

SF loop Baby / Technical Manual



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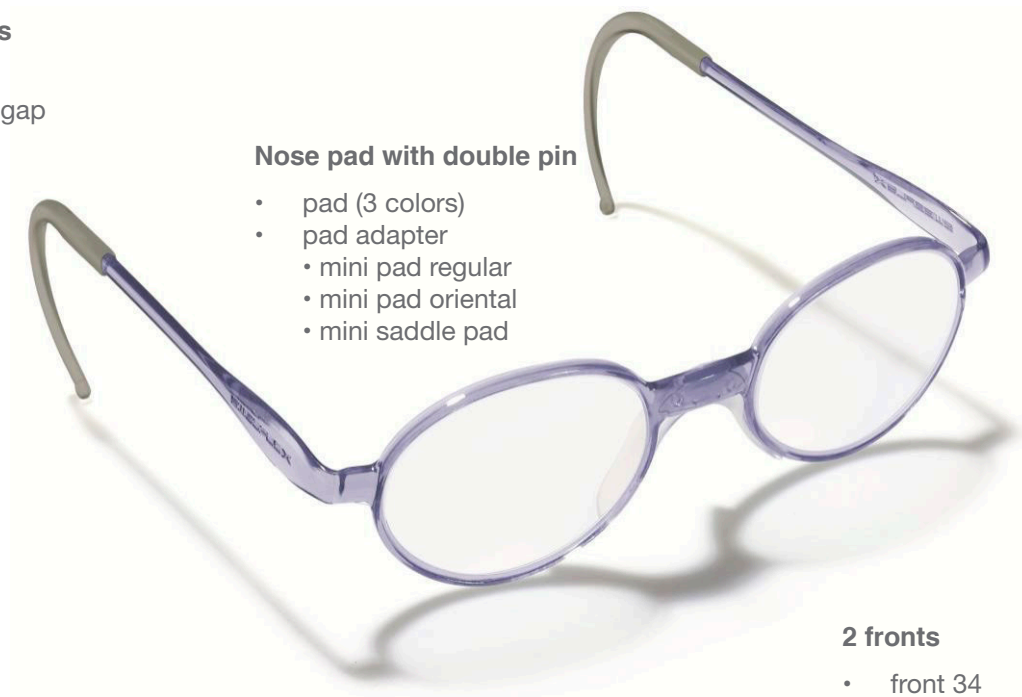
1. Frame system

Earpieces

- baby
- baby gap

Nose pad with double pin

- pad (3 colors)
- pad adapter
 - mini pad regular
 - mini pad oriental
 - mini saddle pad

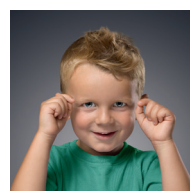


2 fronts

- front 34
- front 36

13 polished colors

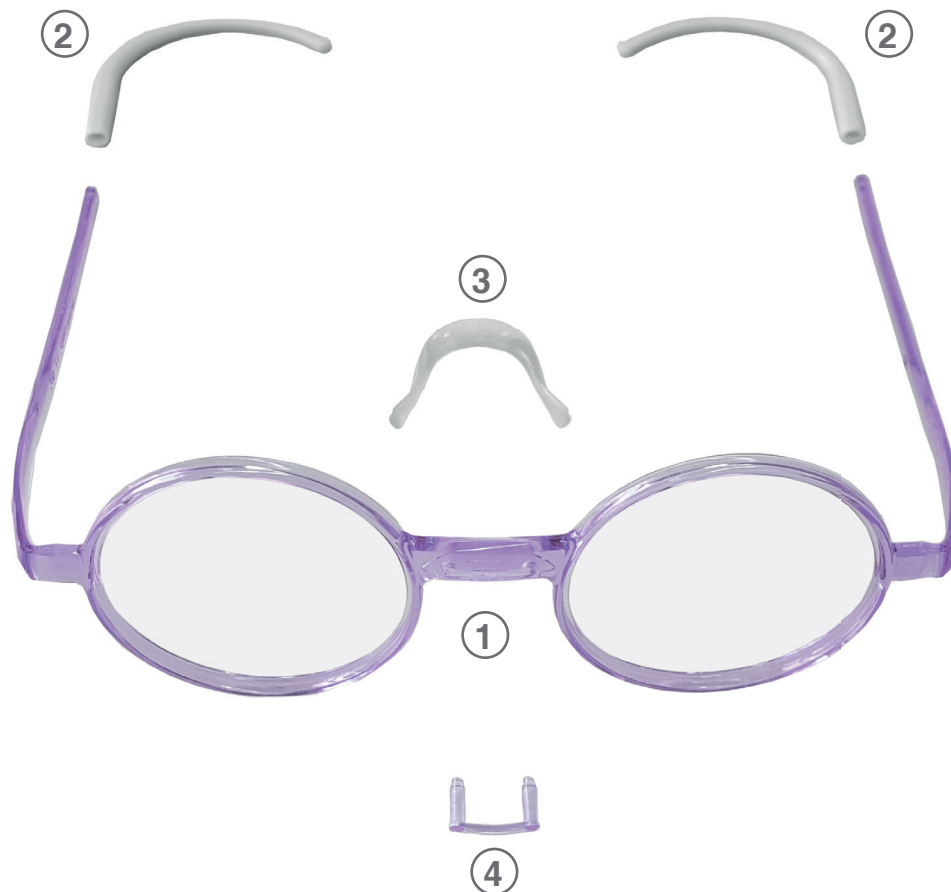
Pictures of all the above elements are available in the legend and the color overviews of the order forms.



like
wearing
nothing.

+
perfekte Passform
modulare Individualität
100% Swiss-made

2. Frame parts



- ① Frame
- ② Endpiece
- ③ Pad
- ④ Double pin

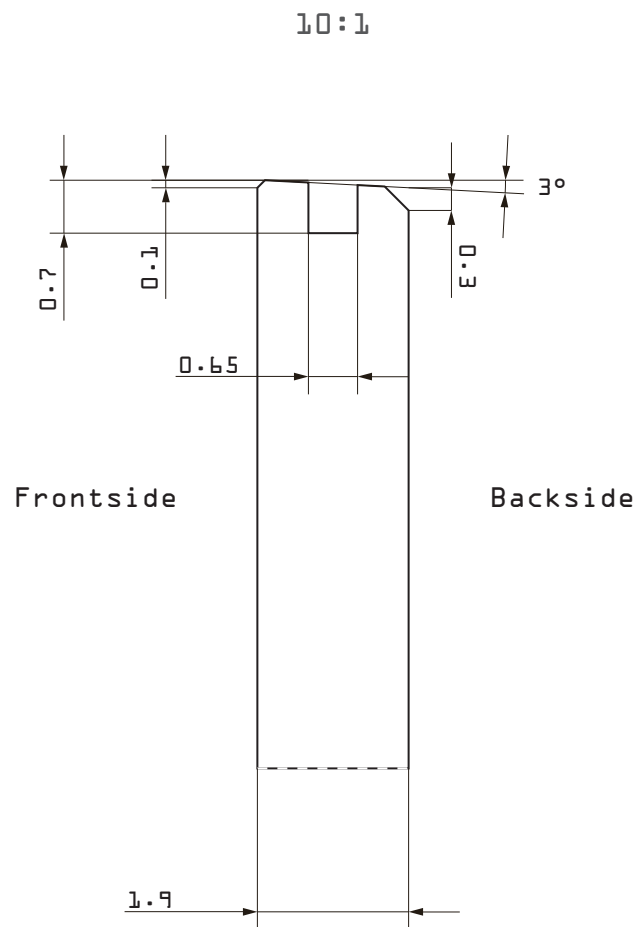
3. Devices / Tools



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 a) Complete riveting device (SFLOb)	70211045
b) SFLOb Swap-System	
Riveting tip (SFLOb)	70214041
Module for eyewear support (SFLOb)	70214042
② Pad presser	70214043
③ Diagonal cutting nipper 632N	70003005
④ Former with master gauge	70311004
Former with master gauge <i>client-specific</i>	70311005

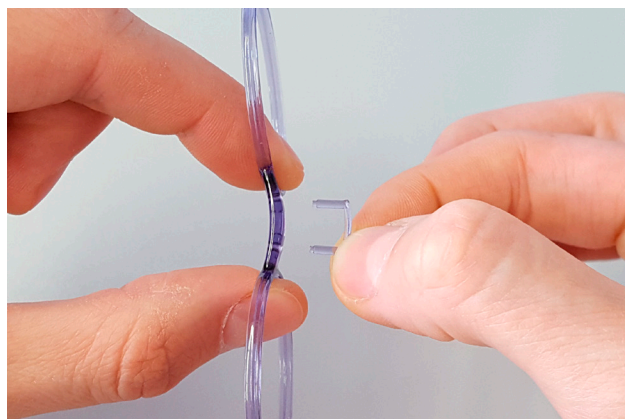
4. Technical data of groove and lens



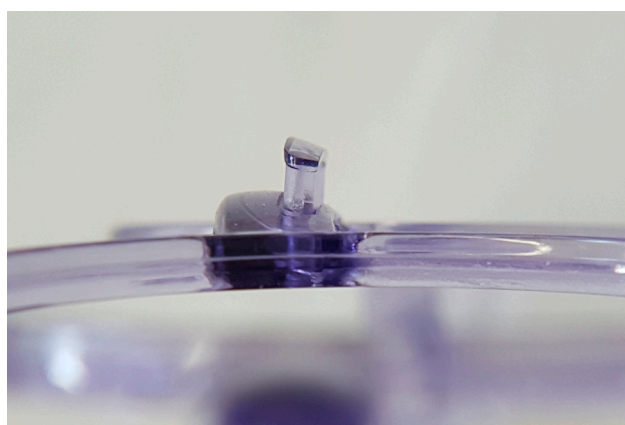
(A minimum glass thickness of 1.9 mm is recommended)

5. Mounting instructions

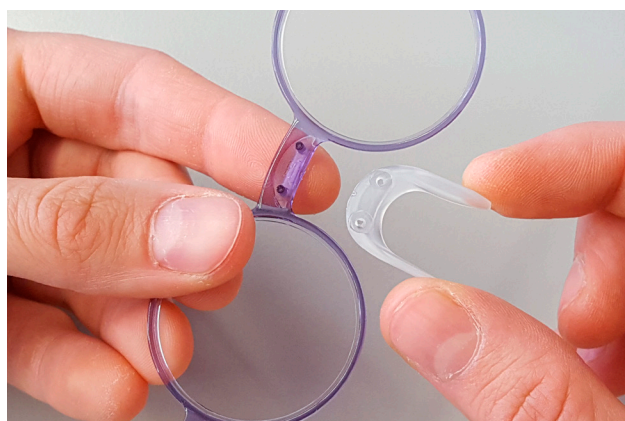
- 1 Insert the double pin into the holes of the frame.



- 2 Make sure that double pin and bridge fit smoothly on the front side.



- 3 Align the pad.

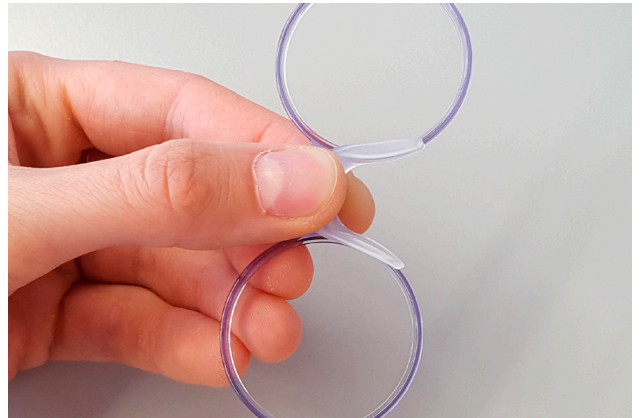


- 4 Place the pad to match the double pin.

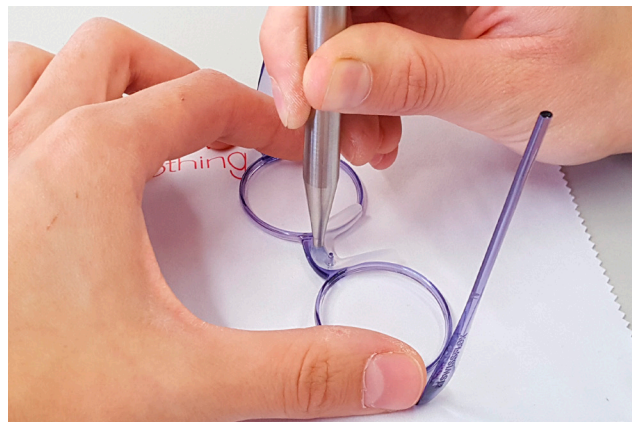


- 5 Fix the pad with the double pin by using slight pressure.

Do not use tools to avoid damaging the pad



- 6 Use the pad presser to push the pad fully against the frame.



- ! Caution!
Before riveting verify that the unheated rivet device is calibrated.
Please refer to the riveting device manual.

Pre-heat the rivet device 5 - 10 minutes.

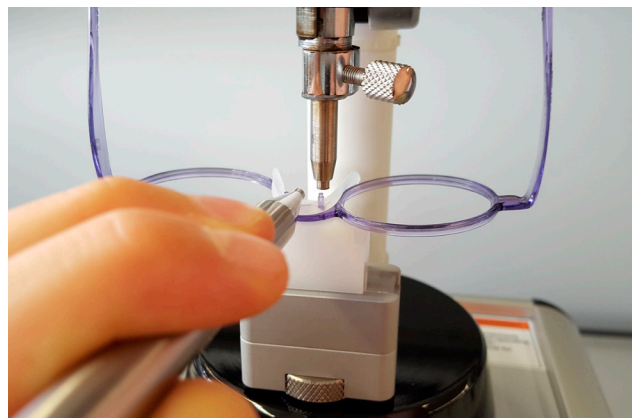
A temperature of 260° C +/- 10° C is recommended.

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.

Best result with less pressure and more time.

- 7 Push the „front-bridge“ against the support take-up using the pad presser.

Riveting of the unshortened rivet pins with a pre-heated rivet tip



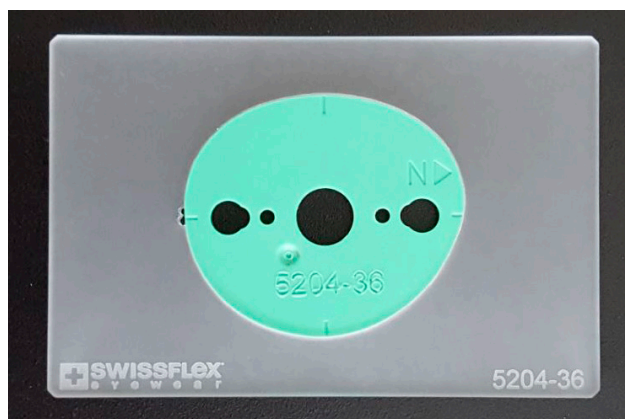
- 8 Push the support take-up until it snaps into place.



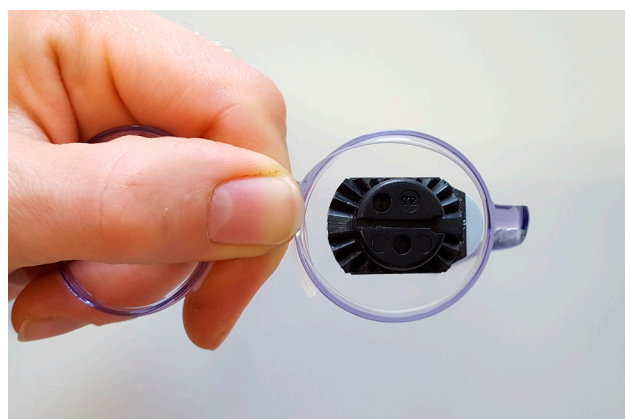
- 9 Mounted pad.
Check the correct fit of the mounted pad.



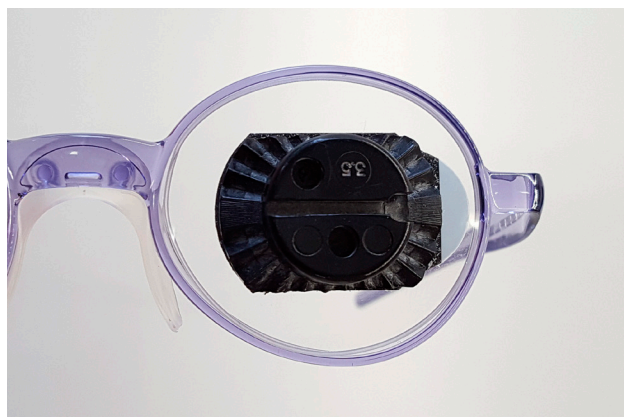
- 10 Preparation.
Milling and grooving the lens to the correct shape and size (use the checking device). Lens shape/size is correct when lens holds with light tension in checking device. A safety bevel of 1/10 frontside and 3/10 backside facilitates inserting the lenses.
Caution: If the lens does not fit properly (too small / too big / not adapted grooving depth) results in breakages or the lenses may fall out.



- 11 Placing lens with groove starting temporally into the frame. Depending on shape and thickness of the lens from the front or the back.



- 12 Started temporarily placing the lens first into the upper and then into the lower rim.



- 13 Lifting the lower rim carefully with little force over the edge of the lens with the help of plastic band.



- 14 Aligning the lenses.
Fixing the frame at the bridge and the hinge and turning the lenses counter clockwise.



- 15 Fixing the frame at the bridge and the hinge the other way around to turn the lenses clockwise.



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



- 17 Mounting of earpieces.
Heating gradually the endings of the temples from both sides in order to mount ear pieces easier.



- 18 Mounted endpieces.



- 19 Mounted frame is ready but not pre-fitted.
More information in the fitting chapter.

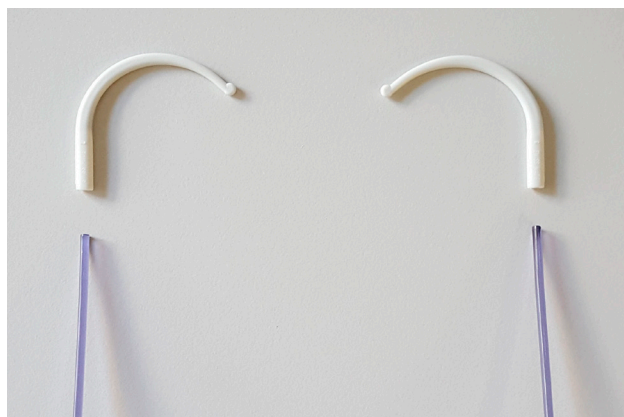


Client-specific assembly

1

Preparation of parts:

- Frame
- Endpieces



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.

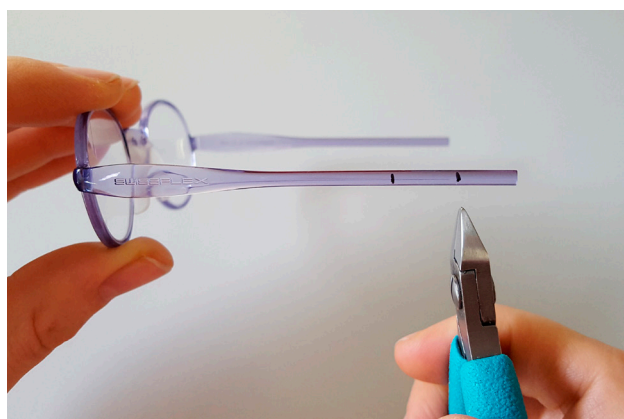
Determination of the necessary allowance and adding it to the length of the temple.



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.

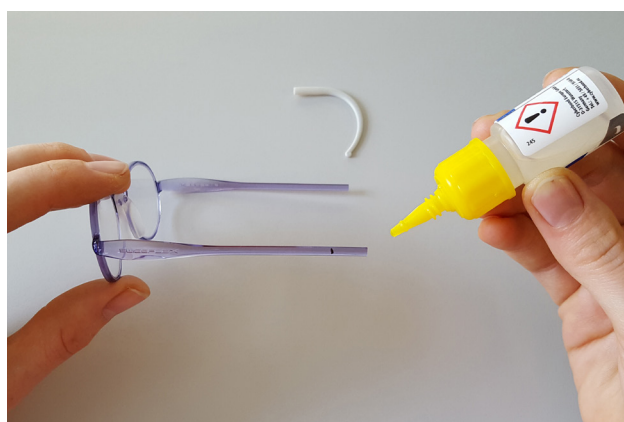


- 6 If necessary the earpiece can be glued to the temple.

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.



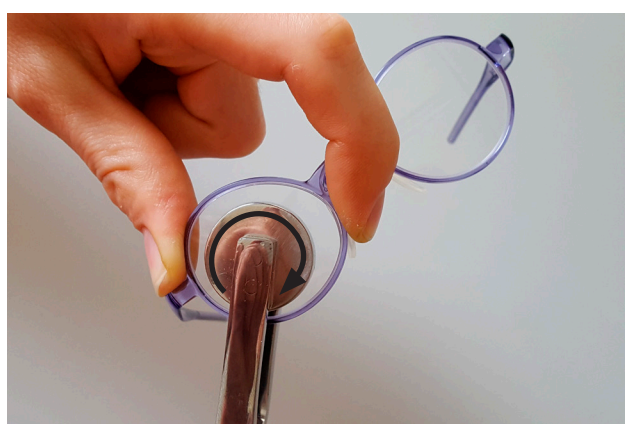
- !** Caution!
Observe the safety regulations regarding glues and solvents.

6. Disassembly: Lens, pad

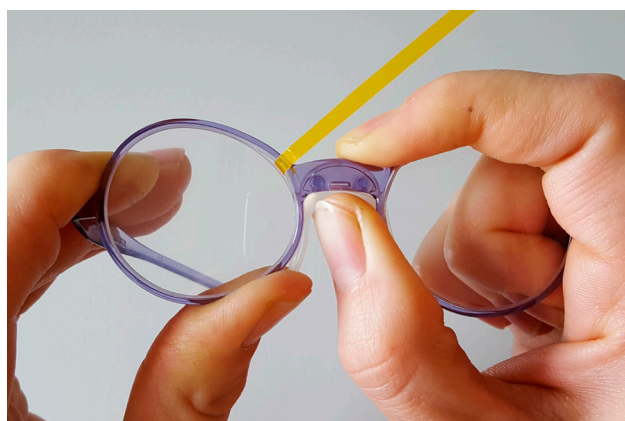
- 1 Fixing the frame at bridge and hinge with fingers opposite to the direction of rotation.



- 2 Turning the lens with the tool until the largest radius directs upward.



- 3 Fixing lens left and bridge. Pulling down the right lens/frame slightly and a small opening appears. Inserting the plastic band for further processing.



- 4 Lifting the upper rim carefully with little force over the edge of the lens.



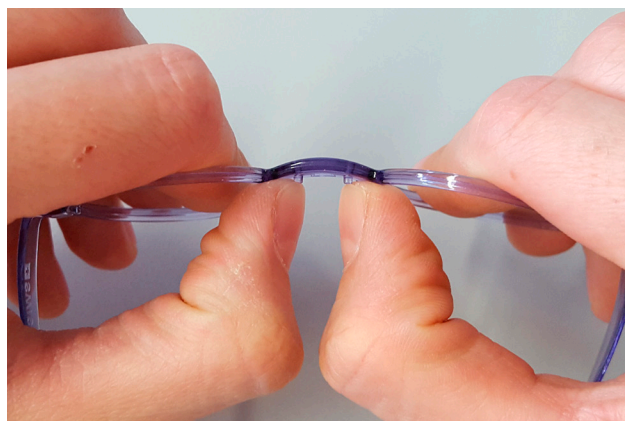
- 5 Cut the rivet heads on both sides using diagonal cutting nipper 632N.



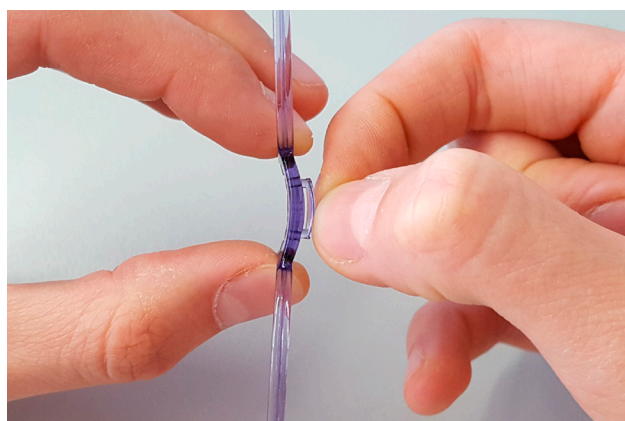
- 6 Remove the pad.



- 7 If necessary recut the pins.
Press the wings with both thumbs downwards until the pad clicks out.



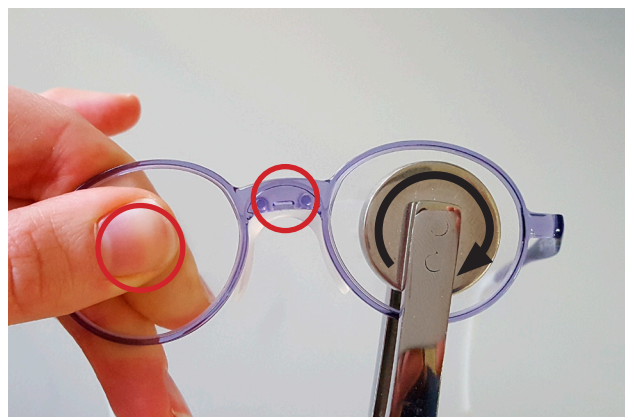
- 8 Remove the double pin.



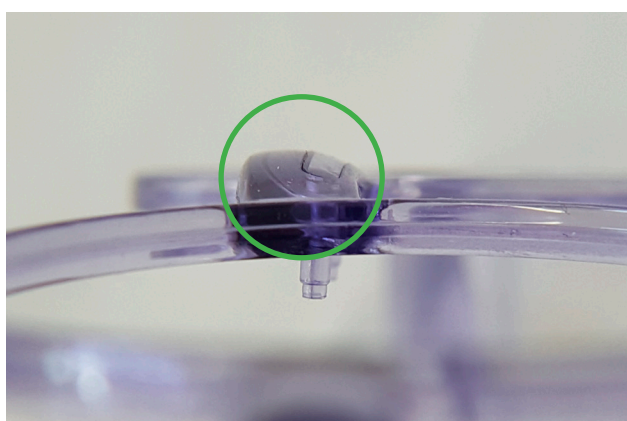
7. Typical mounting mistakes



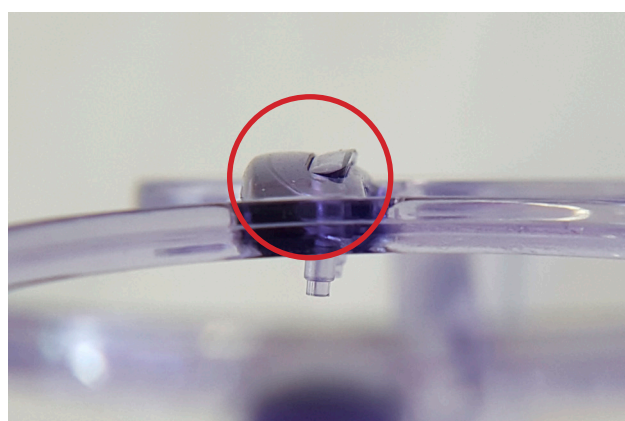
Correct
Fixing the frame above the bridge and below the hinge before turning the lens clockwise.



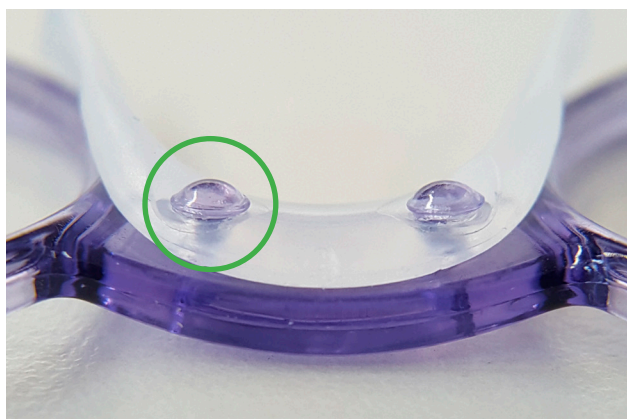
Incorrect
Turning the lens without fixing the frame properly. Danger of overstretching and later breaking of bridge or rim.



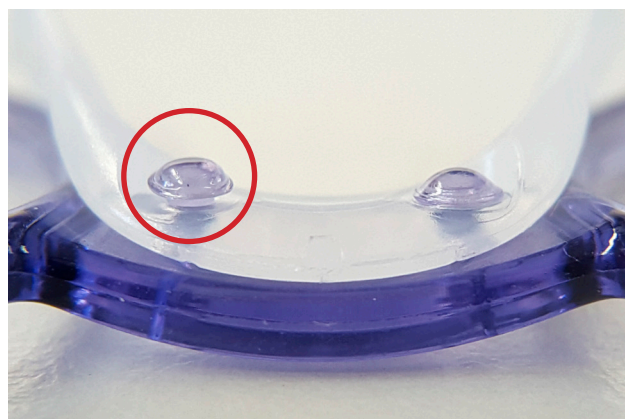
Correct



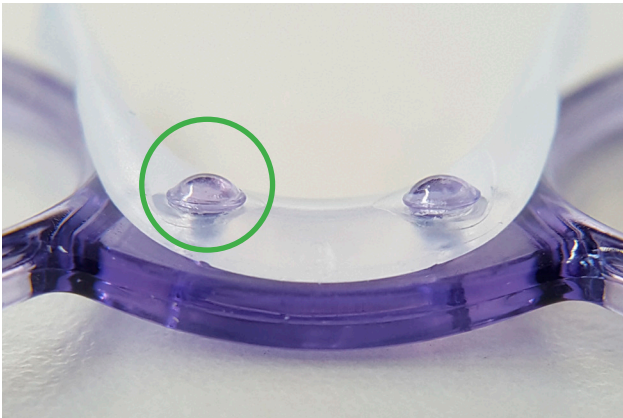
Incorrect



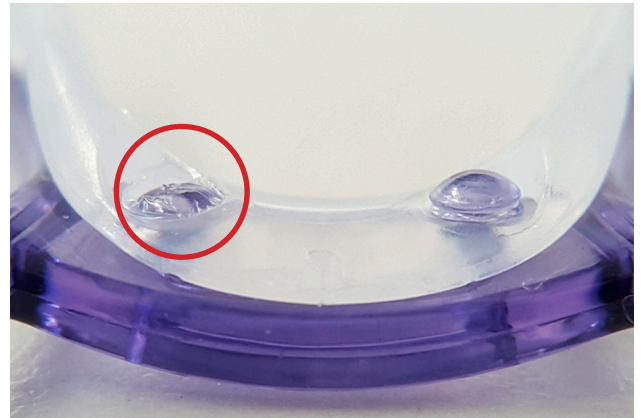
Correct



Incorrect
Due to the gap under the rivet head, recalibrate riveting device.



Correct



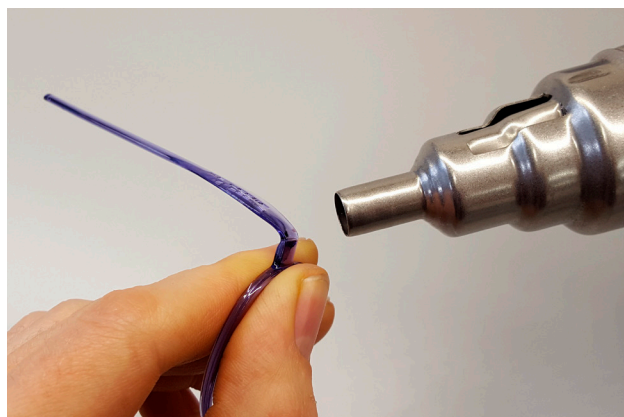
Incorrect
Due to the damaged rivet head, recalibrate
riveting device.

8. Basic fitting in Lab

1

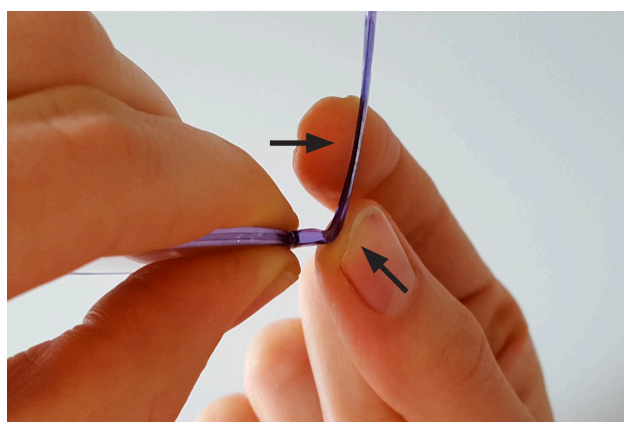
Open the temple. Heating the hinge from both sides gradually while protecting the lens.

Adjust the temperature to the clearance.



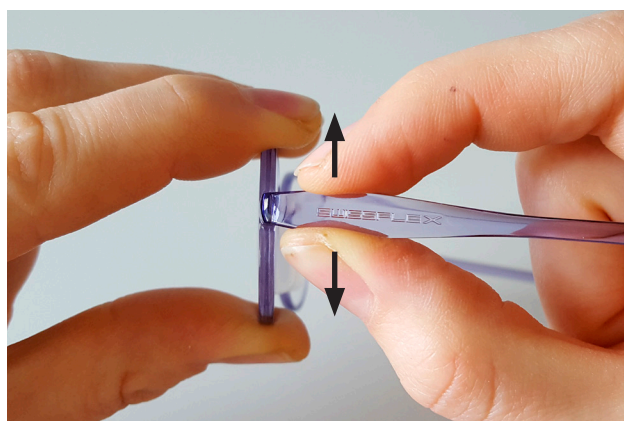
2

Increasing/Decreasing the opening angle.



3

Adjusting inclination.

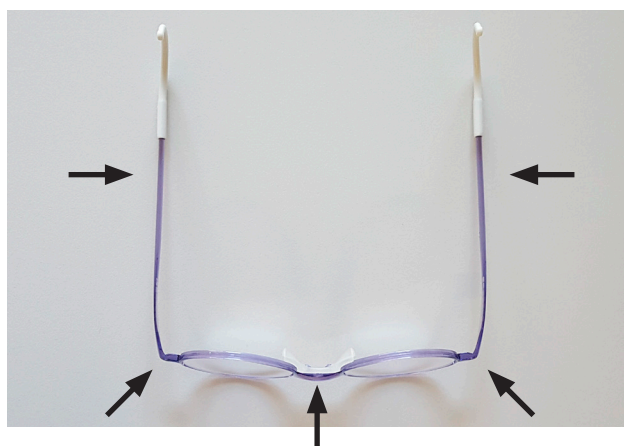


4

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.



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.

