

CNCGLASS

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TECHNICAL NOTE

Attentions for Edging Laminated Glass With EVA Glass Interlayer Film

By Peter Lin

CNCGLASS · Avoid Leaking of EVA Film inside Laminated Glass

The principle of making laminated glass is heating and vacuuming (pressing the glass to squeeze out the air).

When heating, the EVA film melts into liquid, and the EVA film melt index is higher than PVB film. So when vacuuming (the pre-laminated glass is under pressure), the EVA film near the edges of the pre-laminated glass can leak out.

If the EVA film leaks out too much, the edges of the laminated glass may develop bubbles around them.

There are two practical ways to solve this problem in glass processing:

- 1) Use green tape to seal the pre-laminated glass, but make sure you make some small holes on the green tape to help vacuuming.
- 2) If you make small laminated glass, you can put wood bars surrounding the pre-laminated glass. The surrounding wood should be as high as the pre-laminated glass, which helps keep pressure even on the pre-laminated glass.

CNCGLASS · Cooling the Laminated Glass after Heating

If you take the laminated glass out of the silicone vacuum bag too early, the temperature of the laminated glass is still higher than the room temperature. If that temperature gap is too large, the laminated glass may burst, or bubbles may form around the laminated glass edges.

In summer, if the room temperature is higher, you can use a fan to help cool the glass.

In any case, do not stop vacuuming until the temperature of the laminated glass is close to the room temperature.

CNCGLASS · Attentions for Edging Laminated Glass With EVA Film

- 1) Do not edge the laminated glass until the laminated glass with EVA film has been cooled for **24 hours**. Edging too early may cause delamination at the edges of EVA laminated glass.
- 2) It is better to edge the glasses before laminating with EVA film; then you do not have to edge the EVA laminated glass after heating.
- 3) If you laminate with decorative inserts inside the glass, and the decorative inserts easily absorb water, edge the glasses before laminating with EVA film. If you must edge after heating, the decorative inserts may absorb water and lead to delamination.
- 4) Please use a gentle grinding wheel to edge the EVA laminated glass.

CNCGLASS · First In, First Out — Storage of EVA Film

When storing EVA film for laminated glass processing, most EVA film manufacturers will guarantee that the **shelf life** of EVA film for laminated glass is **6 months to 1 years** (also commonly stated as about 1 year).

So when you store the EVA film, remember the “first in, first out” rule. Make sure you use the EVA film you ordered earlier first.

Also make sure you use the EVA film during the shelf-life period. After the EVA film expires, adhesive strength, impact strength, or transparency may decline.



Fig. 1 — EVA film case packing (label: SUPER CLEAR; FIFO storage context)



Fig. 2 — EVA film cartons in crate (use earlier orders first)

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