



Technical Information
edgeprint HT
(eHT)

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1 General

arcon edgeprint HT (eHT) is a black, inorganic-based edge enamel that can be combined with arcon HT coatings and arcon oHT coatings. Enamelling is done by applying and firing a color during the thermal toughening process.

For quality assurance and correct assessment of the products, it is necessary to inform arcon of the **specific area of application and the design and visual requirements** when placing the order.

The use of arcon edgeprint HT on surface 1 (outside) of the glazing or other surfaces that are exposed to external influences is not permitted.

The visual quality is assessed in accordance with the "Guidelines for assessing the visual quality of enamelled and textured coated glass". This is used exclusively to assess the enamelling of the visible area when installed.

The "Guideline for assessing the visual quality of glass for construction" is used to assess the glass.

<https://www.arcon-glass.com/service/technical-information>

2 Production possibilities

The arcon edgeprint HT edge enamel can be combined with the following products in the version as toughened safety glass:

Solar control coatings: sunbelt A HT-Serie, sunbelt D oHT-Serie

Heat control coatings: N34 HT, N10 HT

Minimum glass thicknesses

Solar control coatings: 6 mm

Heat control coatings: 4 mm

Minimum dimension: 380 mm x 380 mm

Maximum dimension: 3210 mm x 6000 mm

Enamel widths

One-sided or on two opposite sides: max. 150 mm

On two adjacent sides, on three sides and all around: max. 60 mm

Other widths on request

For production reasons, we produce all sides that are ordered without edge enamel with edge enamel that is 10 mm wide.

Warping of the edges (edge-dip)

Maximum permissible values for edge-dip: 0,5 mm



3 Properties

Color	black
Gloss level (enamel):	> 40
Mechanical strength (scratch resistance):	> 16 N (depending on the application thickness and firing conditions)
UV-Transmission	0%

4 Further processing

The "Guidelines for processing heat-treated arcon coatings and coated fixed sizes" apply to the processing of arcon edgeprint HT.

<https://www.arcon-glass.com/service/technical-information>

All coated glasses can be stored for five days when packaged. After opening the packaging, the coated glasses can be used within one to two days.

The adhesion of adhesives and sealants to the edge enamel is the responsibility of the processing company. Preliminary tests with original materials must be carried out to ensure adhesion and material compatibility.

Only adhesives and primers may be used that have been tested for bonding to arcon edgeprint HT and for which compatibility or sufficient adhesion has been proven accordingly.

The ability to be bonded must be ensured by the processor's own factory production control (FPC) during production. The relevant known adhesion tests and specifications of the adhesive manufacturer must be carried out. The results must be documented.

The cleaners and primers listed in the sealant manufacturers' processing guidelines must be used.

Before installation, the end product must be stored clean and dry.

When cleaning the project later, aggressive media should be avoided and only pH-neutral and non-abrasive cleaners should be used.

The use of arcon edgeprint HT for structural glazing bonding according to aBG Z-70.1-75 (bonding of enamelled toughend glass, heat-soaked toughend glass and heat strengthened glass with the adhesive DOWSIL 993) **is currently being tested.**

5 Adhesion test results

The adhesion to edgeprint HT edge enamel was randomly tested using a variety of currently available sealants. The tests were carried out in the laboratory of the respective sealant manufacturer.

The following assessments were made on the basis of the laboratory tests carried out. Since we have no insight into the processing parameters, the results do not represent a guaranteed property. In order to assess the interaction of the complex systems in production and application practice, the processor's own tests are essential.

Regardless of the laboratory results stated, the company producing or bonding the insulating glass is responsible for ensuring adhesion to edgeprint HT edge enamel.



Polysulfides	Evaluation of the adhesion
	good
	insufficient

Manu- facturer	Sealant	Cleaning	Bonding agent	Evaluation of the adhesion
FENZI	Thiover	Aceton	Without	N10 HT
FENZI	Thiover	Aceton	Without	N34 HT
FENZI	Thiover	Aceton	Without	sunbelt A HT-Serie
FENZI	Thiover	Aceton	Without	sunbelt D oHT-Serie
Kömmerling	GD 116 (Polysulfid)	Körasolv GL	Without	N10 HT
Kömmerling	GD 116 (Polysulfid)	Körasolv GL	Without	N34 HT
Kömmerling	GD 116 (Polysulfid)	Körasolv GL	Without	sunbelt A HT-Serie
Kömmerling	GD 116 (Polysulfid)	Körasolv GL	Without	sunbelt D oHT-Serie
Kömmerling	GD 116 LV (Polysulfid)	Körasolv GL	Without	N10 HT
Kömmerling	GD 116 LV (Polysulfid)	Körasolv GL	Without	N34 HT
Kömmerling	GD 116 LV (Polysulfid)	Körasolv GL	Without	sunbelt A HT-Serie
Kömmerling	GD 116 LV (Polysulfid)	Körasolv GL	Without	sunbelt D oHT-Serie
Kömmerling	GD 116 NA (Polysulfid)	Körasolv GL	Without	N10 HT
Kömmerling	GD 116 NA (Polysulfid)	Körasolv GL	Without	N34 HT
Kömmerling	GD 116 NA (Polysulfid)	Körasolv GL	Without	sunbelt A HT-Serie
Kömmerling	GD 116 NA (Polysulfid)	Körasolv GL	Without	sunbelt D oHT-Serie



Polyurethanes	Evaluation of the adhesion
	good
	insufficient

Manufacturer	Sealant	Cleaning	Bonding agent	Evaluation of the adhesion
FENZI	Poliver AC	Denatured alcohol	Without	sunbelt A HT-Serie
FENZI	Poliver AC	Denatured alcohol	Without	sunbelt D oHT-Serie
FENZI	Poliver AC	Denatured alcohol	Without	N10 HT
FENZI	Poliver AC	Denatured alcohol	Without	N34 HT
IGK	IGK 130	Aceton	Without	N10 HT
IGK	IGK 130	Aceton	Without	N34 HT
IGK	IGK 130	Aceton	Without	sunbelt A HT-Serie
IGK	IGK 130	Aceton	Without	sunbelt D oHT-Serie
Kömmerling	GD 677 NA (Polyurethan)	Körasolv GL	Without	N10 HT
Kömmerling	GD 677 NA (Polyurethan)	Körasolv GL	Without	N34 HT
Kömmerling	GD 677 NA (Polyurethan)	Körasolv GL	Without	sunbelt A HT-Serie
Kömmerling	GD 677 NA (Polyurethan)	Körasolv GL	Without	sunbelt D oHT-Serie



Silicones	Evaluation of the adhesion
	good
	insufficient

Manu- facturer	Sealant	Cleaning	Bonding agent	Evaluation of the adhesion
DOW	DOWSIL 3363	R-40 Cleaner	Primer 1200 OS	N10 HT
DOW	DOWSIL 3363	Water	Primer 1200 OS	N10 HT
DOW	DOWSIL 3363	R-40 Cleaner	Primer 1200 OS	N34 HT
DOW	DOWSIL 3363	Water	Primer 1200 OS	N34 HT
DOW	DOWSIL 3363	R-40 Cleaner	Primer 1200 OS	sunbelt A HT-Serie
DOW	DOWSIL 3363	Water	Primer 1200 OS	sunbelt A HT-Serie
DOW	DOWSIL 3363	R-40 Cleaner	Primer 1200 OS	sunbelt D oHT-Serie
DOW	DOWSIL 3363	Water	Primer 1200 OS	sunbelt D oHT-Serie
DOW	DOWSIL 993	R-40 Cleaner	Primer 1200 OS	N10 HT
DOW	DOWSIL 993	Water	Primer 1200 OS	N10 HT
DOW	DOWSIL 993	R-40 Cleaner	Primer 1200 OS	N34 HT
DOW	DOWSIL 993	Water	Primer 1200 OS	N34 HT
DOW	DOWSIL 993	R-40 Cleaner	Primer 1200 OS	sunbelt A HT-Serie
DOW	DOWSIL 993	Water	Primer 1200 OS	sunbelt A HT-Serie
DOW	DOWSIL 993	R-40 Cleaner	Primer 1200 OS	sunbelt D oHT-Serie
DOW	DOWSIL 993	Water	Primer 1200 OS	sunbelt D oHT-Serie
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Without	N10 HT
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Sika Aktivator-100	N10 HT
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Without	N34 HT
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Sika Aktivator-100	N34 HT
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Without	sunbelt A HT-Serie
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Sika Aktivator-100	sunbelt A HT-Serie
Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Without	sunbelt D oHT-Serie



Sika	Sikasil IG-25 HM Plus black	Rinsing with deionized water	Sika Aktivator-100	sunbelt D oHT-Serie
Sika	Sikasil SG-500 black	Sika Cleaner P	Without	N10 HT
Sika	Sikasil SG-500 black	Sika Cleaner P	Sika Aktivator-100	N10 HT
Sika	Sikasil SG-500 black	Sika Cleaner P	Without	N34 HT
Sika	Sikasil SG-500 black	Sika Cleaner P	Sika Aktivator-100	N34 HT
Sika	Sikasil SG-500 black	Sika Cleaner P	Without	sunbelt A HT-Serie
Sika	Sikasil SG-500 black	Sika Cleaner P	Sika Aktivator-100	sunbelt A HT-Serie
Sika	Sikasil SG-500 black	Sika Cleaner P	Without	sunbelt D oHT-Serie
Sika	Sikasil SG-500 black	Sika Cleaner P	Sika Aktivator-100	sunbelt D oHT-Serie