TROSIFOL®
PUMMEL TEST
STANDARDS

English
PUMMEL STANDARD 2
PUMMEL DEFINITION

Ref.: U.S. Patent 4,144,376 - R. Beckmann et al.
PUMMEL PROCEDURE FOR LAMINATES WITH SENTRYGLAS® IONOPLAST INTERLAYER

- Testing is done at room temperature (22 °C or 72 °F). Allow laminate to equilibrate to room temperature.

- Pummel on an anvil flat at a 0° angle with a flat headed hammer of 0.5 kg (16 ounce).

- Hit in a row at 1.25 cm (½ inch) intervals, use an interval of 2 cm (¾ inch) in between the rows.

- Compare the pummeled laminate to pummel standard pictures.
PROCEDURE

PUMMEL PROCEDURE FOR PVB LAMINATES

- Cool a laminate for 3 hours at −18 °C (0 °F).
- Pummel on an anvil at a 5° angle with a flat headed hammer of 0.5 kg (16 ounce).
- Hit in a row at 1.25 cm (½ inch) intervals, use an interval of 2 cm (¾ inch) in between the rows.
- Let the pummeled laminate condition (till dew is evaporated) and compare to pummel standard pictures.
CORRELATION OF PUMMEL TO CSS FOR PVB LAMINATES

Y = 0.002x - 0.0044

Correlation is valid for B550 PVB
CORRELATION PUMMEL/CSS TO BALL DROP PERFORMANCE FOR PVB LAMINATES

Height and deviation of the maximum plateau of this curve depends on laminating process conditions, glass thickness, ...

Optimal adhesion for Automotive

ECE R43 minimum Break Height
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