Thindex 1.70 High Index Edging Guide

The following tips are recommended for successful edging of Thindex 1.70 AR coated lenses.

Blocking
• Apply protective tape to both sides of the lens.
• Use edging blocks that best match the front curve of the lens.
• Use minimum pressure to apply the block to avoid exing of the lens.

Edging
• The shape of front and backside chucks should be similar to minimize exing.
• Ensure edger chuck pads are clean.
• Avoid excessive pressure when chucking the lens. Set pressure at the manufacturer’s minimum recommended for AR lenses.
• Ensure all edging wheels and cutter blades are clean and sharp. Follow manufacturer recommendations for cleaning, re-true, and replacement. Dull wheels or blades increase stress during edging, which may lead to coating cracks.
• Use several slow cuts to reduce lens size
• Reduce head pressure and ow rate to manufacturer’s recommendation.
• Do not edge glass lenses with the same edger as particles in the coolant and on chuck pads increase the risk of scratches.

Deblocking
• Rinse the lens in lukewarm water before handling.
• Twist the block to remove it from the lens. Do not pull if from the surface. Avoid exing or bending the lens.
• Soaking the lens in soapy water for a few minutes will help to loosen the block prior to removal.
• Aggressive deblocking can cause AR coating to crack.
• Removing the block after inserting the lens in the frame will help to prevent flexing.

Pin Beveling
• Use light pressure when PIN beveling and while edge polishing.

Axis Alignment
• Use lens alignment pliers only if necessary, trying to avoid altogether

Drilling
• Thindex cuts best with a sharp burr operated at low speed and minimal to moderate pressure. Twist style drills, cutting less aggressively, often leave subsurface damage.
• Place lens with front towards drill bit and slowly operate drill through lens; back drill bit out of hole often to remove cutting debris that will increase heat damage.
• Be sure to chamfer around the hole when nished drilling. (Much like safety beveling after edging)
• Note that excessive pressures and speed create damaging heat, which may create eventual fractures.

For any additional technical questions, call the toll-free Technical Services Hotline: (800) 367-2544 ext. 5301
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