



PILKINGTON

PILKINGTON ARCHITECTURAL PRODUCT PARAMETER SUMMARY

This is a précis ONLY and highlights the main areas for consideration when reviewing a Pilkington **Planar**TM product specification. For the full specification the Pilkington **Planar**TM **Specification 2003** must be consulted

1 EDGEWORKING & DRILLING

Edgework - Normally smooth ground (polishing can be done at an extra charge)

Note: All exposed edge conditions must be marked up on the fabrication drawings. This includes the edges of notches and cut outs. For sizes below 600mm x 900mm off line shape processing is required which effects costs.

Sizes Minimum 360 x 900mm to maximum 2400 x 4800mm

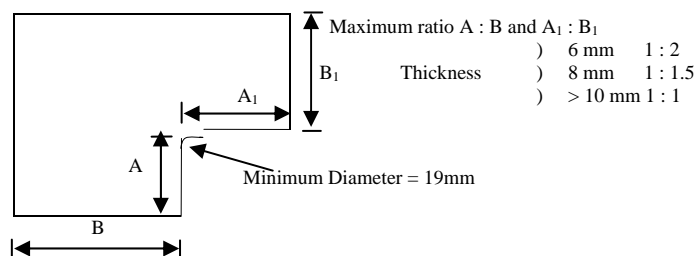
Countersunk holes Can be done in glass thickness 8mm to 19mm only

Maximum N^o of Holes 36 per plate

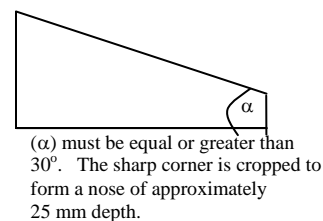
For all bevelled edge specifications a technical enquiry sheet should be submitted.

GUIDANCE NOTES FOR SHAPED GLASSES

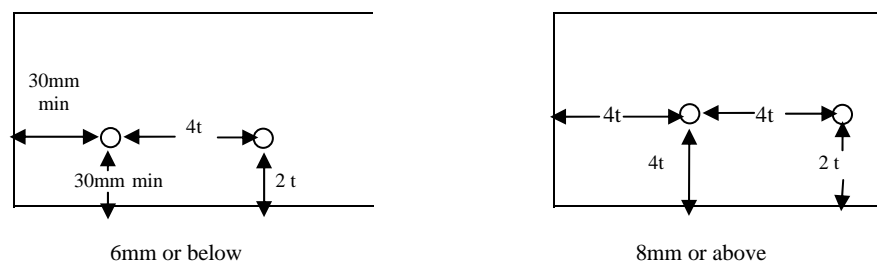
(h) Cut Outs



(i) Acute Angle Triangles



(j) Holes - Proximity to Edges (t = thickness)



2 PRINTING

Standard prints are available (lines, dots and mesh), however, all specifications for print pattern and colour must include the need for approval by sample.

Maximum Size 2400 x 4800mm

Maximum Printed Area 2400 x 4500mm

One Colour ONLY Standard colours are BLACK, GRAPHITE, SIMULATED ACID ETCH and WHITE



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Note

- (a) Caution must be used with White and acid etch effect and some light colours as 100% coverage due to colour variation and “see through” effects.
- (b) Positional tolerance for the screen +/- 3mm
- (c) For inner facing plates in a double glazing unit : (1) A 14mm clear border around the edge of the plate is required.
(2) A 50mm clear border around the centre of holes is required.

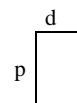
3 TOUGHENING AND HEAT SOAKING

Minimum Size	360 x 900mm Triangles	- all sides > 750mm
Maximum Size	4 mm Thickness	- 2400 x 3000mm (+/- 1mm)
	5mm	- 2400 x 4000mm (+/- 1mm)
	6mm to 19mm	- 2400 x 4800mm (+/- 1mm)

Maximum size of coated products is on request.

Notes

- (a) Aspect Ratio (P/d) Max 10:1
- (b) Diagonal Tolerances
- (c) Bow
- (d) Roller Wave.
- (e) Shaping
- Up to 4m max difference = 3mm
Over 4m max difference = 4mm
- Max bow = 0.1% (non coated or printed glasses)
Max bow = 0.2% (coated or printed glasses)
- 8 – 19mm = Mean of 0.02mm
Max edge dip = 0.25mm
- 4 – 6mm = Mean of 0.05mm
Max edge dip = 0.25mm
- The tolerances will vary dependant upon the complexity.



4 Pilkington Planar™ DOUBLE GLAZING

- 4.1 Sizes Maximum 2400 x 4800mm to minimum 360 x 900mm
(for laminate see below)
- 4.2 General
- (a) Size tolerance +4.5 / - 1mm
- (b) Maximum unit thickness 80mm
- (c) Shapes For all other than simple raked plates
a technical enquiry should be made



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(d)	Spacer Bender	Angles less than 30° not available
(e)	Maximum Number of Sides	8
(f)	Shortest Side	Minimum 150mm

Notes

- 1.Coatings maximum size 3600 x 2000mm
- 2.For soft coating, e.g. HP maximum thickness = 10mm
3. For printed products a clear border around the periphery and holes is required.

5 LAMINATED Pilkington Planar™ (Cast-in-Place Laminating)

5.1	Thickness (common)	Maximum 27mm
	Sizes	Maximum 4500 x 2400mm Minimum 360 x 900mm
	Hole Positions	If not Planar , standard 60mm dimension a technical enquiry form to be submitted
	Number of Holes	Up to 8
	Size Tolerance	(+4/-1mm)

Notes

1. Number of holes may be increased via technical enquiry form.
2. Printing is allowable on any face other than those exposed to the environment.
3. No soft coatings are allowable. Hard coatings allowable on surfaces No 1 and 4.
4. Simple shapes only. All others must be via “Technical Enquiry” form.

If in doubt a technical enquiry form should always be submitted.