

# PLANILAQUE COLOR-IT

PROCESSING GUIDELINES

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# 1. General

## 1.1. PRODUCT DESCRIPTION

PLANILAQUE COLOR IT is a decorative lacquered glass. It is produced by depositing a durable color paint at the back of the glass substrate.

Product is for interior application. Contact your sales representatives for more information. For complete performance data, please refer to the Product catalogue, our documentations and our website [www.saint-gobain-building-glass.pl](http://www.saint-gobain-building-glass.pl).

To improve customer satisfaction, we constantly improve the quality of our products. This could lead to improvement in the processability of our lacquered glasses, so please make sure you have an up-to-date version of these guidelines.

## 1.2. THICKNESS, DIMENSIONS AND TOLERANCES

The complete product range including thicknesses and dimensions is available on SG websites or thanks to your local sales service.

## 1.3. CE-MARKING

At the time of writing, there is only the first part of the standard EN 16477-1 describing the requirements for painted glass. Until the entry into force of the EN 16477-2 standard, the subject of which is the assessment of compliance with the standard, painted glass is not subject to CE marking.

## 1.4. QUALITY CRITERIA

### 1.4.1. Definition of visible defects

Defect definitions are based on EN 16477-1.

- **Defects of base float glass (point and line):** defects admitted according to EN 572-2; directly influencing the distortion of the reflected image;
- **Paint defects:** defects directly related to the lacquer coating, e.g. scratches, spot defects, discoloration, lack of adhesion of the lacquer to the glass:
  - **open spot defects of the paint:** open paint blisters, holes in the paint, scratches, stains (zone color change of the reflective paint coating),
  - **paint defects:** defects directly related to the lacquer coating, e.g. scratches, spot defects, discoloration, lack of adhesion of the lacquer to the glass,
  - **discoloration:** change in the color of the paintwork which may occur after an aging test, e.g. fading
  - **no adhesion:** point lack of adhesion in which the paint is no longer attached to the glass surface, detected in reflection as a shinier point.
- **A cluster of point defects** is a group of not less than 3 point defects, spaced not more than 50 mm from each other on the pane.
- **Linear defects:** scratches, elongated spot defects, etc. on the glass surface or on the varnish, visible from the glass side;
- **Hairline scratches:** very fine, circular scratches, barely visible, related to the glass washing technique;
- **Halo:** optical distortion around a point defect in the float glass.

### 1.4.2. Conditions of observation

For lacquered glass, observation should be done on glass side, at a distance of 1 meter in normal diffused light condition. Inspection is limited to 30 seconds and observation is done front of the glass and not in angle. Detailed guidelines and control methods are described in EN 16477-1.

### 1.4.3. Acceptance criteria

In general, all defects visible on coating face and not visible on glass face are acceptable.

## 2. Transport, acceptance, storage and handling

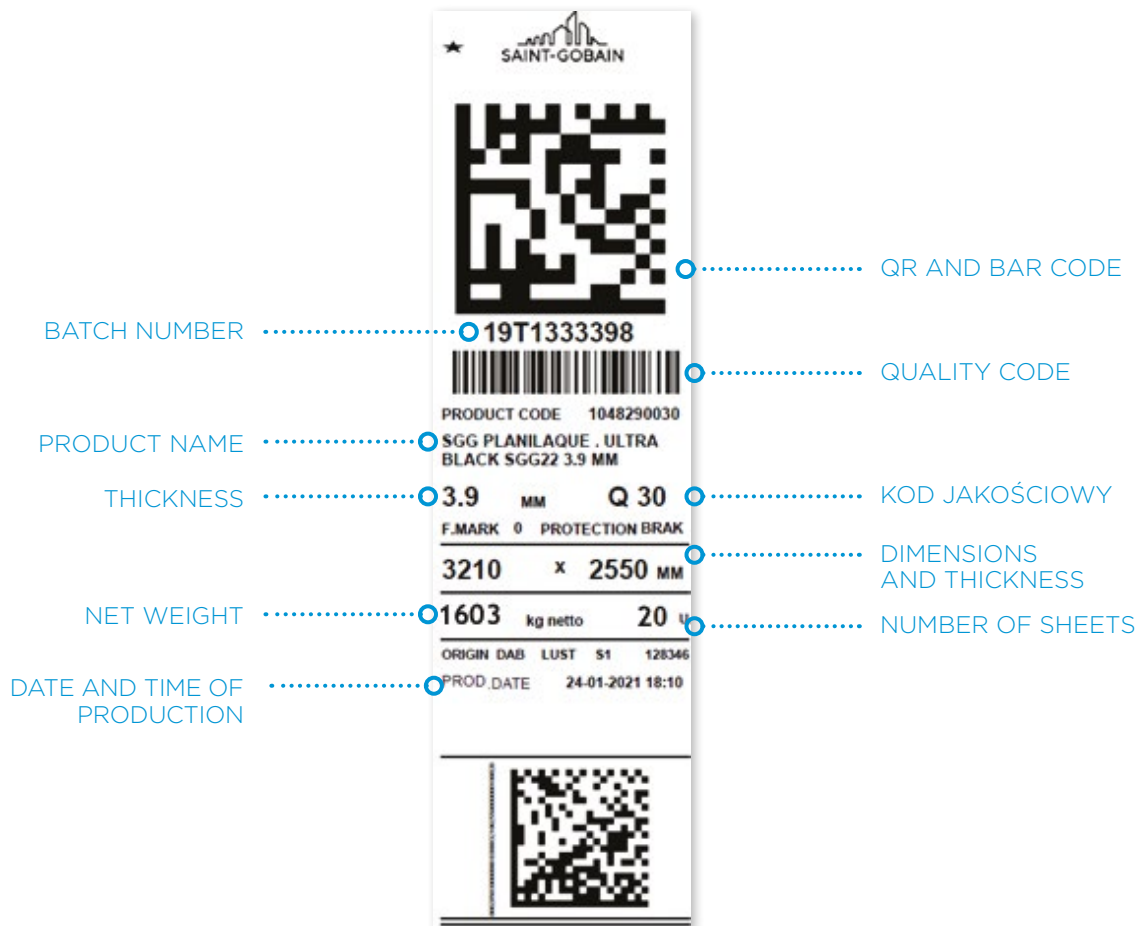
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### 2.1. TRANSPORT

- The lacquered glass sheets are usually transported with L-Racks, VEC.
- Glass sheets must be transported vertically (at 3 - 7 degrees).
- The glass panes never come into direct contact with each other: the glass sheets are always separated by neutral polymeric powder.
- During transport, violent and repeated shocks should be avoided as well as intensive breaking.
- When handling with a manipulator, care must be taken not to damage the pack.
- If the glass is wrapped and sealed, the seal should remain closed until the product is used in the factory.

## 2.2. RECEIPT OF THE DELIVERY

- Every pack must be opened with care in order not to damage the glass sheets (contacts, scratches, etc.). Handling instructions must be respected, especially the instructions for opening.
- All deliveries are identified with a label providing the following data:



## 2.3. STORAGE

All glass products may degrade (become stained or corroded) when stored in humid conditions. The iridescence may take the appearance of a “rainbow” or milky white haze on the surface of the glass. The glass sheets have to be stored vertically (at 3 - 7 degrees) under the following conditions:

- In a dry, well ventilated store, to prevent any condensation on the surface;
- Protected from rain and running water (e.g. any roof leaks must be rectified);
- Never outside or in the open air;
- Protected from wide changes in temperature and humidity to avoid condensation.
- Package should not exceed 300mm, as it provides proper air circulation.
- Coated face should always face front, never place with the varnish side facing each other's.
- Never close to heat sources, corrosive materials or steam sources (chemicals substances, solvents, fuels, acids...)

## 3. Processing

### 3.1. HANDLING ON THE PRODUCTION LINES

The lacquered glass sheets must be handled with dry, clean gloves.

In case you cannot avoid handling operations with vacuum cups, make sure that the vacuum cups are silicone free and perfectly clean.

Direct contact between painted face and rubber on trolley should be avoided. Don't use humid spacers that could degrade the coating face.

### 3.2. CUTTING

Lacquered glass is cut as normal float glass on glass side. However, the following recommendations have to be respected:

- Cutting table should be clean:
  - Perfectly free of glass splinters or shards;
  - The conveying bands are perfectly clean and free of silicone or other greasy substances;
- Use only light **vaporizing cutting oil** (for instance Acecut 5503 or 5250) adapted to coated glass;
- Do not dilute or mix the cutting oil;
- Avoid all excess of cutting oil: max width: 1 cm;
- Fine glass splinters on the coated surface should not be wiped off by hand, but blown off by dry and **oil-free air**;
- During manual breaking and evacuation, limit the sliding of the glass on the table so as not to scratch the coating;
- When stacking cut sizes prior to further processing, separate the panes by either:
  - New cork pads (recommended);
  - Paper interlayer (chlorine free);
  - Foam pads;
  - Corrugated cardboard strips.

This is especially important with glass of different dimensions. Do not put additional separating powder.

In general:

- Make sure, that the cut has no interruption. If necessary, reduce the cutting speed.
- If you face problems during automatic breaking, ensure that the glass cut is positioned at a distance of approximately 2 cm from the breaking bar.

### 3.3. EDGE WORKING

It is good practice to edge work the glass directly after cutting. Provided the glass is stored under above defined conditions, the glass must be edge worked within 5 days from cutting.

- **Wet edge-working:** it is essential to keep the glass fully wet during the whole grinding process and to wash the glass directly afterwards so that the grinding water is not able to dry on the coated surface.
- **Dry edge-working:** such processing is generally not recommended as small glass dust particles may be sprayed on the dry coated surface. In case of use, make sure the suction is powerful enough to avoid a too important dispersion of dust.

### 3.3.1. Manual Edge Working

Generally carried out using manual cross belts to achieve arrised edges (100 - 120 grit belts are recommended);

- The top belt should run downwards to minimize grit deposited on the coated surface;
- Horizontal roller backstops can be fitted to ensure consistent pressure and arriss width;
- The glass should be handled (with glass dust free gloves) at the edges to avoid damaging the painted face.

### 3.3.2. Automatic Edge Working

It is possible to grind the painted glass on vertical, CNC and double edger machines provided that the handling instructions are observed and adaptations of the machines are made (if necessary, contact your local Technical Support Manager). For double-edger and vertical machines, cleanliness and perfect synchronization of the pressure belts must be checked. No damages of painted faced by unadjusted grinding wheel should be observed.

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## 3.4. DRILLING AND SAND-BLASTING

The drilling of lacquered glass can be performed provided that the handling instructions are observed. Possible machine adaptations could be necessary to not generate defects.

The sand-blasting process is a possible source of damaging, following recommendations must be applied:

- Protection film should be applied on painted face
- A first test with film supplier is advised to evaluate film compatibility with paint face. Too adhesive film is prohibiting and no glue residues should be present after film removing.
- No abrasive particles (glass/sand) should be trapped between the plastic film and the paint surface
- Regular machine and conveyors cleaning
- Special care and attention to painted edges is important, no degradation

If necessary, contact your local Technical Support Manager – TSM to support and run some tests.

Possible safety impact could not be quantified. So initial possible safety function is not guarantee after these both processing (drilling and sand-blasting).

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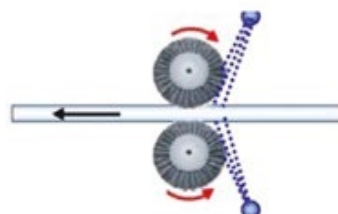
## 3.5. WASHING

It is recommended to wash the glass immediately after edge working. In case product is submitted to several processing steps (edge working + drilling +...) each of them followed by washing, it is recommended to pass the cut sizes in the same direction for each washing phase (to avoid possible generation of multiple crossed scratches).

Tap water could be used for pre-washing, washing and rinsing itself. For sure, use of demineralised water is better and could avoid some residues. Important is to have regular maintenance and cleaning, to have also good drying (blowing installation with filters, clean filters) to avoid water remaining on the glass after drying process.

Zalecenia ogólne:

- Water should be sprayed directly onto the glass, not onto the brushes (as per below drawing);





- The glass sheet does not stop inside the washing machine. The washed panes should not remain in the washing unit for any length of time, especially not while the brushes are rotating;
- No water must remain on the coated surface after the drying process;
- It is strongly recommended that the washing machine is regularly cleaned. Clean the filters every day, and the tanks every week. For the brushes, steam cleaning gives good results, but do not spray the bristles with high temperature and high pressure water.
- In case dirt / stains are still present on the coating after the washer, cleaning may be performed using a soft cloth and isopropanol (IPA) or ethanol followed by rapid drying, provided this is done carefully and immediately after contamination has occurred.
- For interim stacking of washed panes, use cork pads near the edge of the sheets.

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### 3.6. TEMPERING / HEAT-STRENGTHENING

PLANILAQUE COLOR IT can't be heat-treated to get a tempered / heat-strengthened coated glass. Product is not temperable.

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### 3.7. LAMINATION

PLANILAQUE COLOR IT can't be laminated by glass processors in cut size or at their own responsibilities. No safety function is guarantee.

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### 3.8. PROCESSING QUALITY CHECKS

It is the responsibility of the processing plant to define and adjust the quality process control to match the quality standards acceptable for its own market and in respect of relevant national requirements.

- Reception:
  - Control of delivery document of the coated glass supplier. Visual inspection of the packs (breakages, condensation...);
- After cutting:
  - Visual aspect control (scratches, paint degradation, splinters etc.);
  - Normal control of the cutting quality;
- After grinding / drilling / washing:
  - Visual aspect control (scratches, paint degradation, splinters etc.);
  - Visual control (as to whether the pane is completely dry);
  - Check for suction cups or cork pad marks etc...;
  - Check paint face edges, no local degradation
  - Normal control of the grinding / drilling quality;

For plants just starting to use lacquered products, a system of "first off" inspection after each process can be useful until experience is gained. Operator training and experience in identifying faults is important. In any case, a visit from your local TSM should be organised.

## 4. Environment / waste glass / health issues

Edge working residues have to be continuously and completely collected during the grinding process. These residues must be further treated in compliance with national legislation about industrial wastes. In some legislation, residues from grinding process have to be treated as toxic wastes.

As for any dust coming from the grinding process, any inhalation or skin contact of these residues must be avoided.

On request, a Safety Use Instruction Sheet (SUIS) relating to the EC Directive 91/155/EEC can be supplied.

## 5. Cleaning and maintenance of the end products

### 5.1. REMOVAL OF LABELS AND MARKINGS

The identification labels on the glass sheets must be removed before or immediately after installation. Do not use a sharp tool for this purpose. Acetone and alcohol are the approved solvents.

### 5.2. CLEANING AND MAINTENANCE

Alkaline products may be emitted from concrete, plaster, mortar... Such materials or materials containing fluorine and acids will lead to a staining or matting of the surface. To prevent such an occurrence, all such substances must be removed from the glass immediately. It is recommended that the glazing is cleaned as soon as it is installed.

Cleaning means: washing, rinsing and drying the glass. A mild soap or neutral detergent can be used, and subsequently and immediately rinsing with clear water. Excess water must be removed quickly. Washing tools and towels must be free of abrasive particles. Never use abrasive cleaning products, or compounds likely to generate fluorine salts or hydrofluoric acid.

Grease, oil and materials used for facilitating the installation must be removed. The materials recommended for cleaning are isopropyl alcohol or ethanol. Cleaning with solvents must be immediately followed by standard washing with water and rinsing.

The owner of the building must make sure that glass is regularly and properly maintained. This entails washing the glass, checking and if necessary repairing joints and frames, checking and detecting any anomaly.

## 6. Disclaimer

Saint-Gobain Innovative Materials Polska Oddział Glass has taken every reasonable measure to ensure that the information contained in the present leaflet was exact at the time of its publication.

However, Saint-Gobain Innovative Materials Polska Oddział Glass keeps the right to modify or add any information without previous notice. Saint-Gobain Innovative Materials Polska Oddział Glass is not liable for the possible lack of information on PLANILAQUE COLOR IT products that would not be contained in the present document.





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