



NATIONAL GLASS
DISTRIBUTION

Manufacturing Tolerances

Double Glazed
SIG Units



All **Warm Edge Double Glazed SIG Units** manufactured by National Glass will conform to the following tolerance specifications:

Dimensional Tolerances:

Length: +/- 3mm

Width: +/- 3mm

Diagonal: 4mm up to 2000mm longest dimension. Increases by 1mm per 1000mm or part thereof

Overstep: Maximum of 3mm as all units should have 1 square corner and overstep will be as a result of allowable dimensional tolerances

Flatness:

Overall Bow: 3mm per 1000mm as per EN 12150

Roller-Wave: 0.5mm per 1000mm as per EN 12150 (Applies to toughened glass only)

Edge Quality:

Outer pane: Chips and shells up to 2mm diameter are permitted

Inner pane: Chips and shells up to 3mm diameter are permitted

Spacer:

Primary : Warm Edge Spacer – not suitable for structural applications

Secondary: 2 Part silicone mixture with no visible voids and a depth of 4-6mm (Structural units will have a calculated silicone contact depth of > 6mm depending on the wind load)

Visual Inspection:

Distance: Viewed at 90° to its surface from 3m against an evenly lit background from an internal perspective (no direct sunlight)

Surface: Scratches longer than 75mm are not allowed

Stains: Spots, bubbles and pinholes >3mm are not allowed

Marking: The outer pane will be marked 50mm in from the edge of the bottom left corner to identify the manufacturer. If safety glass is required, an additional mark will be visible in accordance with SANS 1263 – 1