

**production skills**

processing	max. length	max. width	thickness	quality	radius	standard
cutting	20,000 mm / 787 in	3,510 mm / 138 in	4–19 mm / $\frac{5}{32}$ – $\frac{3}{4}$ in			
drilling					6 mm–32 mm $\frac{1}{4}$ –1 $\frac{1}{4}$ in	
edging	20,000 mm / 787 in	3,510 mm / 138 in	6–19 mm / $\frac{1}{4}$ – $\frac{3}{4}$ in	matt grinded, polished grinded, mirror polished		DIN 1249

tempering	max. length	max. width	thickness	min. surface tension	standard
heat-strengthened	20,000 mm / 787 in	3,510 mm / 138 in	6–12 mm / $\frac{1}{4}$ – $\frac{1}{2}$ in	70 MPa	DIN EN 1863
fully tempered	20,000 mm / 787 in	3,510 mm / 138 in	6–19 mm / $\frac{1}{4}$ – $\frac{3}{4}$ in	120 MPa	DIN EN 12150
heat soak test	20,000 mm / 787 in	3,510 mm / 138 in	6–19 mm / $\frac{1}{4}$ – $\frac{3}{4}$ in		DIN EN 14179

chemically toughened	max. length	max. width	thickness	max. depth
	4,900 mm / 193 in	2,400 mm / 94 in	2–19 mm / $\frac{5}{64}$ – $\frac{3}{4}$ in	1,120 mm / 44 in

ceramic-ink printing	max. length	max. width	thickness	tolerances frameless printing	tolerance multiple printing	printing resolution
screen printing	2,400 mm / 95 in	1,350 mm / 53 in	4–10 mm / $\frac{5}{32}$ – $\frac{25}{64}$			
roller-coater printing	20,000 mm / 787 in	3,300 mm / 130 in	6–19 mm / $\frac{1}{4}$ – $\frac{3}{4}$ in			
digital printing	18,000 mm / 709 in	3,300 mm / 130 in	6–19 mm / $\frac{1}{4}$ – $\frac{3}{4}$ in	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	standard
	19,450 mm / 766 in	3,200 mm / 126 in	4–19 mm / $\frac{5}{32}$ – $\frac{3}{4}$ in	DIN EN 1096-4

laminating	max. length	max. width	lamination interlayer	special laminations	intermediate materials
	20,000 mm / 787 in	3,510 mm / 138 in	SentryGlas®, PVB, TPU, EVA, special interlayers	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 ( $\frac{1}{4}$ in) 12,000 mm (8 mm) / 472 in ( $\frac{5}{16}$ in) 15,000 mm (10 mm) / 590 in ( $\frac{3}{8}$ in)
cold bent glass	National Technical Approval: Z-70.3-175		

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hot bending	length	width	thickness	bending shape	Rmin.*	max. bending depth	bending angle
gravity curved glass	11,500 mm/ 452 in	3,300 mm/ 130 in	2–19 mm/ 5/64 – 3/4 in	cylindrical, conical, spherical, toric, j shape, double bend and irregular bend			
tempered curved glass	2,440 mm/ 53 in	1,570 mm/ 62 in	4–8 mm/ 5/32 – 5/16	cylindrical	1,000		90°
	4,800 mm/ 189 in	2,440 mm/ 96 in	6–12 mm/ 1/4 – 1/2 in	cylindrical	1,500		90°
	2,440 mm/ 53 in	4,250 mm/ 130 in	6–15 mm/ 1/4 – 19/32 in	cylindrical	2,500		90°
	3,000 mm/ 118 in	1,500 mm/ 59 in	5–10 mm/ 13/64 – 25/32	cylindrical	650		105°
	2,500 mm/ 59 in	1,200 mm/ 47 in	5–8 mm/ 13/64 – 5/16	j shape	350		90°
	5,000 mm/ 197 in	3,200 mm/ 126 in	6–12 mm/ 1/4 – 1/2 in	cylindrical and j shape	1,500		90°
	3,300 mm/ 130 in	3,600 mm/ 142 in	6–15 mm/ 1/4 – 19/32 in	cylindrical	1,500		90°
	3,300 mm/ 130 in	2,500 mm/ 59 in	6–12 mm/ 1/4 – 1/2 in	cylindrical	900		90°
	6,500 mm/ 256 in	3,600 mm/ 142 in	6–19 mm/ 1/4 – 3/4 in	cylindrical	2,000		
	6,500 mm/ 256 in	3,600 mm/ 142 in	6–15 mm/ 1/4 – 19/32 in	double-bending		x = 400 mm/16 in y = 800 mm/35 in	

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 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 18,000 mm)						
hot bent IGU	11,500 mm 452 in	3,300 mm 130 in					

\*All Rmin. details are dependent on the glass width, length and thickness.

**sedak provides further dimensions, finishing and limitation on specific request.**

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