CNCGLASS

Brand: CNCGLASS

Company: CNC Ucolin Interlayer Technology Co., Ltd.

Address: SHENZHEN, GD, CHINA

Peter Lin | cnc@cncGlass.com | WhatsApp/Mobile +86 15013829504 | WeChat wecan365 | www.cncglass.com

TECHNICAL NOTE

Constraining EVA Film Overflow When Laminating Glass

By Peter Lin · CNC Ucolin Interlayer Technology Co., Ltd.

CNCGLASS · 1. Why overflow appears

Overflow of EVA film after heating is a common problem that EVA laminated-glass manufacturers face. During oven heating under vacuum, EVA softens and can flow toward the perimeter; excess outflow thins the edge adhesive pocket and can leave edge bubbles or an uneven finished edge.

- Keep vacuum active through cooling; industry practice often holds vacuum until glass surface is below about **50 °C** so air does not re-enter while the interlayer is still mobile.

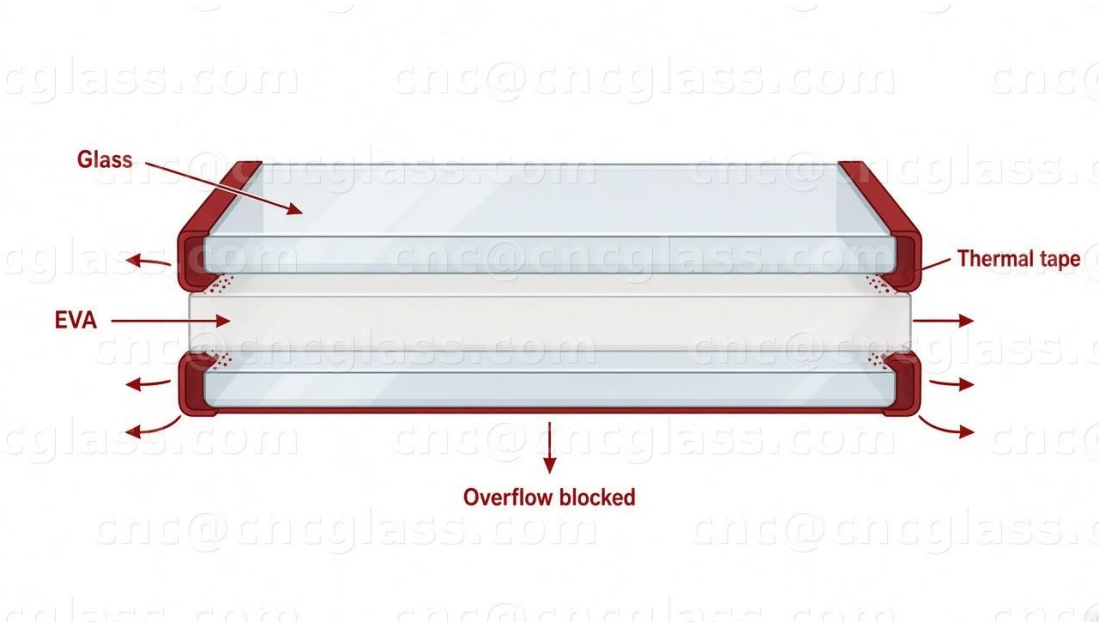

Figure 1 — Principle: thermal tape seals pre-laminated edges to hold back melting EVA overflow.

CNCGLASS · 2. Prevent overflow with thermal tape

Use thermal tape to seal the edges of the pre-laminated glass, which can hold back the overflow of melting EVA film.

High-temperature edge tape is a practical perimeter dam during the heat–vacuum cycle. Choose a grade whose continuous heat resistance exceeds the oven profile used for the interlayer.

- About the thermal tape, you can choose:
- Green Thermal Ribbon Tape for EVA laminated glass processing · continuous heat resistance publicly stated for CNC green tape: **more than 180 °C**
- **150 °C** Brown Thermal Ribbon Tape for EVA laminated glass processing

Figure 3 — Product grades named in the brief: 135 °C Green / 150 °C Brown thermal ribbon tape.

CNCGLASS · 3. Vacuum holes in the tape

Remember to make some holes on the tape to make sure the air can be vacuumed out.

In practice, holes are most useful when sealing would otherwise trap air at corners or edges. If a sealed stack laminates without edge bubbles, holes may be omitted for a cleaner tape line; if corner/edge bubbles appear, add small holes to restore the vacuum path while keeping the overflow dam.

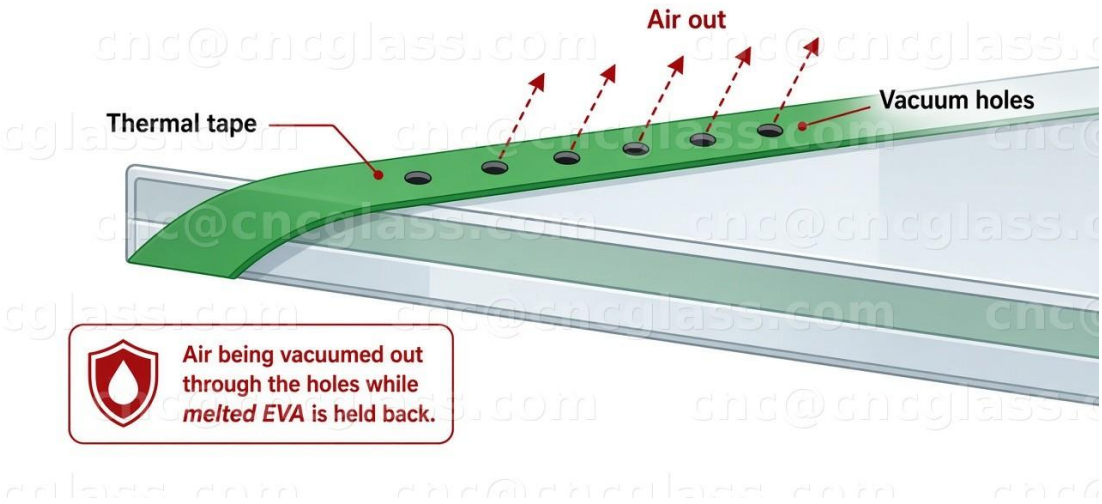

Figure 2 — Vacuum path: small holes in tape allow de-airing while the seal still constrains overflow.

CNCGLASS · 4. If overflow still appears — thermal cutter

If the overflow happens anyway, you can use the Thermal Cutter to remove the overflow EVA film very effectively.

Prevention (tape + vacuum discipline) should come first. Thermal cutting is a remediation step for residual edge overflow after the cycle — use the lowest effective blade set-point and protect the glass faces.

Related product page: www.cncglass.com/thermal-cutter/ · green tape: cncglass.com/green-tape/

Figure 4 — Remediation: thermal cutter removes overflow that still appears after lamination.

CNCGLASS · 5. Practical checklist

- Clean and dry glass edges before lay-up; oil or moisture at the perimeter worsens edge defects.
- Size and place the EVA so the edge adhesive pocket is adequate — excessive squeeze-out is not a substitute for a proper seal.
- Apply thermal tape firmly around the full perimeter of the pre-laminate.
- Decide on vacuum holes based on trial results (cleaner edge vs. de-airing needs).
- Pre-vacuum before full heat rise when the process allows; keep vacuum through cool-down.
- Inspect finished edges; trim residual overflow with a thermal cutter only as needed.

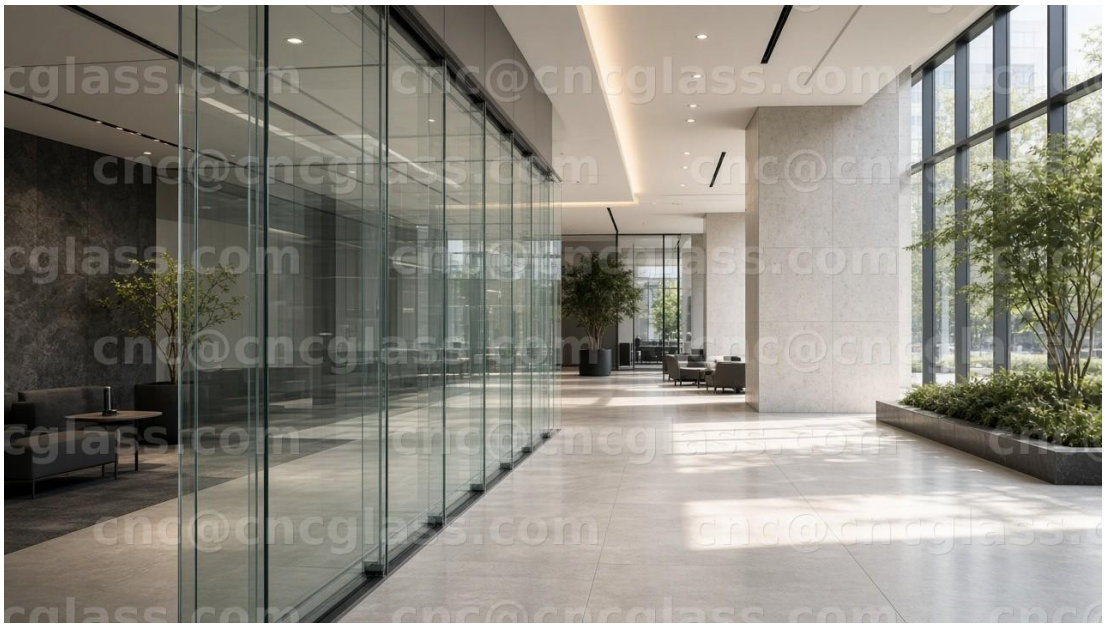

Figure 5 — Application: clean laminated-glass edges on architectural partitions / façades.

CNCGLASS · 6. Notes for reviewers

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