

工程指示 / 要求簡箋 ENGINEER INSTRUCTIONS(E.I.)

工程指示編號:	EI- 6424	修改版本:	-
	HK- 1478.		
工程編號:	J 856	工程名稱:	TSWTL23 天榮
收件人:	生統/Maggie	發件人:	Thomas Wong
工程項目:	玻璃幕牆/趟門/佛沙窗/後裝窗應力測試	日期:	03/07/2023

<input checked="" type="checkbox"/> 原合約工程包	<input type="checkbox"/> 原合約工程加 / 減賬 QT-	<input type="checkbox"/> 新工程報價 QT-
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信件批核號碼/圖紙參考編號:	批核模具圖紙編號:
客戶指示附件:	管理內部批簽署:

<input type="checkbox"/> 初步鋁料 B.M.	<input type="checkbox"/> 加工拆圖, 然後生產	<input type="checkbox"/> 尺寸表
<input type="checkbox"/> 正式鋁料 B.M.	<input type="checkbox"/> 技術上資料/指示	<input type="checkbox"/> 報價
<input type="checkbox"/> 配件 B.M.	<input type="checkbox"/> 樣辦或貨品說明書	<input type="checkbox"/> 分判合約
<input type="checkbox"/> 其他:		

內容: 玻璃應力測試需按BD 要求, 在 TIN side 要放在手到的位置, 請參閱附件
完成上列要求日期: 10/07/2023

國內

<input type="checkbox"/> 生產技術總監	<input type="checkbox"/> 連附件	<input checked="" type="checkbox"/> 技術部	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> 生產部	<input type="checkbox"/> 連附件
<input type="checkbox"/> 採購部	<input type="checkbox"/> 連附件	<input checked="" type="checkbox"/> 生產統籌部	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> 報關組	<input type="checkbox"/> 連附件
<input type="checkbox"/> 質檢部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 會計部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 機械設計部	<input type="checkbox"/> 連附件
<input type="checkbox"/> 香港辦	<input type="checkbox"/> 連附件	<input type="checkbox"/> 其他:			

香港

<input type="checkbox"/> 行政部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 會計部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 統籌部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 工程部	<input type="checkbox"/> 連附件
<input checked="" type="checkbox"/> 採購部	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> QS部	<input type="checkbox"/> 連附件	<input type="checkbox"/> 地盤管理	<input type="checkbox"/> 連附件	<input type="checkbox"/> 維修部	<input type="checkbox"/> 連附件

*發件人簽署: 瑋	*組別成員批核簽署: [Signature]
傳遞編號:	項目經理簽署: [Signature]

4.4 GLASS ASSEMBLIES

4.4.1 Laminated glass

Laminated glass is formed by two or more glass panes bonded by means of an interlayer. The principal materials for the interlayer described in clause 7.4 are films such as polyvinyl butyral (PVB), resin or equivalent. The interlayer usually ranges from 0.38 mm to 6.0 mm in thickness. As described in clause 5.3.3, laminated glass shall be designed with no composite action unless otherwise justified by tests.

Laminated glass can incorporate any of the different glass types and panes with different thicknesses. However, it is recommended to use same glass type and the difference of glass thickness not greater than one thickness grade. The flexibility in the selection of the individual glass panes allows a range of products to be produced with mechanical and optical properties tailored to suit particular applications.

Heat strengthened glass and tempered glass have different amplitude waves on the surface caused by rolling process. In this connection, precaution should be taken to address the risk of separation and delamination by providing sufficient thickness of interlayer. For glass panes with surface treatment applied on the inner surface of the laminated glass, durability tests may be required to examine the quality and durability of lamination.


Glass panes are assembled with an extruded sheet of interlayer between them. The glass assembly is then passed through an oven at about 70°C, from which it passes between rollers that squeeze out any excess air and form the initial bond. The assembly then moves to an autoclave where it is heated to about 140°C under a pressure of about 0.8 N/mm² in a vacuum bag.

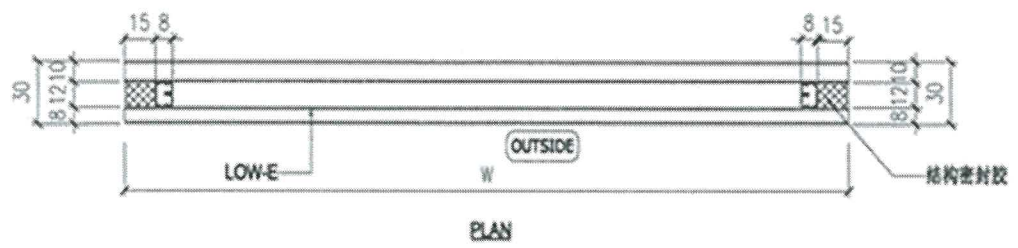
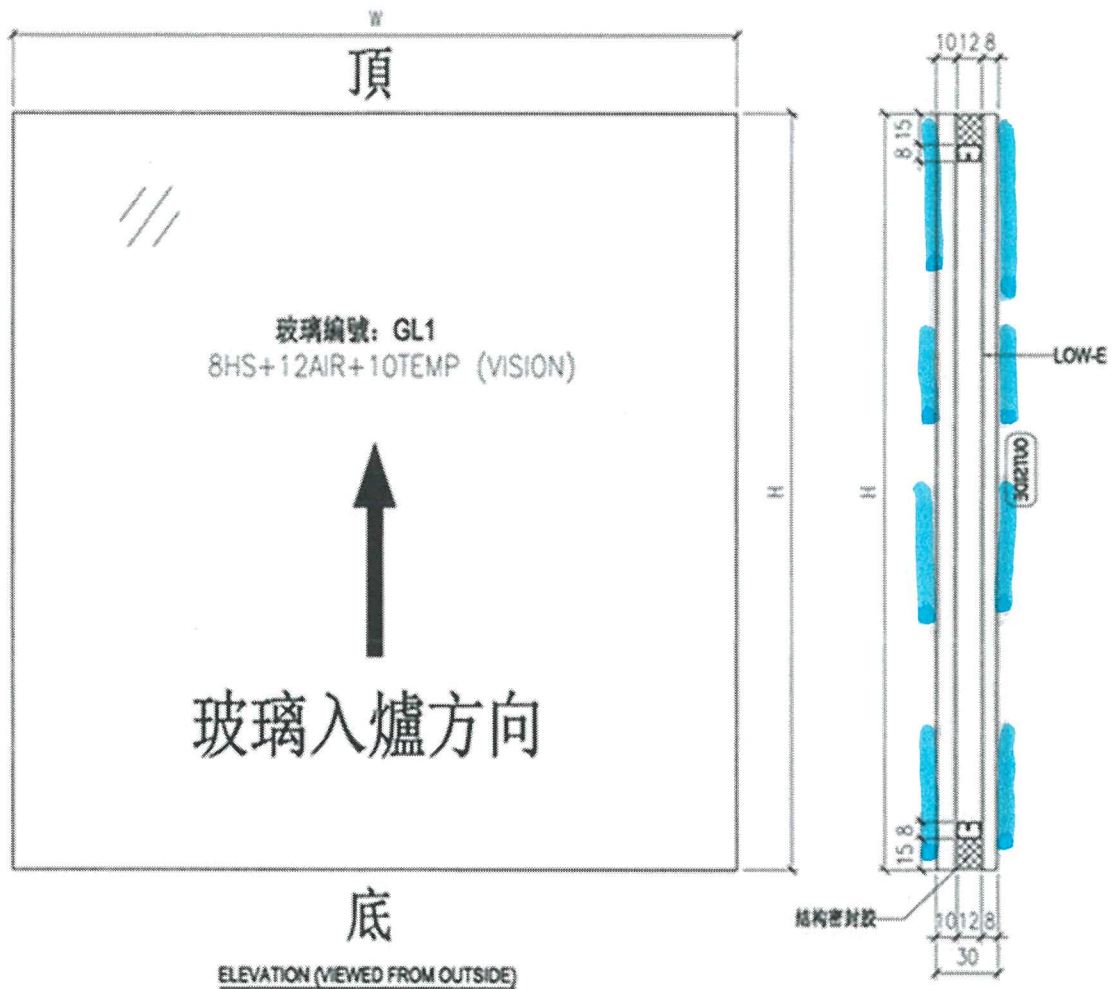
Laminated glass is considered as a safety glass with high reliability, suitable for glass balustrade, as the glass debris is adhered to the interlayer even after breakage. Replacement of damaged laminated glass should be carried out as soon as possible because the entire glass pane may still fall from height. To ensure the lamination quality and minimise the risk of delamination, adequate quality control measures as described in clause 9.2.1 should be implemented. Besides, it is a good practice if the edges of laminated glass are to be protected from direct exposure to weather.

4.4.2 Insulating glass unit

The insulating glass unit (IGU) is formed by two or more panes of glass spaced apart and hermetically sealed to form a single-glazed unit with an air space between glass panes as shown in Figure 4.3. IGU provides better performance in sound and heat insulation. It can further be made to become reflective and low-emissivity (low-E) glass, however the coating at the edge of IGU should be removed to ensure the adhesion of secondary seal. The common form of IGU incorporates spacer bar with desiccant filled, primary seal and secondary seal. Spacer bar shall be made of material compatible with seals and desiccant filled to ensure seal durability to ASTM E2190. Primary seal is of low permeability and serves to minimise water vapour and gas permeating the air cavity between the glass panes of IGU. Secondary seal shall be two-part structural sealant which completely covers spacer with no gaps or voids, continuously bonded to glass. The gap between the two or more panes of glass provides relatively good insulation compared to the normal glass. The gap can be filled by gas, such as hexafluoride, which is a good sound insulator. Tin side of the glass panes should be located on the outermost surfaces of IGU for future surface stress measurement.

例子

 美特鋁質有限公司 MIDI Aluminium Fabricator Ltd.				工程號 J856 地盘 天榮站	類別 制圖 劉燦 復核 徐詳坤 批准 林仁安	物料號 - 日期 2022-10-18 圖號 GL1-F01 數量 - 單件重量 - (KG)	
修改	-	-	採用工廠	✓	圖紙名稱 玻璃加工圖 材料 GLASS		
日期	-	-	材料顏色				



應力量度
 *GASP on TIN side



NOTES
 1. ALL DIMENSION IN mm
 2. ALL EDGE CHAMFER 1x1x45