



Where Custom is Standard

Glass Fabrication Limitations

Any order exceeding these limitations needs to have an 'Exceeding Limitations Sheet' completed, approved and attached to the quote and/or order package.

Weight

Max weight for any one piece is 300 lbs. (or the equivalent of 60 sq. ft. magnetic glass)

Edging

Double Edger:

Minimum Size: 10"

Maximum Size: 142"

Single Edger:

Minimum Size: 4"

Maximum Size: 142"

- * Miters are not available on glass shapes that do not fit on the Single Edger.
- * Tempered/Laminated glass must be edged before tempering and laminating.
- * Float/annealed glass can be edged before or after laminating. To achieve the cleanest edge, it's best to edge the glass after laminating.
- * When edging glass shapes the longest dimension of the glass must not be greater than 8 times the shortest dimension.
- * Glass cannot be edged after heat treating to comply with safety codes.
- * 3mm glass edges cannot be polished only flat ground

	FG	FP	Miter	Pencil	Bullnose
3mm	X				
4mm	X	X			
5mm	X	X	X		
6mm	X	X	X	X	X
10mm	X	X	X	X	X
12mm	X	X	X	X	X
19mm	X	X	X	X	X

X = Edgetype is available on this thickness

Fabrication

- * Hole diameters cannot exceed 1/3 of the narrow measurement of the glass.
- * Cut-outs and notches cannot be more than half the shortest dimension of the glass.
- * All fabrication must be provided by dimensioned drawing or cad file. NO TEMPLATES ARE ACCEPTED.

Radius Corners

CNC - Minimum Inside Radius of 70mm (2.75") for Glass Shapes.

Minimum Outside Radius cannot be less than the thickness of the Glass.

Painting

Float Maximum Size: 60" x 142"

Tempered Maximum Size: 78" x 142"

- * The only tested installation materials are DOW 795 and 995
- * LCBA is only for interior use and never where paint is exposed to foot traffic.
- * All custom color must have an approved control sample.
- * Some colors may require a barrier coat depending on the transparency of the pigments (Ask the lab).
- * Some colors may only be matched on low iron glass. (eg. Starphire)
- * If the textured side of patterned glass is to be painted, it should be a metallic paint or the texture will disappear.

SilkScreening

Pattern Maximum Size: 72" x 130"

Flood Maximum Size: 74" x 142"

- * Ceramic Frit may not be applied to the tin side of glass. This includes the smooth side of acid etched glass.
- * Custom patterns must have an approved sample prior to production.
- * Ceramic frit that is to be back painted after silkscreening must be greencured before tempering.
- * Not all colors can be matched in house.

Tempering

	3mm	4mm	5mm	6mm	10mm	12mm	15mm	19mm
Maximum Size	34 x 76	48 x 96	84 x 120	84 x 142	84 x 142	84 x 142	Call for Info	Call for Info

- * 15mm and thicker, edges must be flat ground or polished before tempering
- * Minimum Size: 18" on diagonal
- * Not all coated glass is temperable, find out before specifying

Laminating

Minimum Size 8" x 8"

EVA/PVB/SGP Maximum size: 84" x 142"

Note: Refer to Edging Section for options on Laminated Glass



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Digital Printing

Diptech Maximum Size: 84" X 142"

UV Printer Maximum Size: 78" X 118"

Additional Information

- 6mm (1/4") Glassboard weight per square foot:
 - Non-Magnetic – 3.27 lbs
 - Magnetic – 5.0 lbs
- Size Limitations based on unfinished sizes; actual finished sizes will be slightly smaller.
- Large projects (small boards) contact Corona Group about 5 square feet minimum rule.
- Decorative Glass and Quick Frost Electrically Switchable Glass Maximum Size: 48" x 120"

END OF DOCUMENT

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