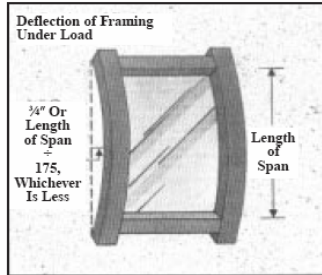


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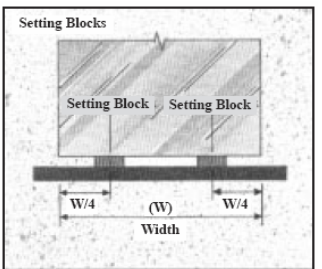
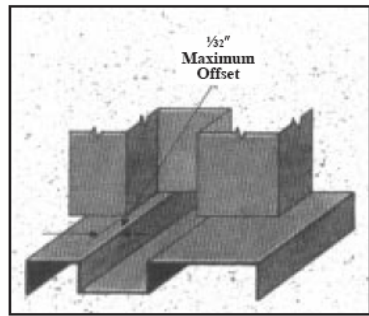
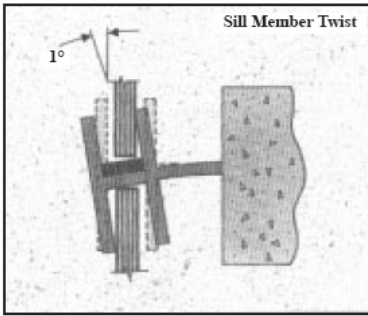
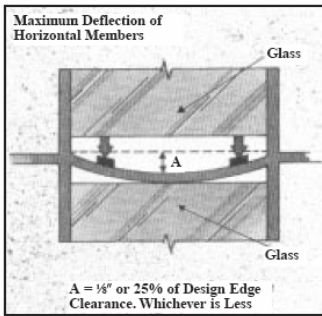


Arch Aluminum and Glass provides quality products for the glazing and construction industry. Our products are designed and manufactured to achieve optimum durability in service. When combined with craftsmanship in installation and sound glazing practices successful projects are achieved. To that end we recommend the following specific items for warranty and following the guidelines established by the Glass Association of North America published in the GANA Glazing Manual. Since our products may be installed in a variety of systems the installer should always reference design or manufacturer's instructions for their specific job. Clarification of any conflicting design instructions and these or GANA guidelines are the responsibility of the installer.

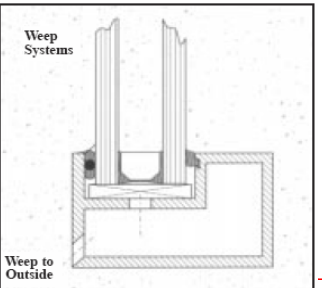


Glass products supplied must be adequately supported and cushioned to prevent breakage. Framing must support the glass edge limiting deflection to $L/175$ or $3/4$ " which ever is less. Torque or rotation should be limited to 1° . Joint offset shall not exceed $1/32$ ". Deflection of sill members must be restricted to $1/8$ " or no more than 25% of recommended edge coverage. DLO should be square to $1/8$ ".

Protect edges of all glass from damage during storage and installation. Poor storage, damage from other trades or rough handling can cause surface damage or chipping of the edges, initiating small fractures which can later run under thermal or glazing pressure. Use only approved rolling blocks when pitching / rolling glass. Reference ATB - 104 and GANA Glazing Manual.



Setting blocks, adequate to support the full depth of glazing, two per lite, should be located at the quarter, but no less than the eighth points of the base of the glass. Block height must be adequate to maintain minimum edge clearance. Setting blocks must not restrict water drainage. Blocks should have a Shore Durometer of 85 ± 5 . Neoprene or silicone setting blocks and gasket material are compatible with Arch Insulated glass. The only exception is in all structural glazing and with OPACI-COAT 300 spandrel coatings. We specifically recommend the use of silicone gasket and blocks when that material will be in contact with the Opaci-Coat 300 silicone coating. Edge blocking is required to prevent lateral movement with in the glazing channel. Edge blocks should be located in the upper one third of the vertical dimension. Shore Durometer 50 ± 5 .

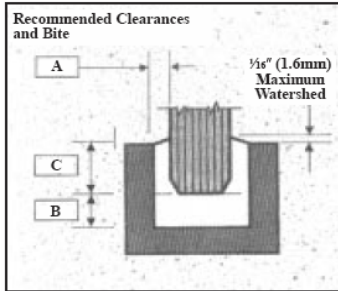


Glass products should not be exposed to standing water. The framing system must either preclude the infiltration of water or be designed to freely allow water to drain. We recommend a minimum of two elongated weep holes with an open area of $3/8$ " as a minimum. Installers should consider the potential of water surface tension to trap and hold water for prolonged periods of time in confined areas. Maintain adequate clearances and remove any dirt or debris from the glazing channel prior to installation.

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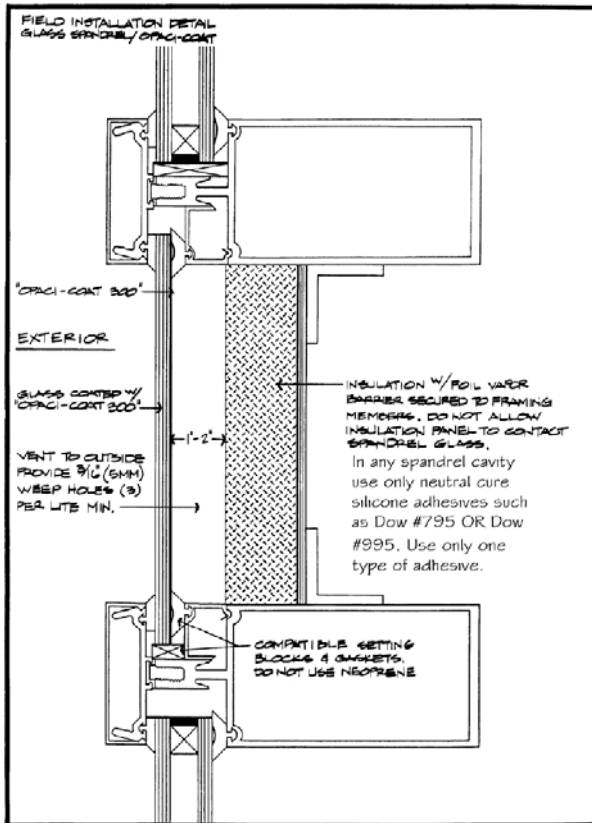


Capillary tubes are recommended when shipping to points requiring an elevation change of 3000 feet from point of manufacture to point of installation. Capillary tubes must be sealed when used with sputter coated glass products. Failure to do so will void warranty.

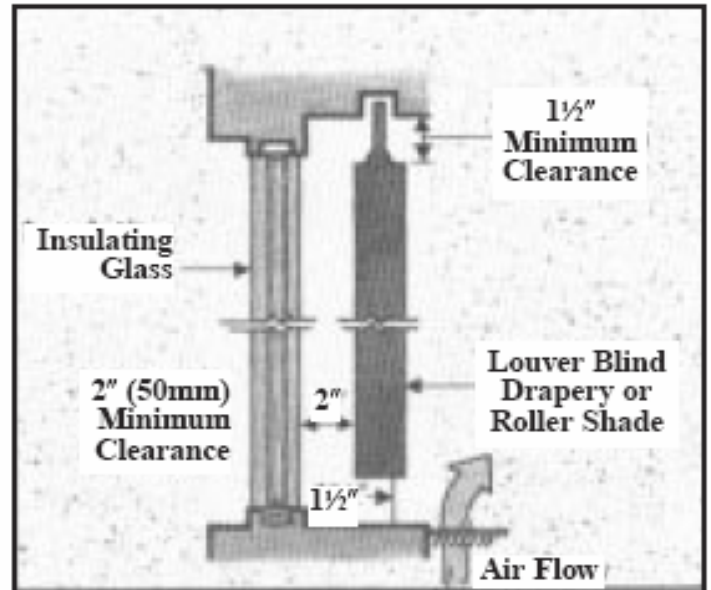


Insulated glass, one inch in overall thickness, should maintain the following minimum clearances within the framing; **B edge, 1/4", A face 3/16"** and have a **minimum bite or capture C of 1/2"**. Reference GANA Glazing Manual for additional information.

Typically neutral cure silicones are compatible with Arch insulated glass sealant. Our standard seal is PRC 469 FM or 449 FM Permapol, a modified polysulphide. Silicone is available, PRC 4400, and must be specified when ordering. Silicone is mandated in all structural glazing applications. We recommend using black spacer on all structural jobs for aesthetics of site line. Specific material compatibility testing is available upon request.



Spandrel products must maintain a minimum of 1" clearance between the installed panel and cavity insulation. Insulation must be secured to maintain minimum clearance for the life of the installation. Do not field apply ANY insulation products to the back of a spandrel.



Avoid using annealed glass in areas with heat traps, tight fitting blinds, drapes, or HVAC ducts that blow directly on the glass. These installations usually require heat strengthened glass. Tints, coated glass, or glass with applied films increase the risk of thermal breakage.

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Installation of Glass:

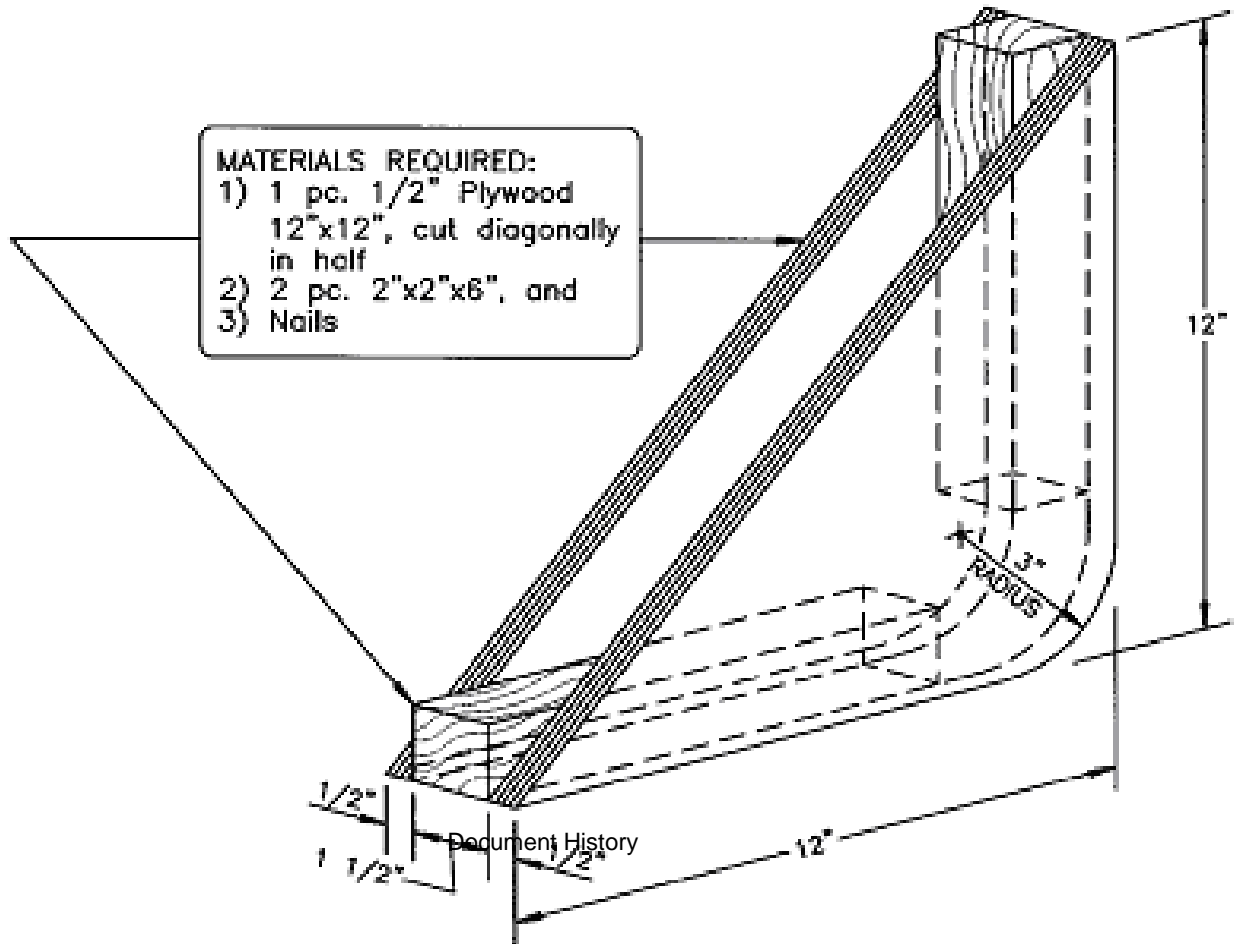
1. Temperature conditions during glazing must be within the limits required by the sealant and gasket manufacturer(s).
2. Measure glass for proper dimensions.
3. Always use a rolling block to rotate glass. See Detail Page Four
4. Do not impact the glass against the framing during installation. This can cause edge damage. Pocket, or "Flush Glazing", is particularly susceptible to glass edge damage from impacting the frame and requires precise sizing of the glass and extra care during installation.
5. Always use suction cups to shift a lite of glass within the opening. Raising or drifting the glass with a pry bar can cause edge damage.
6. Glass with questionable edge conditions should be set aside for inspection by glass manufacturer or fabricator.
7. Post installation the glass should be properly cleaned. This may or may not be within the scope of your work. It is however in your best interest to assure proper cleaning instructions are provided. Improper cleaning of any glass may result in damage. Heat –treated glass is more susceptible to damage from traditional cleaning methods and especially the use of metal scrapers and razor blades. Please provide your customer with the appropriate cleaning instructions provided for your glass type. GANA 01- 0300 Proper Procedures For Cleaning Architectural Glass and GANA Bulletin TD-02-0242 Heat Treated Glass Surfaces are Different. Both are available by contacting 1-866-629-ARCH, www.archaluminum.net, or from your local Arch Aluminum Branch.

Your Arch Product Warranty is a valuable and necessary part of every job. Protect your investment by adhering to these and other referenced guidelines and calling your Arch representative if you have questions or need clarification on any item.

¹ Illustrations courtesy of Pilkington GANA and ICD Coatings

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Insulated Glass Rolling Block



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Document History

Original Document	March 2006	Author TJM
Revision 1	July 2007	Author TJM
Revision 2	September 2007	Author TJM
Revision 3	October 10, 2007 Post Install Cleaning	Author TJM

Related Documents

Arch ATB 113 Heat –Treated Glass Cleaning
GANA Glazing Manual
GANA Laminated Design Guide
PPG TD-109 Thermal Stress Update
PPG TSR 130; 230
ASTM E 1300 Standard Specification For Wind Load
International Code Council- International Building Code