



Cutting instructions

for machine-drawn glasses

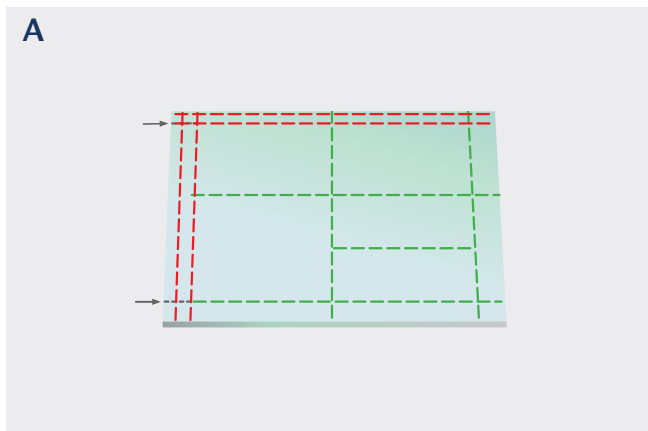
Cutting instructions for machine-drawn glasses

The SCHOTT Restoration Glasses RESTOVER®, RESTOVER® light, RESTOVER® plus, GOETHEGLAS and TIKANA®, as well as the decorative glasses ARTISTA® and RIVULETTA®, are machine-drawn glasses manufactured using the up-draw process. Due to the manufacturing process, the sheets have slightly higher internal stresses (so-called residual cooling stresses) and the following points should be considered when cutting.

Basic information

- Observe the drawing direction of the glass for cutting and yield optimization!
- In the case of glass structure on one side (RIVULETTA®, ARTISTA®), always cut the glass on the unstructured side.
- Bring the glasses to room temperature in time before cutting.

Cutting of rectangular formats from large glass sheets



Always cut the width and height in the same direction as the drawing direction.

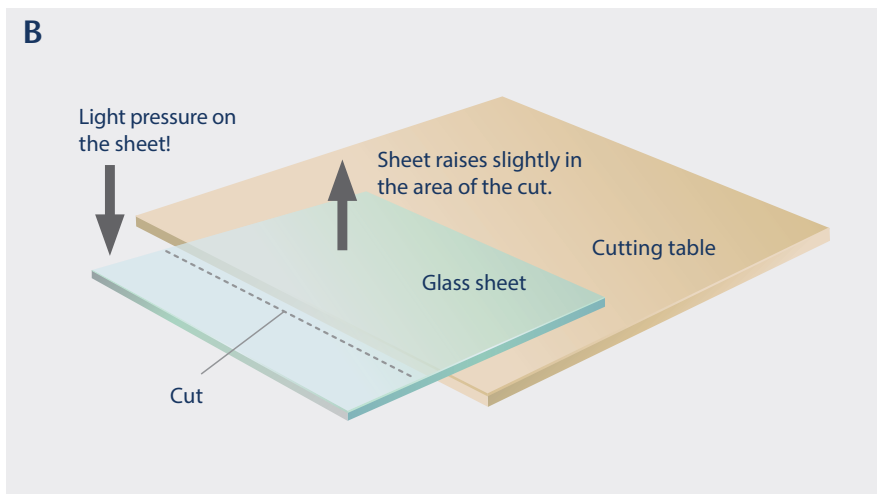
Due to the manufacturing process, machine-drawn glass has a higher residual cooling stress than float glass. To avoid uncontrolled breakage, relief cuts (red dotted lines) are helpful.

In CNC-controlled cutting, the cutting result can be improved by reducing the cutting pressure and cutting speed. The suitable parameters must be determined individually depending on the cutting system, glass thickness and glass format.

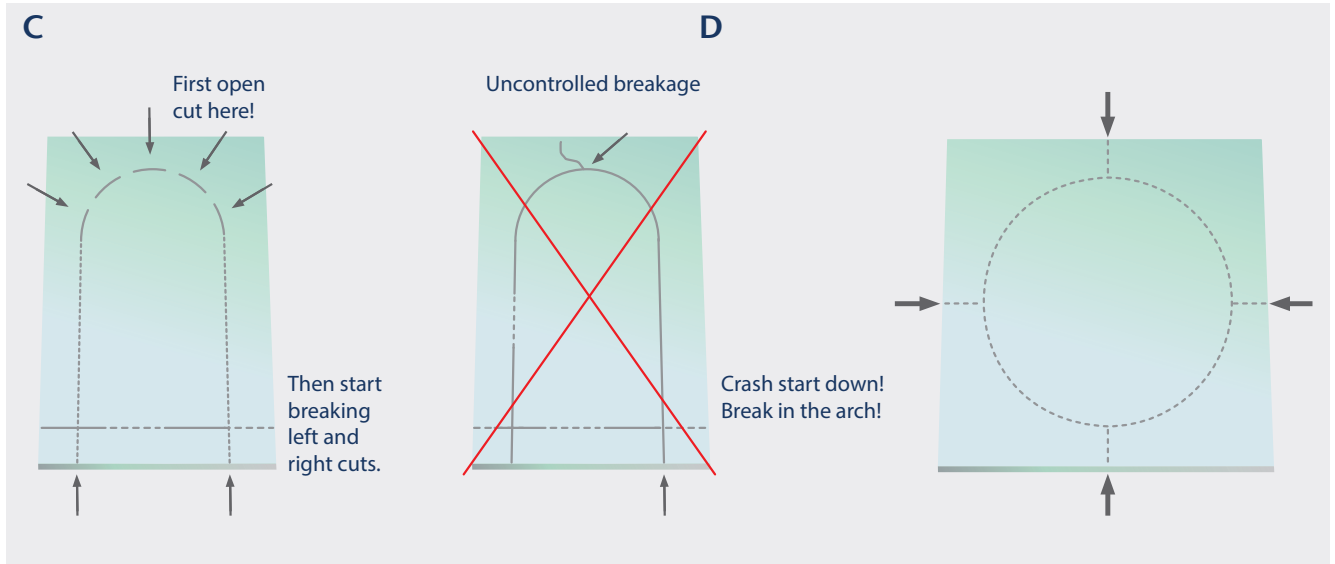
The distance between the relief cuts at the sides and at the top is approx. 30 mm.

Contour cuts and relief cuts can be cut in one step.

First break the relief cuts from the outside to the inside. Then the contour cuts.



Cutting of model glasses

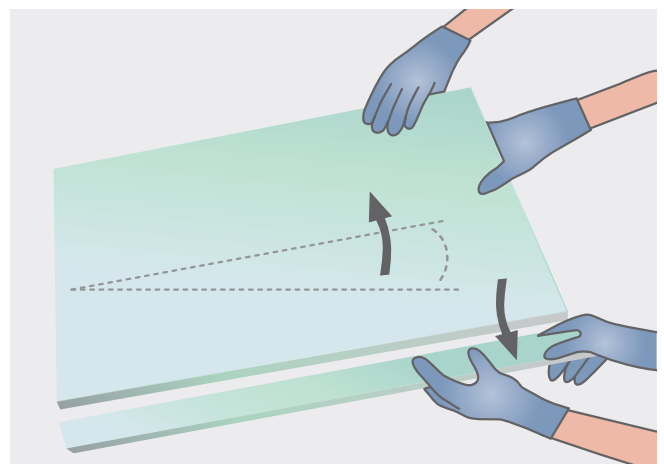
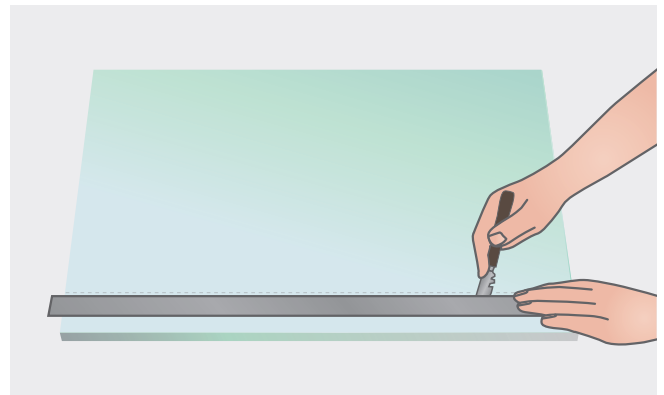


Important when cutting model glasses:

1. Cut a rectangle from the flat glass that is slightly larger than the desired model glass.
2. Always open the cut on the arc first, then press it along the arc again and again, slightly offset, until the cutting line in the entire semicircle is open (picture C).
3. Next crack the strips running straight from the edge.
4. If the model glass is a circle, for example, auxiliary cuts must be made before breaking.

Information on breaking glasses

Machine-drawn glass has slightly higher internal stresses (so-called residual cooling stresses) than float glass due to the manufacturing process. In individual cases, this can cause the crack edge to look unclean, shell out or the crack to run. To ensure a clean crack edge, the scratched glass sheet can be lifted slightly on one side while a second person breaks the glass.





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SCHOTT AG, Hattenbergstrasse 10, 55122 Mainz, Germany
Phone +49 (0)6131/66-2678, info.architecture@schott.com