

Glass Cutting and Edge-deleting

Cutting:

- Soft coat Low-e glass must be cut with the coated surface up. Pyrolytic or Hard coat Low-e glass is usually cut coated side down.
- Only the cutting fluids recommended in Bulletin G005 should be used.
- Methods of transferring glass from the shipping container to the cutting table will vary depending on the size of the glass, the type of table and/or cutting operation.
- A free fall system with an air float table, cutting bridge and breaker bars is the preferred method of cutting.
- If a bridge-type cutting table is used, nothing but the cutting wheel should come in contact with the coated glass surface in case of Low-e glass.
- Glass manufacturer should be consulted for edge-deletion of soft coat Low-e glass. If the glass has to be temporarily returned to a pallet before the next fabrication step, interleaving should be maintained between lites. A powder containing 100% Lucite® beads and no acid (such as Sydeline Corporation's part number 47GS) is preferred. This powder must be run through an 80-mesh screen. When this glass is needed for production, it must be processed with all previous steps taken.
- Once cut, glass must be fabricated into insulating units within 48 hours. Any glass that has been washed must be fabricated into an insulated unit within 24 hours.

Edge Deleting/Stripping Low-e glass:

- Grinding has proven to be the most productive and economical method of removing a narrow strip of the coating from the perimeter of the Low-e glass lite. The width of the strip must be equal to the width of sealant that will be in contact with the glass after fabrication of the insulating glass unit. Typically this will be in the range of 3/8 to 1/2 inch width. Complete removal of the coating from the edge is necessary, and this can be verified by use of an ohmmeter.
- Edge deletion is recommended on most Low-e soft-coated glass; however, some window manufacturers have chosen not to edge delete. One should always check with the glass manufacturer and the sealant manufacturer for specific instructions on edge-deletion. Reference Bulletin G003 for further information on edge deletion.
- The grinding operation must take place with the coated surface face-up.
- Once the grinding is complete, the glass must be fabricated within 24 hours.

Rev. #	Revisions Made	Rev. Date
2	Formatting	06-11
1	Revision date	12-13-01

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