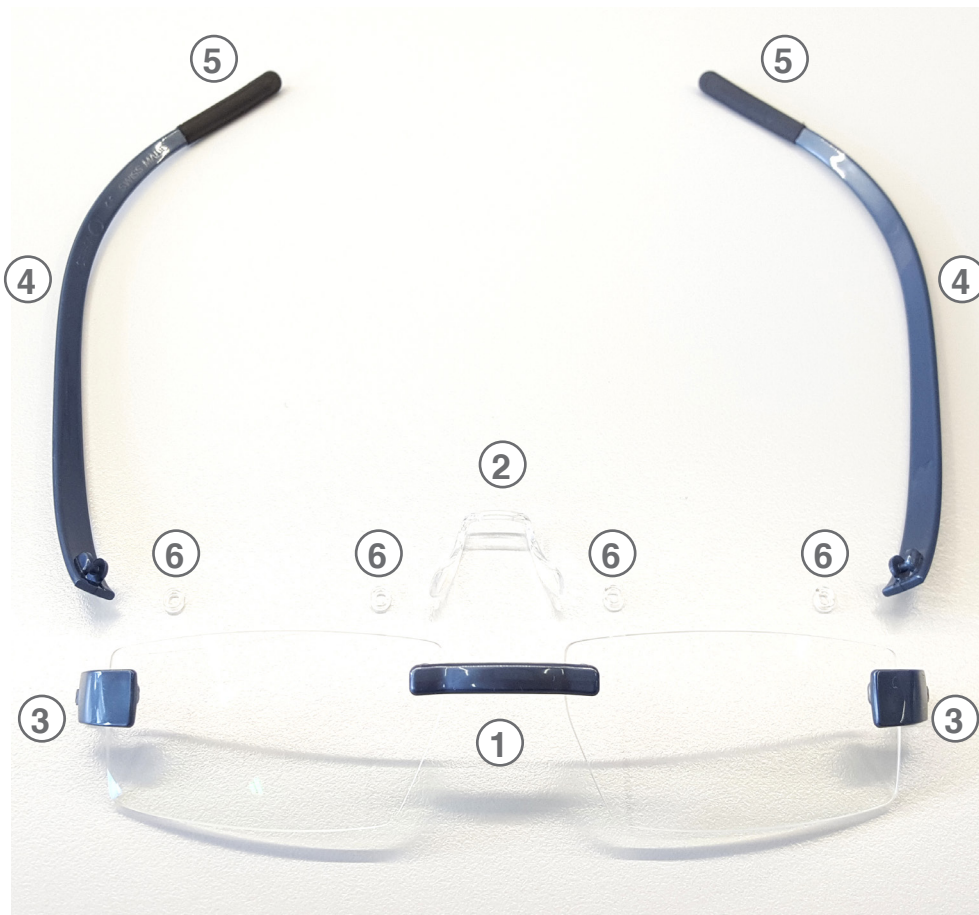
Pictures of all the elements above are available in the legend and the color overviews of the order forms.



like  
wearing  
nothing.

**+**  
perfekte Passform  
modulare Individualität  
100% Swiss-made

## 2. Frame parts



- ① Bridge
- ② Nose pad
- ③ Hinge
- ④ Temple
- ⑤ Endpiece
- ⑥ Mounting ring

### 3. Devices / Tools

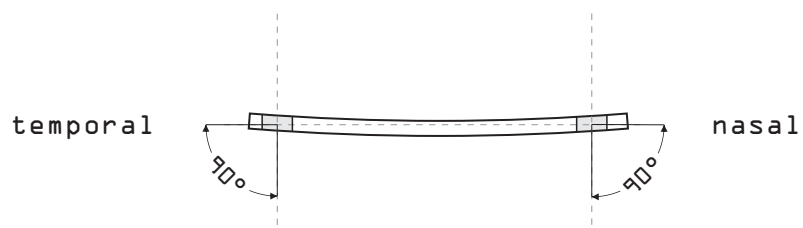
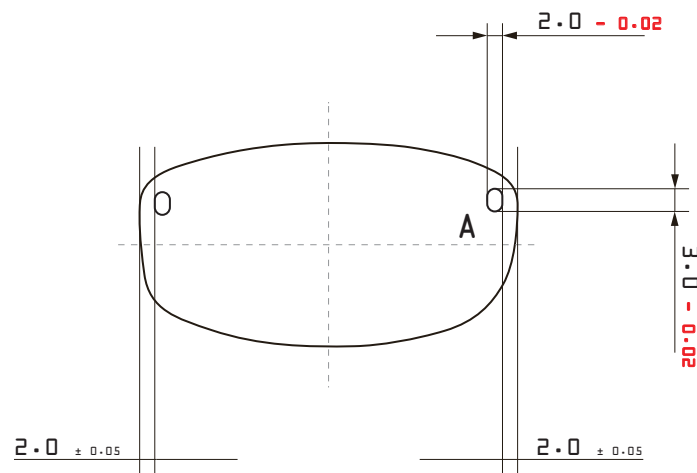
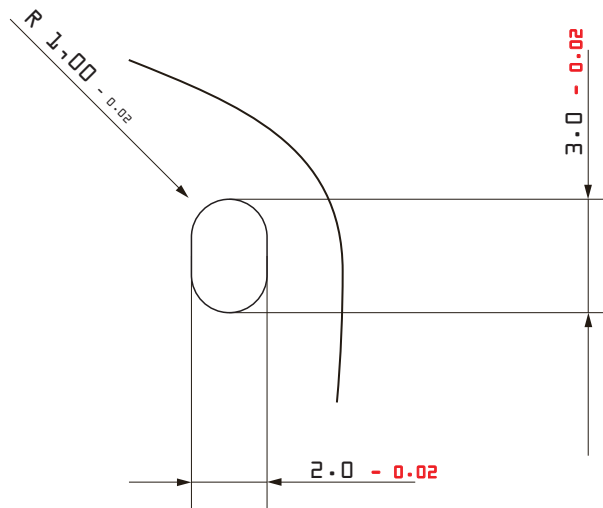


The devices and tools are matched especially for Swissflex and only by using them the optimal mounting quality can be guaranteed.

Tools	Article code
<b>①</b> Rivet device Rivet top Rivet countereffect	70211041 70111041 70111042
<b>②</b> Mounting plier	70212045
<b>③</b> Metal spacer	70212046
<b>④</b> Core drill with handle	70003004
<b>⑤</b> Diagonal cutting nipper 632N	70003005
<b>⑥</b> Diagonal cutting nipper 582N	70003006
<b>⑦</b> Mounting tool for pad clip	70003007

## 4. Technical data drilling

DETAIL A  
5:1



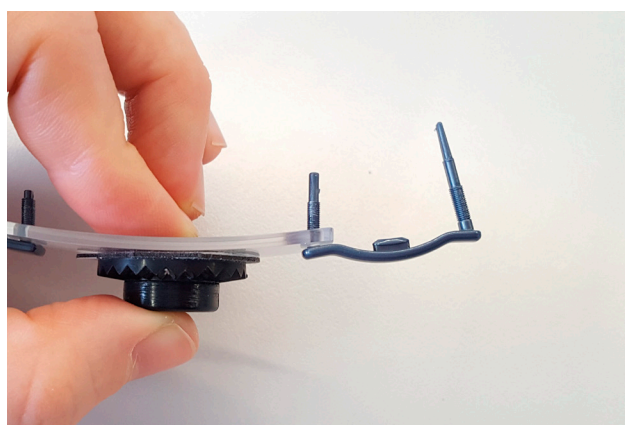
(A minimum glass thickness of 1.8 mm is recommended)

## 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 Slip the mounting rings on the mounting pins.

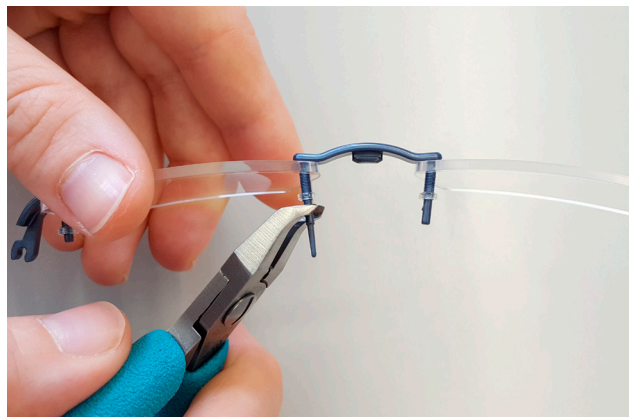


- 4 Depending on the blocking system it is advisable to remove the blockers before further working steps.

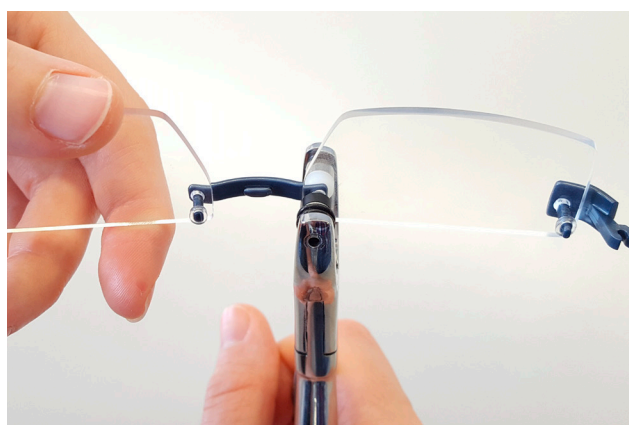





- 5 Cut the assembly pins of the bridge to just behind the mounting ring.  
Cutting the remaining part 1mm behind the mounting ring.



- 6 Pressing all the rings with the mounting pliers.

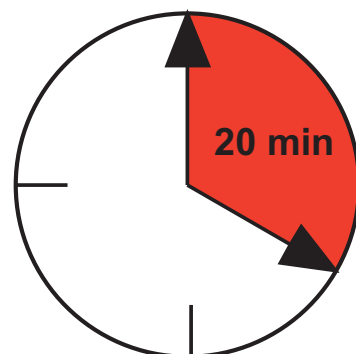


- 7 Application of glue in small quantity.  
Remove any visible glue immediately.  
Official product for glueing is CB 2008.

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

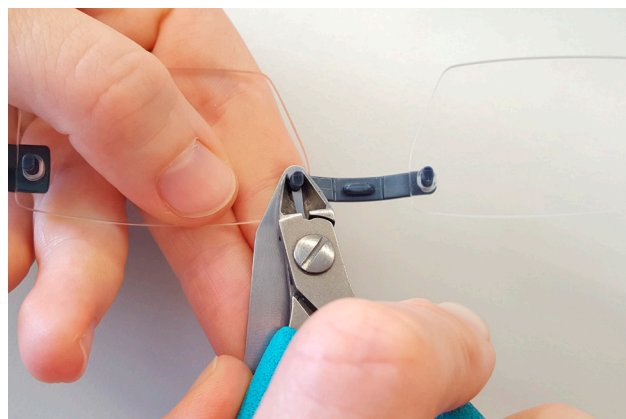


- 8 Curing time at 20°C / 68°F 20min.



- 9 Cutting the protruding rivet pin plan at the distance gauge.

Use the tool side cutter 632N.



- 10 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.



- 11 Preparations of the pad assembly, inserting the mounting aid in the pad.

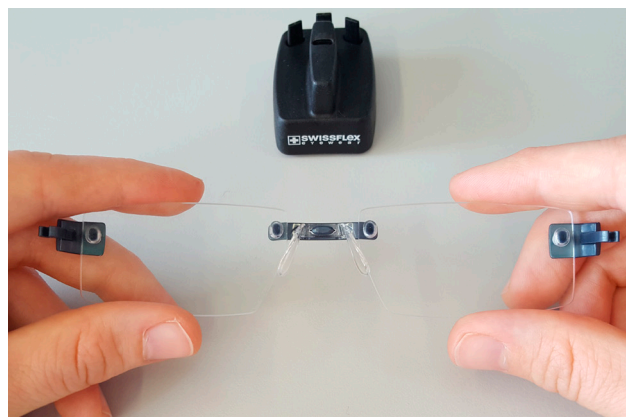


- 12 Placing the bridge with the mushroom downwards vertically on the mounting aid and pushing it down until it clicks into place.

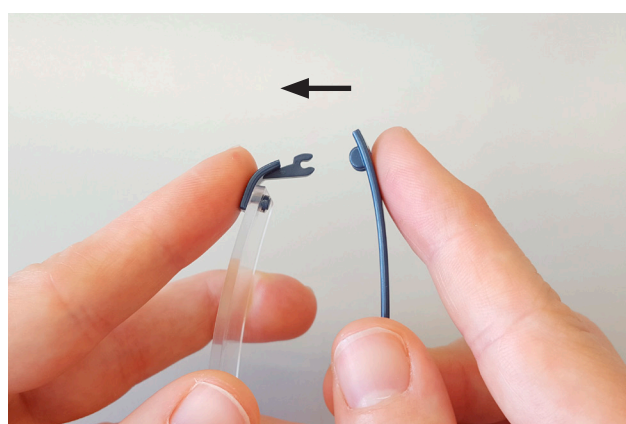




13 Checking the correct fit.



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



15 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.

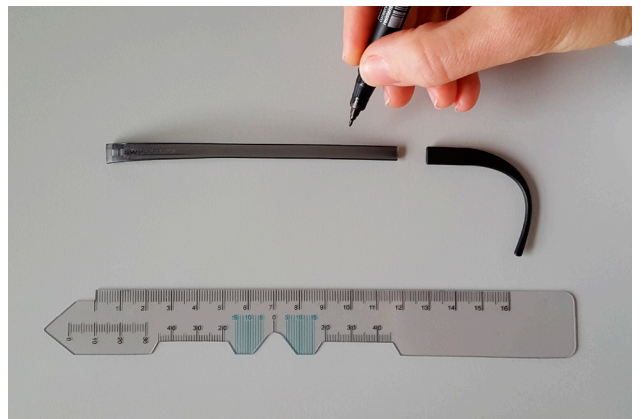
Putting the earpiece close to the ear, marking the overlay at the temple (determine the length for each side individually).



3

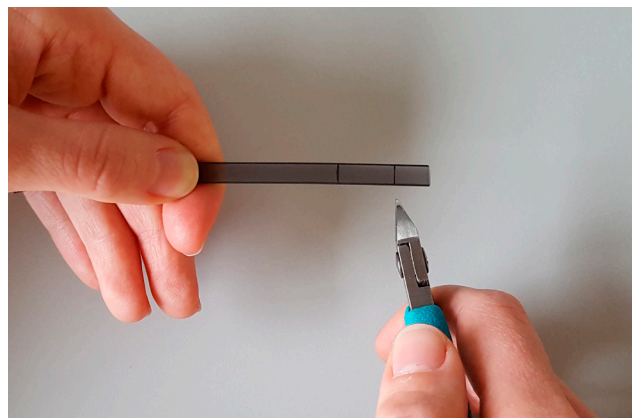
Marking the intersection point.

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

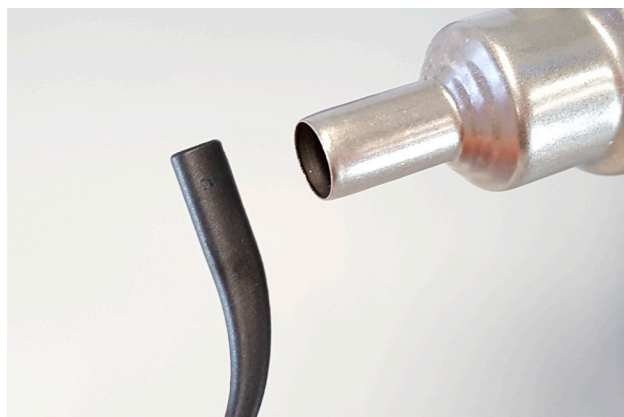


4

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.

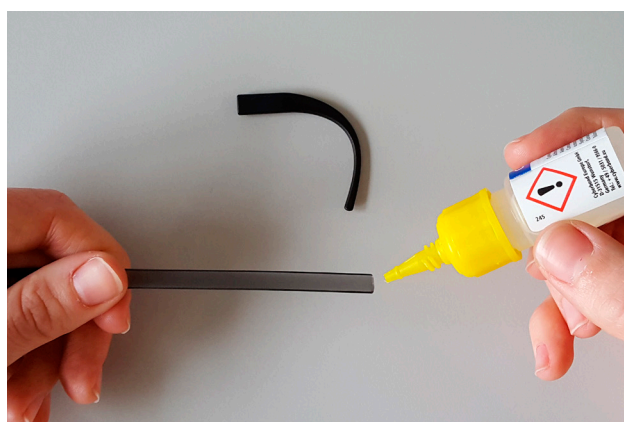



- 6 If necessary the earpiece can be glued to the temple.

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

Remove any visible glue immediately.

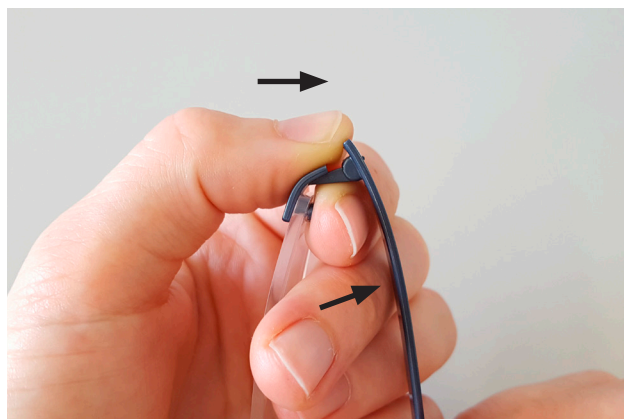
Official product for glueing earpieces is CB 2008.



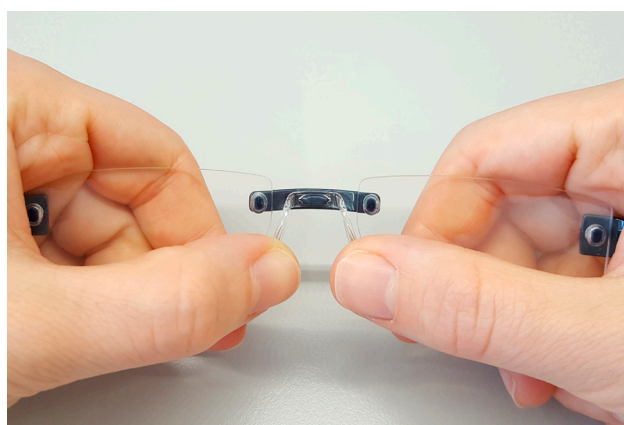
-  **Caution!**  
Observe the safety regulations regarding glues and solvents.

## 7. Disassembly: Temple, nosepad

- 1 Closing the temple.  
Fixing the hinge with thumb and finger and pulling the temple jerking slightly towards the end of the temple.



- 2 Removing the nose pad.  
Press the wings with both thumbs downwards until the pad clicks out.

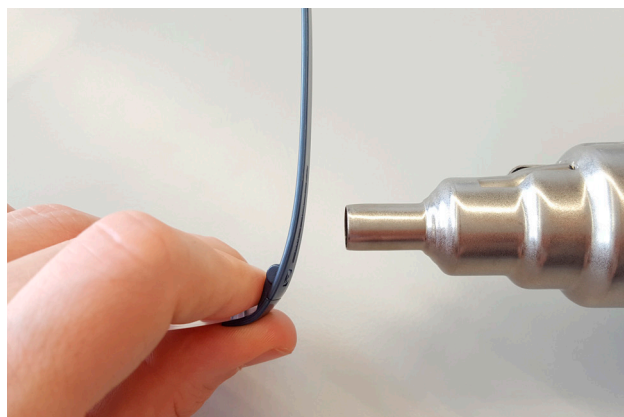




## 8. Basic fitting in Lab

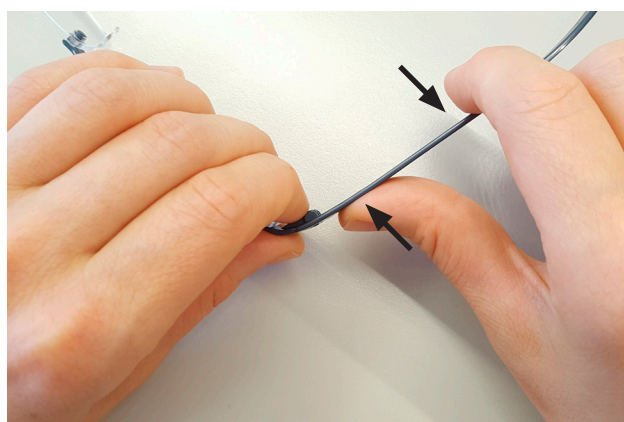
1

Heating temple from both sides slowly and adjust the temperature according to the distance.



2

Increasing/decreasing the opening angle.

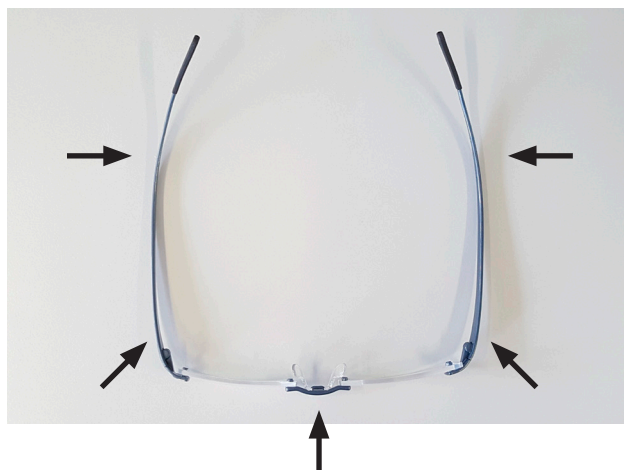


3

Possible points for tuning.

- Bridge (remove pad before)
- Temple (not in the area of the connection of hinge and temple)

Adjusting the temperature to the respective clearance.



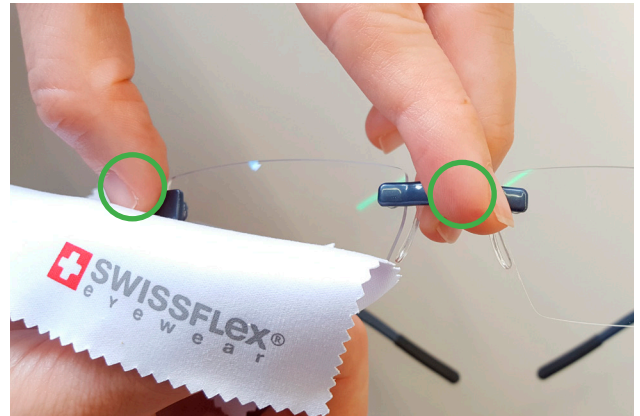


## 9. Cleaning

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.

