

F156

Specifications

Characteristics	Value
Water Content	<0.5%
Optical Purity	>99.98%
Severity Index	<1000
Refractive Index	@546nm
35°C Hydrated	1.555
UV Cutoff	<10%@ 379nm
Extractables	<0.25%

Machining

Diamond Tooling

TOOLING	RADIUS (MM)	TOP RAKE	RELIEF
Rough Cut	0.40	0°/-2.5°	15°
Fine Cut	0.30	0°/-2.5°	15°

Machining Recommendations: Lathe-Cutting Parameters

	Speed (RPM)	Tool Feed	Depth of Cut Blank	Surface Temp
Rough Cut	8,000	0.7 mm/min	0.2 mm	<-20°C
Fine Cut	9,000	0.4 mm/min	0.1 mm	<-20°C

Machining Recommendations: Diamond Milling Parameters

	Speed (RPM)	Tool Feed	Blank Surface Temp
First Cut	50,000	30 mm/min	<-20°C
Fine Cut	50,000	45 mm/min	<-20°C

Polishing

F156 can be polished using normal aqueous media tumble polishing methods.