Inspection criteria for Spot Faults in accordance with SANS 50572 – 8

Spot Fault (Float Glass) is defined as a small, usually round imperfection in the glass that appears as a dot, speck or bubble, sometimes surrounded by a slightly distorted or blurry area. This defect occurs during the glass manufacturing process.

Please note the following extracts from SANS 50572 – 8
(**Glass in building - Basic soda lime silicate glass products Part 8: Supplied and final cut sizes**)

The tables below show the maximum number of faults per pane of glass depending on the glass sizes and size of spots or fault. Please note the different quantities for different sizes of the panels.

A Spot fault of size between 0.6mm and 1.5mm – No limitations

B Spot fault of size between 1.5mm and 3mm – Panel size less than 5m² allows for 1 spot fault

C Spot fault of size between 3mm and 9mm – Panel size less than 5m² No spot faults allowed

D Spot fault of size greater than 9mm – Not allowed irrespective of the size of the panel

6.3.2.3 Spot faults for final cut sizes

6.3.2.3.1 General

The allowable levels of spot faults, in final cut sizes, are dependent on the specific product type and are detailed below.

6.3.2.3.2 Float glass

The allowable numbers for each of the categories of faults (see Table A.1), are shown in Table 16.

Table 16: Acceptance levels for spot faults in final cut sizes of float glass

Category of fault	Surface area of pane (S)		
	S ≤ 5 m²	5 m² < S ≤ 10 m²	10 m² < S ≤ 20 m²
A	No limitation		
B	1	2	4
C	Not allowed	1	1
D	Not allowed		

[a] The minimum distance between category B faults shall be not less than 500 mm.

A.1 Float glass (EN 572-2:2012)

A.1.1 Method of observation

A spot fault consists of a nucleus which is generally accompanied by a halo. The categories of spot faults are defined by the maximum dimension of the spot fault, measured according to the method defined in Annex B.

Note the number of spot faults and the biggest dimension of the halo generated by the nucleus and relate to the four categories of spot faults as shown in Table A.1.

Table A.1: Categories of spot faults

Dimensions in millimetres

Category	Dimension of spot fault
A	> 0,6 and ≤ 1,5
B	> 1,5 and ≤ 3,0
C	> 3,0 and ≤ 9,0
D	> 9,0