

production skills

| processing | max. length | max. width | thickness | max. weight | quality | radius | standard |
|------------|-----------------------|----------------------|---------------------|-----------------------|---------------|------------------------|----------|
| cutting | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 3,000 kg 4,400 lbs | | | |
| drilling | | | | | | min. 6 mm min. ¼ in | |
| edging | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 350 kg/qm | KGS, KGN, KPO | | DIN 1249 |

| tempering | max. length | max. width | thickness | max. weight | min. surface tension | standard |
|-------------------|-----------------------|----------------------|---------------------|-------------------------------------|----------------------|--------------|
| heat-strengthened | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–12 mm / ¼–½ in | 1,584 kg / pane 3,492 lbs / pane | 70 MPa | DIN EN 1863 |
| fully tempered | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 2,508 kg / pane 5,529 lbs / pane | 120 MPa | DIN EN 12150 |
| heat soak test | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 12,000 kg 26,455 lbs | | DIN EN 14179 |

| ceramic-ink printing | max. length | max. width | thickness | max. weight | tolerances frameless printing | tolerance multiple printing | printing resolution |
|------------------------|-----------------------------------|----------------------|---------------------|-------------------------|---|-----------------------------|---------------------|
| roller-coater printing | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 2,822 kg / 6,221 lbs | | | |
| digital printing | 16,500 mm / 650 in | 3,200 mm / 126 in | 6–19 mm / ¼–¾ in | 2,822 kg / 6,221 lbs | 0–4,000 mm: 1 mm 4,000–9,000 mm: 2 mm 9,000–16,500 mm: 3 mm | ± 0.2 mm | max. 1024 dpi |
| type of color | ceramic ink, free of heavy metals | | | | | | |

| coating | max. length | max. width | thickness | max. weight | standard |
|---------|-----------------------|----------------------|------------------------|-------------------------|---------------|
| | 16,500 mm / 650 in | 3,200 mm / 126 in | 4–19 mm / 5/32–¾ in | 2,500 kg / 5,511 lbs | DIN EN 1096-4 |

| laminating | Autoclave 1 | Autoclave 2 | Autoclave 3 | Autoclave 4 | lamination interlayer | special laminations | intermediate materials |
|-------------------|---|---|---|--------------------------------------|-------------------------------|--|--|
| | 3,200 mm × 16,500 mm / 126 × 650 in | 3,200 mm × 15,000 mm / 126 × 590 in | 2,650 mm × 12,000 mm / 104 × 472 in | 590 mm × 1,500 mm / 23 × 59 in | SentryGlas®, PVB, TPU, EVA | metal, stone, projection foils, function elements such as fasteners | Sefar fabrics, southwall, XIR-Interlayer |
| standard | DIN EN 14449, DIN EN 12543 | | | | | | |
| sedak GlasCobond® | abZ: Z-70.3-175, Z-70.3-153 | | | | | | |
| GLY-MarineCobond® | Certificate No. HTS/STAT 24025-14 | | | | | | |
| cold-bent glass | National Technical Approval: Z-70.3-175 | | | | | | |

| bending | min. size | max. size | heat-treated | min. bending radius |
|--|-----------|-----------|--------------|---|
| cold bending (min. bending radius 1,500 × thickness) | | | | 9,000 mm (6 mm) / 354 in (¼ in) 12,000 mm (8 mm) / 472 in (5/16 in) 15,000 mm (10 mm) / 590 in (3/8 in) |

| insulating glass | max. length | max. width | thickness / unit | max. weight | standard | structure | step |
|------------------|---|----------------------|------------------|-----------------------------|-------------|--------------------------------|-------------------------------|
| | 15,000 mm / 590 in | 3,200 mm / 126 in | 102 mm / 4 in | 450 kg / lm 992 lbs / lm | DIN EN 1279 | double to quadruple glazing | max. 700 mm / max. 27 ½ in |
| finishing | low-e coating, solar control coating, sound insulation interlayer, colored glass, colored interlayer, roller-coater printing, digital printing, decorative coating | | | | | | |

sedak provides further dimensions and finishing qualities on request.