

**SCHOTT**  
glass made of ideas

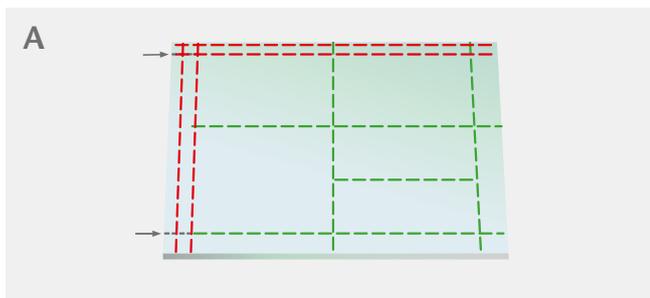
Cutting instructions  
for machine-drawn  
glasses

# Cutting instructions for machine-drawn glasses

The SCHOTT Restoration Glasses RESTOVER®, RESTOVER® light, RESTOVER® plus, GOETHEGLAS and TIKANA®, as well as the decorative glasses ARTISTA® and RIVULETTA®, are machine-drawn glasses manufactured using the Fourcault

up-draw process. Due to the manufacturing process, the sheets have slightly higher internal stresses (so-called residual cooling stresses) and the following points should be considered when cutting.

## Cutting of rectangular formats from large glass sheets



Observe the drawing direction!

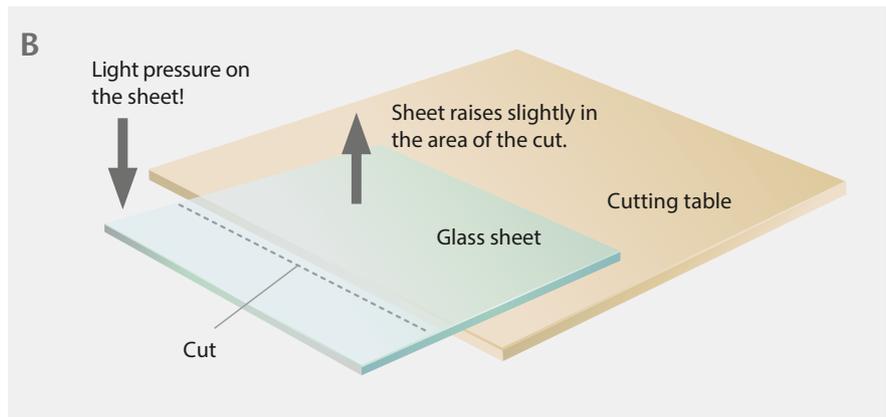
Always cut the width and height in the same direction as the drawing direction.

Due to the manufacturing process, machine-drawn glass has a higher residual cooling stress than float glass. To avoid uncontrolled breakage, relief cuts (red dotted lines) are helpful.

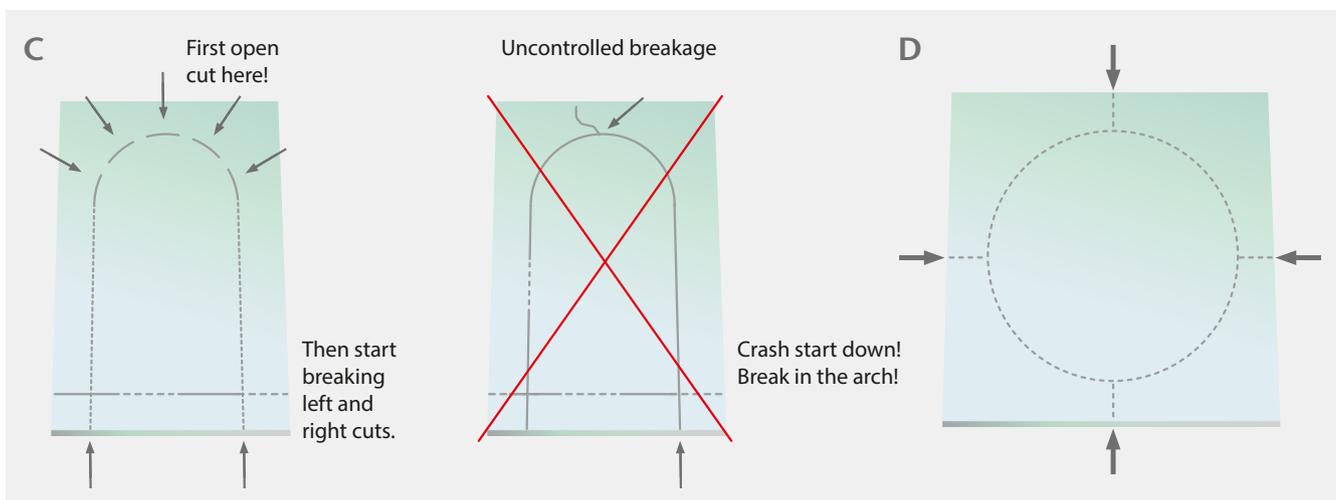
The distance between the relief cuts at the sides and at the top is approx. 30 mm.

Contour cuts and relief cuts can be cut in one step.

First break the relief cuts from the outside to the inside. Then the contour cuts.



## Cutting of model glasses

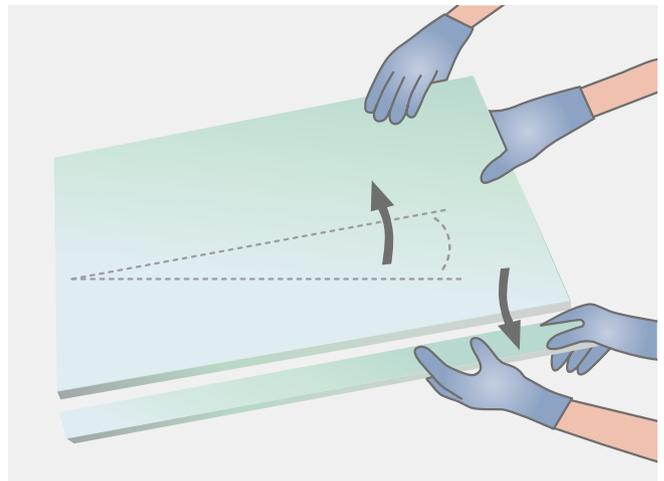
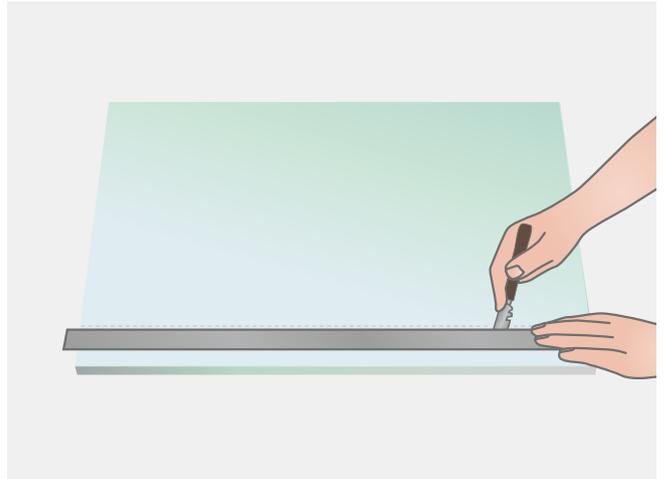


### Important when cutting model glasses:

1. Cut a rectangle from the flat glass that is slightly larger than the desired model glass.
2. Always open the cut on the arc first, then press it along the arc again and again, slightly offset, until the cutting line in the entire semicircle is open ( picture C).
3. Next crack the strips running straight from the edge.
4. If the model glass is a circle, for example, auxiliary cuts must be made before breaking.

### Information on breaking glasses

Machine-drawn glass, which was drawn using the Fourcault process, has slightly higher internal stresses (so-called residual cooling stresses) than float glass due to the manufacturing process. In individual cases, this can cause the crack edge to look unclean, shell out or the crack to run. To ensure a clean crack edge, the scratched glass sheet can be lifted slightly on one side while a second person breaks the glass.



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