

Rough guideline for the usage of dopa resin bonded generator tools



Lens diameter in mm	dopa rough generator tool	dopa fine generator tool
Ø < 5	D35 / D46	D7 - D20
Ø 5 - 20	D35 or rougher	D14 - D28
Ø 20 - 50	D46 - D76	D28 / D38 / D45
Ø > 50	D64 - D160	D45 / D63

Tool grit size	dopa standard tools
D5	STF II-D5
D7	STF II-D7
D10	STF II-D10
D15	STF II-D15
D20	STF II-D20
D25	STF I-D25
D35	STF I-D35
D46	STF I-D46
D64	STF I-D64
D76	STF I-D76
D91	STF I-D91
D125	STF I-D125
D160	STF I-D160

On soft glass types use the finer grit sizes.

On harder glass types rather use the rougher tools.

Standard sizes for generator tools

RF	Outer ring diameter in mm	Inner ring diameter in mm	Lip radius in mm
2	3	1	0.5 / 1
3	4	2	0.5 / 1
4	5	3	0.5 / 1
5	6	4	0.5 / 1
6,5	8	5	0.75 / 1.5
7	8	6	0,5 / 1
8	10	6	1 / 2
10	12	8	1 / 2
12	14	10	1 / 2
13.75	16	11.5	1.125 / 2.25
15	17.5	12.5	1.25 / 2,5
17.5	20	15	1.25 / 2,5
20	22.5	17.5	1.25 / 2,5
22.5	25	20	1.25 / 2,5
25	28	22	1.5 / 3
30	33	27	1.5 / 3
35	38	32	1.5 / 3
40	43	37	1.5 / 3
50	54	46	2 / 4
56	60	52	2 / 4
70	74	66	2 / 4
80	84	76	2 / 4
95	100	90	2.5 / 5
115	120	110	2.5 / 5
135	140	130	2.5 / 5
145	150	140	2.5 / 5

The tools will give you a much better performance if you take care of a good lubrication. Transport as much lubricant into the cutting zone as possible. Central lubrication through the internal hole is always helpful.

Take a larger ring tool if the lens radius allows you to. This will furthermore stabilize your process.

The standard tools have a 6mm, 12mm or a 25mm shank. The shank is made of stainless steel. All 12mm and 25mm shanks are coming with an internal hole for a central lubricant feed.

Should you need another shank or diamond ring size this is also possible. Please contact us.

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