

LACOBEL / MATELAC

PROCESSING GUIDE



VERSION 2.0 – AUGUST 2013

LACOBEL / MATELAC PROCESSING GUIDE

This version of the guide cancels and replaces all previous versions.
Please check www.yourglass.com regularly for updates.



CONTENTS

1. INTRODUCTION.....	3
2. PACKAGING	3
3. UNLOADING	3
4. STORAGE PRIOR TO HANDLING	4
5. STORAGE AFTER OPENING / HANDLING THE PACKS.....	4
5.1. Removing wooden and metal packaging.....	4
5.2. Handling PLFs and DLFs	4
6. CUTTING.....	5
7. SHAPING	6
7.1. Shaping the edges	6
7.2. Washing	6
8. WASHING	6
9. PACKAGING THE PROCESSED PRODUCT	7
10. QUALITY CONTROL	7
10.1. Delivery of the glass.....	7
10.2. Quality control after washing.....	7
11. DOUBLE GLAZING.....	7
12. LAMINATION	7

1. INTRODUCTION

The purpose of this guide is to ensure that users of Lacobel/Matelac glass are able to process the product correctly - cutting, edge shaping, etc. - so that it meets the end-user's requirements in full.

Lacobel/Matelac is a decorative glass that needs careful handling. If you are processing Lacobel/Matelac for the first time, please contact your local AGC Glass Europe agent, through whom you can obtain full guidance on technical issues.

Lacobel/Matelac has been designed for indoor use. Care should be taken when handling and processing the glass in order to avoid damaging the coat of paint. Therefore we strongly recommend that anything coming into contact with the paint on the glass during the processing stage be pre-approved.

For information on installation, please read the "Installation Guide" (also available on www.yourglass.com).

2. PACKAGING

After production, special attention is paid to the packaging in order to preserve product quality.

Lacobel/Matelac is available in standard sizes (for more details, see "Availability")

The following systems ensure that the glass is correctly packaged:

- The painted sheets of glass are standard packed with the paint facing the stillage.
- The packs may be turned around upon request so that the paint is facing outwards.
- The sheets of glass are separated by paper spacers.
- The exact contents are indicated on the label affixed to the edge of the pack or packaging.

3. UNLOADING

The glass packs should be inspected immediately upon arrival. AGC will not accept any claims regarding defects occurring after delivery, or during handling, processing and installation of the final product in the building if the Lacobel processing recommendations have not been respected.

Conditions for unloading Lacobel/Matelac:

- The rack must be positioned on perfectly level ground.
- The appropriate unloading device or grab must be used.
- The grab must be perfectly centred.
- Care must be taken to avoid damaging the protective packaging during handling.
- The glass should be stored on appropriate racks.

General comments:

- Grabs, slings, lifting beams and other hoisting equipment must comply with prevailing regulations and be approved by the relevant authorities.
- Personnel safety must be ensured at all times. Keep all unnecessary personnel out of the handling area. Wear appropriate personal protective gear.
- Personnel must have received the required training.

4. STORAGE PRIOR TO HANDLING

Storing packs correctly reduces the risk of chemical or mechanical damage to the glazings and will therefore make them easier to install.

As a general rule, the glass should be stored in a dry, well ventilated place to avoid major fluctuations in temperature and humidity that may cause condensation to form on the glass. Such variations generally occur near loading and unloading areas. No water must be allowed to come into contact with the sheets of glass and they should never be stored outdoors.

The glass should always be stored away from sources of heat and other corrosive materials or agents such as organic solvent vapours, chemicals, acids or fuel oil, etc.

Factory racks are used for packaging during transport and are not designed to be used for storage.

Consequently, the PLFs must be stored vertically on racks that have a soft base, such as wooden slats.

Separate the packs with spacers ensuring that all packs of the same size are stored together.

5. STORAGE AFTER OPENING / HANDLING THE PACKS

The same conditions for storing the packs prior to opening should also be applied once the packs have been opened. However, it is important to bear in mind a number of additional points:

- Care should be taken to ensure that the ambient air is not polluted by any corrosive elements such as chlorine or sulphur. Sources of such elements include machinery fitted with thermal engines, battery-charging points, road salt on the ground and so forth.
- The sheets must be moved using a suction-pad lifting beam or an automatic unstacking machine.
- If the glass is handled by placing suction pads on the paint, the suction pads must be kept clean.

5.1. Removing wooden and metal packaging

a) Wooden packaging: endcap

- Set the endcap on a support inclined at a slight angle (5°).
- Cut the vertical strapping.
- Remove the upper cover and then the two side covers.
- Remove the plastic protecting the glass.

b) Metal packaging: L frame

- Ensure that the pack rests on the uprights, not on the posts.
- Open the posts.
- Remove the posts.

5.2. Handling PLFs and DLFs

- PLFs must be lifted with a suction pad lifting beam or with an automatic unstacking machine.
- Labels and/or tape on the edge of the pack must be removed before handling PLFs.
- The lifting beam must be properly centred.
- The PLF must first be lifted slightly, and then moved away from the others.
- Care must be taken to prevent scratches, especially when handling coated glass, by ensuring that the edge of one PLF does not rub against the surface of another.

General comments:

- Any direct contact with hard materials must be avoided.
- Suction pad lifting beams and other hoisting equipment must comply with prevailing regulations and be approved by the relevant authorities.
- Personnel must check that the suction pads are adhering correctly before any further manipulation.

- Ensure the safety of personnel at all times. Keep all unnecessary personnel out of the handling area. Wear appropriate personal protective gear.
- Personnel must have received the required training.

6. CUTTING

The following specific precautions must be taken when cutting:

- The cutting and transfer tables must be covered with felt and cleaned frequently to avoid scratches caused by small glass splinters that could damage protective paints and varnishes.
- The glass should be cut with the painted side face down on the cutting table.
- Reduce the pressure of the cutting tool to avoid splinters.
- Use minimal quantities of neutral cutting oils (3).
- Sheets of glass cut to size must be stored on racks.
- Care must be taken to insert paper or cardboard spacers in order to avoid scratches.

(3) Recommended cutting oil:

Product description:

Acecut 5503 (ACW) or Dionol GT641 (MKU Chemie)

Suppliers:

Aachener Chemische Werke (ACW)

Adenauerstraße 20 Europark C3

D-52146 Würselen

Germany

Tel.: +49 / 2405 44970

Fax: +49 / 2405 449730

E-mail: acw@chemetall.com

MKU Chemie GMBH

Rudolf Dieselstrasse, 79

D-63322 Rödermark-Urberach

Germany

Tel.: +49 / 6074 87 520

Fax: +49 / 6074 87 5238

E-mail : Verkauf@mkuchemie.de

7. SHAPING

Lacobel can be shaped in any way. Below is a partial list of the different kinds of shaping options.

Shaping quality depends on clean cutting.

7.1. Shaping the edges

- Adjust the speed of the edging machine according to the number of grinding wheels fitted to it and the thickness of the glass.
- If using shaped spherical grinding wheels, avoid overly angular shapes. It is advisable to use one type of grinding wheel per thickness of glass.
- If grinding a flat joint with edges, avoid edges with an angle greater than 145°.
- The quality of grinding on the painted side of Lacobel/Matelac must be smooth and free of glass shards.
- Use a non-abrasive coolant liquid (neutral pH) to prevent damage being caused to the protective coatings.
- The glass must be kept moist for the entire process to prevent it from drying naturally.
- The glass sheets shall never be stacked wet on a stillage, between edge-processing and washing.

7.2. Washing

- Clean the cooling water circuit regularly in order to remove glass particles.
- Wash processed products immediately, preferably with deionised water, and dry carefully (within 30 minutes after edge processing).

8. WASHING

This stage involves washing, rinsing and drying the glass.

The glass must be washed in clean, deionised water with a pH of 7 (± 1).

No hard particles (such as calcium or others) or acidic/detergent agents should be present in the water used for washing and rinsing as they may damage the paint.

The glass should be completely dry when it leaves the machine.

Water droplets must be wiped off with a piece of tissue.

After washing, cork discs with (self-adhesive) foam can be placed on the glass side, around the edges of each glazing to prevent contact between the glass and the paint.

Summary of the quality of water used for shaping and washing the glass:

	Washing	Rinsing
	Washing	Rinsing
Detergent	No	No
Temperature	< 40 °C	< 40 °C
pH	7 \pm 1	7 \pm 1

9. PACKAGING THE PROCESSED PRODUCT

- Place the sheets vertically on or in the packing material, taking care to avoid scratches caused by stacking (see storage).
- Separate the sheets with paper or cardboard spacers.
- When shrink-wrapping, perforated plastic may be used if the glass is to be stored in a dry area for a normal length of time.

10. QUALITY CONTROL

10.1. Delivery of the glass

Lacobel/Matelac is manufactured in factories that are ISO 9001 certified (certificate available upon request).

Lacobel/Matelac packs must be inspected immediately upon arrival.

10.2. Quality control after washing

We recommend inspecting the glass after washing.

The glass must be dried completely after being washed.

11. DOUBLE GLAZING

Lacobel/Matelac may not be used in double glazing, even with the painted side facing the inside of the building.

12. LAMINATION

Lacobel/Matelac cannot be laminated with PVB interlayers. However, a safety film is available.

See Lacobel/Matelac SAFE or SAFE+.