

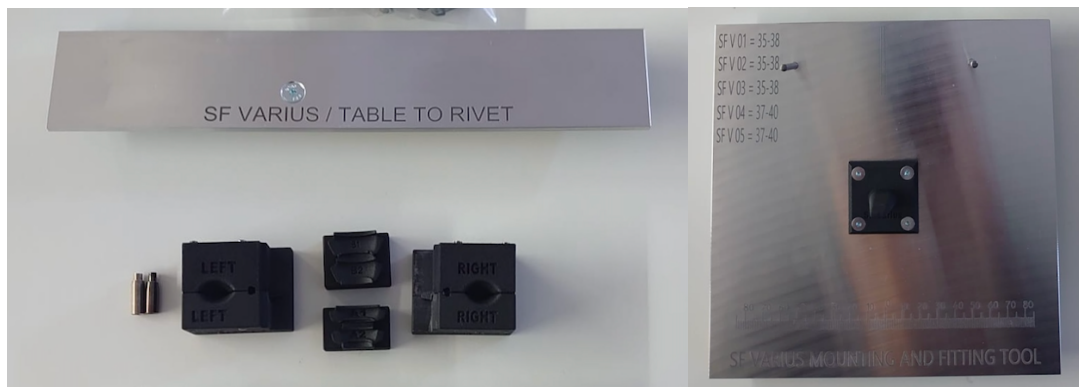
SF varius: Mounting & Fitting & QualityControl

Manual and Base steps of Video-Clip / v6-final

A. DEVICES & TOOLS & CONVERSION

1. Base Equipment

- BaseDevice&Tool: Riveting-Device-SFC & Cutting-Plier-Straight
- SFV-MountingKit: Rivet-Table, Rivet-Top-SFV, Rivet Gauge (ViseHinges-L&R and ViseBridge-A&B), Plate with mandrel for clicking in the individual parts and checking the correct opening angle of the brackets



2. Conversion (SFC -> SFV)

Mounting of Rivet-Top and Rivet-table, Temperature of Device 240-250 Degrees.

B. MOUNTING

1. Assemble Front

1.1. Plug together all SFV-parts (by hand only)

- Sequence: Bridge-Ocular-L&R / Hinge-R&L
- => Check1:
- Correct Parts? -> see L&R-Labeling
- Hinges on proper side? -> if not they stand out in regards to Ocular)

1.2 Click in permanently all parts (with mandrel on the plate)

- Sequence: Bridge-Oculars / Hinges /// push only on the other side of the pin until it clicks in audible and perceptible
- => Check2:
- All borders of the parts are completely flush with one another?

1.3. Cut the pins

- Sequence: from left to right /// cutting exactly where they become thicker
- => Check3:
- All cuts horizontal?

2. Insert Front in Rivet Gauge

- Sequence: Bridge / Hinge-L&R (Push in the Bridge next to the pins)
- => Check4:
- Correct Bridge-Gauge (A1, A2 / B1, B2) used?
- Bridge fits/holds stable in Gauge?

3. Riveting Front Parts

- Lower heated RivetTop with feel&practice (little pressure) on cut of pins / repress1-2x lightly
- Sequence: Bridge-Pins / Hinge-Pins
- Caution: for maximal accuracy hold (push together) the Vise-L&R while riveting / extract the front by putting the finger into the hole on top of the Vises-L&R
- => Check5:
- No plastic threads (otherwise too hot), tight cohesion, no gap under rivet head, even/round rivet ends, front transitions still perfect?

4. Putting Slider & Nosepad

4.1 Mounting Slider

- Hold the handle with 'hook' upwards and insert it into the nose pad hole.
- Firmly click the slider into the nose pad hole with your finger
- Cut off slider handle (with pliers or by twisting)
- Caution: Note correct cutting angle, slider can be mounted without handle (with some practice)!
- => Check6:
- Parallel tight fit of the slider in the nose pad hole?

4.2 Mounting Nosepad

- Insert the slider into the nose pad vertically from below using your thumb and click it into place.
- Caution: Nose pad assembly and disassembly different from all other SF models
- => Check7:
- Does slider sit flush in bridge?

5. Mounting Temple

- Fix hinge with fingers, click in bracket vertically and attach end pieces.
- Caution: Insertion angle for SFV bracket different from SFC!!! (SFV bracket can be inserted into SFC hinge (plumbs) - but not the other way round.
- => Check8:
- Bracket holds and is not loose?

C. BASE-FITTING

- General: all frame parts can be heated and adjusted
- Sequence: bridge / hinges / temples
- Attention: heat bridge exclusively diagonally from above in the middle (not directly at rivets, otherwise they become soft&loose)
- => Check9:
- No shiny surfaces? (too long or too high heat)
- Opening angle according to specifications on plate

D. QUALITY CONTROL (wird später noch weiter ausgeführt)

- all parts clicked in / slight curvature of the front / 4-point support / angle of the stirrups
- => Check10:
- Correct according to official fitting parameters from OW