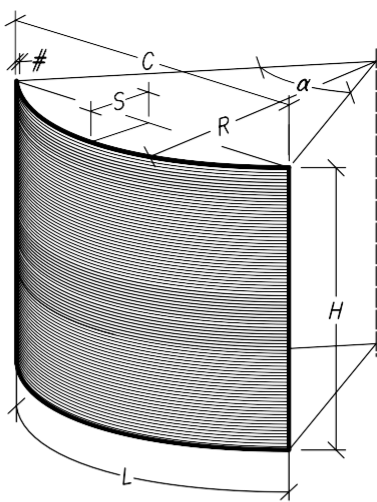


Annealed cylindrical glass (not hardened)



Parameters

- R – Radius
- L – Arc Length
- C – Chord
- S – Deflection
- α – Angle
- H – Height
- # – Glass Thickness

Maximal glass dimensions

#	3 – 19
L x H	1800 x 3300 lub 3000 x 1800
S	600
α [°]	125

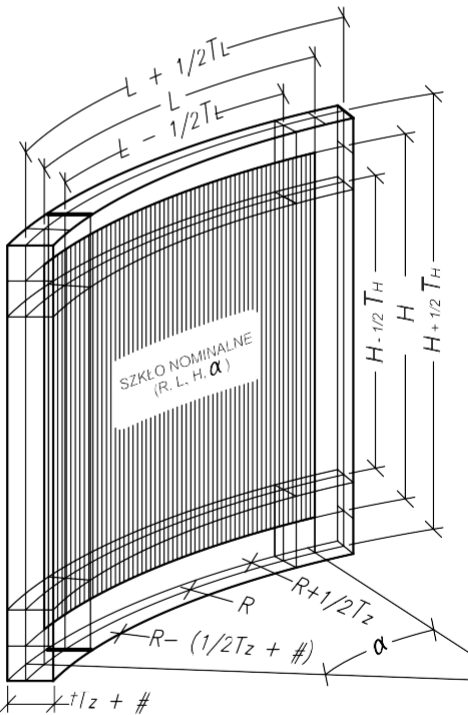
Minimal radius range depending on glass thickness

#	4	6	8	10	12	15	19
R _{min}	120	140	160	180	200	250	300

Tolerances ¹⁾

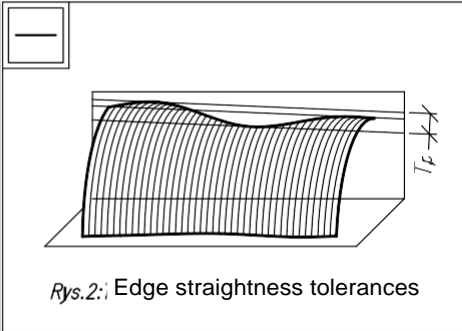
Range of nominal dimensions L or H [mm]	Dimensional tolerances T _L , T _H [mm] following "fit in the box" principle. (Rys. 1)				Shape Tolerances				
	Monolithic glass	Laminated glass (VSG)	Insulated glass		Edge Straightness T _p * (Rys.2)	Edge skewness T _s ** (Rys.3)	Of the outline T _z ** (Rys.4)		
			IGU	Double (or more) IGU			Monolithic / Laminated glass	IGU	Double (or more) IGU
L v H ≤ 1000	2 (±1.0)	4 (±2.0)	6 (±3.0)	8 (±4.0)	2 mm/m	3 mm/m	6	8	10
1000 < L v H ≤ 2000	3 (±1.5)	5 (±2.5)	8 (±4.0)	10 (±5.0)			8	10	12
L v H > 2000	4 (±2.0)	6 (±3.0)	10 (±5.0)	12 (±6.0)			10	12	14

*), Nominal dimension – H, **) Nominal dimension – H – if H > L, – L – if L > H

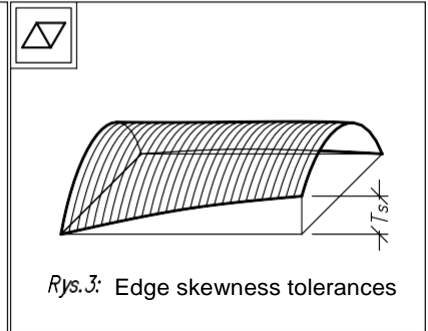


Rys.1: "fit in the box" principle

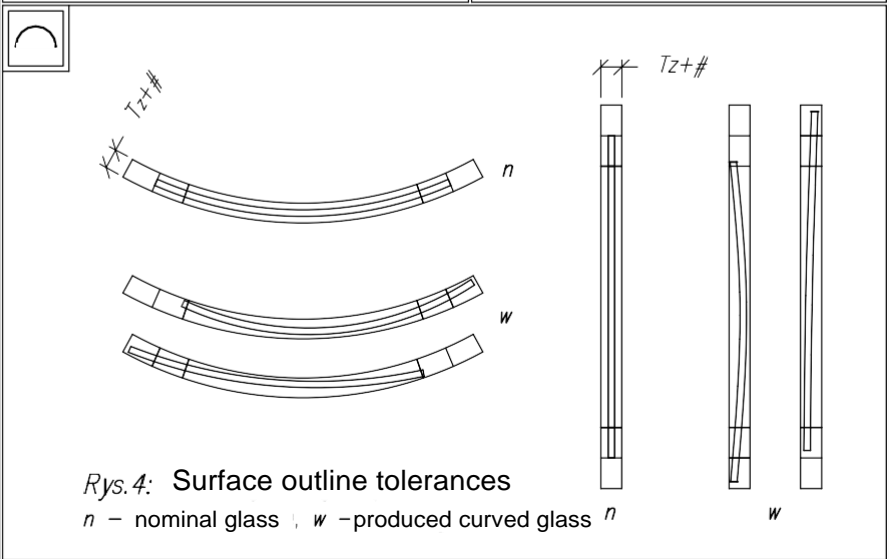
None of the points of the surface of produced curved glass should go beyond the space contained between the sections of roll surfaces defined in the figure above.



Rys.2: Edge straightness tolerances



Rys.3: Edge skewness tolerances



Rys.4: Surface outline tolerances

n – nominal glass ; w – produced curved glass

1) Standards PN-ISO 1803:2001 Construction -- Tolerances -- Expression of measurement accuracy -- Principles and terminology and PN-ISO 3443-1:1994, PN-ISO 3443-5:1994, PN-ISO 3443-6:1994, PN-ISO 3443-7:1994, PN-EN ISO 12543-5, PN-EN 1279-1/5

When ordering, please specify the height H [mm] and thickness # [mm] of glass and two parameters of following five: R, L, C, S [mm], α [°] uniquely defining the shape of glass.

Note! it is assumed that the dimensions refer to the outer (convex) surface of the glass. In the case of defining an inner surface, this should be clearly indicated and the parameters indexed with the letter "w" (R_w, C_w, S_w, L_w).

In order to avoid misunderstandings, we kindly ask you to familiarize yourself with the tolerances of the dimensions and shapes of bent glass.