

QUALITY STANDARD FOR THE AUTOMOTIVE GLASS

This standard specifies the requirements and limits of allowable defect of the Original sheet glass.

Glass type			F-Green		
Thickness rage			2 mm ~ 6.00 mm		
Thickness deviation	Thickness(mm)		Tolerance(mm)		
	e<4.0		±0.1		
	e≥4.0		±0.2		
Thickness gradient			Tolerance(mm)		
			GB11614: 2022		
Dimension deviation	Length≥3000		Width≤3000		
	+/-2 mm		+/-2 mm		
Thickness gradient			Tolerance(mm)		
			≤0.10		
Verticality			≤1.5 mm/m, Big size less than 4 mm, diagonal less than 4 mm		
Flatness			Tolerance(%)		
			≤0.10		
Surface quality	(scratches,abrasions ,roller marks, lines, tinning, etc.)		No defects can be seen at a distance of 1 meters from the glass plate under normal light		
	Crack		Not allowed		
Optical	Zebra		Thickness≤3.2 mm, Zebra≥45°; 3.2mm<Thickness≤4.00 mm, Zebra≥50 °; Thickness>4.00 mm, Zebra≥55°		
	Wave		Check with defined Zebra, there are no obviously optically distortion		
Non-continuous defect (bubbles, stones, nodules, drop, etc.)	Defect size L(mm)		Allowed number per SQM		
			Windshield	SL BL etc.	
	L<0.3		No aligned or grouped defect	No aligned or grouped defect	
	0.3≤L<0.5		0.5	1	
	0.5 ≤L≤0.8		0.3	0.5	
	0.8<L≤1.0		0	0.3	
	L>1.0		0	0	
Rainbow	Before tempering, no rainbow allowed				
Shelf life	Within 6 months after delivery date, it is not accepted that the glass is with mildew, which will causes cleaning problem or printing problem.				
Tin side mark	One the first piece glass,s corner of each package, paste with “Tin side” marke				
Ream index	(For windshield) ≤ 3.0				
Optical technical data	Refer to Appendix 1<optical technical date specification>				
Others	Other items not mentioned follow GB11614-2022				
Optical technical data	Thickness(mm)	Visible light transmittance (%)	Color space		
			L*	a*	b*
	2.2	85.3±1.5%	94±0.4	-3.25±0.4	0.54±0.4
	2.5				
	3.2				
4.0					