

CNCGLASS

Brand: CNCGLASS

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CASE STUDY / TECHNICAL NOTE

How to Solve Glass Haze After Lamination

By Peter Lin

A CNCGLASS client laminated fifteen panels in a five-tray oven and found haze only on the panels closest to the oven door, while middle and rear trays stayed clear. This case study records the customer cycle, Peter Lin's diagnosis (uneven oven heat → incomplete EVA reaction), the urgent reheat fix that cleared the haze, and the one-time reheat warning for future runs.

CNCGLASS · Problem

Some panels in a batch of laminated glass showed haze after the oven cycle. The haze was not uniform across the load: panels closest to the oven door were hazy; panels in the middle and rear of the trays were clear.

Customer enquiry (paraphrased): Good Day Peter — We laminated a batch of 15 panels in our 5-tray oven. Panels closest to the door are hazy; middle and rear trays are clear. We need another run today. Please assist.

CNCGLASS · Cycle & Lay-up

Glass makeup: 2 × 8 mm toughened clear glass + 2 × 0.76 mm EVAFORCE EXTREME.

Customer-reported oven cycle (retained as case data):

Stage	Setting
De-air	90 min
Low temperature	60 °C
Low-temperature hold	30 min
High temperature	130 °C
High-temperature hold	60 min
Cooling	180 min

The programmed cycle values above are consistent with common architectural EVA high-stage practice at about 130 °C. In this case the numbers themselves were not the failure mode — heat delivery across the tray was.

CNCGLASS · Diagnosis — Uneven Oven Heat

First: the customer's laminate heating cycle data was correct for the product and lay-up.

Second: the spatial pattern of haze showed that glass temperature was not even. Middle and rear tray positions received more heat energy than the panels closest to the door. The hazy panels had not absorbed enough heat to finish the EVA crosslinking / reaction — incomplete cure appears as haze.

CNCGLASS · Urgent Reheat Solution & Result

Urgent fix: return the hazy laminated glass to the oven and reheat, prolonging the high-temperature 130 °C hold from 60 min to 90 min. Run a small-quantity test first before committing the full batch.

Do not raise the set temperature above about 130 °C in most situations — extend hold time so the under-heated door-zone panels can absorb enough energy to complete the reaction and clear the haze.

Result (customer thank-you): The 90 min high-temperature hold worked and cleared the haze.

CNCGLASS · One-Time Reheat Warning & Long-Term Fix

Critical: reheat usually works only once. A second reheat will not work in most situations. Make full use of the first reheat opportunity — set hold time long enough that the panels finish the reaction in that single pass.

Long-term: ask the laminating-machine supplier to check the oven so heat is even across all tray positions, and every panel sees the same temperature profile — including the door zone.

Solutions can vary by furnace, load density, and glass thickness. Contact Peter Lin (cnc@cncGlass.com) with process doubts on EVA glass lamination — you are welcome even if you are not using EVAFORCE interlayer film.

CNCGLASS · Figures



Figure 1. EVA laminated glass panels (edge view) — typical finished safety glazing stack; archive product photo (overlay contact text softened; watermarked).

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