CNCGLASS
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Regular Fogging Defects in SGP Laminated Glass

A veil that copies itself from pane to pane

In the case under discussion, every lite showed a fog-like defect in exactly the same position, with a nearly identical outline. The outer surface was polished, which ruled out a mark on the face, and the scatter was confirmed to sit inside the glass. A repeating shape of that kind is not random dirt. It is a process signature, and it appeared on a batch that had to be reworked under a tight delivery.



Figure 1. A fog that repeats in the same place and outline is a process signature: confirm it is internal, open the load, and cool with a controlled, adequately rapid rate.

Autoclave settings, not a blind second heat

A regular internal veil in SGP laminated glass is closely tied to autoclave parameters and to how the chamber is used: processing temperature, hold time, cooling rate, how many plates are loaded, and how they are spaced. The useful response is not an unplanned extra cycle on the same crowded rack. The hold and the loading pattern should be corrected first, then the defective plates can be re-processed with those corrections in place. In this case, that directed rework brought the glass to the required standard and allowed the delivery to be met.

Two rules that prevent most repeats

When loading, leave enough space for air to circulate freely around every face. Treat that gap as a quality setting, not as wasted chamber volume. And control the cooling rate so that it is not slower than 3.3 degrees Celsius per minute. A sluggish cool lets residual moisture and volatiles redistribute before the bond is locked; an adequately rapid, repeatable cool-down, with an open load, is one of the more reliable preventions we know for this repeated internal veil.

A fog that repeats in the same outline is a map of the autoclave. Confirm that it is internal, open the load, set a proper hold, and cool at no less than 3.3 degrees Celsius per minute before you rework the plates. That is how a tight delivery can still be met without printing the same veil a second time.

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If SGP laminates show a repeated internal veil, we can help review loading, hold, and cooling practice and a controlled rework path.