

# TEMPERING GUIDELINE

Sunlux				iplus		Energy	Stopray Smart		Stopray T	
Chroma	Dark Chroma	Shadow	Orion	Solid	AS	Light	Smart 18	Smart 30 Smart 51	Stopray Ace	Vision Titanium

Emissivity (after thermal treatment)	-	0.125	0.064	0.024	0.025	0.046	0.054	0.019		
0Ag	x									
1Ag		x	x				x	x		
2Ag				x					x	x
Can be tempered	x					x		x		
Must be tempered		x	x				x		x	x

## Temperature

Top T° (°C)	680	680	680	680	680	680	680	680	680
Bottom T° (°C)	680	690	690	690	690	690	690	690	690

## Heating time (sec/mm)

Radiative furnaces	45	NO	NO	NO	NO	NO	NO	NO	NO
Medium convective furnaces	40-45	42-47	45-50	52-57	50-55	50-55	52-57	52-57	52-57
High convective furnaces	35-40	40-45	42-47	50-55	45-50	45-50	50-55	50-55	50-55
Convection top	allowed	essential	essential	essential	essential	essential	essential	essential	essential
Convection bottom	allowed	allowed	allowed	allowed	allowed	allowed	allowed	allowed	allowed

## Convection settings\*

Top	Same as for uncoated glass, same thickness	The profile vs time shall be fine-tuned according the glass flatness inside the oven. If concave, increase the pressure. If convex, decrease it
Bottom	Same as for clear float, same thickness	Generally use the bottom convection in order to insure a consistent heating of the bottom surface, at the end of the heating process.
Convection settings depend on:	1. The glass substrate type and thickness 2. The emissivity of the coating 3. The furnace type (radiative, medium or high convective) AGC Obeikan Glass recommends to perform preliminary trials before confirming any order. For further support please contact: Hamza AlNaimat, Technical Support Manger, hamza@agc-obeikanglass.com.sa	