

# **TECHNICAL SALES BULLETIN 028**

13th October 2021

## **Edge Quality of Processed Glass**

### **Monolithic Safety Glass Edges**

Depending on the final position/application of the glazing, specific glass edge finishes may be required. Below are some typical examples.

#### **No Edge Finish**

As Cut (Risk of cuts to person when being handled)



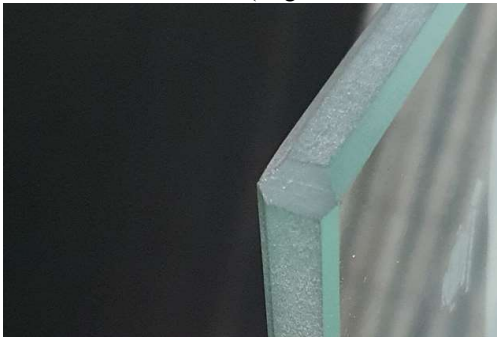
#### **AAR**

Arrised All Round (Also referred to as Seaming)



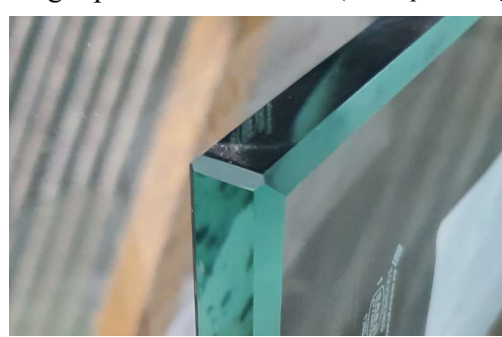
#### **PAR**

Polished All Round (Edge are Bevelled And Ground)



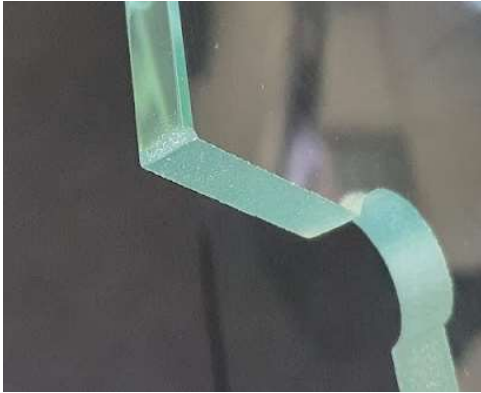
#### **BPAR**

Bright polished All Round (For exposed edges)

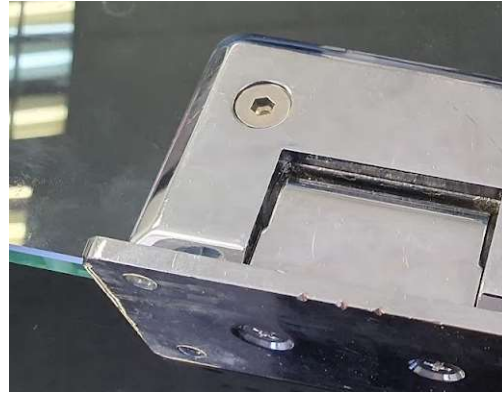


Areas where the glass edges is concealed by framing or hardware components more leniency is allowed. These edges are not exposed once fitted and in final position.

Smaller chips, reworked edges, waterjet cut, arrised/seamed, or polished edges are acceptable in concealed applications or in non-critical areas (bottom edge of balustrade in channel, reworked corner for concealed edge in frame/hardware)



Glass Edge Exposed



Glass Edge Inside Fitting (Concealed)

### **Laminated Safety Glass Edges**

In addition to above glass edges, Laminated Safety Glass has the addition of a PVB, EVA or similar Interlayer that has it's own set of tolerances/allowances as listed below.

#### **Mismatch of glass panes**

2mm on two adjacent edges and a maximum of 4 mm on the other two edges.

#### **Spot Defects -**

- > 3mm - Inside dirt greater than 3 mm is not permitted
- > 1.5mm - Pinholes greater than 1.5mm are not permitted
- < 1mm - No limitation but no accumulation of defects (accumulation is four or more at a distance less than 200 mm from each other)

*Note: Spot defect limits are in line with ISO 12543-6.*

#### **Vinyl Protrusion**

A maximum of 2mm on any edge is allowed.

#### **Short Vinyl**

A maximum of 2mm on the two aligned adjacent edges, on the other two edges a maximum of 4mm is allowed.

#### **Bubbles In Interlayer & Edge Delamination**

Edge bubbles up to 5mm from the edge are permitted and edge delamination equal to glass thickness is allowed.

#### **Vinyl On Edge –**

Certain interlayers will flow and adhere to the glass edges, in most applications this is acceptable. On exposed edges it is critical to review a sample to clearly understand the edge quality that can be expected.