

GLASS PROCESSING

OK / NOK SITUATION EXAMPLES

TRAINING SUPPORT WITH YOUR TECHNICAL SUPPORT

V1. 07-2025

SAINT-GOBAIN GLASS PROPERTY

PROCESSING SITUATION

GLASS STORAGE

OK

OK

NOK

NOK

1



2



STORAGE

CUTTING

EDGE-DELETION

EDGE WORK

WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



PROCESSING SITUATION

GLASS HANDLING

- STORAGE
- CUTTING
- EDGE-DELETION
- EDGE WORK
- WASHING
- SCREEN-PRINTING
- DIGITAL PRINTING
- TEMPERING
- BENDING
- LAMINATION
- LAMINATION AGAINST PVB
- IGU ASSEMBLY



OK



OK



NOK

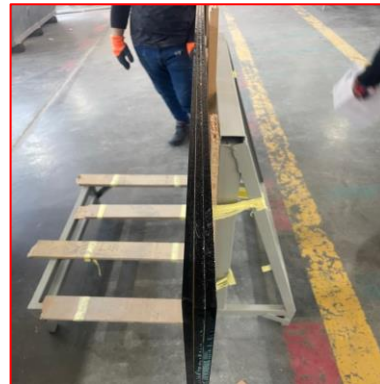
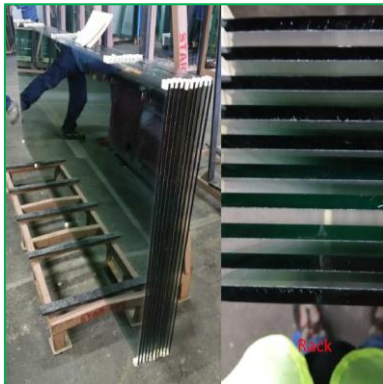


NOK



1

2



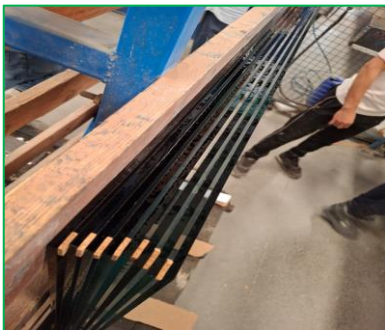
PROCESSING SITUATION

GLASS HANDLING

OK



OK



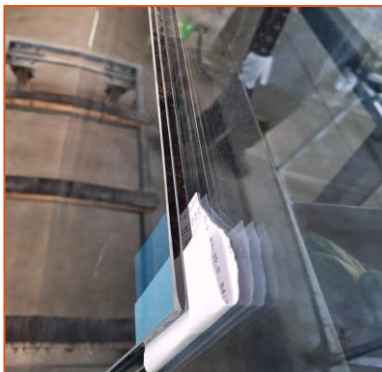
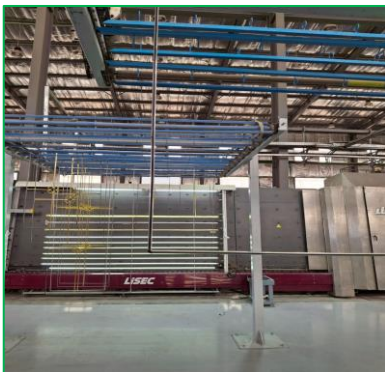
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NOK



3



STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

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IGU ASSEMBLY



PROCESSING SITUATION

CUTTING QUALITY

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



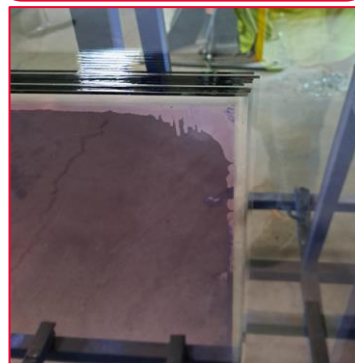
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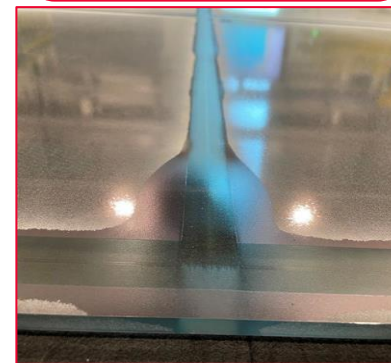
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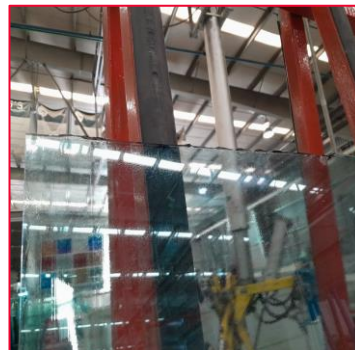
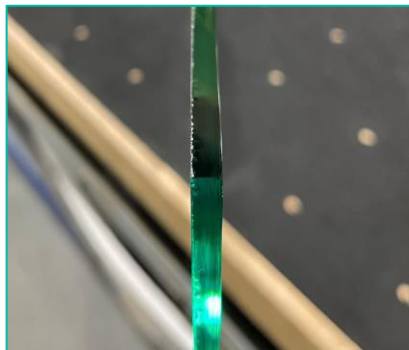
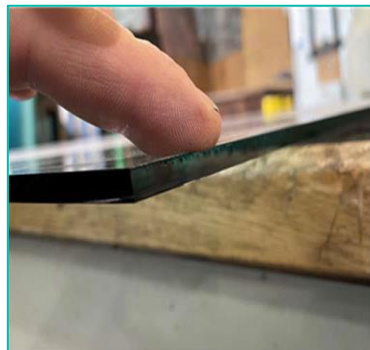


NOK



1

2



PROCESSING SITUATION

CUTTING QUALITY

OK



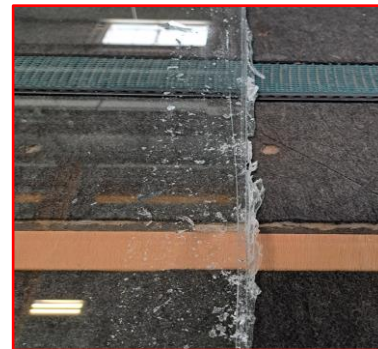
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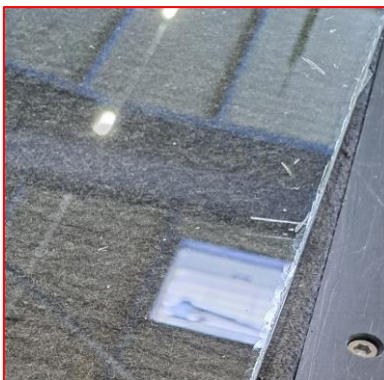
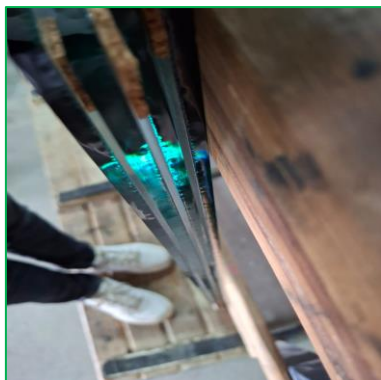


NOK



3

4



STORAGE

CUTTING

EDGE-DELETION

EDGE WORK

WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

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LAMINATION AGAINST PVB

IGU ASSEMBLY



PROCESSING SITUATION

CUTTING QUALITY / LAMINATED GLASS

- STORAGE
- CUTTING
- EDGE-DELETION
- EDGE WORK
- WASHING
- SCREEN-PRINTING
- DIGITAL PRINTING
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- BENDING
- LAMINATION
- LAMINATION AGAINST PVB
- IGU ASSEMBLY

OK

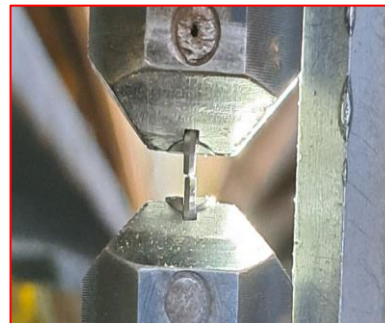
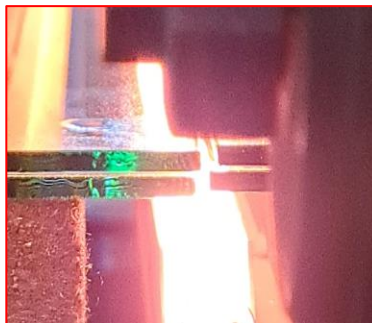
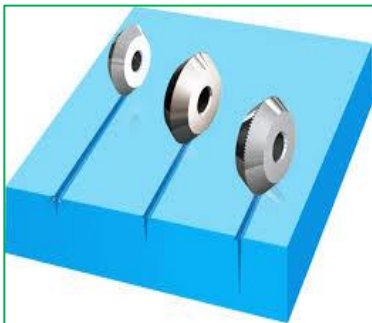
OK

NOK

NOK

CHECKLIST FOR CUTTING MACHINE

SR NO	POINTS OF INSPECTION	Y	N	REMARKS
1	Double insulated plastic body			
2	Machine body without Cracks / Cut / Damage			
3	Switch physical conditions is good			
4	*ON & *OFF switch functioning			
5	Double insulated cable			
6	Cable free from wear / Cut / Damage			
7	Cable is of appropriate rating			
8	Machine body without Cracks / Cut / Damage			
9	Iron clad type electric plug Top and Socket is provided			
10	Cutting Circular Saw guard is available			
11	Guard free from crack / damage			
12	Guard properly lightened			
13	Circular saw should be free from Crack and Damage			
14	Cutting saw properly lightened			
15	Machine sound should be normal during operation			
16	Substrate should be free from Crack and Damage			



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PROCESSING SITUATION

CUTTING QUALITY / LAMINATED GLASS

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OK

OK

NOK

NOK

3

Tolérance réglage $\pm 0,2$

Molette sup.	Pressions molettes		Pressions rampage	Angle molette
	Molette inf.	Roue de rompage		
2,2	2,4	1,1	145°	
2,4	2,5	1,4	152°	
2,8	3,2	2,4	152°	
3,1	3,6	2	152°	
2,4	2,5	1,4	152°	
3,2	2,8	2	152°	
3,2	2,8	2	152°	
3,2	2,8	1	152°	



4



PROCESSING SITUATION

EASYPRO® EDGE DELETION

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



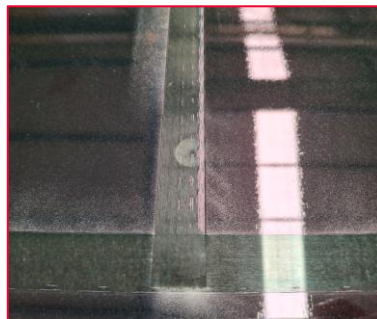
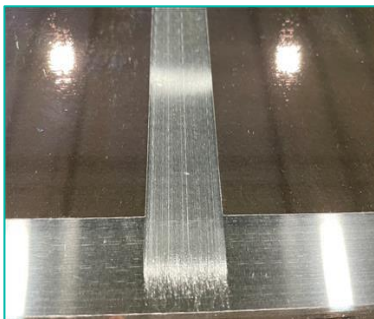
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OK

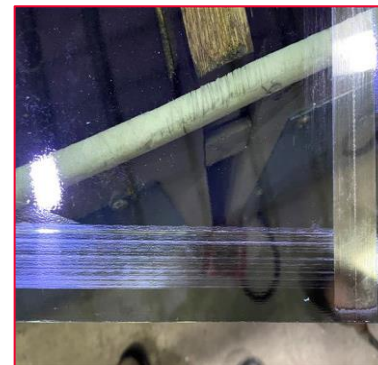
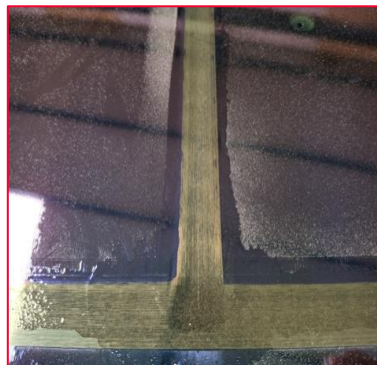
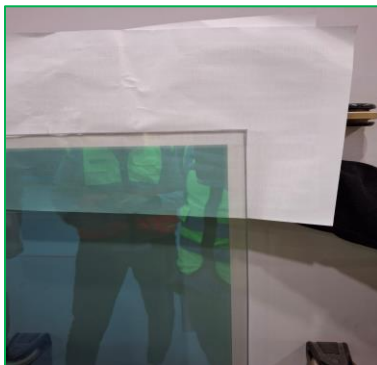
NOK

NOK

1



2



PROCESSING SITUATION

EASYPRO® EDGE DELETION / ASPIRATION

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

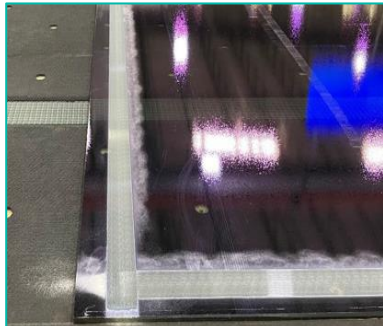
IGU ASSEMBLY



OK



OK



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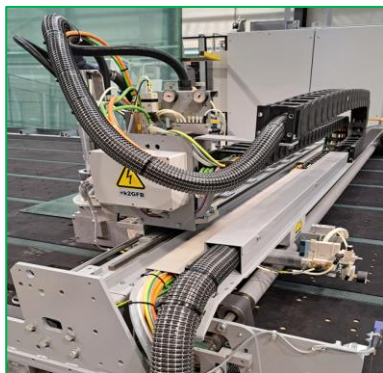


NOK



3

4



PROCESSING SITUATION

EDGE DELETION COATINGS

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



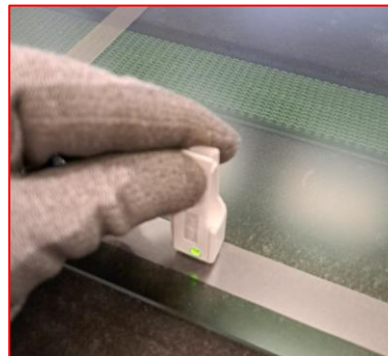
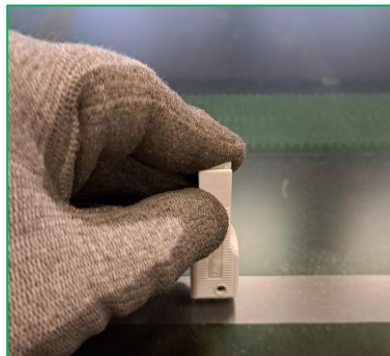
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OK

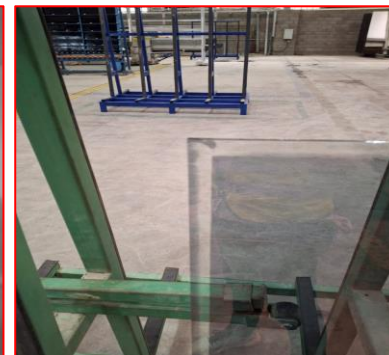
NOK

NOK

1



2



PROCESSING SITUATION

GLASS SEPARATION AFTER WASHING

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

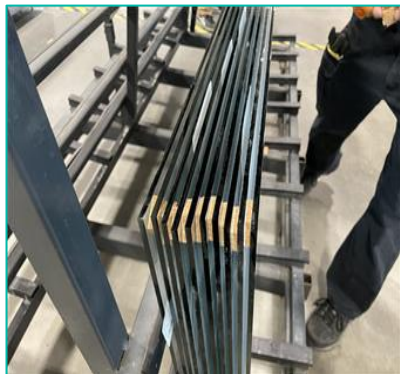
LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



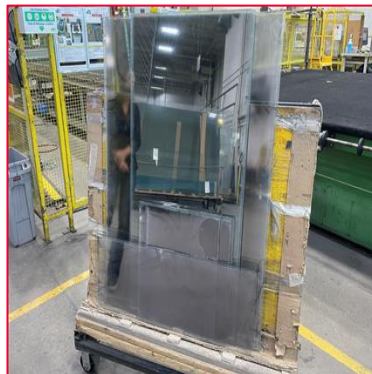
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OK



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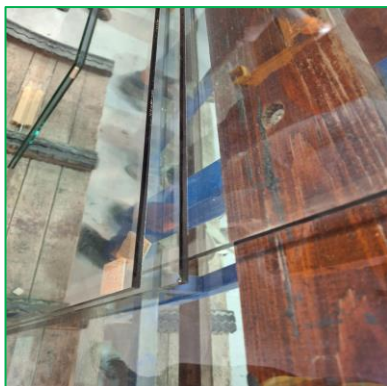


NOK



1

2



NT-GOBAIN GLASS

PROCESSING SITUATION

WASHING

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

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TEMPERING

BENDING

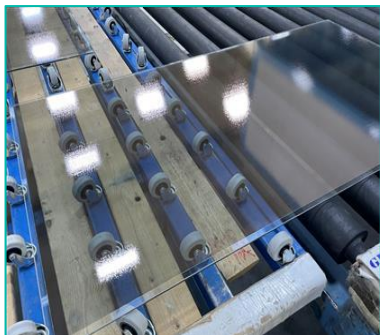
LAMINATION

LAMINATION AGAINST PVB

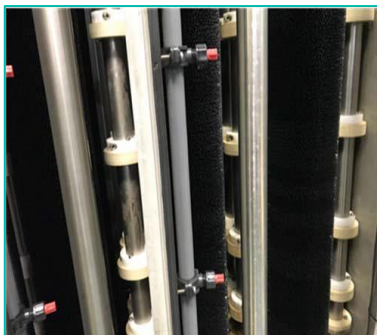
IGU ASSEMBLY



OK



OK



NOK

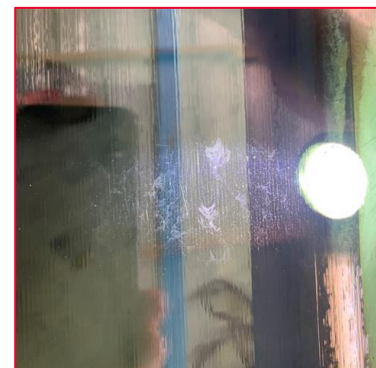
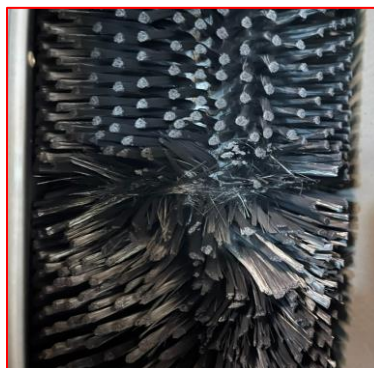
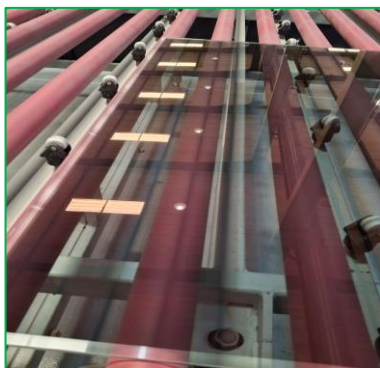


NOK



1

2



PROCESSING SITUATION

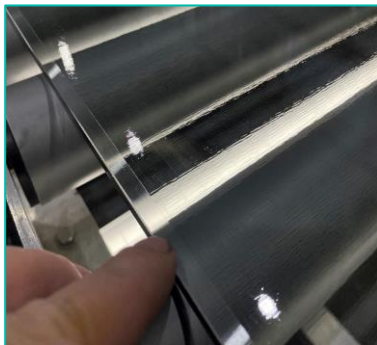
WASHING

- STORAGE
- CUTTING
- EDGE-DELETION
- EDGE WORK WASHING**
- SCREEN-PRINTING
- DIGITAL PRINTING
- TEMPERING
- BENDING
- LAMINATION
- LAMINATION AGAINST PVB
- IGU ASSEMBLY

OK



OK



NOK



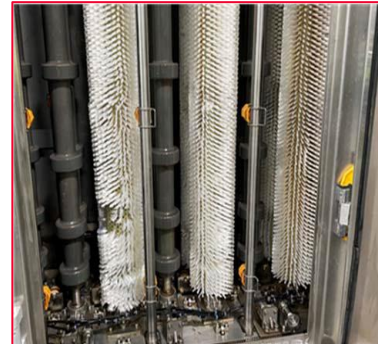
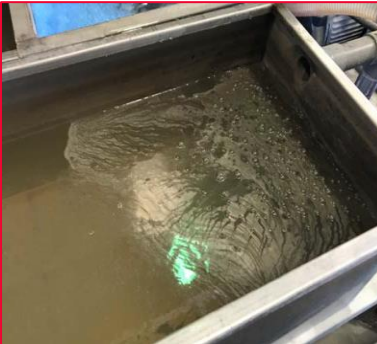
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3



4



PROCESSING SITUATION

EDGE WORK

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

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LAMINATION AGAINST PVB

IGU ASSEMBLY

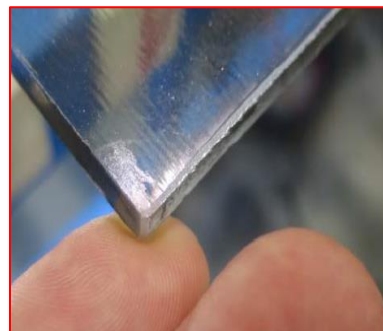
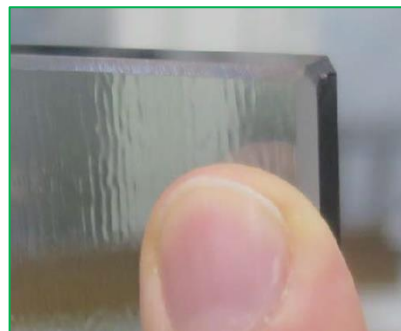


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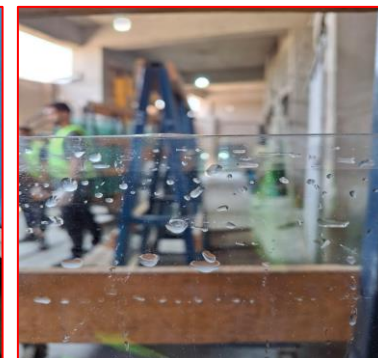
NOK

NOK



1

Edge Diagram	Description	Typical Application
	Flat Ground	Silicone structural glazing with exposed edges
	Flat Polish	Silicone structural glazing where edge condition is critical for aesthetic purposes
	Ground Pencil Edge	Mirrors, Decorative furniture glass
	Polished Pencil Edge	Mirrors, Decorative furniture glass
	Ground Miter	Silicone structural glazing
	Bevel	Mirrors, Decorative furniture glass
	Seamed Edges	Normal edge treatment for heat-treated glass



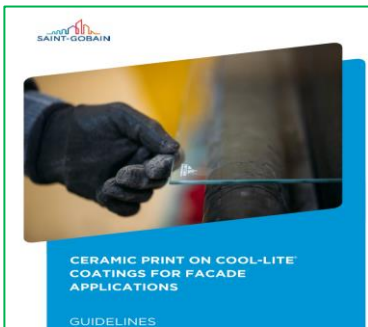
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PROCESSING SITUATION

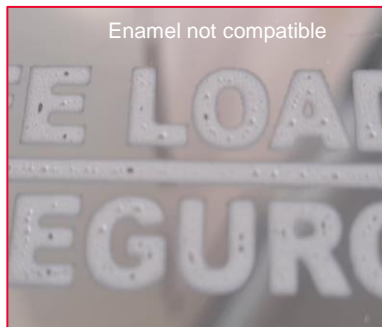
ENAMELING

- STORAGE
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- EDGE-DELETION
- EDGE WORK
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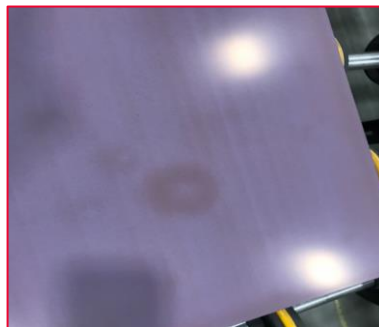
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NOK



NOK

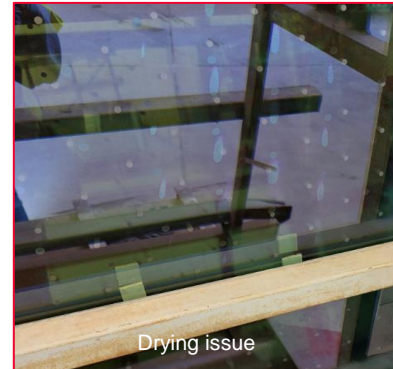
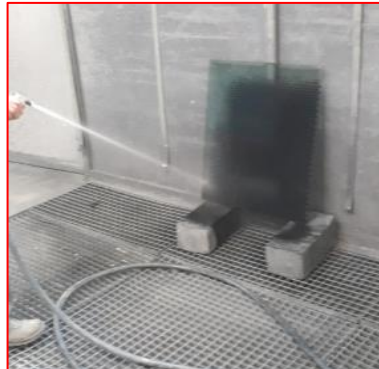


NOK



1

2



PROCESSING SITUATION

HEAT-TREATMENT WITH or WITHOUT EASYPRO®

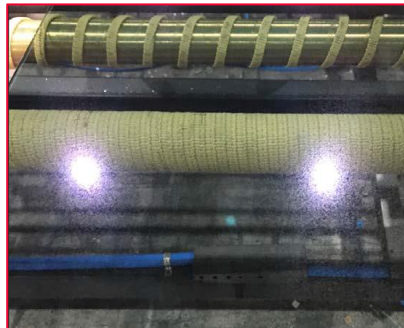
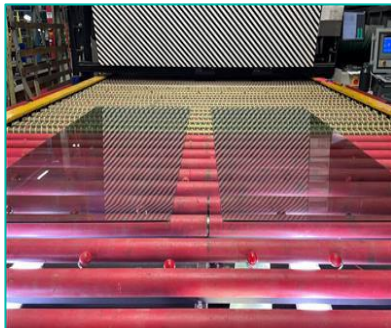
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OK

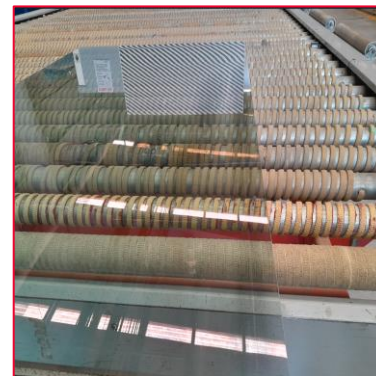
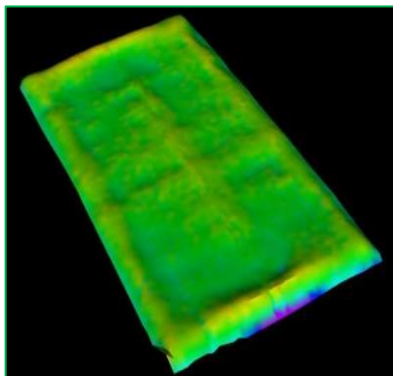
NOK

NOK

1



2



STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

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DIGITAL PRINTING

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IGU ASSEMBLY



PROCESSING SITUATION

HEAT-TREATMENT

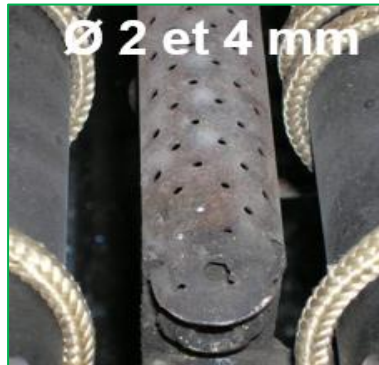
- STORAGE
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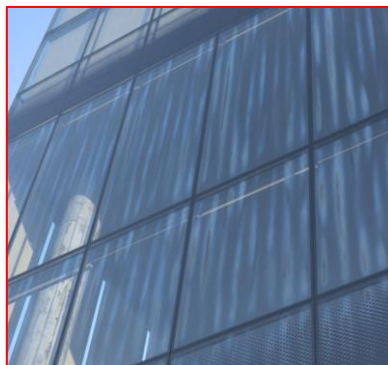
OK



OK



NOK



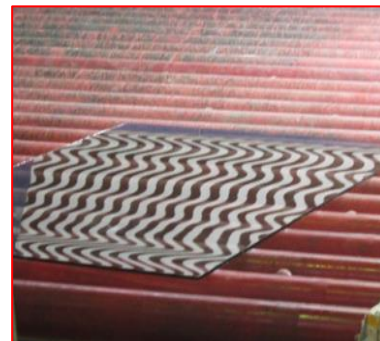
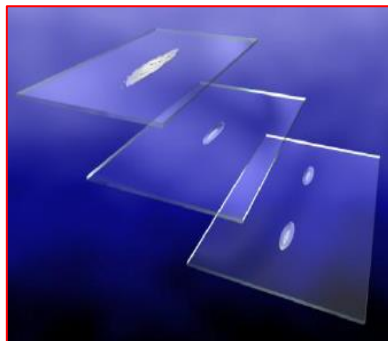
NOK



1



2



PROCESSING SITUATION

HEAT-TREATMENT / BENDING

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OK

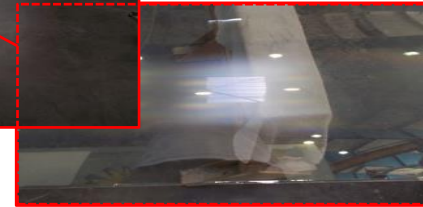
OK

NOK

NOK

3.9. Bending

COOL-LITE® SKIN II / COOL-LITE® XTREME II can be curved annealed (sagging process) or tempered (in tempering furnaces fitted with a bending cell). Not all curvature radii may be attainable with convex or concave shape according to the type of process used. The processor is then asked to check and validate that its bending process is capable to obtain a good quality on a particular shape before giving a final offer for a project requesting this shape.



SAINT-GOBAIN GLASS

1

2

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OK

OK

OK

NOK

1



2



CELLA STOCK PVB TEMP 8.0	MAGAZ, ROTOLI TEMP 9.0 %UR 26.5
SALA ASS, PLF TEMP 15.8 %UR 31.5	SALA ASS DLF TEMP 11.7 %UR 27.0
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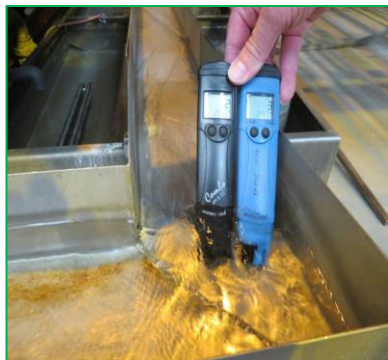


PROCESSING SITUATION

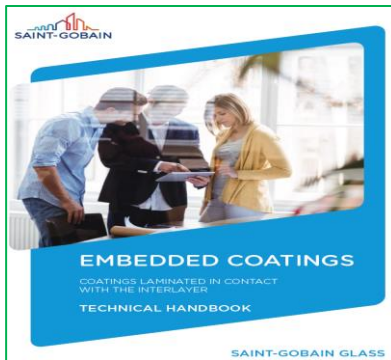
LAMINATION

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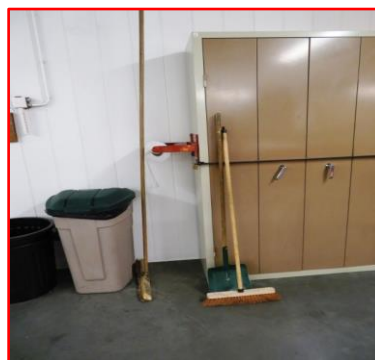
OK



OK



NOK



NOK



3

3.12. Lamination

- Lamination of COOL-LITE® SKN (II) / COOL-LITE® XTREME (II) can be performed with the coating placed outside (not in contact with the interlayer).
- In case the coating will face the PVB interlayer, please refer to last applicable version of SGG-TI-01H document, not all coatings could be used against PVB interlayer.
- Please refer to interlayer supplier recommendations to obtain best final quality product (storage conditions...)
- To assemble the glass, ensure that the calendaring rollers are in good condition (clean and free of glass shards or particles). Check that the circumferential speed is regular and corresponds to that of the conveyor system. Clean off all deposits of PVB in contact with the coating before placing in the furnace or autoclave. Calendaring rollers must touch the glass and should be flat to apply regular pressure at any position.
- When laminating heat treated COOL-LITE® SKN II / COOL-LITE® XTREME II take care that the PVB thickness is adapted as to compensate the possible glass deformation (roller wave, bow, edge lift) created during the heat-treatment process. Optimised heat treatment recipes are recommended to limit glass deformation and avoid any defect after the lamination process. Contact your local TSM if necessary.
- Use of clamps to do lamination is not recommended at any time, especially during autoclaving. This could be a cause of optical distortion of the glass and possible delayed glass delamination. Use of clamps can hide possible quality deviation in production.
- In any case, the coating must be edge deleted with a minimum width of 10 mm.

4

User guide SGG COATING DETECTOR

LED Display: lighting in different colors: each color corresponds to a specific Saint-Gobain Glass coating range

Measurement button: press to start the detection of a coating in a glazing

Interpretation of results: explanation of the different colors of the 2 LEDs



PROCESSING SITUATION

IGU ASSEMBLY

- STORAGE
- CUTTING
- EDGE-DELETION
- EDGE WORK
- WASHING
- SCREEN-PRINTING
- DIGITAL PRINTING
- TEMPERING
- BENDING
- LAMINATION
- LAMINATION AGAINST PVB
- IGU ASSEMBLY**

OK



1

OK



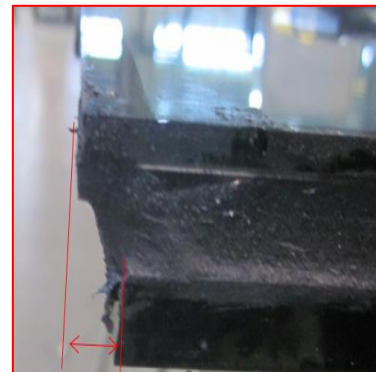
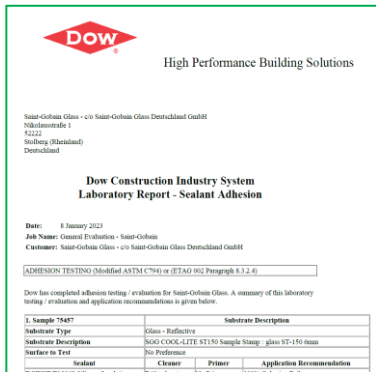
NOK



NOK



2



PROCESSING SITUATION

IGU ASSEMBLY

STORAGE

CUTTING

EDGE-DELETION

EDGE WORK
WASHING

SCREEN-PRINTING

DIGITAL PRINTING

TEMPERING

BENDING

LAMINATION

LAMINATION AGAINST PVB

IGU ASSEMBLY



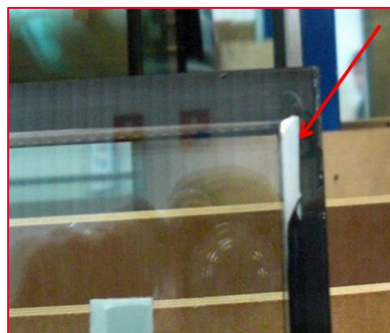
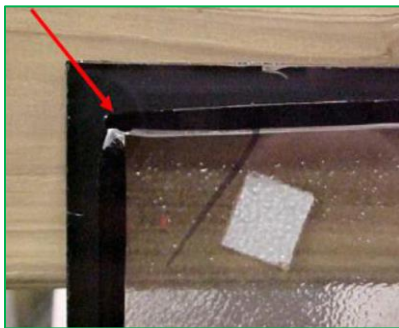
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3



4

