GLASS CORNER DUBBING AND CHAMFERED CORNERS

S-032

GLASS

Introduction

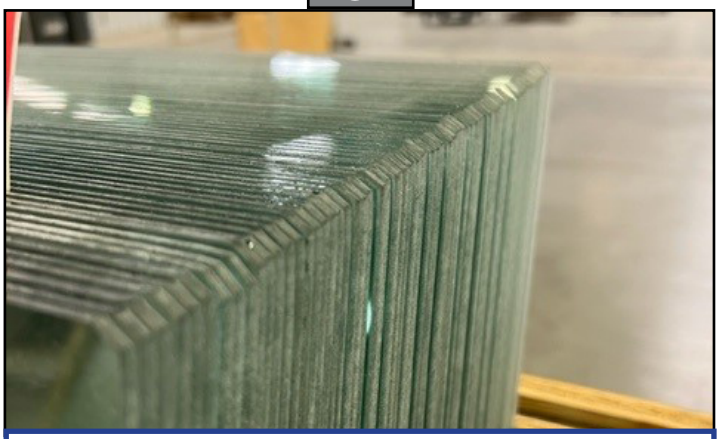
Corner Dubbing is the process of muting or chamfering the sharp 90 degree corner on square edges. Often window manufacturers ask/request dubbed corners because they are wrapping the perimeter of the glass in a soft gasket material with an uncontrolled process. As the gasket material stretches the corner of the glass may penetrate the material and eventually tear further over time affecting the seal between metal and glass.

Corner Dubbing Specifications

On a standard seamed/#4 edge, corner dubbing is not a perfectly defined process. Dubs can range from 1mm in width to 5-6mm in width but maintaining consistency (on a standard seamed/#4 edge) is difficult due to the tolerances on the cut glass. Typically a range of 2-5mm is specified by the customer (Seamed/#4 edge quality glass has dimensional tolerances of +/-2mm.)

The technology deployed at the glass fabrication plant will also affect the aesthetic quality of the dub. If the fabricated glass supplier deploys automated dubbing in a double edger application, the corners will appear more "clipped" or chamfered (Fig. 1). In manual corner dubbing applications, the corners will appear more "rolled" or rounded (Fig. 2).

Fig. 1



Stack of clear glass with a ~5mm automated corner dub. The corners will appear consistent but may fluctuate in width by 1-2mm

Fig. 2

Dubbed/rolled corner on a manual seaming station. The corner of the glass is stabbed into the a dry seaming belt causing more of a "roll" or a burn.

In **Insulated glass products**, Lippert does not guarantee any corner dubbing outcome. Due to the secondary sealing application and overall thickness of an IG, the corner will be muted or softened by default. Every attempt to equally dub all 8 corners will be made but cannot be guaranteed.

In **Laminated glass products**, corners are dubbed pre-assembly and guaranteeing precision accuracy is also difficult. Every attempt to build a functional product will be taken however, if perfect alignment is required, the glass must be specified as a ground/#1 edge.

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