

Technical Services Department

Technical Tip

Outlook™ Tegra® Processing Tips

General Information

- **Select** the Vision-Ease recommended Base Curve for the Rx range.
- **Verify** the correct Sag.
- **Do Not Sag Lenses**; compute lenses with data provided in the software.

Layout

- **Layout lenses** at the prism reference point, which is located between the engraved circles.
Do Not Grind Prism for Decentration! Prescribed prism (doctor's prism) can be ground up to 3.5 diopters.
- **Taped lenses** should be free of wrinkles, air bubbles, and foreign debris.
- **Do not** leave lenses taped and blocked overnight.

Blocking

- Use 117° alloy or thermoset plastic wax (blocking medium) and keep temperature as low as possible.
- Do not allow blocking alloy to reach temperatures in excess of 121°.
- Use chilling ring with 50mm or larger diameter blocks, filling the cavity completely.
- Place blocked lenses in tray, blocked side up, and allow to cool at room temperature (about 20 minutes).

Generating

- **Generating** polycarbonate requires maintaining the cutting chamber swarf-free.
- **Cutting** passes are to be made at up to 3mm at a speed where the drive motor does not slow.
- **Using a final cut** of 0.3mm will ensure a quality surface: Polycarbonate can be cut wet or dry using either a toric or 3-axis generator. Fly-Cutter wheels are recommended for toric generators.
- If dry cutting, use a vacuum to remove swarf and keep the lens cool.
- When cutting minus lenses, make 2mm to 3mm cuts with the last cut no more than 0.3mm to 1.0mm.
- On plus lenses, the final cut should be 0.2mm to prevent edge cracking.

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Outlook™ Tegra® Processing Tips (Continued)

Fining

- **Use fresh water**, if possible, at a 45° to 60° temperature. If re-circulating water is used, filter with a 10 to 15 micron filter. Use good coolant flow. Rinse tools and lenses between each step.
- **All first fine pads** should be pad pressed to avoid wrinkles. **A two step fining system** is recommended:
 - A. First fine pad280 grit pad
 - B. Time2 minutes at high speed
 - C. Pressure12 to 16psi pin pressure
 - D. Second fine pad1000/1200 grit pad
 - E. Time2 minutes at high speed
 - F. Pressure12 to 16psi pin pressure

Polishing

- **Polish** should be constantly filtered, chilled to 45° to 60°, replaced at least weekly, and the Baume' maintained to the manufacturer's recommendation:
 - A. Polishing padhigh-nap, densely flocked
 - B. Time5.0 to 6.0 minutes
 - C. Pressure16 to 18psi

Process

- **All polycarbonate lenses** are to be thoroughly cleaned, then scratch coated prior to handling. Contact your coater manufacturer representative for specific cleaning process needs or requirements.

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@vision-ease.com

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