

Title (en)

NOVEL LAMINATION PROCESS TO PRODUCE LAMINATED VACUUM INSULATING GLAZING ASSEMBLY

Title (de)

NEUES LAMINIERUNGSVERFAHREN ZUR HERSTELLUNG EINER VAKUUMISOLIERVERGLASUNG

Title (fr)

NOUVEAU PROCÉDÉ DE STRATIFICATION POUR PRODUIRE UN ENSEMBLE VITRAGE STRATIFIÉ ISOLANT SOUS VIDE

Publication

**EP 4326551 A1 20240228 (EN)**

Application

**EP 22723638 A 20220420**

Priority

- EP 21169721 A 20210421
- EP 2022060369 W 20220420

Abstract (en)

[origin: WO202223586A1] The present invention concerns a process for the production of a laminated vacuum insulating glazing assembly (1) that comprises at least one vacuum insulating glazing (2), at least one interunit polymer (3) and at least one functional unit (4); that have been made separately. The functional unit has been produced at a processing pressure (PP) from 5.5 bar to 15.0 bar ( $5.5 \text{ bar} \leq PP \leq 15.0 \text{ bar}$ ). The process for the production of a laminated vacuum insulating glazing assembly (1) that complies with the High Temperature Test of the norm ISO12543-4:2011; comprises at least the following steps :1) Stacking the vacuum insulating glazing (2), the interunit polymer (3) and the functional unit (4); thereby creating a pre-assembly; 2) Inserting the pre-assembly into a vacuum ring or vacuum bag; 3) Processing the pre-assembly into a laminated VIG assembly by at least the following sub-steps:a. Evacuating to a vacuum of minus 0.1bar to minus 1bar, preferably minus 0.5bar to minus 1bar, within the vacuum ring or vacuum bag, b. Heating the pre-assembly to a temperature ranging from 50°C to 200°C, preferably from 75°C to 175°C, more preferably from 90°C and 150°C.c. Pressurizing the pre-assembly under an overpressure (OP) equal to or lower than 4.5bar ( $OP \leq 4.5 \text{ bar}$ ); and 4) Releasing the evacuation 3)a), the heating 3)b) and the overpressure 3)c).

IPC 8 full level

**B32B 17/10** (2006.01); **B32B 27/32** (2006.01); **E06B 3/66** (2006.01); **E06B 5/16** (2006.01)

CPC (source: EP)

**B32B 17/10055** (2013.01); **B32B 17/10091** (2013.01); **B32B 17/10137** (2013.01); **B32B 17/10165** (2013.01); **B32B 17/10311** (2013.01); **B32B 17/10761** (2013.01); **B32B 17/1077** (2013.01); **B32B 17/10788** (2013.01); **B32B 17/10844** (2013.01); **B32B 17/10871** (2013.01); **B32B 17/1088** (2013.01); **B32B 17/10972** (2013.01); **B32B 27/325** (2013.01); **E06B 3/6612** (2013.01); **E06B 3/6775** (2013.01); **B32B 2307/102** (2013.01); **Y02B 80/22** (2013.01)

Citation (search report)

See references of WO 202223586A1

Designated contracting state (EPC)

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)

BA ME

Designated validation state (EPC)

KH MA MD TN

DOCDB simple family (publication)

**WO 202223586 A1 20221027**; EP 4326551 A1 20240228; JP 2024516143 A 20240412

DOCDB simple family (application)

**EP 2022060369 W 20220420**; EP 22723638 A 20220420; JP 2023564107 A 20220420