

Glass processing-Laminated Glass processing

2.1 Preparation and selection of glass

The glass used for laminated glass is float glass, tempered glass, **heat-treated glass**, ceramic fritted glass, reflective glass, **LOW-E glass**, etc. Before processing, glass should be selected according to the internal control standard of laminated glass. Waves, stones, scratches, chipping, check the flatness of the glass for tempered glass; due to the unevenness of the glass, the glass and film cannot be completely bonded during the pressing process.

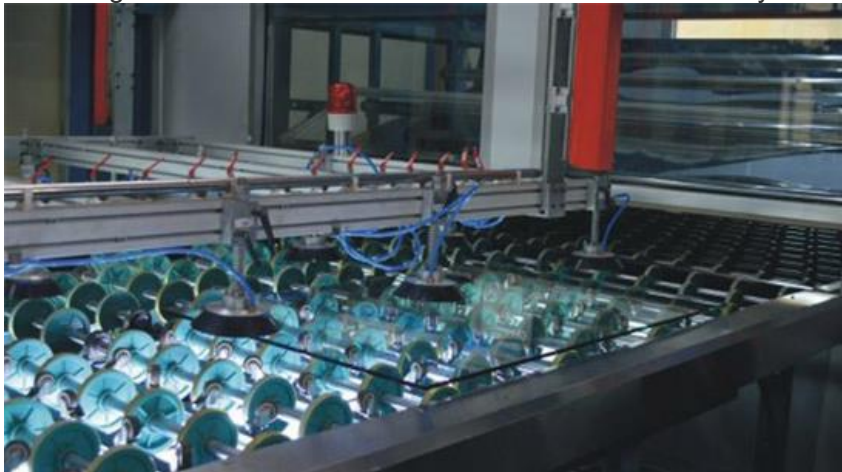
2.2 Glass cleaning

In order to eliminate the dust, dirt, greasy and dirty of the glass surface, it is necessary to carefully wash the glass. Even if a small amount of greasy oil remains on the surface of the glass, the oil will greatly reduce the adhesion of the film to the glass; the tempered glass should be cleaned along the direction of tempering to ensure that the bending direction of the two glasses.



2.3 Laminating process

The laminating process is carried out in the dust free laminating room. The staff is required to replace the cleaning sneakers before entering the laminating room, wear the cleaning work hood and gloves, and record the temperature of the laminating room. Humidity and moisture content of the film. The temperature and humidity of the laminating room were controlled at $20 \pm 3^{\circ}\text{C}$ and the humidity was controlled at $23 \pm 3\%$.



1.) PVB film storage and cutting

According to the order, the PVB film should be transported to the laminating room 2-3 days in advance for drying. The film should be 10-20mm larger than glass size.

2.) laminating the glass with interlayer

When laminating, check the quality and cleanliness of the glass, and wipe the water and dirt with a dry special paper towel. If there is no smudge, then spread the film on the glass. The film must be laid flat without overlapping. Then, the second piece of glass is stacked. the stacking difference shall not exceed 1.5mm each side, the film shall be 5mm larger than glass.



The purpose of the pre-pressing is to remove the air between the glass and the film so that air is not trapped during the pressing, and bubbles are generated. The glass and the film are initially bonded together, and there is no staggering between the sheets when pressing, and the external moisture does not penetrate into the laminated glass.

The temperature control has a decisive influence on the quality of the pre-pressed glass. if the glass temperature is high, the glass and film are prematurely bonded together, and the edges and the back are sealed too early. The air is difficult to remove and form bubbles, if the temperature is too low, which will reduce the adhesion of the film to the glass, so that the film and the glass are not firmly bonded, the edge sealing is not good, and the external gas enters the film during the pressing process; Therefore, it is required to control the temperature appropriately. It is necessary to adjust the temperature of each zone according to the season and climate conditions, and to ensure the temperature of the glass.



The control of the pressure also has a great relationship with the quality of the pre-pressed glass. Since the film is a plastic material, under the action of pressure, the glass and the film have a little unevenness, and may be flattened. The pressure control depends on the processed glass. The thickness, the thicker the glass, the greater the pressure, but the pressure will be too high to crush the glass, the pressure is too low, the glass and film are not firmly bonded, the edge is not well sealed, and the product will have bubbles, so the pressure adjustment should be appropriate. . According to the production status of our company, different pressures should be selected according to the thickness of the processed sandwich products.

The speed control has a great relationship with the temperature. At the same furnace temperature, the faster the speed, the lower the temperature at which the glass is discharged. On the contrary, the higher the temperature is, the speed is adjusted according to the thickness of the glass, and the premise of the glass exit temperature is guaranteed. The slower the speed, the slower the speed and the better the rolling effect. The pre-pressed laminated glass is a semi-finished product. Place it on the glass rack and sent into the autoclave for processing as soon as possible. The glass cannot be placed in the atmosphere for a long time; otherwise, the moisture will enter the interior of the laminated glass through the film, causing bubbles in the laminated glass.

2.5 Autoclave:

After the autoclave working process is finished, the temperature in the autoclave will continue to drop to 45 °C, move the glass outside asap or round bubbles will appear under high temperature. Trim the glass edge and packing.

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QINGDAO MORN BUILDING MATERIALS CO.,LTD

Your turnkey China tempered glass/laminated glass/insulated glass supplier

Tags: ceramic fritted glass, China Laminated Glass, dust free laminating room, FLOAT GLASS, glass cleaning, glass Laminating process, Heat treated glass, laminated glass, laminated glass bubbles, laminated glass process, laminated glass processing, laminated glass supplier, low e glass, PVB interlayer, reflective glass, tempered glass

About Morn Building Materials:

Morn Building Materials Co.,Ltd is trading company offering the right facade materials for a wide range of applications for architectural,design and system requirements.Cooperating with China premium glass fabricators,Morn is able to supply whatever glass products applied in facade,Spandrel ,roof ,handrail,partition,balustrade,canopy,greenhouse,sun room ,interior exterior application.

Other facade materials:Aluminium alloy profiles,aluminium plates,aluminium windows&doors,Assa Abloy hardware,spider fitting,railing systems,shower rooms,polyurethane panels,machines&tools,steel structure, are also available since 2019.

From aesthetics, to strict environmental and energy specifications, to critical budget and delivery requirements, our input can make a difference.

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