

CNCGLASS

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TECHNICAL NOTE

Delamination Solutions for Processing Laminated Glass with EVA Film

By Peter Lin

Delamination of EVA-film laminated glass is usually a loss of glass–interlayer adhesion. In production and after installation, the most common drivers are incomplete melt and cross-linking, film that is past its usable life, film quality issues, excess moisture, surface contamination (oils, organics, or sweat), wet or heavily inked decorative papers, and incompatible edge sealants. This note lists practical causes and corrective actions for laminated-glass fabricators. Heating settings follow the EVA grade manufacturer's guidance; no numeric process temperatures are stated here beyond the shelf-life note that most EVA film remains usable for about one year or longer, depending on the manufacturer.

CNCGLASS · Causes and Solutions for Delamination in EVA Film Laminated Glass

1. Heating temperature too low or heating time too short

If the heating temperature is not high enough, or the heating time is not long enough, the EVA film may not melt and cross-link completely. An incomplete cross-link reaction leaves weak glass–film adhesion and can lead to delamination.

Solution: Increase the heating temperature or prolong the heating time of lamination, following the EVA film manufacturer's recommended temperature–time window for the specific grade, until melt and cure are complete.

2. EVA film past its shelf life

The EVA film may be past its shelf life. For most EVA films, shelf life is about one year or longer. Different manufacturers may specify different shelf-life periods for their grades.

Solution: Use EVA film within the shelf life stated by the film manufacturer. Do not process film that has expired or that shows clear storage damage.

3. EVA film quality

Delamination may also result from a quality problem in the EVA film itself.

Solution: Send film samples back to the EVA film manufacturer for retesting and confirmation before continuing large-volume production with the same lot.

4. Excess moisture on glass or EVA film

Moisture on the glass or in the EVA film before lamination may be too high. EVA film is generally less moisture-sensitive than some other interlayers, but excessive moisture still harms adhesion and can promote later delamination.

Solution: Dry the glass thoroughly before lay-up, and store EVA film properly—keep unused rolls sealed, cool, and dry, and re-seal opened packaging promptly.

5. Organic or oily residue on the glass surface

Organic substances on the glass surface—especially oily residues—interfere with EVA adhesion and can cause local or edge delamination.

Solution: Clean the glass before lamination when necessary. Suitable cleaning media include clean water, industrial alcohol, or acetone, selected as appropriate for the residue and shop safety rules.

6. Painting papers (PP / PVC) with wet or excess ink

When laminating with painting papers (such as PP or PVC), excess printing ink that has not dried can weaken interlayer bonding and lead to delamination around the decorative insert.

Solution: Dry the printing papers fully before laminating them between glass and EVA film.

7. Edge delamination from oily or sweaty hands

If delamination appears mainly at the edges of the laminated glass, workers' bare hands may have touched the glass edges. Natural oils on the skin reduce EVA adhesion. In summer, heavy sweating can leave moisture and salts at the edge that also harm bonding.

Solution: Require operators to wear clean gloves during lay-up and edge handling. In hot weather, manage sweat carefully so that moisture and skin oils do not contact the glass–film interface at the edges.

CNCGLASS · After Installation — Glass Sealant Compatibility

If delamination appears only after the laminated glass has been installed in a building, check the glass sealant used at the edges or frame. The sealant must be a **neutral** type. Acidic (for example acetoxy-cure) silicones and other incompatible sealants can attack or discolor the EVA interlayer and undermine edge adhesion. Confirm sealant–EVA compatibility with the sealant and film suppliers before installation.

CNCGLASS · Further Assistance

For any other situation, or if you need process guidance on heating and cure, film storage and shelf life, moisture control, glass cleaning, decorative-paper drying, handling discipline, or sealant selection for EVA laminated glass, please feel free to contact us.

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