

Specification

Technical Properties for stock sizes

TP

B 270[®] i

1.0 Thickness

nominal thicknesses [mm]*	permissible tolerance [mm] **
0.90	± 0.1
1.00	± 0.1
1.10	± 0.1
1.35	± 0.15
1.65	± 0.15
1.85	± 0.15
2.00	± 0.2
2.30	± 0.2
2.50	± 0.2
3.00	± 0.2
3.50	± 0.2
4.00	± 0.2
4.50	± 0.2
5.00	± 0.2
5.50	± 0.3
6.00	± 0.3
6.50	± 0.3
7.00	± 0.3
8.00	± 0.3
10.00	± 0.4

* other thickness on request

** closer tolerances on request

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Distribution of thickness / wedge

The thickness deviation is in mm/cm within a distance of 1 cm (measurement point intervals) specified.

thickness [mm]	wedge [mm/cm]
0.90 – 1.20	0.015
1.35 – 3.00	0.020
3.50 – 5.50	0.022
6.00 – 8.50	0.025
> 8.50	0.035

2.0 Dimensions

thickness [mm]		length x width [mm]
0.90 – 4.00	stock sizes from melting tank	1680 x 840 - 920 ± 25
	cut sizes	840 - 920 x 560 840 - 920 x 840 ± 10
4.50 – 10.00	stock sizes from melting tank	1680 x 860 - 920 ± 25
	cut sizes	860 - 920 x 560 860 - 920 x 840 ± 10

Special dimensions upon request

VW 0050/3e

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thickness [mm]		length x width [mm]
0.90 – 4.00	Cut sizes	406 x 258 ± 1
4.50 – 10.00		

3.0 Rectangularity / Squareness

The deviation from rectangularity of the panel edge is ascertained in mm / m edge length.
 - A maximum deviation of 10 mm/m is permissible.

4.0 Cut edge quality

Chips which occur as a result of cutting and handling are permissible in the whole of edge area.
 The size of the chips may not, exceed the thickness of the glass.

5.0 Warp

The maximum deviations of the glass surface from an ideal plane, referred to an area of 320 mm x 320mm.

thickness (mm)	maximum deviation
0.90 – 8.00	0.48 mm
> 8.00	On request

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6.0 Defects

In the glass melting process bubbles and inclusions cannot be avoided. The defect quantity and size distribution is depending on the glass schedule.

Knots which may cause breakage during transportation are not admissible.

Permissible defects in stock sizes

Defects < 1.0 mm are not taken into account.

thickness 0.90 – 10.0 mm			
area [mm]	defect >= 1 mm	Σ length	max.- length per sheet
406 x 258	5 pcs	50 mm	20 mm per defect
840 - 880 x 560	7 pcs	100 mm	100 mm per defect
> 880 - 920 x 560	8 pcs	100 mm	
840 - 880 x 840	11 pcs	100 mm	
> 880 - 920 x 840	12 pcs	100 mm	
1680 x 840 - 880	19 pcs	100 mm	
1680 x > 880 - 920	21 pcs	100 mm	

Drawing stripes: according as limit sample

7.0 Annealing quality

thickness [mm]	birefringence (tension)
0.90 – 3.00	≤ 30 nm/cm
3.50 – 6.00	≤ 40 nm/cm
6.50 – 10.00	≤ 60 nm/cm