

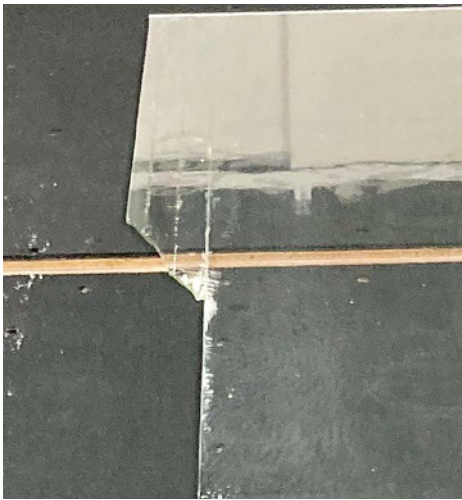
SCHOTT machine-drawn glass

Quick fixes in case of...



Breakage during the machine-scribing process

- Reduce the speed of the cutting machine: 50m/minute max.
- Reduce the contact pressure: reduce by 20% steps, ideally to ~0.85 bar.
- Use a smaller cutting-edge angle, and you will be able to reduce scribing pressure while keeping a proper score.
- Use a structured cutting wheel, and you will be able to reduce scribing pressure even with higher cutting-edge angles.



Undefined breakage of the relief cuts

(break runs to the outer edge)

- Lift the glass during breaking the relief cuts.
- In case of very long cuts, one person lifts the glass while a second person opens the scribe and breaks the parts.



Undefined breakage

(curved ending of the break, lost corners)

- Do not open the score by hand (thumbs on the left and right sides of the score)!
- Do not use breaking bars for long cuts like these.
- Instead, break the glass over the edge of the cutting table.
- Breaking the glass over the edge of the cutting table (as described in figure C of the processing instructions) will result in much better and controlled breakage and edge quality.

