



VISHAKHA SOLAR GLASS (P) LIMITED

SPECIFICATION FOR LOW IRON SOLAR TEXTURED GLASS (Tempered Glass)

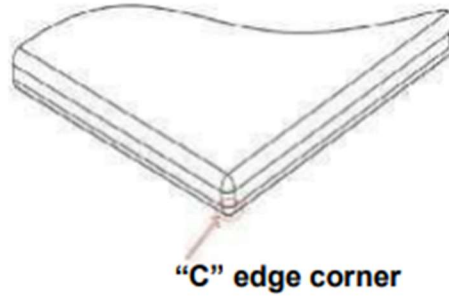
Parameters	Test Method / Standard	Specification	
DIMENSIONS, PHYSICAL AND EDGE QUALITY			
Dimensional (L x W) mm		As per Specified Dimensions	
Dimensional Tolerance (L x W) mm	Measuring Tape	Length: + 1mm, - 1.0mm Width: + 1 mm, -1.0mm	
Nominal Thickness (mm)	Disc Micrometer (ø 20mm)	± 0.2 mm	
Density of Glass	Sink & Float method	2.5 ± 0.0020 gram/cc	
Angularity (maximum difference in diagonal lengths)	Measuring Tape	Maximum 2.0 mm	
Corner Cut (Tape)	Measuring Tape	Min: 1.0 mm, Max: 4.0 mm	
Edge Processing	Visual	C-Edge grinding	
Shells/ Chipping (Max: L x W x D)	Visual / Measuring Tape	Not allowed	
General Bow	EN 12150-1:2015	2.0 mm / meter	
Local Bow	EN 12150-1:2015	Maximum 0.5 mm / 300 mm	
Light Transmittance Tv	EN 410 (D65), 380 – 1100 nm, AM 1.5	≥ 91.5% (Without ARC) ≥ 93.8% (With ARC) Avg 350 ~ 1100 nm wavelength range.	
Fragmentation	--	Fragment Count in 50x50 mm ≥ 40 Nos.	
Surface Roughness Ra Value Avg.	Surface roughness tester from Mitutoyo	0.3 µm ~1.6 µm	
Iron content In Glass (PPM)	AAS	≤ 120 PPM	
GLASS QUALITY			
Test criteria (EN 572 – 5 : 2012 / 5.2.1) The glass pane to be examined is illuminated in conditions approximating to diffuse light and is observed in front of a matt grey screen Place the pane of Glass to be examined vertically 3m in front of parallel to a matt grey screen. Arrange the point of observation 1.5m from the glass, keeping the direction of observation normal to the glass surface.	Spherical bubbles/core/ per m² (Cluster type blister/bubble not allowed)		
	Diameter		Max Allowed
	≥ 0.5 - ≤ 1.0mm		5
	≥ 1.0 - ≤ 2.0mm		2
	> 2.0 mm		0
	Longitudinal bubbles per m²		
Length	>1.5mm - ≤ 5 mm	> 5mm - ≤ 10 mm	>10 mm
Width ≤ 0.5mm	3	1	0
Width > 0.5	0	0	0
Cleanliness	Irremovable dirt is not permitted		
Open Blister	Not permitted		
Cluster	Visual	Cluster not allowed	
Scratches	L≤5 and W≤0.5	5 ≤ L ≤10 and W ≤ 0.5	
	4/sqm	1/sqm	
Edge Defect	L≤10mm, W≤2mm, D≤ 1/3 of the glass thickness, allowed 1 per glass		

Note: In addition to above

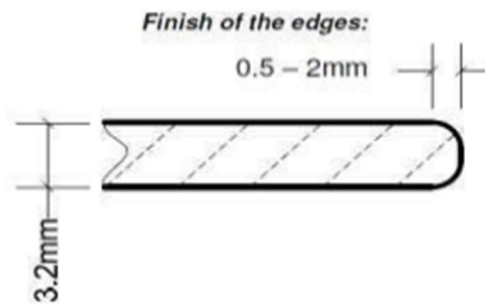
- Micro chipping, Open Bubble, Stone, Crush, Crizzles ,White Speek, Roller Scar , Lines Solid inclusion,Prism aberrations, Surface defect not allowed.
- For defects ($\phi/L > 2mm$), the gap between the defects must be more than 600mm.
- Cluster means Spherical Bubbles are more than 20 nos or Longitudinal Bubbles are more than 10nos within the circle with 100mm diameter.
- Scratches or Inclusion must be not more than 2 nos within the circle with 100mm diameter.

e) Supplier shall provide third party test report for the Young Modulus–70GPa Min and Hardness–6Mohs Scale min or 470 Knoop (intender load 500g) for the glass supplies

Cut Corner:- Min. – 1.0 mm, Max. - 4.0 mm (Sharp edge not allowable)



Edge grinding -C-Edge



Packaging

- There has to be interleaving protective in form of paper
(a) PH should be 6.0 ± 1.0
- Silica gel has to be provided for absorbing moisture. 60 ~ 100 micron polythene to be used for wrapping the sheets fully covered or as per the last supplies delivered, for any material change prior approval is mandatory.