



# neoceram

Cut sizes



# Specifications for Neoceram cut sizes

## 1. Application

This specification is only applicable for flat Neoceram N-0 cut size glass ceramic panels.

## 2. Tolerances

2.1 Thickness  $T=3, 4$  and  $5\text{mm}$   
Allowed deviation  $\pm 0,3\text{mm}$

2.2 Allowed dimensional deviation cutting measure  $\pm 0,75\text{mm}$

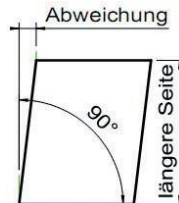
2.3 Allowed distortion (warpage)



- a) Total distortion (warpage) longest side  $\leq 300\text{mm}$   
-> deformation max.  $1,0\text{mm}$   
Longest side  $> 300\text{mm}$   
-> deformation max.  $1,5\text{mm}$   
max.  $0,3\text{mm}$  every  $150\text{mm}$
- b) Partial distortion (warpage)

2.4 Allowed angular deviation

- a) Edge length  $\leq 500\text{mm}$   
-> Deviation max.  $1,0\text{mm}$
- b) Edge length  $> 500\text{mm}$   
-> Deviation max.  $1,5\text{mm}$



The longer side counts as reference for the deviation.

## 2.5 Allowed tolerances for drill holes and drill pattern

### 2.5.1 Drill hole diameter

Drill holes with  $\varnothing \leq 20\text{mm} \pm 0,5\text{mm}$

Drill holes with  $\varnothing \geq 20\text{mm} \pm 1\text{mm}$

### 2.5.2 Drill pattern/position

The allowed deviation of the drill pattern/position is  $\pm 0,5\text{mm}$

## 2.6 Edge processing

### 2.6.1 Arriss

a) Straight cut or ground edges

$0,5\text{mm} \times 45^\circ \pm 0,5\text{mm}$

b) Corner shape arrised edge

-> blunted corners

manual radius  $R=2\text{mm} \pm 1\text{mm}$

-> cut corners

at least  $5\text{mm} \times 45^\circ \pm 1\text{mm}$

-> radius corners

radius  $R=\text{acc.to requirement} \pm 0,5\text{mm}$

c) Corner shape ground edges

-> blunted corners

$2\text{mm} \times 45^\circ \pm 1\text{mm}$

-> cut corners

at least  $5\text{mm} \times 45^\circ \pm 1\text{mm}$

-> radius corners

radius  $R=\text{acc.to requirement} \pm 0,5\text{mm}$

## 2.6.2 Chipping

a) Ground edges

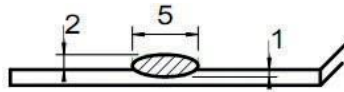
not allowed

b) Arrissed edges

allowed size (picture 2.5.2.b)

-> < 2mm x 5mm x 1mm

-> max. 1 chip/edge



picture 2.5.2.b

## 3. Visual defects

a) Bubbles

- Ø1,0mm or smaller: any number allowable

-> as long as they are not grouped and do not detract from the overall picture.

- Ø 1,01mm to 1,5mm: max. 2 pcs allowed

-> but they have to be at least 300mm away from each other

b) Elongated bubbles

- 0,5mm high x 2,5mm long or smaller: any number allowable

-> as long as they are not grouped and do not detract from the overall picture.

- 0,5mm high x 2,5mm long to 0,8mm high x 5,0mm long: max. 3 pieces allowable
- > but they have to be at least 200mm away from each other

#### c) Stones

- Ø 1,0mm or smaller: any number allowable
- > as long as they are not grouped and do not detract from the overall picture
  
- Ø 1,01mm to 1,5mm: max. 3 pieces allowable
- > but they have to be at least 200mm away from each other

#### d) Devitrifications

- 0,5mm wide x 2,5mm long: any number allowable
- > as long as they are not grouped and do not detract from the overall picture.
  
- 0,5mm wide x 2,5mm to 0,8 high x 5,0mm long: max. 3 pieces allowable
- > but they have to be at least 200mm away from each other

#### e) Stains

- Ø 1,0mm or smaller: any number allowable
- > as long as they are not grouped and do not detract from the overall picture.
  
- Ø 1,01mm to 1,5mm: max. 3 pieces allowable
- > but they have to be at least 200mm away from each other

#### f) Scratches

- Noticeable scratches: 5,0mm or smaller: max. 3 pieces allowable  
-> but they have to be at least 400mm away from each other
- Light scratches: 30,0mm or smaller: max. 3 pieces allowable  
-> but they have to be at least 400mm away from each other
- Fine scratches: allowable
- Concentration of scratches:  $\emptyset$  20,0mm or less: max. 4 pieces allowable  
-> but they have to be at least 400mm away from each other

#### g) Mixture of visual defects

Should a glass panel show several of the above- mentioned visual defects, these defects must not be grouped or detract from the overall picture.

#### h) Visual defects on edges

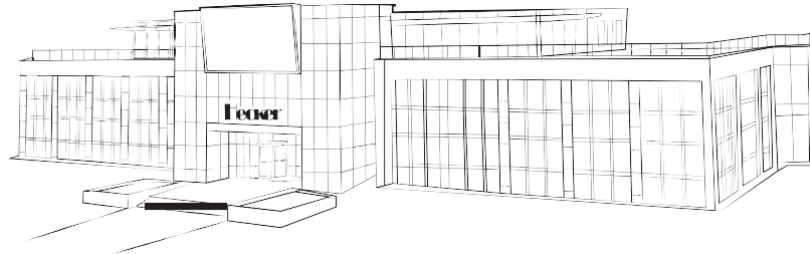
Allowable are defects of any kind as long as they occur within 20mm from the outer edge.

4. Definition „Visual defects“, with reference to item 3ff
- a+b. bubbles
    - round or elongated, gaseous content
  
  - c. stones
    - cloudy, crystalline inclusion in the glass
  
  - d. devitrifications
    - Surface defect, usually transparent and comparable to concave bubbles or holes on the glass surface
  
  - e. stains
    - surface defect, dull (beamless) stain on the surface
  
  - f. scratches
    - incision or lap in the glass
      - > heavy scratches: can be easily felt with a finger nail
      - > light scratches: can be weakly felt with a finger nail
      - > fine scratches: only visible, cannot be felt with a finger nail

The values and data given correspond to our current state of knowledge and are based on empirical values, literature references, measurements or manufacturer data. Not all data have been verified by us or are subject to verification by us. Depending on the test condition, design and installation condition of the glass, the stated values may be exceeded or undershot.

The data listed are for your information only. A legally binding assurance of the suitability of the product for a specific application cannot be derived from this and no liability can be assumed for any damage that may occur.

We reserve the right to make updates and changes without notice.



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