

LAMINATED GLASS GENERAL GUIDELINES

| STRAIGHT LINE LAMINATION | |
|--|---|
| Minimum overall size | 8" x 16" |
| Maximum overall size | 86" x 144" |
| Maximum length | |
| Maximum size per overall thickness 2.5mm / 2.5mm annealed | 72" x 96" |
| Maximum size per overall thickness 2.7mm / 2.7mm annealed | 72" x 120" |
| Maximum size per overall thickness 3.2mm / 3.2mm annealed | 72" x 130" or 60" x 144" |
| Maximum size per overall thickness 4mm / 4mm annealed | 84" x 130" |
| Maximum size per overall thickness 5mm / 5mm annealed | 84" x 144" |
| Maximum size per overall thickness 6mm / 6mm annealed | 84" x 144" |
| Maximum size per overall thickness 3mm / 3mm heat treated | 38" x 84" |
| Maximum size per overall thickness 4mm / 4mm heat treated | 48" x 96" |
| Maximum size per overall thickness 5mm / 5mm heat treated | 72" x 100" |
| Maximum size per overall thickness 6mm / 6mm heat treated | 84" x 144" |
| Minimum overall thickness | 5mm (2.5mm / 2.5mm) |
| Maximum overall thickness | 3" (any combination) |
| Maximum overall weight | <1000 lbs. |
| VACUUM BAG LAMINATION (Special Order. Call for Details) | |
| Maximum size for vacuum bag lamination | 68" x 144" |
| Maximum overall weight for vacuum bag lamination | 1000 lbs. |
| SureStep stair treads & flooring | Must be vacuum bagged |
| TEXTURED/OBSCURE GLASS | |
| Satin Etch | .015 vinyl and .030 vinyl |
| Rain, Niagara, Pinhead Morocco, Mistlite*, Gluechip* | Minimum .060 vinyl |
| Arctic**, Cathedral**, Delta (clear or frost)** | Minimum .060 vinyl - vacuum bagged |
| Berman Glass editions (BGe: Ima, Aqui, Etre, Esto)** | Minimum .060 vinyl (.090 recommended) - vacuum bagged |

*Tempered **recommended**. **Heat treating **required**.

EDGEWORK

Only flat grind/polish is recommended for laminated glass. Flat polishing tempered laminated glass (after lamination) can be done on 6mm or thicker glass but is not recommended as altering tempered glass compromises the stability of the edge. Mitred or bevelled edges are NOT available on HS / tempered laminated glass. Available on annealed laminates only, must be edged after lamination.

FABRICATION

Holes, edge cutouts and notches are available in heat treated laminated glass only as annealed lites with fabrication are subject to break during the lamination process. Limited fabrication on annealed laminated lites can be done after lamination. Glass fabrication rules & guidelines for heat treated glass apply (i.e. spacing and location of holes, notches, etc.) We recommend using the largest possible hole dimensions to insure the holes align. Tolerance for alignment varies and is dependent on glass thickness.

A minimum of .060 vinyl must be used when laminating heat treated glass with cutouts, holes, notches, etc. Only flat polish (prior to lamination) is available on all glass bullet resistant products – no holes, notches or cutouts available.