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(54) METHOD FOR PRECISION ALIGNMENT DURING A BLOCKING PROCESS OF LENS MANUFACTURING

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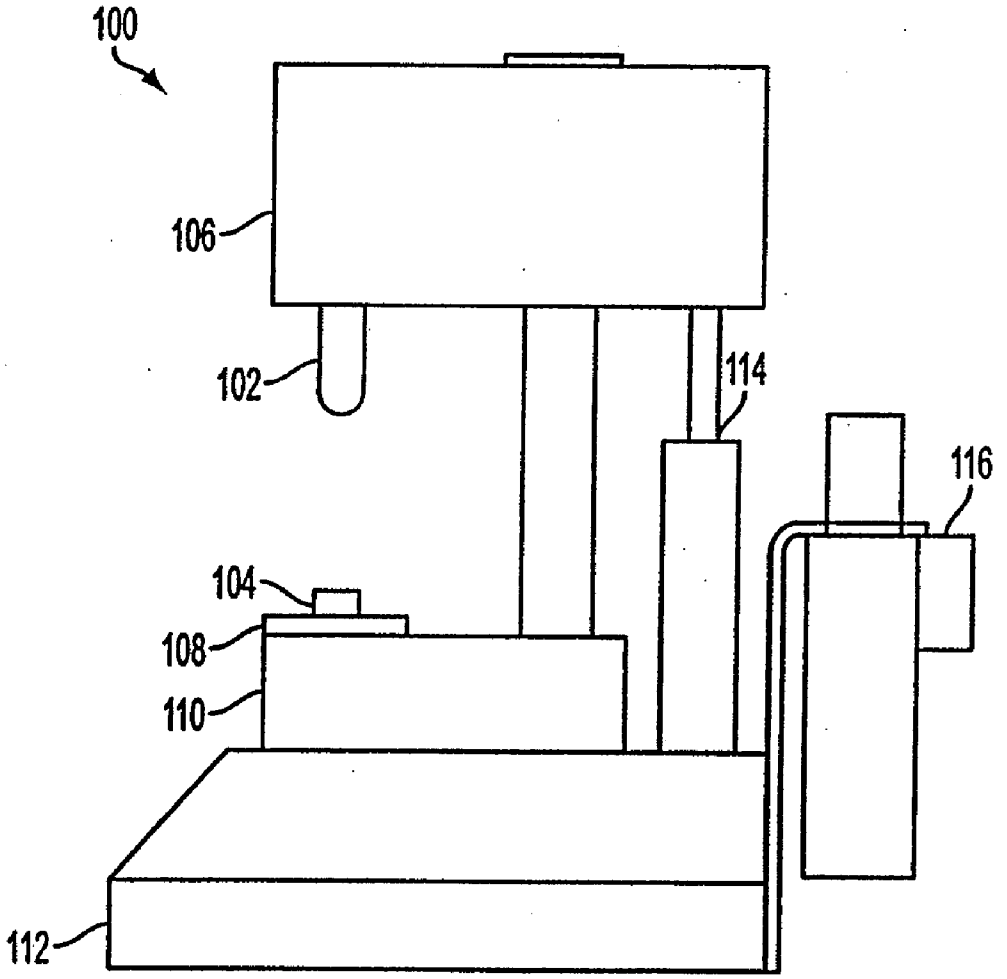
B24B 1/00 (2006.01)

(52) **U.S. Cl.** **451/41**

(57) **ABSTRACT**

A blocking apparatus and a blocking method allow precise alignment of an axis of a button with an axis of a block for a blocking process of lens manufacturing. According to another aspect, the invention provides a blocking apparatus and a blocking method for automatically compensating variations in button geometry without requiring complex adjustments during the blocking process of lens manufacturing. According to yet another aspect, the invention provides a button holder that may adjustably float on a seat stage of a blocking apparatus, where the button holder may include a mechanism to self-align on the seat stage after a block of the blocking apparatus interfaces with the button holder.



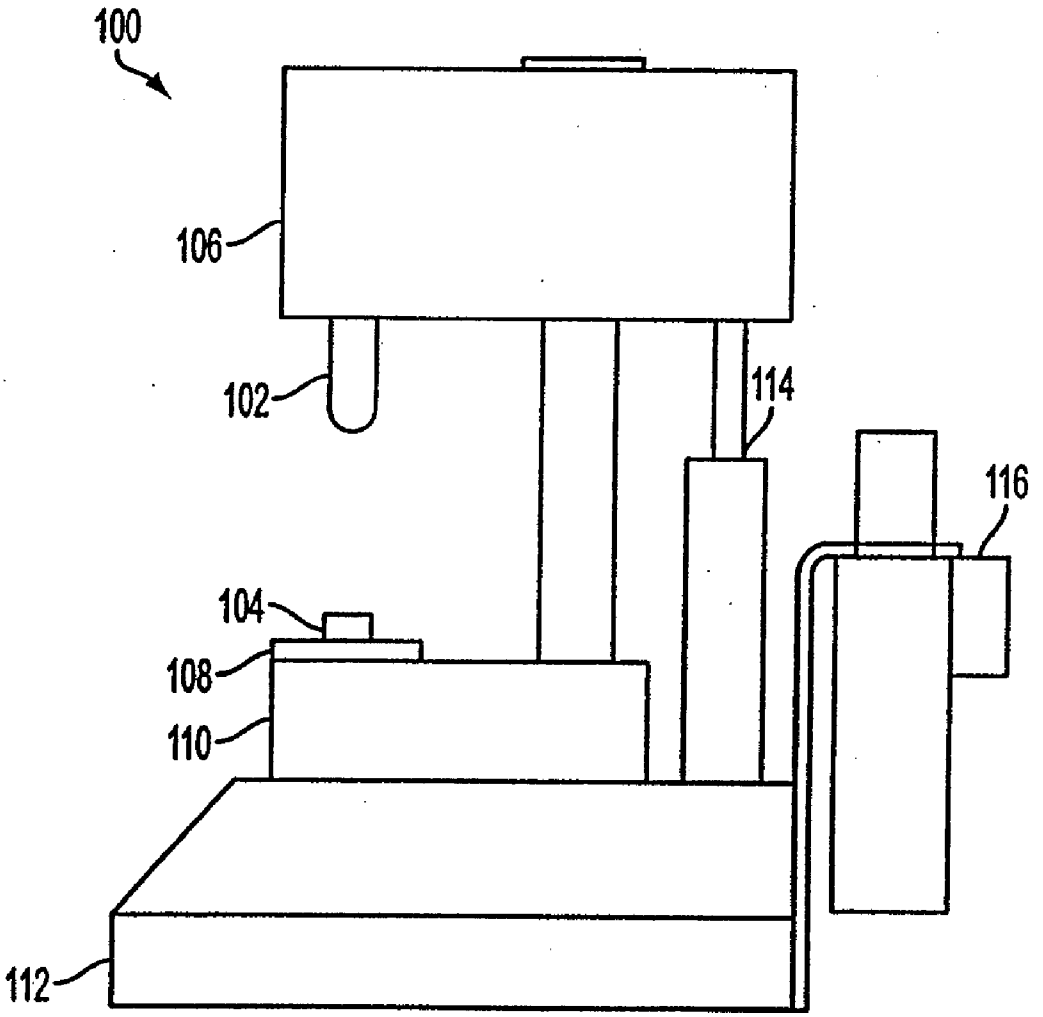


FIG. 1A

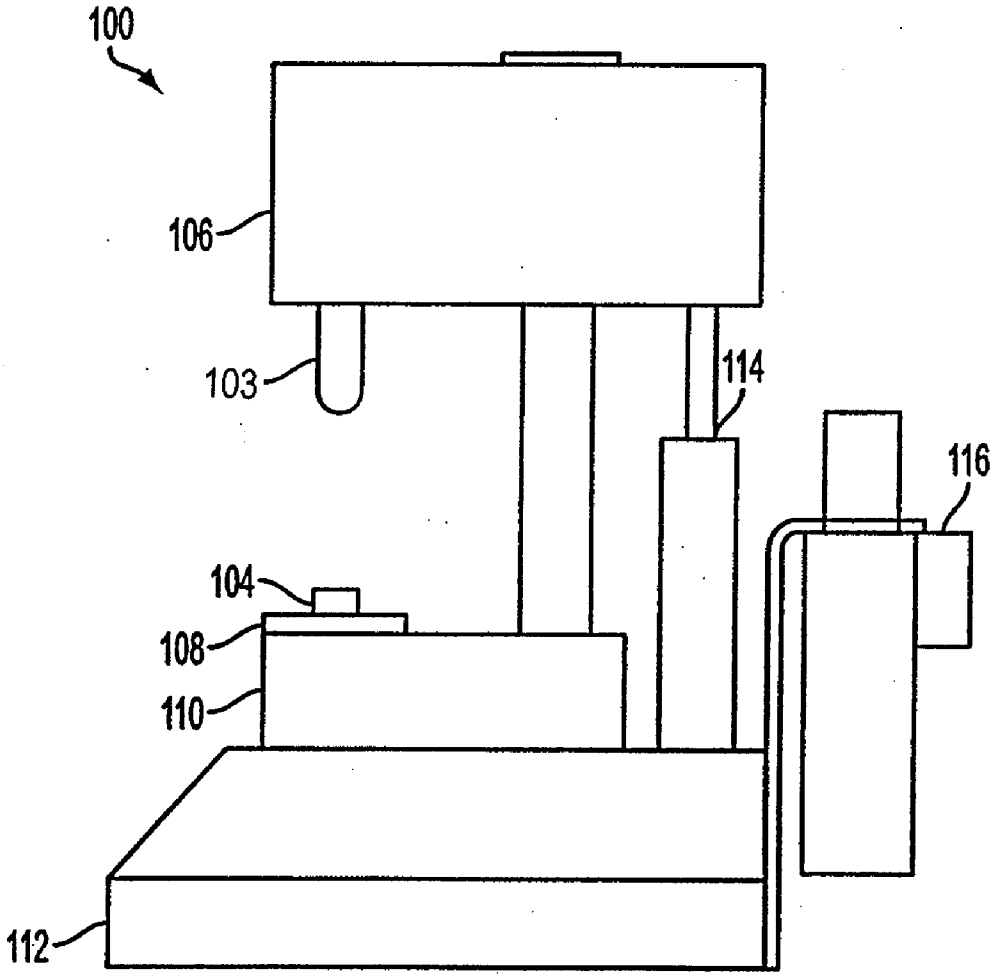


FIG. 1B

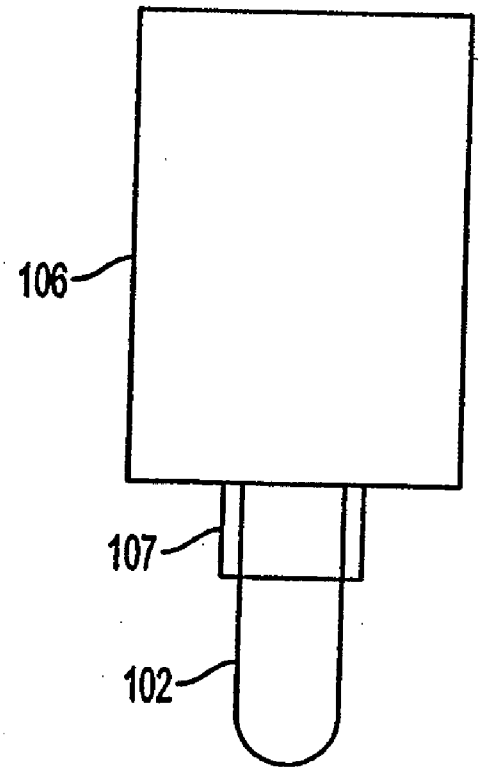


FIG. 2

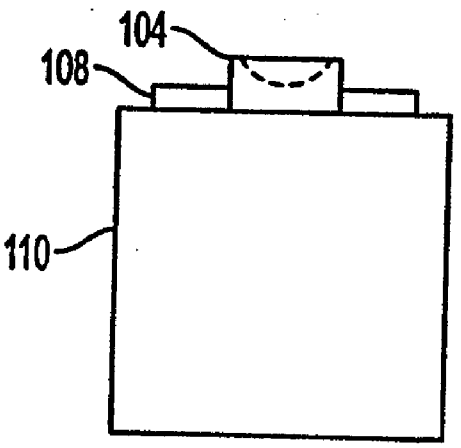


FIG. 3

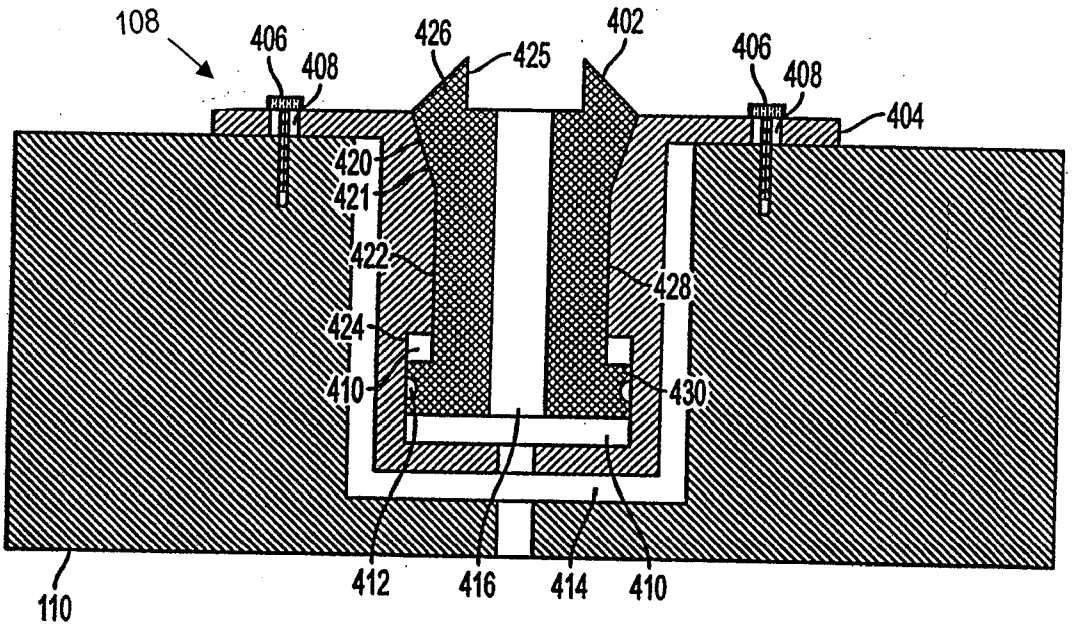

108
406
408
426
425
402
406
408
404
420
421
422
428
424
410
430
110
412
416
414
410

FIG. 4A

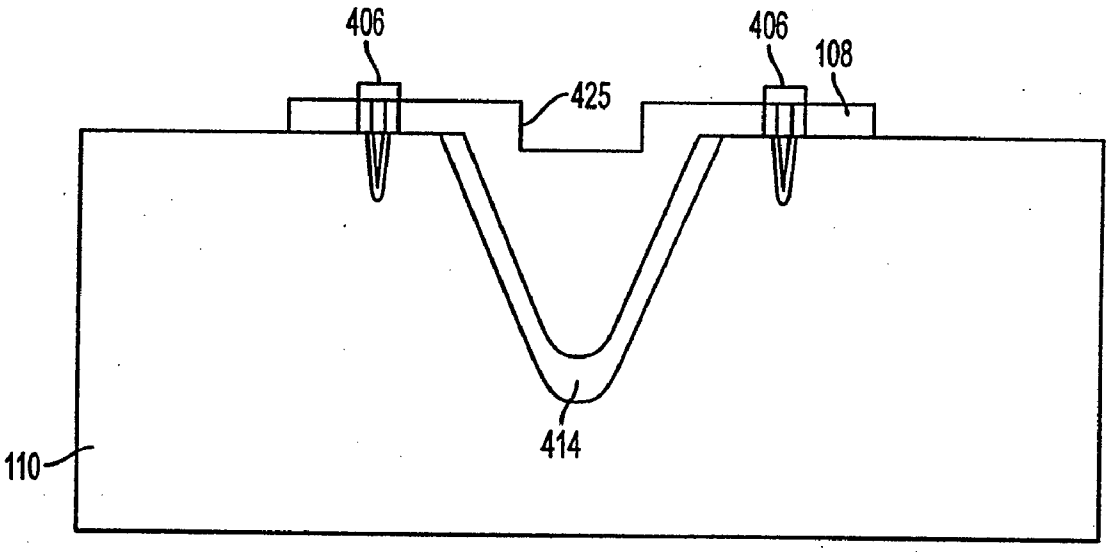


FIG. 4B

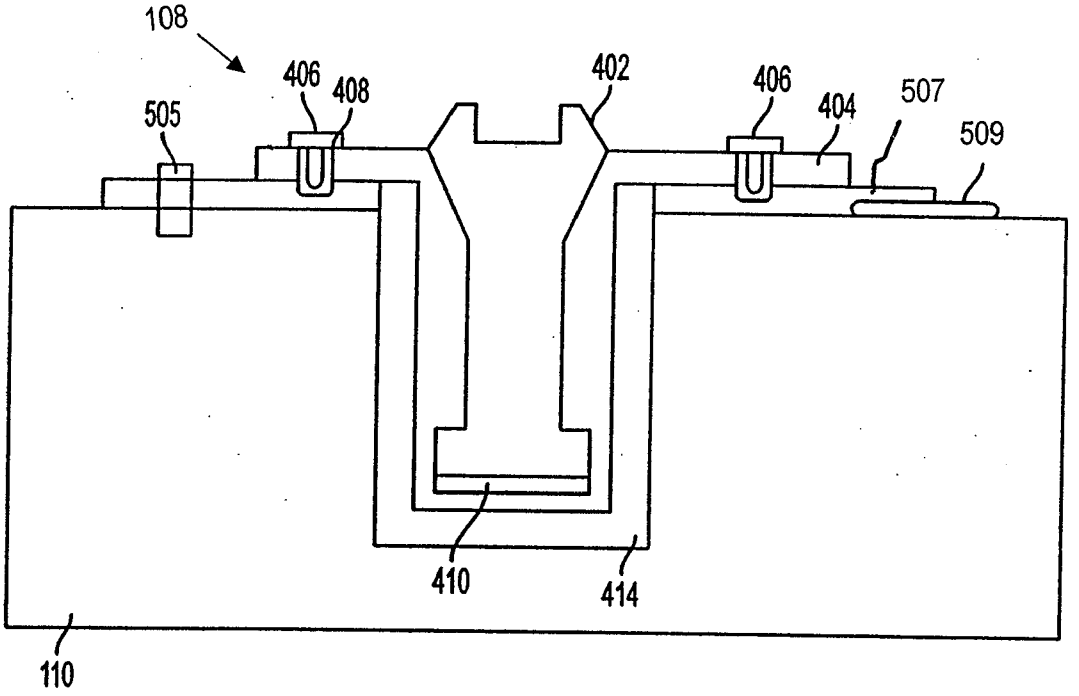


FIG. 5A

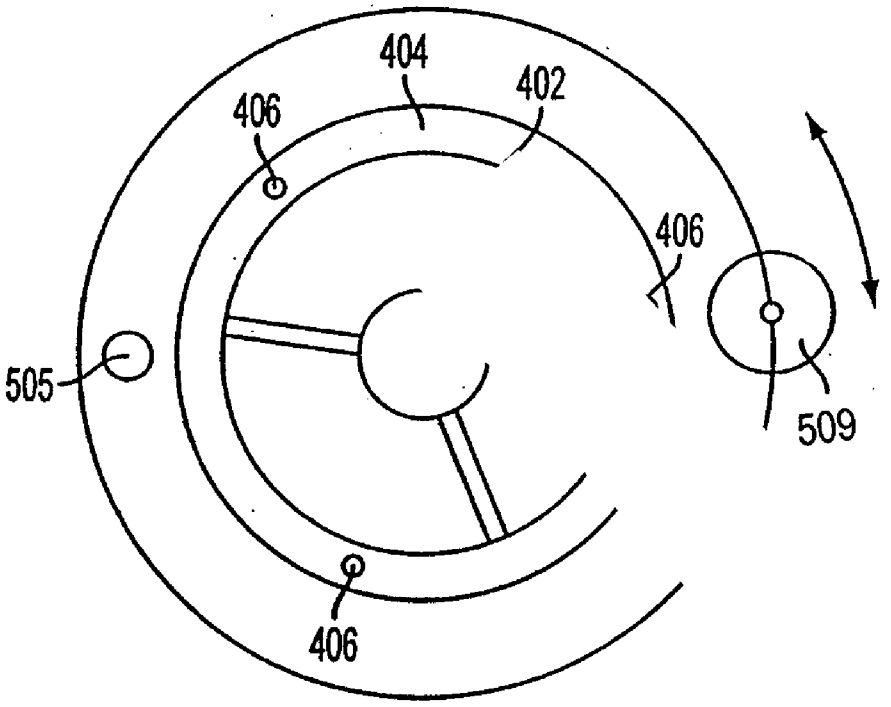


FIG. 5B

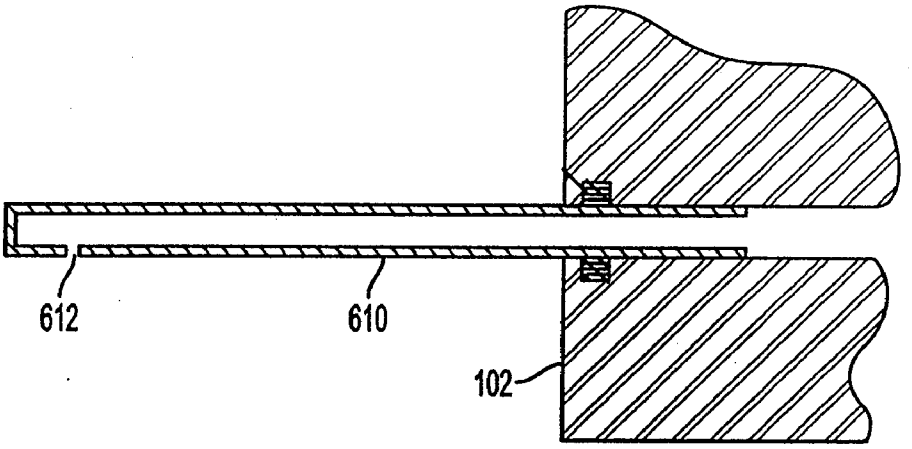


FIG. 6A

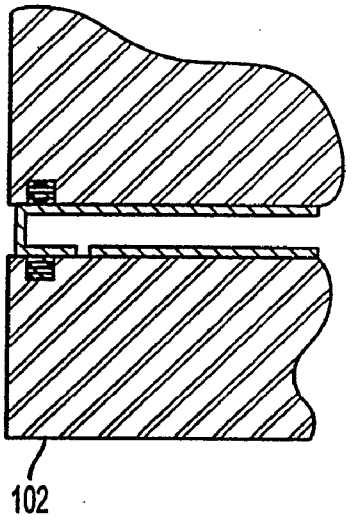


FIG. 6B

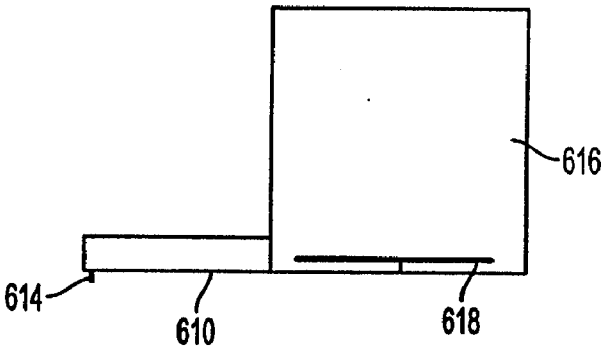


FIG. 6C

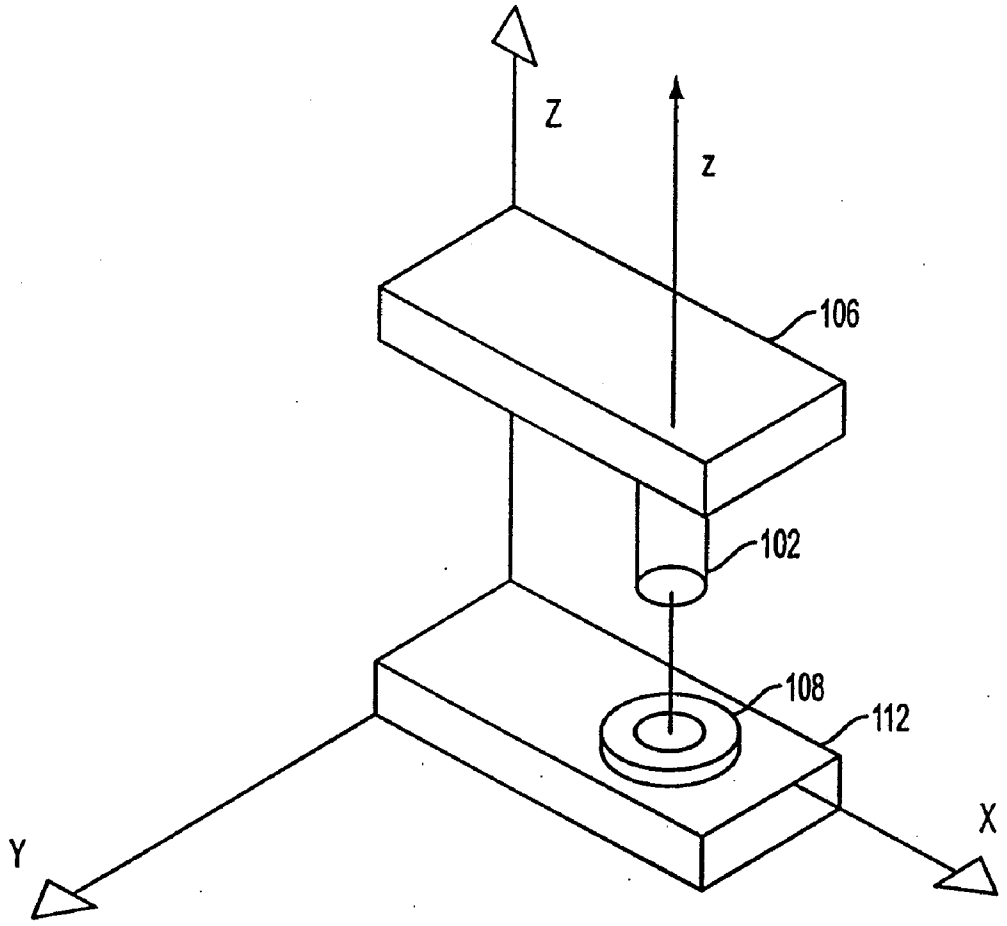


FIG. 7

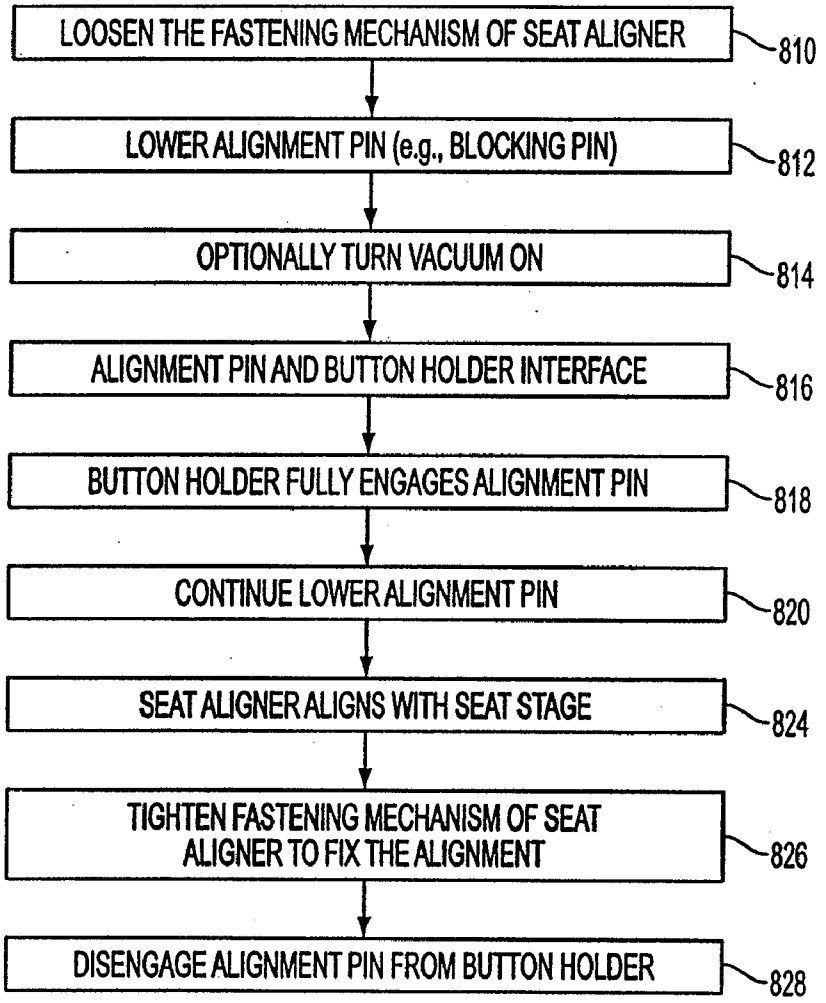

LOOSEN THE FASTENING MECHANISM OF SEAT ALIGNER
810
LOWER ALIGNMENT PIN (e.g., BLOCKING PIN)
812
OPTIONALLY TURN VACUUM ON
814
ALIGNMENT PIN AND BUTTON HOLDER INTERFACE
816
BUTTON HOLDER FULLY ENGAGES ALIGNMENT PIN
818
CONTINUE LOWER ALIGNMENT PIN
820
SEAT ALIGNER ALIGNS WITH SEAT STAGE
824
TIGHTEN FASTENING MECHANISM OF SEAT ALIGNER TO FIX THE ALIGNMENT
826
DISENGAGE ALIGNMENT PIN FROM BUTTON HOLDER
828

FIG. 8

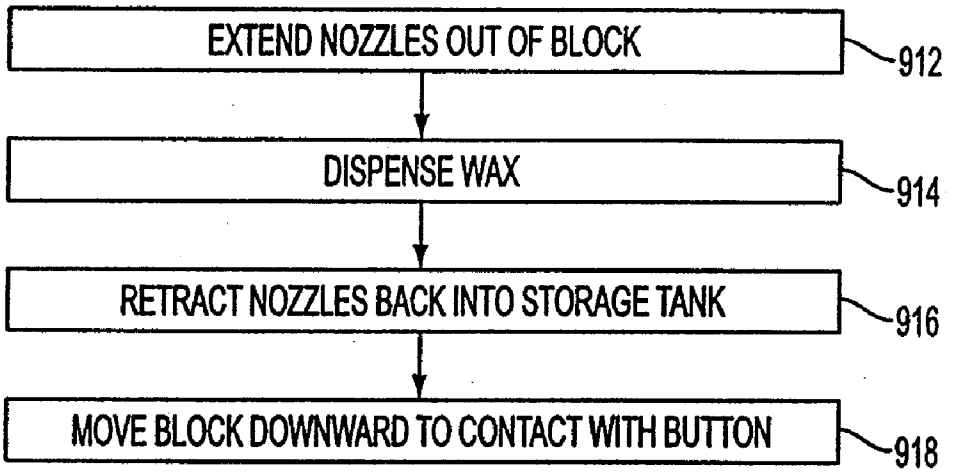

EXTEND NOZZLES OUT OF BLOCK
912
DISPENSE WAX
914
RETRACT NOZZLES BACK INTO STORAGE TANK
916
MOVE BLOCK DOWNWARD TO CONTACT WITH BUTTON
918

FIG. 9

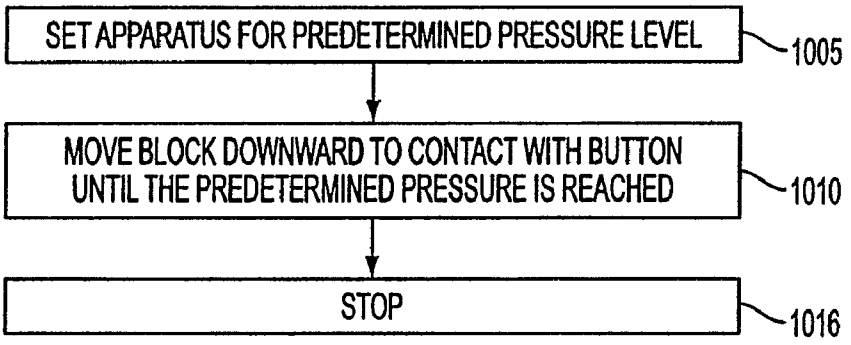

SET APPARATUS FOR PREDETERMINED PRESSURE LEVEL
1005
MOVE BLOCK DOWNWARD TO CONTACT WITH BUTTON UNTIL THE PREDETERMINED PRESSURE IS REACHED
1010
STOP
1016

FIG. 10

METHOD FOR PRECISION ALIGNMENT DURING A BLOCKING PROCESS OF LENS MANUFACTURING

RELATED APPLICATIONS

[0001] This application is a continuation of prior U.S. application Ser. No. 10/676,124, filed on Oct. 2, 2003, the entire teachings of which are incorporated herein by reference.

BACKGROUND

[0002] Contact lens manufacturing involves multiple complex operations. Each of these operations requires a high degree of accuracy in order to achieve a precise fabrication for the contact lens.

[0003] An unprocessed contact lens is generally known as a "button." The button must be precisely aligned to a block, and then fixed to the block using a fixing material, such as wax, glue, or other adhesive, so that subsequent machining or other operations on the button can be conveniently performed. This process of fixing a button to a block is referred to as "blocking." A device that performs the blocking must accurately align the button with the block in order to achieve certain optical characteristics of the lens. Precise alignment and positioning of the button during blocking reduces prism, increases concentricity of the lens and permits control of the center thickness of the lens.

[0004] In conventional systems, a button is typically transferred to a block in such a way that an axis of the button is more or less aligned to an axis of the block. The block is then moved a known distance relative to the button (or vice versa) so as to contact with the button and fix the two together with the adhesive. This process presents problems if the thickness or geometry of the button varies. If the button is too thick, the block may deform the button. If the button is too thin, the block may not achieve sufficient "contact" to achieve proper adherence. In order to compensate these variations, manual adjustments to this distance may be required. These adjustments are time consuming and require a skilled operator.

[0005] Furthermore, conventional systems typically dip the block in the fixing material or dispense the fixing material through a nozzle. One problem with these methods is a non-uniform adherence of the wax on the block. In addition, wax left in the nozzle cools, causing it to solidify, particularly at the tip, thereby hampering further wax from being dispensed.

[0006] Other drawbacks also exist.

SUMMARY

[0007] Embodiments of the invention may overcome these and other drawbacks.

[0008] According to one aspect of the invention, a blocking apparatus and a blocking method are provided for precisely aligning an axis of a button with an axis of a block for a blocking process of lens manufacturing.

[0009] According to another aspect, a button holder is provided for holding a button intact without any risk of potential damage to the button.

[0010] In one embodiment, the button holder operates with a vacuum to hold a button in place on a button placement surface or recess of the button holder.

[0011] According to another aspect, a button holder is coupled to an adjustable offset mechanism for creating a selectable offset between the axis of the button holder and the axis of the block. The adjustable offset mechanism may include an offset device (e.g., a screw, a cam, etc.) for providing this offset.

[0012] According to another aspect, a button holder is adjustably positioned within a seat aligner. The button holder may include a hole formed therein that receives a button, a body with a slanted surface, and a flange.

[0013] According to another aspect, a seat aligner that can hold a button holder is provided. The seat aligner may include a chamber formed therein; the chamber may further include a bottom portion for receiving a flange of the button holder and a top portion for receiving the body of the button holder. The bottom portion may include a predefined depth that is larger than the thickness of the flange of the button holder. The top portion may include a surface (e.g., a slanted surface) for holding the button holder's body.

[0014] In one embodiment, the seat aligner holding a button holder includee at least one adjustment hole for receiving a fastening mechanism that fastens the seat aligner to a seat stage. The adjustment hole of the seat aligner may enable moving the seat aligner within the seat stage while the seat aligner is still attached to the seat stage.

[0015] According to another aspect, a seat stage has a stage cavity formed therein for receiving a seat aligner. The stage cavity may enable moving the seat aligner within the seat cavity.

[0016] According to another aspect, a button holder may adjustably float on a seat stage of a blocking apparatus, where the button holder may include a mechanism to self-align on the seat stage after a block interfaces with the button holder.

[0017] According to another aspect, a blocking apparatus and a blocking method can automatically compensate for variations in a button geometry without requiring complex adjustments during blocking process of lens manufacturing.

[0018] In one embodiment, the blocking apparatus includes mechanisms for positioning a block on a button based on a predetermined pressure applied on the block in order to compensate for variations in the button geometry.

[0019] In another embodiment, the blocking apparatus includes mechanisms for positioning a block on a button based on a predetermined pressure between the block and the button in order to compensate for variations in the button geometry. In some embodiments, the blocking apparatus may include a sensor indicative of a force between a block and a button.

[0020] In another embodiment, the blocking apparatus includes a pressure chamber and a regulator, which are coupled to a block, for regulating a pressure applied on the block.

[0021] According to another aspect, the blocking apparatus includes a mechanism for automatically applying a wax

material on a button. In some embodiments, the wax material can be stored within the blocking apparatus.

[0022] In one embodiment, the blocking apparatus includes a storage tank. The storage tank may include a reservoir for holding a fixing material and a retractable dispensing nozzle for dispensing the fixing material on a button.

[0023] Other features of the invention will become apparent from the following detailed description considered in connection with the accompanying drawings that disclose embodiments of the invention. It should be understood, however, that the drawings are designed for purposes of illustration only and not as a definition of the limits of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0024] In the accompanying drawings, described below, like reference characters refer to the same or similar parts throughout the different views. The drawings are not necessarily to scale, emphasis instead being placed upon illustrating particular principles of the methods and apparatus characterized in the Detailed Description.

[0025] **FIG. 1A** illustrates a blocking apparatus according to one embodiment of the invention.

[0026] **FIG. 1B** illustrates the blocking apparatus of **FIG. 1A** with a blocking pin substituted for the block.

[0027] **FIG. 2** illustrates a block coupled to a block head according to one embodiment of the invention.

[0028] **FIG. 3** illustrates a seat positioned on a seat stage according to one embodiment of the invention.

[0029] **FIG. 4A** illustrates a seat positioned on a seat stage, where the seat includes a seat aligner and a button holder according to one embodiment of the invention.

[0030] **FIG. 4B** illustrates a button holder positioned on a seat stage according to one embodiment of the invention.

[0031] **FIG. 5A** illustrates an apparatus including an adjustable offset mechanism for creating an offset in the alignment according to one embodiment of the invention.

[0032] **FIG. 5B** illustrates a top view of an apparatus including an adjustable offset mechanism for creating an offset in the alignment according to one embodiment of the invention.

[0033] **FIG. 6A** illustrates a retractable dispensing nozzle in an extended position according to one embodiment of the invention.

[0034] **FIG. 6B** illustrates a retractable dispensing nozzle in a retracted position according to one embodiment of the invention.

[0035] **FIG. 6C** illustrates a storage tank including a retractable dispensing nozzle according to one embodiment of the invention.

[0036] **FIG. 7** illustrates an alignment of a blocking process according to one embodiment of the invention.

[0037] **FIG. 8** illustrates a process of aligning a block and a button holder according to one embodiment of the invention.

[0038] **FIG. 9** illustrates a process of dispensing a fixing material using a retractable dispensing nozzle according to one embodiment of the invention.

[0039] **FIG. 10** illustrates a pressure based blocking process according to one embodiment of the invention.

DETAILED DESCRIPTION

[0040] According to an embodiment of the invention illustrated in **FIG. 1A**, a blocking apparatus **100** of the invention may include, for example, a block **102** (e.g., a fixture, an arbor, etc.), a block head **106**, a button **104** (e.g., an unprocessed contact lens), a seat **108**, a seat stage **110**, a base **112**, a force control mechanism **114**, and a force adjustment mechanism **116**. Block **102** may be coupled to block head **106**. Block **102** and block head **106** may be movable along a vertical axis. While block **102** and block head **106** are described herein as operating along a vertical axis, the invention may also be constructed to operate block **102** and block head **106** along a horizontal or along any other axis, as would be apparent.

[0041] According to an aspect of the invention, button **104** is placed on seat **108**. Seat **108** may be positioned on and attached to seat stage **110**. In some embodiments, seat **108** may be movable in one or more axes relative to seat stage **110**.

[0042] According to an aspect of the invention, block **102** may be moved vertically to contact button **104**. Seat **108** may be moved horizontally (or in some embodiments, vertically) to align an axis of block **102** with an axis of button **104**. In some embodiments, these axes may be central axes of the respective components. During the alignment process, itself, a blocking pin **103** (shown in **FIG. 1B**) is used in place of block **102**. Blocking pin **103** may include a pin of substantially identical diameter to that of buttons **104**. Blocking pin **103** may also include a block **102** to which a button **104** is already attached in the desired alignment.

[0043] According to an aspect of the invention, as illustrated in **FIG. 4A**, blocking apparatus **100** may include, for example, seat **108** and seat stage **110**. Seat **108** may include, for example, a button holder **402** and a seat aligner **404**. The combination of button holder **402** and seat aligner **404** illustrated in **FIG. 4A** is sometimes referred to as a collet. In one embodiment, button holder **402** may include, for example, a top portion **426**, a middle portion **428**, and a bottom portion **430**. Top portion **426** may include, for example, a button-receiving surface **425** or recess for receiving button **104**. In some embodiments, top portion **426** of button holder **402** includes a surface, such as slanted surface **420** for positioning button holder **402** within seat aligner **404**. Bottom portion **430** of button holder **402** may include a flange **412**.

[0044] According to another aspect of the invention, button holder **402** may hold a button **104**. In some embodiments, button holder **402** may include one or more holes **416** or air-spaces that may assist holding button **104** in place. In some embodiments, button holder **402** may include, for example, one or more holes **416** operating in conjunction with a vacuum that holds button **104**. Vacuum or a predefined air pressure inside button holder **402** may enable holding button **104** in place on button-placement surface **425**.

[0045] Seat aligner **404** of seat **108** may include, for example, one or more adjustment holes **408**. Adjustment hole **408** may receive a fastening mechanism **406** (e.g., a screw, a nail, a bolt, etc.) for securely fastening seat **108** to seat stage **110**. According to one embodiment of the invention, the diameter of adjustment hole **408** may be sufficiently larger than the diameter of fastening mechanism **406** to enable some movement of seat **108** relative to seat stage **110** when fastening mechanism **406** is loosened. In other embodiments, clamps or clips may be used to fasten seat **108** to seat stage **110**, as would be apparent.

[0046] Seat aligner **404** may include, for example, a chamber **410** formed therein. Chamber **410** may include, for example, a top portion **420**, a middle portion **422**, and a bottom portion **424**. The top portion **420** of seat aligner **404** may include, for example, a surface such as slanting surface **421** for interfacing with a surface of button holder **402** (e.g., slanting surface **420** of button holder **402**). The bottom portion **424** of seat aligner **404** may receive a flange portion of button holder **402**. The depth of bottom portion **424** of seat aligner **404** may be larger than the thickness of the flange portion of button holder **402** to accommodate piston-like movement of the flange therein.

[0047] According to another aspect of the invention, a vacuum may be used to create a pressure drop inside chamber **410** of seat aligner **404**. This pressure drop inside chamber **410** may facilitate disengaging the respective surfaces of button holder **402** and seat aligner **404** during alignment as well as holding button **104** in place during blocking.

[0048] According to another embodiment, seat stage **110** may include a stage cavity **414** to accommodate seat aligner **404** as illustrated in **FIG. 4A**. Stage cavity **414** may permit sufficient movement of seat aligner **404** within seat stage **110** so as to achieve alignment. Stage cavity **414** of seat stage **110** and adjustment holes **408** of seat aligner **404** may assist seat aligner **404** to self align with seat stage **110**. In one embodiment, seat aligner **404** may self align with seat stage **110** when slanting surface **421** of seat aligner **404** engages slanting surface **420** of button holder **402**.

[0049] In some embodiments during the alignment process, when vacuum is applied, a surface (e.g., slanting surface **420**) of button holder **402** may be disengaged from a surface (e.g., slanting surface **421**) of seat aligner **404** as the blocking pin seals button seat **425** of button holder **402**. This aligns the blocking pin with button holder **402**. In one embodiment, as the blocking pin is lowered on button holder **402**, a surface (e.g., slanting surface **420**) of button holder **402** may be reengaged to a surface (e.g., slanting surface **421**) of seat aligner **404** thereby aligning button holder **402** and seat aligner **404**.

[0050] According to another aspect, as illustrated in **FIG. 4B**, a seat **108** is provided that may directly interface with the blocking pin on seat stage **110**. Seat **108** may include button seat **425**. While illustrated as having slanted surfaces, seat **108** may have any shape including vertical or horizontal surfaces as would be apparent to the one skilled in the art. When seat **108** engages the blocking pin, alignment of seat **108** can be achieved on seat stage **110**.

[0051] According to another aspect of the invention, as illustrated in **FIGS. 5A and 5B**, blocking apparatus **100** may provide an adjustable offset mechanism **507** for creating an offset to the alignment of seat **108**, seat aligner **404** or button holder **402** against block **102**. Adjustable offset mechanism **507** may be coupled to seat **108**, seat aligner **404** or button holder **402**. In one embodiment, adjustable offset mechanism **507** may include a pivot point **505** and an adjusting tool **509** (e.g., a screw, a cam, etc.). One side of adjustable offset mechanism **507** may be permanently or removably attached to seat stage **110** via pivot point **505**, and the other side of adjustable offset mechanism **507** may be moved in a pivotal motion on seat stage **110**. Adjusting tool **509** (e.g., a screw, a cam, etc.) may facilitate moving adjustable offset mechanism **507** to create an offset in the alignment of button **104** and block **102**. For example, a user may use adjusting tool **509** to move adjustable offset mechanism **507** so as to move seat **108**, seat aligner **404** or button holder **402** relative to seat stage **110**.

[0052] In some embodiments where adjustable offset mechanism **507** includes a pivot motion, certain alignment accuracy can be achieved because there is no "play"; adjustable offset mechanism **507** is always in contact with the supporting pivot surface. In addition, the motion of the other side of adjustable offset mechanism **507** can be achieved easily and accurately by using adjusting tool **509** (e.g., a screw, a cam, etc.). Not only is this mechanical advantage working, but, in conjunction with the pivot motion of the mechanism itself, provides a very high degree of accuracy. An accurate offset can be achieved with a simple scale and hand motion.

[0053] Further, this offset motion is performed independently of the original process of aligning blocking apparatus **100** described elsewhere and can be readily set or reset without requiring realignment of the blocking apparatus itself.

[0054] According to another aspect of the invention, blocking apparatus **100** includes a mechanism for automatically compensating variations in a button geometry without requiring complex adjustments during blocking process of lens manufacturing. Buttons **104** may vary in thickness. These variations are caused by errors during manufacturing of button **104**. While these variations are present, moving block **102** a fixed distance relative to button **104** may deform thicker buttons or affect adherence to thinner buttons. Manual positioning of block **102** on button **104** to compensate for these variations is a time consuming operation.

[0055] In some embodiments of the invention, blocking apparatus **100** automatically compensates for variation in button geometry by providing a predetermined amount of "contact" or applying a predetermined pressure between block **102** and button **104**. According to the invention, block **102** is moved relative to button **104** until a predetermined amount of "contact" or pressure occurs between the two. Thus, the contact between button **104** and block **102** is the same regardless of the thickness of button **104**.

[0056] In one embodiment, blocking apparatus **100** may include a mechanism for moving block **102** to contact button **104**. In another embodiment, blocking apparatus **100** may include a mechanism for moving button **104** to contact block **102**. In both embodiments, one of block **102** and button **104** is moved relative to the other until a predetermined contact is achieved.

[0057] To achieve a particular amount of contact between block **102** and button **104**, block **102** may need to move less

distance towards button **104** when button **104** is thicker than the optimal geometry, and more towards button **104** when button **104** is thinner than the optimal geometry.

[**0058**] According to another embodiment of the invention, contact between block **102** and button **104** may be controlled by regulating pressure (e.g., air pressure) in cylinder **114**. In some embodiments, as illustrated in **FIG. 2**, blocking apparatus **100** may include, for example, a regulator **116** for regulating pressure applied on block **102**. Regulator **116** may include, for example, a pressure controller **214** that controls pressure applied on block **102**. In one embodiment, regulator **116** may include, for example, an air-pressure controller **216** for regulating air-pressure applied on block **102**, thereby controlling air-pressure applied on block **102**.

[**0059**] According to the invention, the amount of contact between block **102** and button **104** may be achieved by applying a predetermined pressure on block **102**. In some embodiments, cylinder **114** may be set for a predetermined pressure so that block **102** may be allowed to move downwards to interface with button **104** only up to the level that corresponds to the predetermined pressure. Cylinder **114** may not allow further motion once the corresponding predetermined pressure is reached. In some embodiments where block head **106** moves along vertical axis, the predetermined pressure of cylinder **114** would account for a weight of block head **106** as would be apparent. Other mechanisms may be used to provide a particular amount of pressure between block **102** and button **104**, as would be appreciated.

[**0060**] In conventional systems, wax is used to affix block **102** to button **104**. According to another aspect of the invention, as illustrated in **FIG. 6A**, blocking apparatus **100** may include a retractable dispensing nozzle **610** for dispensing wax. Retractable dispensing nozzle **610** may include, for example, a dispensing orifice **612** to deliver a wax or other fixing material on button **104**. Retractable dispensing nozzle **610** may be extended out of a tank or storage reservoir in order to dispense wax (or similar fixing material) on button **104**. After dispensing the wax or any other fixing material, retractable dispensing nozzle **610** may be retracted back inside the tank or reservoir. By extending and retracting retractable dispensing nozzle **610**, the temperature of wax inside retractable dispensing nozzle can be maintained at the same temperature as wax in the reservoir thereby eliminating the problems found in conventional dispensing systems.

[**0061**] In some embodiments, as illustrated in **FIG. 6B**, after retractable dispensing nozzle **610** is retracted inside storage tank or reservoir **616**, the surface of a storage tank or reservoir **616** may be sealed or otherwise covered. In some embodiments, storage tank or reservoir **616** may include a squeegee **624** that seals retractable dispensing nozzle **610**. This may serve one or more purposes including: preventing contaminants from being pulled into storage tank or reservoir **616**; cleaning retractable dispensing nozzle **610** from any residual wax that may be accumulated on or around orifice **612**; preventing wax from being clogged out of reservoir; and others as would be apparent.

[**0062**] In some embodiments, retractable dispensing nozzle **610** may be adapted to hold a wax or any other fixing material at elevated temperatures. These temperatures may include a temperature sufficient to maintain wax in a liquid state or at a particular viscosity, as would be apparent.

[**0063**] According to another embodiment, blocking apparatus **100** may include, for example, a temperature control mechanism (not otherwise illustrated) for controlling internal temperature of a storage tank or reservoir **616**. According to another embodiment, blocking apparatus **100** may also include, for example, a cooling mechanism (e.g., a laminar flow cooling jet, etc.) (not otherwise illustrated) for cooling the dispensed wax on button **104** to quickly solidify the wax.

[**0064**] According to another embodiment, as illustrated in **FIG. 6C**, blocking apparatus **100** may include, for example, a storage reservoir **616** for storing a fixing material (e.g., wax). In one embodiment, storage reservoir **616** may include, for example, retractable dispensing nozzle **610**. In some embodiments, dispensing nozzle **610** may include, for example, a protruding delivery tube that delivers a fixing material (e.g., wax) on button **102**. In another embodiment, storage reservoir **616** may include, for example, an electrode **618** for heating the fixing material (e.g., wax). In some embodiments, storage reservoir **616** may include, for example, a temperature controller (not otherwise illustrated) that interfaces with electronic control system to control the heating of fixing material (e.g., wax). In yet another embodiment, storage reservoir **616** may include, for example, an insulating material that insulates the surface of storage reservoir **616** for preventing heat dissipation from storage reservoir **616**.

[**0065**] **FIG. 7** illustrates an example of an alignment of a blocking apparatus **100**. As illustrated in **FIG. 7**, seat **108** may be moved horizontally along the X or Y axis so that a position of seat **108** or button holder **402** may be adjusted to align with block **102**.

[**0066**] According to another aspect of the invention, button holder **402** may be aligned to block **102** as illustrated in the process outlined in **FIG. 8**. As discussed above, during alignment, an alignment pin **103** (e.g., a blocking pin) is used in place of block **102**. An alignment pin **103** (shown in **FIG. 1B**) may be a blocking pin, a sample block or any fixture for the purpose of the alignment that would be apparent to the one skilled in the art. In operation **810**, fastening mechanisms **406** of seat aligner **404** may be loosened to allow movement of seat **108** upon or within seat stage **110** so that alignment can be achieved. In operation **812**, block head **106**, with the alignment pin **103** installed, may be lowered towards button holder **402**. In operation **814**, vacuum may be created optionally inside chamber **410** of seat aligner **404**. In operation **816**, the lowered alignment pin **103** may interface with button holder **402**. In operation **818**, the interfaced button holder **402** may fully engage the alignment pin **103**. At this point, the alignment pin **103** and button holder **402** are aligned. In some embodiments, button holder **402** may disengage seat aligner **404** because of presence of vacuum inside chamber **410**. As shown in operation **820**, the alignment pin **103** may be further lowered. In some embodiments, a surface (e.g., slanting surface **421**) of seat aligner **404** may engage a surface (e.g., slanting surface **420**) of button holder **402**. In operation **824**, seat aligner **404** aligns on seat stage **110** as their respective surfaces are engaged. In some embodiments, seat aligner **404** may self-align on seat stage **110**. In other embodiments, seat aligner **404** may be manually or automatically aligned on seat stage **110**. In operation **826**, fastening mechanism **406** of seat aligner **404** may be tightened to fix the alignment. In operation **828**, after fixing the alignment, the

alignment pin **103** may be disengaged from button holder **402** and block **102** may be placed for blocking. Once fixed, the alignment may be used for multiple blockings.

[**0067**] According to another aspect of the invention, a fixing material, in particular wax, may be dispensed onto button **104** during the blocking process using a retractable dispensing nozzle as illustrated in the process outlined in **FIG. 9**. In operation **912**, retractable dispensing nozzle **612** is extended out of storage tank **616**. In operation **914**, retractable dispensing nozzle **612** may dispense fixing material on button **104**. In operation **916**, retractable dispensing nozzle **612** retracts back inside storage tank **616**. In one embodiment, squeegee **624** may wipe any residual wax accumulated in or around orifices retractable dispensing nozzle **612**. In some embodiments, after retractable dispensing nozzle **612** retracts back inside storage tank **616**, a nozzle position of storage tank **616** may be automatically sealed or covered. In operation **918**, block **102** may be moved downward to contact with button **104**.

[**0068**] According to another aspect of the invention, a pressure-based blocking process may be carried out as illustrated in **FIG. 10**. As shown in operation **1005**, blocking apparatus **100** or any part of blocking apparatus **100** (e.g., cylinder **114**) may be set for a predetermined pressure, beyond which further motion of block **102** is inhibited. As shown in operation **100**, block **102** may be moved downward for contacting or interfacing with button **104** until the predetermined pressure is reached. As shown in operation **1016**, once the amount of contact reaches a predetermined level (e.g., a predetermined pressure); further movement of block **102** towards button **104** is stopped. If the amount of contact does not reach the predetermined level (e.g., the predetermined pressure), moving of block **102** towards button **104** may be continued until reaching the predetermined level (e.g., the predetermined pressure).

[**0069**] While a particular embodiment of the present invention has been described, it is to be understood that modifications will be apparent to those skilled in the art without departing from the spirit of the invention. The scope of the invention, therefore, is to be determined solely by the following claims.

What is claimed is:

1. A method for aligning a block with a work piece, the method comprising:

providing a work-piece holder;

coupling an alignment pin to a block head;

displacing the work-piece holder or the alignment pin along an axis to bring the work-piece holder into engagement with and into alignment with the alignment pin;

placing a work piece in the work-piece holder;

substituting a block for the alignment pin in the block head; and

displacing the work-piece holder or the block along the axis to bring the work-piece into contact with the block and to fix the work piece to the block.

2. The method of claim 1, wherein the work-piece holder is displaceably mounted on a seat stage such that it can be displaced in a plane orthogonal to the axis of displacement of the work-piece holder or alignment pin.

3. The method of claim 2, wherein the work-piece holder is displaced in the plane when the alignment pin engages the work-piece holder as a result of the engagement.

4. The method of claim 3, wherein the plane in which the work-piece holder is displaced is a horizontal plane

5. The method of claim 1, wherein the work piece is placed in a recess of the work-piece holder.

6. The method of claim 1, wherein the work-piece holder is adjustably positioned on a seat stage.

7. The method of claim 6, wherein the work-piece holder is adjustably positioned in a cavity defined by the seat stage.

8. The method of claim 1, wherein the work-piece holder defines an air space, and wherein the method further comprises regulating air pressure inside the air space of the work-piece holder to hold the work piece in place on the work-piece holder.

9. The method of claim 1, wherein the block head is displaced along a vertical axis to displace the block and the alignment pin.

10. The method of claim 9, further comprising controlling the displacement of the block head with a controlling mechanism.

11. The method of claim 1, wherein the work piece is an unprocessed lens.

12. The method of claim 1, wherein the work-piece holder is coupled with the seat stage via one or more fastening mechanisms.

13. The method of claim 12, wherein the fastening mechanisms permit displacement of the work-piece holder on the seat stage.

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