



Lacobel T and MatelacT with protection foil

Important Instructions

Please carefully read the following instructions before processing Lacobel T and MatelacT glass with protection foil.

AGC strongly recommends that each processor who wants to heat strengthen or toughen Lacobel T or Matelac T products should contact AGC's Technical Advisory Service (tas@eu.agc.com) and ask for assistance from one of its Coating Coaches in setting up the toughening furnace. This will make the processing procedure smooth and easy for the customer and will limit possible risks of claims in future. If the trial is successful, the processor will receive an AGC certificate showing that they are an AGC Certified Processor of Lacobel T and Matelac T and their contact details will be listed on AGC's product website www.agc-yourglass.com.

- Product** - Lacobel T and MatelacT must be either thermally toughened according to EN12150 or heat strengthened according to EN1863.
- Product** - Process Lacobel T and MatelacT within 24 months of delivery.
- Storage and Handling** - The protection foil protects the paint from water and humidity during glass transport, storage and processing. However, store and handle Lacobel T with care to avoid damaging its paint against mechanical abrasions.
- Cutting** - Lacobel T and MatelacT with protection foil should be cut using BOHLE cutting wheels (see table below) to successfully cut the glass with protection film through the film side. 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. The cutting pressure has to be increased (approx. 2.4 bar for 4 mm and 3 bar for 6 mm). The cutting speed has to be decreased (vs. the same thickness without protection foil) by approx. 30%.

Cutting wheel	Angle (°)	Thickness (mm)	
B0 03A100M	100	3-4	
B0 03A110M	110	4-5	
B0 03A115M	115	5-6	
Cutting wheel including plastic holder			
B0 416A100M	100	3-4	
B0 416A110M	110	4-5	
B0 416A115M	115	5-6	

5. **Edge processing - Single edger** - Painted side facing the operator, use clean pads. Crossed belts: painted side face-up, use sprinklers.
Double edger - Painted side face-up, use clean belts. CNC: painted side face-up or facing the operator.

6. **Washing** - Do not stack wet glass sheets between edge-processing and washing. To avoid damages to paint, the whole process of Lacobel T, from cutting to tempering, should be carried out continuously, in the shortest possible period of time. To avoid damages to paint, carefully dry the glass within 15 minutes after edge processing.

If, for any reason, the film peels-off from the paint, along the sides or near the corners of the glass, AGC recommends to push the film back to the glass, in order to expel the water out of the interface.

7. **Removing of the foil**: The **protection foil must be removed** before any heat treatment.

8. **Heat treatment - Never use furnaces without convection**. Once processed, AGC recommends to heat-treat the glass within 5 days.

Painted side face-up:

- Furnace settings with top convection only: 690°C top and 710°C bottom;
- Furnace settings with top & bottom convection: 690°C top and 700°C bottom.

The convection (on top and, if available, on bottom) shall be set as follows: 35% of the maximum pressure, for the first 100 seconds of the heating time.

Temperatures and convection pressure settings are the same, whatever the colour and thickness.

9. **Enamel quality** - Test the quality of the enamel after heat treatment by touching the painted side with a wet finger: no wet stain may be visible from the glass side.

10. **Further information** - Please visit www.agc-yourglass.com - Lacobel T and MatelacT brand description - to download your language version of this Instruction Sheet or to contact AGC's Technical Advisory Services (TAS). Or visit www.youtube.com/user/yourglass to view the Lacobel T processing video.