

## MANUFACTURING RECOMMENDATIONS

### DEFINITIVE 50

#### DIAMOND TOOLING

Rough Tool Radius 0.25 - 0.50 mm

Fine Tool Radius 0.20 - 0.50 mm

#### MACHINING RECOMMENDATIONS

Back rough cut amount 0.3 - 0.5 mm

Back rough feed rate 3 - 4 in per min

Back rough spindle speed 7000 - 9000 rpm

Back rough cut amount (last pass) 0.05 - 0.15 mm

Back rough feed rate (last pass) 1.5 - 2.5 in per min

Back rough spindle speed (last pass) 7000 - 9000 rpm

Back final feed rate 1.5 - 2.5 in per min

Back final spindle speed 6500 - 8000 rpm

Back final cut amount 0.02 - 0.06 mm

Front rough cut amount 0.2 - 0.4 mm

Front rough feed rate 2 - 4 in per min

Front rough spindle speed 7000 - 9000 rpm

Front rough cut amount (clean up pass) 0.05 - 0.15 mm

Front rough feed rate (clean up pass) 1.5 - 2.5 in per min

Front rough spindle speed (clean up pass) 7000 - 9000 rpm

Front final feed rate 1.5 - 2.5 in per min

Front final spindle speed 7000 - 9000 rpm

Front final cut amount 0.02 - 0.10 mm

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### Environment Control

For best manufacturing conditions Contamac recommends 21°C (± 2) with a relative humidity of 45 % - 60%.

### Polishing

If polishing is required the recommended polish compound is Contapol 2 with a spindle speed of 500 – 2000rpm and using minimal weight. The duration of the polishing cycle should be kept to a minimum (10 – 30 seconds).

### Blocking

Use low temperature blocking wax with an operational temperature of 60°C such as Contamac Low Melt Wax.

### De-Blocking

We recommend the use of Isopar E, Petroleum Ether or equivalent in an ultrasonic bath for dissolving blocking wax and cleaning the lens. The solvent in the ultrasonic bath must not be allowed to become overheated and should be changed frequently. The solvent should be dried off the lens using a medical grade tissue.

### Hydratation

Plasma treatment required prior to hydration.

Hydration of Definitive 50 is best performed in buffered saline, with a pH of 6.80 - 7.50.

### Reference

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### Contamac Ltd

Carlton House, Shire Hill  
Saffron Walden, Essex  
CB11 3AU

T. +44 (0)1799 51480  
E. sales@contamac.co.uk  
www.contamac.com