

production skills

| processing | max. length | max. width | thickness | max. weight | quality | radius | standard |
|------------|---------------------|--------------------|----------------------------|-----------------------|---------------|--------------------------------|----------|
| cutting | 20,000 mm 787 in | 3,510 mm 138 in | 4 – 19 mm 5/32 – 3/4 in | 3,000 kg 4,400 lbs | | | |
| drilling | | | | | | 6 mm – 32 mm 1/4 – 1 1/4 in | |
| edging | 20,000 mm 787 in | 3,510 mm 138 in | 6 – 19 mm 1/4 – 3/4 in | 350 kg/qm | KPO, KGN, KGS | | DIN 1249 |

| tempering | max. length | max. width | thickness | max. weight | min. surface tension | standard |
|-------------------|---------------------|--------------------|---------------------------|---------------------------------|----------------------|--------------|
| heat-strengthened | 20,000 mm 787 in | 3,510 mm 138 in | 6 – 12 mm 1/4 – 1/2 in | 1,584 kg/pane 3,492 lbs/pane | 70 MPa | DIN EN 1863 |
| fully tempered | 20,000 mm 787 in | 3,510 mm 138 in | 6 – 19 mm 1/4 – 3/4 in | 2,508 kg/pane 5,529 lbs/pane | 120 MPa | DIN EN 12150 |
| heat soak test | 20,000 mm 787 in | 3,510 mm 138 in | 6 – 19 mm 1/4 – 3/4 in | 12,000 kg 26,455 lbs | | DIN EN 14179 |

| chemically toughened | max. length | max. width | thickness |
|----------------------|-------------|------------|--------------------|
| | 5,000 mm | 2,600 mm | from 2 mm to 19 mm |

| ceramic-ink printing | max. length | max. width | thickness | max. weight | tolerances frameless printing | tolerance multiple printing | printing resolution |
|------------------------|-----------------------------------|--------------------|---------------------------|-----------------------|---|-----------------------------------|------------------------|
| roller-coater printing | 20,000 mm 787 in | 3,300 mm 130 in | 6 – 19 mm 1/4 – 3/4 in | 2,822 kg 6,221 lbs | | | |
| digital printing | 18,000 mm 709 in | 3,300 mm 130 in | 6 – 19 mm 1/4 – 3/4 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. 1,024 dpi |
| type of color | ceramic ink, free of heavy metals | | | | | | |

| coating | max. length | max. width | thickness | max. weight | standard |
|---------|---------------------|--------------------|----------------------------|-----------------------|---------------|
| | 19,450 mm 766 in | 3,200 mm 126 in | 4 – 19 mm 5/32 – 3/4 in | 2,500 kg 5,511 lbs | DIN EN 1096-4 |

| laminating | max. length | max. width | lamination interlayer | special laminations | intermediate materials |
|---------------------|-----------------------------------|----------------------|-------------------------------|--|---|
| | 20,000 mm 787 in | 3,510 mm x 138 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 12543-2 | | | | |
| sedak GlasCobond® | abZ: Z-70.3-175, Z-70.3-153 | | | | |
| sedak MarineCobond® | Certificate No. HTS/STAT 24025-14 | | | | |

| cold bending | max. length | max. width | min. bending radius (glass thickness) |
|--|---|--------------------|---|
| cold bending (min. bending radius 1,500 x thickness) | 20,000 mm 787 in | 3,510 mm 138 in | 9,000 mm (6 mm)/354 in (1/4 in) 12,000 mm (8 mm)/472 in (3/16 in) 15,000 mm (10 mm)/590 in (3/8 in) |
| cold bent glass | National Technical Approval: Z-70.3-175 | | |

production skills

| hot bending | | length | width | thickness | bending shape | minimum radius | bending angle |
|-----------------------|--------------|-----------|----------|--------------------|---|----------------|---------------|
| gravity curved glass | SG1 | 3,200 mm | 2,200 mm | from 2 mm to 19 mm | cylindrical, conical, spherical, toric, j shape, double bend and irregular bend | | |
| | SG3 | 6,500 mm | 3,300 mm | | | | |
| | SG45 | 11,500 mm | 3,300 mm | | | | |
| tempered curved glass | TSG1 | 2,440 mm | 1,570 mm | from 4 mm to 8 mm | cylindrical | 1,000 | 90° |
| | TGS2 CB LINE | 4,800 mm | 2,440 mm | from 6 mm to 12 mm | cylindrical | 1,500 | 90° |
| | TGS2 LB LINE | 2,440 mm | 4,500 mm | from 6 mm to 15 mm | cylindrical | 2,500 | 90° |
| | NGS1 | 3,000 mm | 1,500 mm | from 5 mm to 10 mm | cylindrical | 650 | 105° |
| | NGS2 | 2,500 mm | 1,200 mm | from 5 mm to 8 mm | j shape | 350 | 90° |
| | NGS3 | 5,000 mm | 3,200 mm | from 6 mm to 12 mm | cylindrical and j shape | 1,500 | 90° |
| | NGS4 RA LINE | 3,300 mm | 3,600 mm | from 6 mm to 15 mm | cylindrical | 1,500 | 90° |
| | NGS4 RB LINE | 3,300 mm | 2,500 mm | from 6 mm to 12 mm | cylindrical | 900 | 90° |

| insulating glass unit | max. length | max. width | thickness/ unit | max. weight | standard | structure | step |
|-----------------------|--|--------------------|--------------------|-------------------------|---------------|--------------------------------|-----------------------------|
| | 20,000 mm 787 in | 3,510 mm 138 in | 102 mm 4 in | 450 kg/lm 992 lbs/lm | DIN EN 1279-5 | double to quadruple glazing | max. 700 mm max. 27 ½ in |
| finishing | low-e coating, solar control coating, with laminated safety glass, sound insulation interlayer, colored glass, colored interlayer, roller-coater printing, digital printing and decorative coating (up to 18,000 mm) | | | | | | |
| hot bent IGU | 11,500 mm | 3,300 mm | | | | | |

sedak provides further dimensions and finishing qualities on request.

sedak GmbH & Co. KG

Einsteinring 1
86368 Gersthofen
Germany

Phone: +49 821 2494-222

Fax: +49 821 2494-777

info@sedak.com

www.sedak.com