

Specification	TE
Technical Properties for stock sizes	B 270 Draw glass

1.0 Thickness

Nominal thickness [mm] *	Permissible tolerance [mm] **
0,80	± 0,1
0,90	± 0,1
1,00	± 0,1
1,10	± 0,1
1,15	± 0,15
1,20	± 0,15
1,35	± 0,15
1,50	± 0,15
1,65	± 0,15
1,85	± 0,15
2,00	± 0,2
2,20	± 0,2
2,30	± 0,2
2,50	± 0,2
3,00	± 0,2
3,50	± 0,2
4,00	± 0,2
4,50	± 0,2
5,00	± 0,2
5,50	± 0,3
6,00	± 0,3
6,50	± 0,3
7,00	± 0,3
8,00	± 0,3
9,00	± 0,4
10,00	± 0,4
12,00	± 0,5
14,00	± 0,5
15,00	± 0,5
17,00	± 0,5

* other thickness on request
 ** closes tolerance on request

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Distribution of thickness / wedge

The thickness deviation in mm/cm within a distance of 1 cm (measurement point intervals) is specified.

Thickness [mm]	Wedge [mm/cm]
0,80	0,010
0,90 - 1,20	0,015
1,35 - 3,00	0,020
3,50 - 5,50	0,022
6,00 - 8,50	0,025
> 8,50	0,035

2.0 Dimensions

Thickness [mm]		Lenght (±25) x width (±25) [mm]
0,80 – 4,00	Stock sizes from melting tank	1680 x 900* 1680 x 920*
	Cut sizes	840 x 840 900 x 560 900 x 840 920 x 840
4,50 – 17,00	Stock sizes from melting tank	1300 x 900*
	Cut sizes	840 x 840 900 x 560 900 x 650 900 x 840 920 x 840

*For production reasons the panel width indicated can vary by +100 mm/-200 mm.
Special sheet formats upon request.

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Thickness [mm]		Lenght (±1,0) x width (±1,0) [mm]
0,80 – 4,00	Cut sizes	405 x 225 406 x 258 830 x 620 ¹⁾
4,50 – 17,00		405 x 225 406 x 258

¹⁾ ± 5,0 mm

3.0 Rectangularity / Squareness

Deviation of the panel edge from rectangularity is advised in mm/m of edge length.
 - A maximum deviation of 10 mm/m is permissible.

4.0 Cut edge quality

Spalling which occurs as a result of cutting and handling is permissible in the whole of edge area.
 The size of the spalling may not, exceed the thickness of the glass.

5.0 Warp

The maximum deviations of the glass surface from an ideal plane, referred to an area of 320 mm x 320mm.

Thickness (mm)	Maximal deviation
0,80 - 8,00	0,48 mm
> 8,00	On request

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6.0 Defects

In the glass melting process bubbles and solid inclusions cannot be avoided. The bubbles quantity and bubble size distribution is depending on the glass formula.

Knots which may cause breakage during transportation are not admissible.

Permissible features in stock sizes

Features $\leq 1,0$ mm are not taken into account, if the features are not appear in accumulation.

Thickness 0,80 – 4,00 mm			
Area	defect > 1mm	Σ Lenght	Max.-Lenght at cut sizes
405 x 225 406 x 258	4 pcs	40 mm	20 mm per feature
830 x 620	8 pcs	103 mm	100 mm per feature
840 x 840	10 pcs	141 mm	
900 x 560	7 pcs	100 mm	
900 x 840	11 pcs	151 mm	
920 x 840	11 pcs	154 mm	
1680 x 900	22 pcs	200 mm	
1680 x 920	23 pcs	200 mm	
width $\leq 1,0$ mm permissible			

Thickness 4,50 – 17,00 mm			
Area	defect > 1mm	Σ Lenght	Max.-Lenght at cut sizes
405 x 225 406 x 258	5 pcs	50 mm	20 mm per feature
840 x 840	14 pcs	176 mm	100 mm per feature
900 x 560	10 pcs	126 mm	
900 x 650	12 pcs	146 mm	
900 x 840	15 pcs	189 mm	
920 x 840	15 pcs	193 mm	
1400 x 900	25 pcs	250 mm	
Breite $\leq 1,0$ mm permissible			

Streaks: according as limit sample
Drawing marks: according as limit sample

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7.0 Annealing quality

Thickness [mm]	Birefringence (tension)
0,80 - 3,00	≤ 30 nm/cm
3,50 - 6,00	≤ 40 nm/cm
6,50 - 12,00	≤ 60 nm/cm
14,00 - 17,00	≤ 70 nm/cm