

## 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 / ⅝–¾ 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		
bent tempered glass	400 mm × 600 mm / 16 × 24 in	3,200 mm × 5,000 mm / 126 × 196 in	6–19 mm / ¼–¾ in max. bending angle 90°		2,000 mm (6 + 12 mm) / 79 in (¼ + ½ in) 1,500 mm (8 + 10 mm) / 59 in (⅝ + ⅜ in) 2,500 mm (15 mm) / 98 in (⅝ in) 3,000 mm (19 mm) / 118 in (¾ in)		
cold bending (min. bending radius 1,500 × thickness)					9,000 mm (6 mm) / 354 in (¼ in) 12,000 mm (8 mm) / 472 in (⅝ in) 15,000 mm (10 mm) / 590 in (¾ 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.