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(11) Publication number:

**0 389 706 A3**

(12)

## EUROPEAN PATENT APPLICATION

(21) Application number: **89305744.8**

(51) Int. Cl.<sup>5</sup>: **E06B 3/66**

(22) Date of filing: **07.06.89**

(30) Priority: **30.03.89 US 335683**

(43) Date of publication of application:  
**03.10.90 Bulletin 90/40**

(84) Designated Contracting States:  
**AT BE DE FR GB SE**

(88) Date of deferred publication of the search report:  
**02.10.91 Bulletin 91/40**

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(54) **Method and apparatus for producing gas-containing insulating glass assemblies.**

(57) A method and apparatus for producing multi-pane glass units having a non-air gas in the interpane space. A plurality of insulating glass units (70) is assembled, each unit comprising a pair of glass panes (72) and a peripheral spacer (74). A separator (110) is placed between the panes of each unit to space them from one another, providing an opening therebetween. Once the units (70) are assembled, they are placed in a vacuum chamber (10) and a vacuum is drawn to remove air from the interpane spaces. The chamber (10) is then refilled with the desired gas (e.g., argon), and the separator means is removed from each of the units (70), allowing the units (70) to close, sealing the interpane space of each glass unit (70). The units (70) are then removed from the vacuum chamber (10).

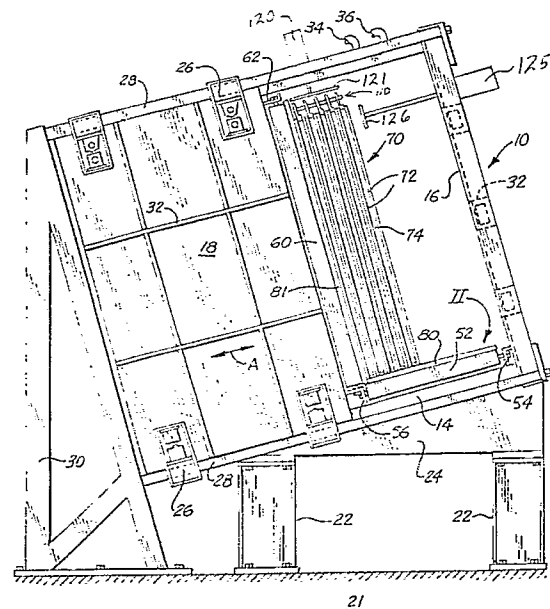


Fig. 2

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## EUROPEAN SEARCH REPORT

Application Number

**EP 89 30 5744**

DOCUMENTS CONSIDERED TO BE RELEVANT					
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)		
D,A	US-A-4 780 164 (E.W. RUECKHEIM et al.) * whole document * - - -	1,9-13	E 06 B 3/66		
D,A	US-A-4 369 084 (P. LISEC) * figure; column 2, lines 64-68 * - - -	1			
A	EP-A-0 056 762 (SAINT-GOBAIN VITRAGE) * whole document * - - - - -	1,10-13			
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)		
			E 06 B		
The present search report has been drawn up for all claims					
Place of search Berlin		Date of completion of search 19 July 91	Examiner KRABEL A.W.G.		
<table><tr><td><b>CATEGORY OF CITED DOCUMENTS</b> X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention</td><td>E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons ----- &amp;: member of the same patent family, corresponding document</td></tr></table>				<b>CATEGORY OF CITED DOCUMENTS</b> X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention	E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons ----- &: member of the same patent family, corresponding document
<b>CATEGORY OF CITED DOCUMENTS</b> X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention	E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons ----- &: member of the same patent family, corresponding document				