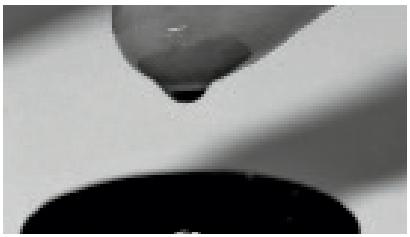
Lunor

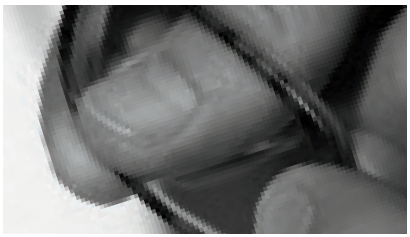
PROCESSING AND GLAZING OF NATURAL HORN FRAMES

FULL-RIM GLAZING

LENS SELECTION AND LENS CUTTING

- Select the lens so that the curve already matches the curve of the frame as closely as possible, otherwise adjust the frame pre-bend to the lens curve (after heating in line with the following description).
- Match the lens shape and size as closely as possible to the frame shape.
- If necessary, reduce nasal and temporal corners slightly (depending on the shape of the lens) to avoid tension in these areas; rectangular shapes, for example, can be reduced slightly in length and extended by the same amount in height, as the frame edge is more flexible in height than in length.
- Lens groove depth for full-rim frame: 0.5 mm.
- Be sure to break lens facet tip slightly before inserting.





WARMING

- It is easier to work if you unscrew the temples before heating.
- In addition, it is easier to fit the frame later and protects the polished finish if you rub suitable odorless oil onto the rim of the frame and the lens facing before heating.

FULL-RIM GLAZING

MATCHING THE FRAME CURVE TO THE LENS CURVE

- Natural horn absorbs heat slowly and conducts it very slowly. An intermittent heat supply is therefore recommended to evenly and gently warm the horn interior.
- Set frame warmer temperature to its highest power after warming up (approx. 200 - 220 °C).

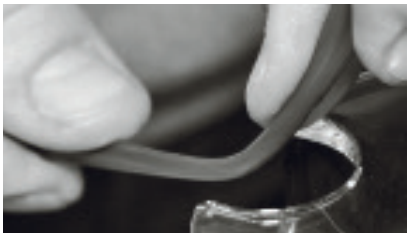
INSERTING THE LENS

- Heat for 5-8 seconds while continuously rotating in the frame warmer, then pause for about 5 seconds to allow the heat to soften the material.
- Since the Lunor natural horn frame is a multi-layered material, it should be heated evenly from all sides.
- Repeat the process several times until the material becomes elastic. The process can or must be repeated more often in the case of thick frame edges.
- Glaze from the outside.
- After intermittent heating, quickly insert the lens, inserting the lens in the upper groove first, then glaze over the lower rim of the frame.

DEGLAZING THE FRAMES

- Use suitable oil to deglaze.
- Heat the rim of the frame at four-second intervals (repeat according to the thickness of the rim and the condition of the lens) and carefully remove the lens by hand, working from the inside out; lens turning tongs prevent the lens from getting too hot during heating and protect the lens surface.

FULL-RIM GLAZING



BENDING THE TEMPLE

- After warming up (approx. 200 - 220 °C), set the frame warmer temperature to its maximum power.
- Oil the bending point with odorless vegetable oil. This protects the polish.
- Pre-temper the area to be bent over a wide area before each bending (approx. 8 seconds while rotating).
- Then heat the temple on the frame warmer under constant bending pressure (see illustration on the left), directing the heat effect to the outer radius, until the temple yields.
- Immediately bend it quickly, slightly beyond the usual bend and allow to cool.
- Pressing gives a small radius, pulling gives a larger radius.
- Reheat the temple and then bend it back briefly until the desired shape is reached. This makes the bending point stress-free and keeps its shape in the long term.
- When a longer bending time is needed, increase the distance to the frame warmer opening to avoid overheating, which would come across as wrinkles or reddish discoloration.

REDOING A TEMPLE BEND

- Heat the old bending point and straighten it again.
- Allow the temple to cool completely, then bend it again as previously described.

PROCESSING AND GLAZING

CARE INSTRUCTIONS

- Please pass these care instructions on to your customer. The customer will also have all the information in the brochure enclosed with their glasses. Also recommend that the glasses be brought in for an occasional "eyeglass inspection" and advise the customer not to bend the frame themselves or put any heavy weight on it under any circumstances.

- Avoid high temperatures, too much humidity and abrasive cleaning agents.

- Do not use ultrasonic cleaning.

- The special care cream, developed from pure and natural substances, will provide effective care. The natural horn parts of the frame should be rubbed with a thin layer of cream from time to time, depending on their usage, and then polished with a soft cloth.

GENERAL WORKING INSTRUCTIONS

- Natural horn expands only slightly when heated, but is then somewhat more resilient than when cold. The material shrinks back to its original size when cooled.

- Eyeglass frames made of natural horn do not become as soft as plastic does when heated. The material just gets hotter, not softer – even after a longer heating time. The material and polish may suffer from moisture loss if heated.

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