

# Processing guide for STRATOBEL



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*Updated information on products, product availability and processing guidelines are regularly updated on the AGC Flat Glass Europe website:*  
[www.YourGlass.com](http://www.YourGlass.com)

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## 1. Packaging

Stratobel glazings are available in standard sizes: PLF (bulk: A or L frames), DLF (bulk: A or L frame, endcap).

The sheets of glass are separated by a powder interlayer.

The exact contents of each package are indicated on the label affixed to the edge of the pack or packaging.

## 2. Unloading

### Unloading PLFs

- The rack must be positioned on perfectly level ground;
- Use the appropriate clamp;
- Handle one pack at a time;
- The clamp must be perfectly centred;
- Prevent any damage to the glass by using protective materials in those areas where there is contact with the glass.

### Unloading DLFs

#### Bulk packaging :

- The trailer must be positioned on perfectly level ground;
- Release the straps and blocks;
- Use the appropriate clamp or sling;
- Handle one pack at a time;
- The clamp must be perfectly centred;
- The slings must be positioned under the pack, at the ends. The angle between the slings must be no more than 90°;
- Prevent any damage to the glass by using protective materials in those areas where there is contact with the glass.

#### Packaging on L frames :

- The trailer must be positioned on perfectly level ground;
- Release the straps and blocks;
- The posts must NOT be opened at this stage;
- Use an appropriate lifting beam, with a double hook at each end (see diagram on frame);
- Handle one frame at a time;
- Check that the glass is correctly centred on the frame before lifting.

#### Packaged in wooden endcaps :

- The trailer must be positioned on perfectly level ground;

- Release the straps and blocks;
- The strapping on the endcaps themselves must NOT be cut at this stage;
- Use slings or an appropriate lifting beam;
- The slings must be positioned under the upper or lower ends of the endcap;
- The angle between the slings must be no more than 90°;
- Handle one endcap at a time.

#### General notes:

- Clamps, slings, lifting beams and other hoisting equipment must comply with prevailing regulations and be approved by the relevant authorities;
- Ensure the safety of personnel at all times. Keep all unnecessary personnel out of the handling area. Wear appropriate personal protective gear;
- Personnel must have received the required training.

### **3. Storage**

Correct storage helps prevent deterioration caused by the following hazards:

- chemicals: surface defacement caused by water, moisture or condensation;
- mechanical hazards: surface accidents, breakage, etc.

Ideal storage areas are well ventilated and out of sunlight to prevent the risk of thermal stress. AGC recommends maintaining a temperature of between 15 and 25 °C and a relative humidity of less than 80%.

Glazings showing signs of moisture due to temperature fluctuations during transport must be dried or installed as soon as possible.

Factory racks are used for transport packaging; they are not meant for storage. Consequently, glazings must be stored on racks with interlayers for each pack. The same sizes should be stored together.

As a general rule, AGC recommends ensuring proper rotation of stored glazings.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.

### **4. Handling PLFs and DLFs**

#### *Handling PLFs*

- PLFs must be lifted with a suction pad lifting beam or with an automatic unstacking machine.
- Labels and/or tape on the edge of the pack must be removed before handling PLFs.

- The lifting beam must be properly centred.
- The PLF must first be lifted slightly, and then moved away from the others.
- Care must be taken to prevent scratches by ensuring that the edge of one PLF does not rub against the surface of another PLF.

### Handling DLFs

#### Bulk packaging

- DLFs must be lifted with a suction pad lifting beam or with an automatic unstacking machine.
- Labels and/or tape on the edge of the pack must be removed before handling DLFs.
- The lifting beam must be properly centred.
- The DLF must first be lifted slightly, and then moved away from the others.
- Care must be taken to prevent scratches by ensuring that the edge of one DLF does not rub against the surface of another DLF.

#### Packaged in L frames

- Ensure that the pack rests on the uprights, not on the posts.
- Open the posts.
- Remove the posts.
- DLFs must be lifted with a suction pad lifting beam or with an automatic unstacking machine.
- Labels and/or tape on the edge of the pack must be removed before handling DLFs.
- The lifting beam must be properly centred.
- The DLF must first be lifted slightly, and then moved away from the others.
- Care must be taken to prevent scratches by ensuring that the edge of one DLF does not rub against the surface of another DLF.

#### Packaged in wooden endcaps

- Set the endcap on a support inclined at a slight angle (5°).
- Cut the vertical strapping.
- Remove the upper cover and then the 2 side covers.

- Remove the plastic protecting the glass.
- DLFs must be lifted with a suction pad lifting beam or with an automatic unstacking machine.
- Labels and/or tape on the edge of the pack must be removed before handling DLFs.
- The lifting beam must be properly centred.
- The DLF must first be lifted slightly, and then moved away from the others.
- Care must be taken to prevent scratches by ensuring that the edge of one DLF does not rub against the surface of another DLF.

#### General notes

- Suction pads must be perfectly clean.
- Any direct contact with hard materials must be avoided.
- Suction pad lifting beams 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 any further manipulation.
- Ensure the safety of personnel at all times. Keep all unnecessary personnel out of the handling area. Wear appropriate personal protective gear.
- Personnel must have received the required training.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.

## **5. Cutting**

*Below are several recommendations that should be complied with when cutting Stratobel glazings :*

- A cut must be made on both sides. The two cuts must be perfectly aligned, one on top of the other.
- Pressure, diameter of the cutting wheel, cutting speed and other parameters must be appropriate for the thickness of each of the sheets.
- The cut must be lubricated using an appropriate oil that is sufficiently volatile and easy to wash off.
- Each sheet must be broken separately and in such a way as to avoid chipping.

- Various techniques can be used to separate the PVB (heating, cutting with a razor blade, etc.). Avoid overheating the edges, as doing so could lead to thermal breakage. Avoid chipping.
- Cut sheets must be separated by a spacer.

#### Working conditions

- Cutting personnel must wear clean gloves.
- All tools, conveyors, etc. that might come into contact with the glass must be kept clean.
- When using templates, special care must be taken to ensure that the templates are clean.

Stratobel consisting of more than two sheets of glass must be cut with a saw.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.

## **6. Shaping**

*Below are several recommendations to comply with when shaping Stratobel glazings :*

- Check that the shaping equipment settings are correct for this type of glass ;
- If a liquid is used during the shaping process, it must be chemically compatible with this type of glass and easy to wash off ;
- AGC recommends carrying out tests before starting the process.

#### Working conditions :

- Shaping personnel must have received the required training and must wear clean gloves ;
- All tools, conveyors, etc. that might come into contact with the glass must be kept clean.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.

## **7. Washing**

Stratobel glazings must be washed with clean water. A small quantity of a mild detergent solution which does not contain any abrasives or acids (specifically chlorine, fluorine or alkalis) may be mixed into the water.

Before washing the glazings, make sure to remove all residue and particles that could scratch the surface of the glass (grains of sand, glass splinters, iron oxides, etc.).

If the glazings are washed in an automatic machine it is important to check regularly the wash water as well as the cleanliness and hardness of the brushes in the washing machine so as to prevent the build-up of abrasives. Doing so will help prevent any damage to the surface of the glass.

Glass must be dried immediately after washing and must be dried thoroughly. AGC recommends regularly checking the filtration quality of the air used to dry the glazings.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.

## **8. Assembly in insulating glazing**

Stratobel glazings can be assembled in insulating glazing. First, however, the glazing must be thoroughly rinsed and dried to prevent any traces of drops on the glass.

There are no special recommendations for the assembly process itself.

For laminated compositions incorporating a coated glass, personnel should also consult the specific recommendations for handling and processing that type of glass.