

MIROX MNGE

PROCESSING GUIDE



VERSION 1.0 – APRIL 2019

Please check <http://agc-tas.com/> regularly for updates.

AGC

CONTENTS

- 1. PACKAGING..... 3
- 2. STORAGE 3
- 3. LIFTING 4
- 4. QUALITY CHECKS..... 5
- 5. CUTTING 5
- 6. EDGE PROCESSING & DRILLING 5
- 7. LAMINATING 6
- 8. SANDBLASTING 6
- 9. PACKING THE PROCESSED PRODUCT 6
- 10. CLEANING..... 6

1. PACKAGING

Appropriate packaging prevents the glass from damage caused by:

- **Chemical risks:** marks on the surface caused by rain (water falling directly on the glass in the packs) or condensation (as a result of a change in temperature);
- **Mechanical risks:** accidents involving the surface of the glass, breakages and so forth.

Mirox MNGE mirrors are available in standard dimensions. (please contact AGC sales representatives for more details)

A label affixed to the edge of the pack indicates the exact contents of each load.

Label	Explanation
XXXXXXXXXXXXXXXXXX	Product Barcode
MIROX MNGE	Product Name
MX5	Product Code
72 x 48 in	Product Dimension
3 mm	Product Thickness
P-T7	Product Packing
AS	Product Inserters
100 Lembar	Product Quantity

2. STORAGE

Upon receiving your order, check the condition of each pack of glass carefully and report any breakages, moisture, humidity or serious defects to AGC representatives.

Do not neglect to check the product upon arrival.

The product must always be:

- a. unpacked as soon as possible
- b. stored as follows:
 - Vertically on a soft surface, such as wooden boards with spacers;
 - In a dry, well ventilated place that is not subject to major temperature fluctuations, so as to avoid condensations;
 - Away from sources of heat and corrosive materials or agents such as organic solvent vapours, chemicals, acids, or fuel;
 - Never outside

Storage time depends on the aforementioned conditions.

3. LIFTING

General comments:

- Wear personal protective equipment (PPE) properly.
- Personnel must have received the required training.
- Ensure the safety of personnel at all times. Keep all unnecessary personnel out of the handling area.
- Direct contact with hard materials must be avoided.
- Labels and/or tape on the edge of the pack must be removed before handling.
- Lifting gear must be properly centred.
- Each sheet must first be lifted slightly and then moved away from the others.
- Care must be taken to prevent scratches, especially when handling silvered glass, by ensuring that the edge of one sheet does not rub against the surface of another.
- Suction lifting gear and other hoisting equipment must comply with prevailing regulations and be approved by the relevant authorities.
- Personnel must check that the suction pads are adhering correctly before handling.

Prior to the process of mirror, it is advisable to follow below specific handling according to each method:

Specific handling:

Manual Handling:

- Adjust manpower quantity based on size of glass for safety reason.
- Only lift the glass wearing safety gloves and safety shoes.
- It is advisable to avoid any contaminant around the cut-size of mirror.

Stock Sheets:

- Sheets must be lifted using either suction lifting gear or an automatic unstacking machine.
- Proceed as described in the general comments.

A-Racks:

- Set the A-racks on a stile inclined at a slight angle (4° - 8°).
- Cut the strapping.
- Remove or cut the front plastic cover and then the two side covers.
- Proceed as described in the general comments.

Endcaps:

- Set the endcap on a stile inclined at a slight angle (3° - 4°).
- Cut the vertical strapping.
- Remove the upper cover and then the two side covers.
- Remove the plastic protecting the glass.
- Proceed as described in the general comments.

Safety back products:

- Static electricity may build up while unloading safety back products after transport.
- You can discharge the build-up of static electricity by using insulated wire to ground personnel.

4. QUALITY CHECKS

We recommend performing quality checks based on the requirements of standard EN 1036-1:2007 for the following visible factors: float glass defects, optical deformation, scratches, dimensions, etc.

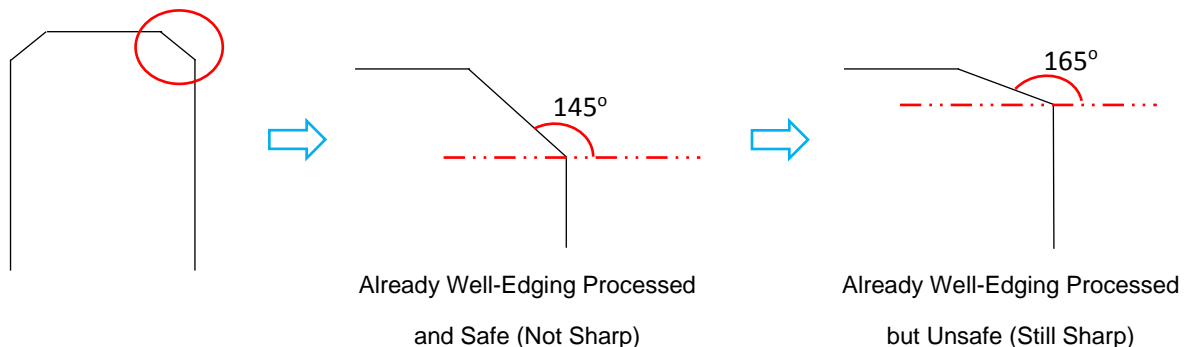
5. CUTTING

- The cutting and transfer tables must be covered with felt and cleaned frequently to avoid scratches caused by small glass splinters that could damage protective paints and varnishes.
- Cut the mirror with glass side face upward.
- Reduce the pressure applied to the cutting tool to avoid cullets.
- When starting, cut slowly and build up pressure until you achieve a good cut.
- Use small quantities of neutral cutting oils (e.g. ACECUT 5503 cutting oil or equivalent).
- Correct cutting settings can differ from one cutting installation to another and can be tested by cutting test strips 100mm wide and at least 1m long. It should be possible to break the cut strips by hand.
- AGC provides this information for advisory purpose. The user/customer is solely responsible for using this advice.

6. EDGE PROCESSING & DRILLING

Edge grinding	YES
Edge treatment	YES
Drilling	YES
Notching	YES

- Processing quality depends on clean cutting.
- Adjust the speed of the processing machine according to the number of grinding wheels fitted to it and the thickness of the glass.
- If using spherical grinding wheels, avoid overly angular shapes.
- If processing a flat joint with arise edges, avoid edges with an angle greater than 145°.



- Processing on the painted side of mirrors must be smooth and free of glass cullets to prevent the risk of corrosion.
- Use non-abrasive coolant additives (neutral pH) to prevent damage being caused to the mirror's protective coatings.
- Clean the cooling water circuit regularly to remove glass particles and plastic particles originating from the safety backing film.
- Wash processed products immediately, preferably with deionised water, and dry carefully, especially around the edges.
- Use spacers when stacking processed products.

7. LAMINATING

Mirox MNGE are silvered glass products for use in interior applications only. They cannot be laminated or used in double glazing units, even on the inner side of the glazing unit. The plasticizers in the PVB would have a negative influence on the paint coating.

However, Mirox MNGE safety back is the perfect solution for your safety needs. Safety backed mirrors according to standard AS/NZS 2208 grade A have a similar breakage pattern to laminated glass (pieces of glass remain attached to plastic film without separating).

8. SANDBLASTING

Mirox MNGE may be partially sandblasted.

9. PACKING THE PROCESSED PRODUCT

- Place the sheets vertically on or in the packing material, taking care to avoid scratches caused by stacking (see storage)
- Use soft spacers, e.g. wood powder, or medium particle size polyolefin based interleaving powder, but avoid organic products such as Lucite beads, as these can scratch paintwork.
- Wrap the processed product, keep the product dry, and avoid from chemical contamination.
- When shrink-wrapping, perforated plastic may be used if the glass is to be stored in a dry area for a normal length of time.

10. CLEANING

The following instructions are valid for initial cleaning after installation, routine cleaning and special maintenance:

- Mirox MNGE mirrors Painted Side can be cleaned only with clean water.
- Ammonia-based or other abrasive products, such as anti-limescale products, must never be used.
- Neutral Detergents with pH 7 ±2 can be used only in Glass Side, not in the edge and backside.
- The mirror must be dried immediately after cleaning, especially around the edges.
- For further, more detailed cleaning instructions, please consult the "Cleaning Guide" section in the Mirox MNGE Guideline on <http://agc-tas.com/>.