

# CD 400/500

## SCL CD 500 COATING GUIDELINES

1. MUST: Always let the airflow fan open all the time. (24 hours)
2. MUST: Always keep the varnish temperature at the same value. (24 hours) otherwise the varnishes can not be used.
3. MUST: Check the temperature of tanks 1, 2, 4, 6, primary varnish, main varnish and ovens and check everyday.
4. MUST: Primary and Main varnishes should be filtered by 1 micron filters. (We put a sample into the machine)
5. Add city water to the tanks 1, 2 and 4 and their detergents (explained in datasheet 279) and turn on heater. Adjust the temperature to 55°C. Check the temperature before starting to the process. The temperature should be 55°C ± 3°C (depending on the detergent, the detergent solution lasts 2-3 weeks)
6. Turn the valve of 3rd and 5th tank (city water) on and see the water flow. Only clean water should be used in these tanks. There should be NO detergent residue in the tank. That's why these tanks should be filled and pumped out continuously...(NO circulation, only clean water in, dirty water out)
7. Set 6th tank to 48°C ± 3°C and check the deionised water flow (circulation). Turn on U.S. of tanks 1, 2, 4 and 6 for 15 minutes for degassing. (with no lenses)
8. Suggestion; Clean/wash organic lenses starting from 2. tank followed by 3, 4, 5, and 6 each for 4-5 minutes. (time should be advised by the detergent producer)
9. Suggestion; For Transitions lenses, clean/wash organic lenses starting from 1. tank followed by 2, 3, 4, 5, and 6 each for 4-5 minutes. (time should be advised by the detergent producer)
10. Suggestion; For 1.56 and 1.61 index organic lenses, clean/wash them first in tank 1 for 8 minutes, 2nd, 3rd, 4th, 5th, 6th tanks for 4-5 minutes. (time should be advised by the detergent producer)
11. Suggestion; For 1.67 index organic lenses, clean/wash them first in tank 1 for 12 minutes, 2nd, 3rd, 4th, 5th, 6th tanks for 4-5 minutes. (time should be advised by the detergent producer)
12. Suggestion; Set time to 4-5 minutes. (time should be advised by the detergent producer)
13. Turn on Ultrasonic cleaners with pushing "Time" and "String" buttons and start cleaning.
14. After 4-5 minutes, when you hear the signal, hit "Time" button and move the lenses to the next tank and hit Time button again.
15. Make sure to put lenses to every emptied tanks.
16. When the Ultrasonic clean finishes, put them to tank 1. When time is up, take the lenses with a holder and put to the varnish holder bar.
17. Primary coating (needed for the lens types which they don't pass the tests): adjust the "tank 7" to 90°C for polycarbonates, 120°C for other types of lenses. 8th tank primary coat varnish temperature should be between 14°C - 16°C.
18. Suggestion; Dipping speed should be 2.00 (30-45 seconds / 72mm) You must check Density and viscosity everyday. (depends on the varnish producer datasheet)+

19. Suggestion; Dry the lenses in 9th tank at 120°C for 10 minutes.
20. Main coating: Adjust the temperature of the varnish to 10°C - 11°C. Dipping speed should be 2.50 (25-30 seconds / 75mm) Density can be 35.5 – 36.5 You must check Density and viscosity everyday. (depends on the varnish producer datasheet)
21. Suggestion: Dry the lenses in 11th tank at 120°C for 10 minutes.
22. To maintain a certain dipping speed, choose a value from the potentiometer taking into account of lens index. Your varnish is important and you should try and find yourself. Example of ours:  
Type A varnish:  
For Progressives and 1.5 index: 8.00 - 7.00  
High base and lenticular lenses: 5.00 – 4.00  
Bifocal lenses : 3.30 - 3.00  
Type B varnish:  
Progressives, 1.5 index organics, high base and lenticular lenses: 3.00  
Bifocal lenses 2.50
23. After 4-5 minutes when the signal is heard, hit 'Time' button, then open the cap of the tank and hit 'dipping' button.
24. Do not touch anywhere when the dipping starts. Otherwise there might be waves/leaks on the surface of the lenses.
25. After ascending (elevating) of the lenses from the varnish tank, hold the lenses slightly with the holder and put them to the rest bar. Close the cap of the varnish tank.
26. Put the next followed lenses to the varnish holder and hit 'Time' button.
27. Wait for 1-2 minutes for cooling off on the bar.
28. Put the lenses to the tank 2. After 4 - 5 minutes, take from the tank with a holder and out them in front of the check lamp.
29. Take every lenses one by one from the holders and check the dots, scratches, leaks and stains on the lenses. Put them away.
30. Put the succesfully coated lenses to Polimerisation ovens (not in the machine, sold seperately)  
Suggestion notes for ovens:  
For 1.6 and upper index and polycarbonates, set the oven to 100 degrees celcius and cook for 3.5 hours. For 1.5 and 1.56 indexes, set the oven to 115 degrees celcius and cook for 2h15m  
Check the time and record all cycles.
31. Record the unproper lenses as well.
32. Sort the re-coatable lenses from the faulty coated lenses and start from the beginning.

