

# Technical Tip

## 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 flexing of the lens.

### Edging

- The shape of front and backside chucks should be similar to minimize flexing.
- 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 slow 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 it from the surface. Avoid flexing 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 finished 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

You can also send messages to us via e-mail: [techservices@visionease.com](mailto:techservices@visionease.com)

This Technical Tip is provided to you by the Technical Services Group of Vision-Ease, 6975 Saukview Drive, Suite 104, St. Cloud, MN, 56303, USA