



MANUFACTURING SPECIFICATIONS

INSULATING GLASS

ANNEALED, COATED AND HEAT TREATED INSULATED GLASS

	MINIMUM SIZE	MAXIMUM SIZE	OVER SIZE MAXIMUM
Annealed Insulated	8" x 20"	84" x 144"	96" x 144"
Heat Treated Insulated	8" x 20"	82" x 142"	82" x 142"
For units over 50 square feet or under the minimum size a technical review is required			

Insulating glass units are certified in accordance with IGMA certification requirements, (Insulating Glass Manufacturers Alliance. Triple Seal Ltd meets ASTM E 2190 as well as CGSB 12.8

IG THICK PER MM	MAXIMUM SQ FT	IG THICK PER MM	MAXIMUM SQ FT
3 on 3	15	4 on 6	28
3 on 4	15	5 on 3	15
3 on 5	15	5 on 4	28
3 on 6	15	5 on 5	40
4 on 3	15	5 on 6	40
4 on 4	28	6 on 6	66
4 on 5	28	6 on 8	66

GUIDELINES FOR COATED GLASS INSPECTION (ASTM C 1376).

- **Pinholes**-Inspect glass from a distance of 10 ft. (3 m) in transmission, at a viewing angle of 90° to the specimen, against a bright uniform background. If a pinhole is readily apparent, the following criteria apply: Pinholes larger than 1/16" (1.6 mm) in diameter are not allowed in 80 percent of the central glass area. Pinholes larger than 3/32" (2.4 mm) are not allowed in the outer 20 percent of the glass area. No more than two readily apparent blemishes are allowed in a 3" (75 mm) diameter circle and no more than five readily apparent blemishes are allowed in a 12" (300 mm) diameter circle.
- **Uniformity**-When viewing coated glass from a minimum distance of 10 ft. (3 m), color variation may occur from one unit to another. This can be caused by variations within the float glass substrate and normal production variations, and this is not considered a defect.
- **Distortion**-Various factors involved in heat processing, insulating air spacers and frame binding may distort reflected objects viewed on the glass surface. These are not considered defects of the coated glass or the final fabricated product.
- **Scratches**-Inspect glass from a distance of 10 ft. (3 m). Scratches up to 2" (50 mm) are allowed in 80 percent central glass area, and scratches up to 3" (75 mm) are allowed in the outer area. Concentrated scratches or abraded areas are not allowed.