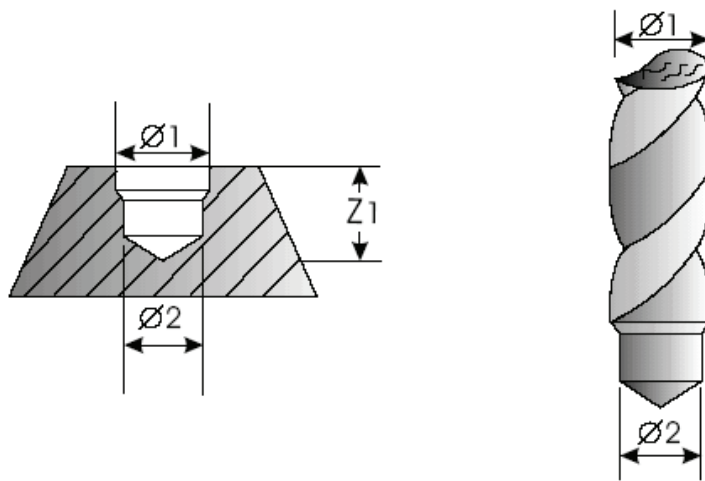


1.2. PRESETTING FOR SOLID MATERIALS

1.2.1. Drilling into solid materials



The following list shows the exact dimensions of the (two-stage) drill bits/ holes for the various mountings (in millimeters):

Size	Drill bit Small		Drill bit Standard		Drill bit Large		Drilling depth
	Ø1	Ø2	Ø1	Ø2	Ø1	Ø2	
1.50mm	1.75	1.36	1.76	1.36	1.77	1.36	1.85 till 1.95
2.00mm	2.25	1.86	2.26	1.86	2.27	1.86	1.85 till 1.95
2.50mm	2.75	2.36	2.76	2.36	2.77	2.36	1.85 till 1.95
3.00mm	3.25	2.86	3.26	2.86			1.85 till 1.95

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These special two-stage drill bits are made of tungsten carbide and can be obtained from SWAROVSKI GEMS™.

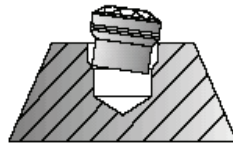
We recommend using a Standard Drill Bit for first applications. Depending on the materials used, it may be necessary to change the drill bit to a larger or smaller size for your specific purposes.

1.2.2. Setting our pre-set gemstones

The pre-setting for solid materials can either be set with the flat part of tweezers or our specially designed setting pencil. Make sure you place the tool so you can press straight down on the pre-setting, not on an angle.



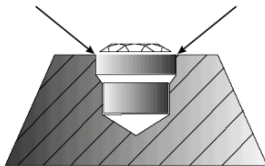
Correct



incorrect

1.2.3. Flush set pre-settings

To guarantee a firm hold, flush set pre-set stones so they are level with the work piece surface.



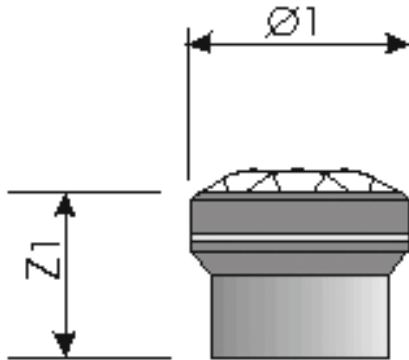
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1.2.4. Application

1. Create a CAD/CAM technical drawing to programme the CNC-milling machine
2. Milling of the cavities with our two-stage drill bit standard
3. Remove any excess particles from the two-stage cavities
4. Position Presetting into the hole, ensuring that the BSO at right angle
5. Set Presetting using one of the following tools:
 - a) tweezers or
 - b) setting hammer or
 - c) setting pencil or
 - d) vacuum pump

1.2.4. Technical drawing

1.2.4.1. Pre-setting Bezel Solid (BSO):

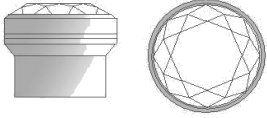
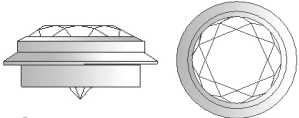
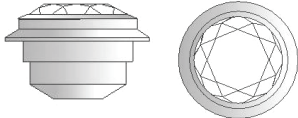


Stone Size mm	Ø1	Z1
1,50	1,78	1,70
2,00	2,28	1,70
2,50	2,78	1,70
3,00	3,29	1,70
Tolerances mm	+0,005	-0,1

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1.3. PRESETTING MOUNTING WEIGHTS

1.3.1. Mounting weights (in gram per 100 pieces without stones)

	 BSO				 BHO					 BHC				
Size in mm	1.50	2.00	2.50	3.00	1.30	1.50	2.00	2.50	3.00	1.30	1.50	2.00	2.50	3.00
925 Silver	1.07	1.56	2.27	2.63	0.80	0.88	1.12	1.48	1.70	0.80	1.21	1.87	2.41	4.24
Yellow Gold 18kt.	1.68	2.60	3.13	3.98	1.23	1.33	1.84	2.17	2.48	1.23	1.89	2.81	3.61	5.63
White Gold 18kt.	1.64	2.53	3.45	4.06	1.29	1.43	1.89	2.24	2.47	1.29	1.96	3.02	3.64	5.70