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54 **Method for grinding a lens and apparatus thereof.**

57 A lens grinding method of the present invention includes a first step for finding a lens-edge thickness over the entire circumference of a lens-edge vector radius locus of a lens to be cut, a second step for finding a lens-edge vertex position information for dividing the lens-edge into a desired ratio over the entire circumference thereof, and a third step for V-edge edging the lens-edge based on the V-edge vertex position information. Also, a lens grinding apparatus of the present invention includes measuring means (12) for finding a lens-edge thickness over the entire circumference of a lens-edge vector radius locus of a lens to be cut, input means (16) for inputting a desired ratio, calculating means (15) for finding a positional information of a V-edge vertex for dividing the lens-edge at the input ratio over the entire circumference thereof, and controlling means for V-edge edging the lens-edge based on the V-

edge vertex positional information.

And according to the lens grinding method and the apparatus for carrying out the method, as the lens-edge thickness is measured over the entire circumference of the lens-edge and the movement of the lens in the Z-axis direction is controlled such that the V-edge is formed at a desired ratio over the entire circumference of the lens-edge, the V-edge can be desirably positioned even if a lens having an aspherical refracting surface like a progressive multifocus lens.

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X	GB-A-2170130 (ESSILOR INTERNATIONAL) * abstract; figures 1-7 * ---	1, 3-5, 6, 8-10	B24B9/14
X	EP-A-196114 (TOKYO KOGAKU KIKAI KABUSHIKI KAISHA) * claim 1; figures 1-13 * ---	1-3, 5-8, 10	
A	EP-A-298129 (HOYA CORPORATION) * abstract; figures 1-4 * -----	1-10	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B24B
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 10 OCTOBER 1990	Examiner CUNY, J
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	