# Releasing a Lens Grinding Fixture Bond

**Objective**  
A fixture used in lens grinding uses a metallic bond to secure the glass form to the fixture during grinding. Induction is used to release the lens from the bonding material.

**Material**  
bonded grinding fixtures; Teflon-coated helical coil

**Temperature**  
55°C (130°F)

**Frequency**  
355 kHz

**Equipment**  
Ambrell 5kW induction heating system including:
- **Coil**: custom-designed helical coil
- **Workhead**: two 1.5µF capacitors (Total 0.75µF)

**Process**  
The bonded assembly is placed (glass up) within a helical coil which circles the bonding slug. Induction heats the material to the melting point in 5-7 seconds. Upon melting, the lens is released from the fixture, the fixture drops away.

**Results/Benefits**  
**Efficiency**: the bond is released cleanly, in a very few seconds  
**Economy**: energy is applied only where required