

Job Procedure

Glass Cutting

Tools/Equipment Required: Glass Cutter, Glass Pliers,
Square, Straight Edge, Clamp
Small Suction Cup (for straight edges)

Materials Required: Cutting Oil (Solvent & 20% Oil)

Steps:

1. Must wear required personal protective equipment (PPE). (Boots, Glasses)
2. Cutting 2mm & 3mm are very brittle so a new cutter should be used.
3. 5mm & 6mm are much softer so a dull cutter works well. The thicker the glass the duller the cutter.
4. When cutting 15mm & 19mm you may require a special angle on the cutter wheel 134 to 142 degrees. This produces a cut that is not very deep and this gives less chance of running out.
5. The table should be swept clean of any glass chips before a sheet is put down.
6. If used glass is being cut it should be cleaned first.
7. New glass from a block or crate should be clean enough to cut.
8. The cutter scoring the surface of the glass will be hot, so oil is used as a coolant. The oil should be thin enough to flow freely.
9. If any easy cut is being made, just dip the cutter and score.
10. If you are shape cutting, apply oil with a brush to the cutting area.
11. When scoring the glass surface your pressure should be light as possible but heavy enough to prevent skipping.
12. A straight cut is broken by hand, pliers, or sliding the straight under the glass center of the score.
13. Shape cutting can be run by pressing the opposite side of the score or by tapping the cut with a pointed object to start it.
14. Shape cutting when the cut is fully ran out, some relief cuts are necessary to remove cut off pieces.
15. Heavy glass cutting is basically the same as other glass, but is very important to always use plenty of oil and old dull cutter.
16. Be sure to grind all flares (if any) off the edges before doing edge work on machine.