

# CRISTEC PC.Polarized / PA.Polarized

## Operation Noted (Cutting & Assembling)

### 1. Groove (Frame)

#### a). Uniform / Equal

The deep of groove have to equal. It is better over 1.00mm of groove deep. The width of groove that is better over 2.20mm (the final groove width better over 2.00mm after spray or coating) for plastic frame.

#### b). Lens groove variety

Recommend to use the "U" groove shape. It can avoid problem during lens cutting.

#### c). Curvature

The curve of frame that is very important to match on lens. The tolerance should be less than 0.5 R. Otherwise, it may change the lens optical quality (Spherical, Astigmatic & Prismatic power)

#### d). Reverse Groove

It is not recommend to use the lens for reverse groove to avoid lens crack.

### 2. Cutting Pattern

#### a). Size

This is very important to reach the Polarized lens in good condition on frame. It may easy to cause lens-stress and lens crack if ***pattern is not proper*** or the ***lens cutting is over large***. That is, it is not recommend to cutting the lens very tightly as normal Sun lens. At the same time, it also can be avoid lens pop out or too loss.

#### b). Reduce Stress

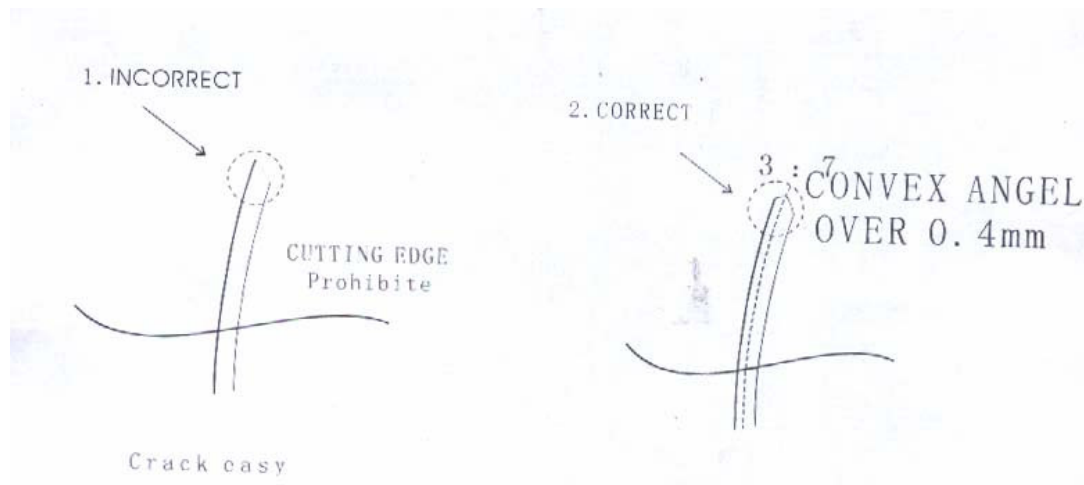
To work proper on the lens pattern & size, we recommend to inspect by "STRESS EQUIPMENT" (as attached photo) to judge. Please use the ***defective Polarized*** lens to test on frame after cutting. You may easy to find out the major "Stress points" or "Rainbow" from



the "STRESS EQUIPMENT". To solve the stress points, please mark with Text pens on major "Stress" point on lens pattern. Then polish the pattern a little bit till the stress point as less as possible. As per to avoid the "Rainbow", please reduce the lens size as small as possible.

**c). Lens edge**

It is very important to cut the lens edging line in position of " 3 : 7 ". The convex film' side of the edge that should be around 0.40 mm less than the top of edge. Thus, it can be avoid the breakage on the lens (top of film, film thickness 0.20mm). See below drawing.

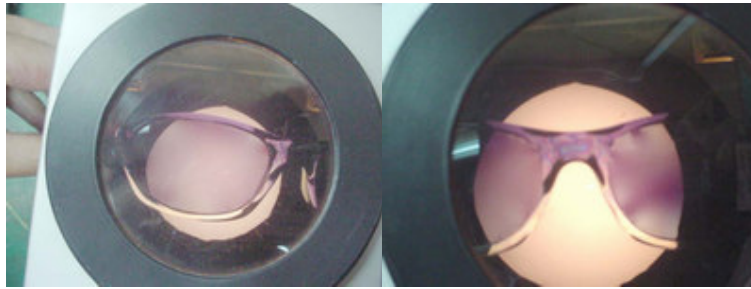


**e). Reach the right result after cutting & assembling**

If you are not concern above points, it will be happen as photo result which more stress



If you try to work as above proposal which can be reach the better result on optical quality as photo



### **3. Lens cleaning or extra vacuum mirror coating**

There is special requirement as below range, it may cause destroy the lens quality if out of this range to over rework on lens.

#### **a). Cleaning by Ultrasonic equipment**

Power (in mechanics): not over 900W

Temperature: less than 60 C degree

Timing (water timing): not over 10 mins.

#### **b). Cleaning liquid**

PH 7 would be best proposal.