

Edge-working to DIN 1249 Part 11

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### Cut-to-size (KG)



Term for the resulting straight edge of float glass which has been cut and remains untreated (cut edge). The sides of the cut edge are sharp. Slight wave lines (so-called Wallner lines) occur in the edge zone, perpendicular to the cutting edge.

Generally the edges are clean broken, however, it is possible, in thicker sheets and straight-edged shaped units, that irregular breaks occur. E.g. through positioning of the cutting edge or cutting of the glass with nips. Laminated glass of sheets with cut edges will have a step at the edge.

### Arrissed (KGS)



Term for a cut edge whose sharp sides have been swiped with a grinding tool.

### Raw (KMG)



Term for a cut edge whose sides have been arrissed and which has had any uneven surface protrusions along its edge flattened.

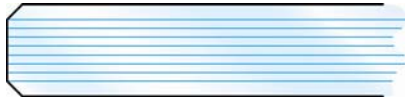
### Chamfered edge (GK)



Edge shape which, for constructive reasons, has been chamfered into an angle less than  $90^\circ$  whereby the point of the angle is a max. 2 mm.

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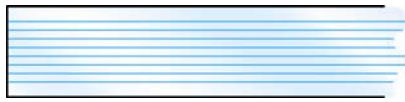
### Ground (KGN)



corners.

Term for an edge which has been completely ground. Ground edges have a matt appearance with arrissed

### Water-jet cut (KGNW)



edges have a matt appearance. Cut-outs, openings or corner cut-offs are generally cut using this method.

Term for an edge which has been completely treated with water-jet. Water-jet cut

### Polished (KPO)



structure of the grind is allowable but must not be matt.

Term for a flat ground edge which has a fine shiny surface appearance achieved through polishing. The surface

### ECKELT – Standard edges

STADIP laminated glass with ground or polished edges (KGN or KPO) of two or more sheets have the individual sheeys machined. The corners of edge-worked rectangular sheets are swiped matt.

### Blocking egde

With heavy laminated units with thin individual sheets, we recommend that the blocking edge be ground.