

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		

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hot bending		length	width	thickness	bending shape	minimum radius	middle 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	12,500 mm	3,300 mm					

sedak provides further dimensions and finishing qualities on request.

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