

## 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	
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-bent glass	National Technical Approval: Z-70.3-175						
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 x 138 in	9,000 mm (6 mm)/354 in (1/4 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
	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 1/2 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 18,000mm)						

sedak provides further dimensions and finishing qualities on request.