

Pilkington **Plateau™** Product Specification Toughened Product

Glass Geometry

Size

Standard max size: 2200 mm x 3300 mm

Note:

The following larger sizes can be supplied with prior agreement only:

- 2650 mm x 3450 mm clear
- 2350 mm x 3450 mm acid etched

Tolerance

- Edge length: +/- 3 mm
- Diagonal length: +/- 5 mm

Thickness

- 8 mm : +/- 0.2 mm
- 10 mm : +/- 0.13 mm
- 12 mm : +/- 0.2 mm

Wedge (maximum)

- 8 mm : 0.20 mm
- 10 mm : 0.13 mm
- 12 mm : 0.20 mm

Glass Shape

Clear / Gloss Paired to Clear / Gloss

- Bow maximum for dimensions below 3250, 1.5 mm/m
- Pairing maximum for dimensions below 3250, 0.8 mm or as agreed with customer

Etch / Matte Paired to Clear / Gloss

- Bow maximum for dimensions below 3250, 2.5 mm/m
- Pairing maximum for dimensions below 3250, 2.2 mm
- Pairing maximum for dimensions below 2450, 1.6 mm

Etch / Matte Paired to Etch / Matte

- Bow maximum for dimensions below 3250, 3 mm/m
- Pairing maximum for dimensions below 3250, 3 mm
- Pairing maximum for dimensions below 2450, 2 mm

Pairing information

When requested at order, Pilkington will provide the following data

- Case plates – showing the deviation of each glass pair as packed in the case
- Plate data – individual plate data allowing customer selection of best pairs

Edge Condition

Edge profile

All plates will have a 'C' profile smooth ground edge unless otherwise stated

Edge zone quality

Note:

The "edge zone" is a 10 mm wide border around the periphery of the plate

Acceptable faults

- Occasional bright spots (equivalent to a good arris)
- Shells that are less than 4 mm wide and are less than 1 mm deep

Unacceptable faults

Any vent, dig, raw edge burn (crizzle & metallic lustre) fire vent

Tong marks

- The glass will have tong marks close to one edge
- Tong marks shall not protrude into the plate a distance of further than the nominal glass thickness
- Glass plates 2000 mm x 3000 mm in size shall have tong marks along the 3000 mm edge

Tong kink

Note:

"Tong kink" is the variation of the tong point from the mean line of the tong edge

- Tong kink shall be measured along a line running parallel to and spaced 25 mm in from the tong edge
- The maximum allowable variation in tong kink is 0.5 mm over any 300 mm length

Toughening stress

- Pilkington **Plateau™** toughened product is not manufactured or tested to safety glazing standards
- Glass stress is controlled by non-destructive in-house methods
- At point of despatch, product shall have a DSR reading of approx. 26 (equivalent to a surface compression of 83.5MPa, or a particle fracture count of 60 per 50 mm square)
- It should be noted that repeat exposure to high temperatures over long time periods can reduce surface compression in Pilkington **Plateau™** toughened glass



Glass Quality

Raw material quality

Acceptable faults

- Body faults that do not break the surface of the glass

Unacceptable faults

- Ream and cold metal drag lines that break the surface of the glass

Surface quality – clear glass

Acceptable faults

- Fine sleeks, providing that there are not more than 6 per plate and less than 2 per 0.1 m²

Note:

Generally such fine sleeks will be barely discernable by finger nail and as such can be rectified by hand polishing

Unacceptable faults

- Digs, scars, obvious stain, open bubble. Deep surface blemishes than can be detected with a pencil

Surface quality – acid etched glass

Surface finish

- Satin product : Ra 3 +/- 0.4
- Sheen product : Ra 2.2 +/- 0.4
- Silk product : Ra 1.2 +/- 0.4

Acceptable faults

- Light water marks/streaks
- Fine sleeks, providing that there are not more than 6 per plate and less than 2 per 0.5 m²
- Spots, providing that
 - there are no more than 6 per plate
 - all are less than 1 mm diameter
 - there are less than 2 per 0.5 m²

This publication provides only a general description of the products. Further, more detailed, information may be obtained from your local supplier of Pilkington products. It is the responsibility of the user to ensure that the use of these products is appropriate for any particular application and that such use complies with all relevant legislation, standards, codes of practice and other requirements. To the fullest extent permitted by applicable laws, Nippon Sheet Glass Co. Ltd. and its subsidiary companies disclaim all liability for any error in or omission from this publication and for all consequences of relying on it.

Please note that imagery throughout is for illustration purposes only.

Unacceptable faults

- Visual non-uniformity (i.e. patches, swirls, lines)
- Digs, scars, obvious stain, open bubble. Deep surface blemishes than can be detected with a pencil

One siders

Clear glasses that are not in-case paired and having rejectable faults on one surface only will be accepted on all orders providing they are no greater than 30%. The "defective" surface shall be identified by a white label advising to "Use other side of glass." All etch/matte glasses are classed as for use on this surface only.

Packing

- Glass will be packed in open boarded export wooden cases which should be handled with slings only – DO NOT use forks
- Glass will be interleaved with paper
- Glass cases will be lined with polythene or Alufoil

Glass Marking

- Each glass will be marked on one edge as follows:
PILKINGTON PLATEAU [x] [y] [z]
Where, x = plate number
y = position
z = date of manufacture
- The marking will be etched on the air side of the glass



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