

CNC MACHINING

Heat Treated Glass Products - Fabrication Guidelines:

1. Hole to Glass Edge Location: The minimum distance from the rim of a hole to the nearest edge of the glass shall be 1/4 inch (6 mm) or twice the glass thickness, whichever is greater. Tolerance for location of hole from specified edge is plus or minus 1/16 inch (1.5 mm).
2. Hole to Hole Location: The minimum distance between the rims of adjacent holes shall be 3/8 inch (9.5 mm) or 2 x glass thickness, whichever is greater. Tolerance for dimension between hole centers is plus or minus 1/16 inch (1.5 mm).
3. Hole to Corner Location: Holes in the vicinity of a corner shall be positioned so that the nearest edge of the hole is a minimum distance from the corner of 6.5 x the glass thickness.
4. Minimum Hole Diameter and Notch Radius: Circular holes shall have a diameter no less than 1/4 inch (6 mm) or equal to the glass thickness, whichever is greater.
5. Notches and cutouts shall have a radius corner greater than the glass thickness. Tolerance of hole diameter is $\pm 1/16$ inch (1.5 mm). Dimensional tolerances of notches and cutouts is $\pm 1/16$ inch (1.5 mm) for glass thicknesses less than 1/2 inch and plus or minus 1/8 inch (3 mm) for glass thicknesses of 1/2 inch (13 mm) or greater.

EDGE POLISHING

1. Code: BMCNCG.
 - a. Name: CNC ground back mitre.
Description: Variable angle ground mitre. Glass is removed on the back surface.
2. Code: BMCNCP.
 - a. Name: CNC high polish back mitre.
Description: Variable angle polish mitre. Glass is removed on the back surface. Use of cerium wheel.
3. Code: BMCNHP.
 - a. Name: CNC high polish back mitre.
Description: Variable angle polish mitre. Glass is removed on the back surface. Use of cerium wheel.
4. Code: BMDTGR.
 - a. Name: Diamond tool ground back mitre.
Description: Variable angle ground mitre. Glass is removed on the back surface.
5. Code: BMDTHP.
 - a. Name: Diamond high polish Back mitre
Description: Variable angle polish mitre. Glass is removed on the back surface. Use of cerium wheel.
6. Code: FLAKSR.
 - a. Name: Belt edge arris.
Description: Diamond belt arrissed.
7. Code: FLASYM
 - a. Name: Asymmetrical chamfer CNC polish.
Description: Used for tempered laminates. Initial CNC polish to size and shape followed by diamond high polish on straight-line single edger.
8. Code: FLCNCG
 - a. Name: CNC flat ground.
Description: Dull edge with a chamfer on each side.
9. Code: FLCNCP
 - a. Name: CNC polish.
Description: Shiny edge with lines parallel to surfaces and chamfers on each side.
10. Code: FLCNHP.
 - a. Name: CNC high polish.
Description: Dull edge with a chamfer on each side.

11. Code: FLDTHP.
 - a. Name: Diamond high polish.
Description: Shiny edge with a chamfer on each side.
12. Code: FLGKSR.
 - a. Name: Belt flat ground.
Description: Diamond Belt flat ground. Some spots remain "as cut".
13. Code: FMCNCG.
 - a. Name: CNC ground front mitre.
Description: Variable angle ground mitre. Glass is removed on the front surface.
14. Code: FMCNCP.
 - a. Name: CNC polish front mitre.
Description: Variable angle polish mitre. Glass is removed on the front surface.
15. Code: FMCNHP.
 - a. Name: CNC high polish front mitre
Description: Variable angle polish mitre. Glass is removed on the front surface. Use of cerium wheel.
16. Code: FMDTGR.
 - a. Name: Diamond tool ground front mitre.
Description: Variable angle ground mitre made on single edger. Glass is removed on the front surface.
17. Code: FMDTHP
 - a. Name: Diamond high polish mitre.
Description: Variable angle polish mitre made on single edger. Glass is removed on the back surface.

**** NOTE TO SPECIFIER ** Delete type not required**