



# Standard Specification for Laminated Architectural Flat Glass<sup>1</sup>

This standard is issued under the fixed designation C 1172; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope

1.1 This specification covers the quality requirements of flat laminated glass consisting of two or more lites of glass bonded with an interlayer material for use in building glazing.

1.2 Depending on the number, thickness and treatment of lites, and the number and thickness of interlayers, the glass shall be laminated for applications including but not limited to safety security, detention, hurricane/cyclic-wind resistant, blast resistant, bullet resistant and sound reduction glazing applications. Laminated glass used in furniture applications is not included in this specification.

1.3 Optical distortion and the evaluation thereof are not currently within the scope of the standard. Mockups are recommended as a method to evaluate glass. (See [Appendix X1](#).)

1.4 The dimensional values, except thickness designations, stated in inch-pound units are to be regarded as the standard. The values in parentheses are for information only.

1.5 The following safety hazards caveat pertains only to the test method portion, Section 7, of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

2.1 Reference to these documents shall be the latest revision unless otherwise specified by the authority applying this specification.

### 2.2 ASTM Standards:

- [C 162 Terminology of Glass and Glass Products](#)
- [C 1036 Specification for Flat Glass](#)
- [C 1048 Specification for Heat-Treated Flat Glass—Kind HS, Kind FT Coated and Uncoated Glass](#)
- [C 1376 Specification for Pyrolytic and Vacuum Deposition Coatings on Flat Glass](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee C14 on Glass and Glass Products and is the direct responsibility of Subcommittee C14.08 on Flat Glass.

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[C 1422 Specification for Chemically Strengthened Flat Glass](#)

[C 1503 Specification for Silvered Flat Glass Mirror](#)

[E 308 Practice for Computing the Colors of Objects by Using the CIE System](#)

[E 1886 Test Method for Performance of Exterior Windows, Curtain Walls, Doors, and Impact Protective Systems Impacted by Missile\(s\) and Exposed to Cyclic Pressure Differentials](#)

[E 1996 Specification for Performance of Exterior Windows, Curtain Walls, Doors, and Impact Protective Systems Impacted by Windborne Debris in Hurricanes](#)

[F 1233 Test Method for Security Glazing Materials And Systems](#)

[F 1642 Test Method for Glazing and Glazing Systems Subject to Airblast Loadings](#)

[F 1915 Test Methods for Glazing for Detention Facilities](#)

2.3 *ANSI Standard:*

[Z97.1 Safety Glazing Materials Used in Buildings—Safety Performance Specifications and Methods of Tests<sup>2</sup>](#)

2.4 *Federal Document:*<sup>3</sup>

[CPSC 16CFR1201 Consumer Product Safety Commission Safety Standard for Architectural Glazing Materials](#)

2.5 *UL Standards:*<sup>4</sup>

[UL 752 Standard for Bullet Resisting Materials](#)

[UL 972 Standard for Burglary Resisting Glazing Materials](#)

## 3. Terminology

3.1 *Definitions*—Refer to Terminology [C 162](#), Specifications [C 1036](#) or [C 1048](#), as appropriate.

3.1.1 *blemishes in flat glass*—Refer to Specifications [C 1036](#) or [C 1048](#), as appropriate.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *adhesion chips*—See *fuse*.

3.2.2 *blow-in*—a separation of glass and interlayer at or close to the laminate edge caused by penetration of the autoclaving medium into the edge during manufacturing.

<sup>2</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

<sup>3</sup> Available from U.S. Consumer Product Safety Commission (CPSC), 4330 East West Hwy., Bethesda, MD 20814, <http://www.cpsc.gov>.

<sup>4</sup> Available from Underwriters Laboratories (UL), 333 Pfingsten Rd., Northbrook, IL 60062-2096, <http://www.ul.com>.

3.2.3 *boil (bubble)*—a gas pocket in the interlayer material or between the glass and interlayer.

3.2.4 *covered edge*—the peripheral area of the laminate covered by the channel or sash when installed.

3.2.5 *delamination*—a condition in which one or two of the lites of glass loses the bond between the glass lite and the interlayer.

3.2.6 *discoloration*—a visibly noticeable color change (from original) in the appearance of a material.

3.2.7 *distortion*—the inability to see an image clearly; the image is twisted out of natural shape.

3.2.8 *edge boil*—See boil (bubble).

3.2.9 *exposed edge*—the peripheral area of the laminate exposed to the environment after installation.

3.2.10 *fuse*—a glass particle or crystalline material that is permanently bonded to a surface of a lite.

3.2.11 *hair*—a slender, pigmented filament from human or animal epidermis or other thread-like filament.

3.2.12 *inside dirt*—foreign material trapped inside the laminate.

3.2.13 *interlayer*—a layer or multiple layers of material acting as an adhesive between lites of glass which adds additional performance to the finished product, for example, impact resistance, solar control, acoustical insulation.

3.2.14 *laminated glass*—an assembly consisting of two or more lites of glass, conforming to Specification **C 1036** or **C 1048** that are bonded together by interlayer material.

3.2.15 *lint*—short fibers of yarn or fabric trapped within the laminate.

3.2.16 *lite or light*—a panel or sheet of glass or a panel or sheet of laminated glass.

3.2.17 *mismatch*—misalignment of the edges of two lites of glass, when laminated.

3.2.18 *nonsymmetrical*—a term used to describe the construction of a laminate comprised of different glass types or thickness, or both.

3.2.19 *offset*—glass lites that are intentionally not aligned in a laminate.

3.2.20 *rub*—abrasion of a glass surface producing a frosted appearance. Also known as a scuff.

3.2.21 *separation*—an area of the laminate that has become delaminated (see delamination).

3.2.22 *shiner*—an area on a glass edge that has not been ground or polished.

3.2.23 *short interlayer*—a condition of the laminate in which the interlayer does not extend to the edge.

3.2.24 *streak*—a noticeably visible directional blemish or discoloration on or in the laminated unit.

3.2.25 *symmetrical*—a term used to describe the construction of a laminate comprised of only one glass type and thickness.

3.2.26 *template*—a pattern used as a guide to define the overall size and shape of a cut lite.

3.2.27 *unlaminated area*—an area of the laminate that failed to laminate during the laminating process. This blemish may be discernible due to the textured appearance of the interlayer material.

## 4. Classification

4.1 *Type*—Laminated flat glass furnished under this specification shall be of the following types, as specified:

4.1.1 *Type I - Laminated Glass*—an assembly consisting of two or more lites of glass, conforming to Specification **C 1036** or **C 1048** that are bonded together by interlayer material.

4.1.2 *Type II - Laminated Safety Glass*—as defined in ANSI **Z97.1** or **CPSC 16CFR1201** or both. Two or more lites of flat glass, bonded by interlayer material. In the case of breakage, the interlayer serves to retain the glass fragments, limit the size of the opening and reduce the risk of cutting or piercing injuries.

4.2 *Application*—the following terms are designed to guide the user to the appropriate inspection charts and requirements. The glazing can usually, but not always be viewed in transmittance and reflectance.

4.2.1 *Laminated Vertical Glazing*—Glazing used in an installation in which the lower edge of the glazing is a maximum of 1.8 m (6 ft) above the walking surface. The glazing is usually vertical, however may also be sloping in or out from the vertical plane. The glazing can be approached within 3 m (10 ft) or less (if distance is greater than 3 m (10 ft) see Laminated Overhead Glazing). Interior decorative glazing will be judged according to laminated vertical glazing criteria.

4.2.2 *Laminated Overhead Glazing*—Glazing used in an installation in which the lower edge of the glass is more than 1.8 m (6 ft) above a walking floor level or cannot be approached within 3 m (10 ft). The glazing is usually sloping from the vertical plane, however may also be vertical. Sloped glazing is considered any glazing that slopes more than 15 degrees from the vertical in any direction.

4.2.3 *Laminated Spandrel Glazing*—Glazing used in an installation in which the glazing is only viewed in reflection from the building's exterior. The glazing is usually installed vertically, however, may be at a slope to the vertical plane. Laminated spandrel glazing shall be inspected using the criteria of vertical or overhead laminated glazing. (See section 4.2.1 or 4.2.2) based upon installation as vertical or overhead glazing.

## 5. Ordering Information

5.1 Purchasers should select the preferred options permitted in this specification and include the following information in procurement documents:

5.1.1 Title, number, and date of this specification.

5.1.2 Type of laminated flat glass as referred to in this specification (see Section 4).

5.1.3 Edgework requirements (see 8.2).

5.1.4 Thickness requirements:

5.1.4.1 Thickness designation of each individual lite of glass to be used in the laminate,

5.1.4.2 Interlayer type and thickness designation, and

5.1.4.3 Overall nominal thickness of the laminate.

5.1.5 Nominal length and width of the laminate.

5.1.5.1 Blueprint, drawing, template, configuration specification, or other forms of information which detail overall size, configuration, and orientation.

5.1.6 Types of each individual lite of glass to be used in the laminate.

5.1.6.1 Color, tint, coating, decorative effect and strength of each individual lite of glass.

5.1.7 Color, tint and decorative effect of the interlayer.

5.1.8 The luminous transmittance of the laminate (see 7.11).

5.1.9 Safety standards or regulations to which the laminate must conform.

5.1.10 All other standards to which the laminate must conform.

5.2 *Packaging Requirements*—Glass packaging and protection will be standard manufacturer practice unless otherwise specified. Consult manufacturer before specifying.

## 6. Other Requirements

6.1 Annealed glass lites shall conform to the requirements of Specification C 1036 for the incorporated glass type.

6.2 Chemically strengthened glass lites shall conform to the requirements of Specification C 1422.

6.3 Heat strengthened or fully tempered glass lites shall conform to the requirements of Specification C 1048.

6.4 Mirror glass lites shall conform to the requirements of Specification C 1503.

6.5 Pyrolytic and vacuum deposition coated glass plies shall conform to the requirements of Specification C 1376.

6.6 solar and Optical property shall be as specified..

6.7 Solar Heat Gain Coefficient shall be as specified.

6.8 Spandrel glass lites shall conform to the requirements of Specification C 1048 for the incorporated glass type.

6.9 Visible reflection shall be as specified.

6.10 Visible transmittance shall be as specified.

6.11 U-factor shall be a specified.

## 7. Test Methods

7.1 *Impact Test for Safety Glazing*—Test and interpret in accordance with ANSI Z97.1 or CPSC 16CFR1201, or both, as applicable.

7.2 *Test for Missile Impact and Cyclic Pressure*—Test and interpret in accordance with Test Method E 1886 and Specification E 1996.

7.3 *Test for Security Glazing*—Test and interpret in accordance with Test Method F 1233.

7.4 *Test for Glazing Subject to Airblast Loading*—Test and interpret in accordance with Test Method F 1642.

7.5 *Test for Detention Glazing*—Test and interpret in accordance with Test Method F 1915.

7.6 *Test for Bullet Resisting Glazing*—Test and interpret in accordance with specified standards such as Test Method F 1233 and Standard UL 752.

7.7 *Test for Burglary Resisting Glazing*—Test and interpret in accordance with specified standards such as, but not limited to: Test Method F 1233, NIJ, and UL 792.

7.8 *Overall Bow/Warp*—Place sample glass in a free-standing vertical position, with the longest edge resting on blocks at the quarter points. With the laminate in this position, place a straightedge across the concave surface, parallel to and within 1 in. (25.4 mm) of the edge, and measure the maximum deviation with a taper or feeler gage. A dial indicator may also be used.

7.9 *Size*—Measure length and width from edge to edge, including flares, mismatch, or offset (see 8.5).

TABLE 1 Maximum Allowable Laminating Process Blemishes for Vertical Glazing, in. (mm)

NOTE 1—Refer to Specification C 1036 for the quality specification for the individual glass lites.

NOTE 2—All imperfections noted should be separated by a minimum of 300 mm (12 in.)

NOTE 3—See 7.10 for method of inspection.

NOTE 4—Laminates with more than two lites of glass may contain proportionally more blemishes.

Blemish	Up to 2.5 m <sup>2</sup> (25 ft <sup>2</sup> )		2.5 to 7.0 m <sup>2</sup> (25 to 75 ft <sup>2</sup> )		Over 7.0 m <sup>2</sup> (75 ft <sup>2</sup> )	
	Central <sup>A</sup>	Outer <sup>A</sup>	Central <sup>A</sup>	Outer <sup>A</sup>	Central <sup>A</sup>	Outer <sup>A</sup>
Boil (Bubbles)	1.6 mm (1/16 in.)	2.4 mm (3/32 in.)	3.2 mm (1/8 in.)	4.8mm (3/16 in.)	6.4 mm (1/4 in.)	(6.4 mm (1/4 in.)
Blow-in; edge boil	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 1.6 <sup>1/6</sup> <sup>C</sup>	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 1.6 mm (1/16 in.) <sup>C</sup>	<sup>B</sup>	CE 8.0 mm (5/16 in.) EE 3.2 mm (1/8 in.) <sup>C</sup>
Fuse	0.8 mm (1/32 in.)	1.6 mm (1/16 in.)	1.6 mm (1/16 in.)	2.4 mm (3/32 in.)	2.4 mm (3/32 in.)	4.0 mm (5/32 in.)
Hair, lint (single strand)	light intensity <sup>D</sup>	medium intensity <sup>E</sup>	light intensity <sup>D</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>
Inside dirt (dirt spot)	1.6 mm (1/16 in.)	2.4 mm (3/32 in.)	2.4 mm (3/32 in.)	4.0 mm (5/32)	3.2 mm (1/8 in.)	4.8 mm (3/16 in.)
Lint-areas of concentrated lint	light intensity <sup>D</sup>	medium intensity <sup>E</sup>	light intensity <sup>D</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>
Separation, discoloration	none	none	none	none	none	none
Short interlayer; unlaminated area chip	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 1.6 mm (1/16 in.) <sup>C</sup>	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 2.4 mm (3/32 in.) <sup>C</sup>	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 3.2 mm (1/8 in.) <sup>C</sup>
Scuff; streak	light intensity <sup>D</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>	medium intensity <sup>E</sup>

<sup>A</sup> The *central area* is an area formed by an oval or circle whose axes or diameters, when centered, do not exceed 80 % of the overall dimension. The *outer area* is the area outside of the *central area*.

<sup>B</sup> Not applicable.

<sup>C</sup> CE = covered edge of glass edge bite and

EE = exposed edge. (If CE or EE is unknown use EE tolerance.)

<sup>D</sup> *Light Intensity*—Barely noticeable at 1 m (39 in).

<sup>E</sup> *Medium Intensity*—Noticeable at 1 m (39 in) but not at 3 m (10 ft).

TABLE 2 Maximum Allowable Laminating Process Blemishes for Overhead Glazing, in. (mm)

NOTE 1—Refer to Specification C 1036 for the quality specification for the individual glass lites.  
 NOTE 2— All imperfections noted should be separated by a minimum of 12 in. (300 mm).  
 NOTE 3—See 7.10 for method of inspection.  
 NOTE 4—Laminates with more than two lites of glass may contain proportionally more blemishes.

Blemish	up to 2.5 m <sup>2</sup> (25 ft <sup>2</sup> )		ft <sup>2</sup> or greater 2.5 m <sup>2</sup> or greater (25 ft <sup>2</sup> or greater)	
	Central <sup>A</sup>	Outer <sup>A</sup>	Central <sup>A</sup>	Outer <sup>A</sup>
Boil (Bubbles)	2.4 mm (3/32 in.) <sup>B</sup>	3.2 mm (1/8 in.)	4.8 mm (3/16 in.) <sup>B</sup>	6.4 mm (1/4 in.)
Blow-in; edge boil		CE 6.4 (1/4 in.) EE 2.4 mm (3/32 in.) <sup>C</sup>		CE 8.0 mm (5/16 in.) EE 3.2 mm (1/8 in.) <sup>C</sup>
Fuse	1.6 mm (1/16 in.)	1.6 mm (1/16 in.)	2.4 mm (3/32 in.)	4.0 mm (5/32 in.)
Hair, lint (single strand)	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>
Inside dirt (dirt spot)	2.4 mm (3/32 in.)	2.4 mm (3/32 in.)	4.0 mm (3/32 in.)	4.8 in (3/16 in.)
Lint-areas of concentrated lint	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>
Separation, discoloration	none	none	none	none
Short interlayer; un-laminated area, chip;	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 2.4 mm (3/32 in.) <sup>C</sup>	<sup>B</sup>	CE 6.4 mm (1/4 in.) EE 3.2 mm (1/8 in.) <sup>C</sup>
Scuff; streak	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>	medium intensity <sup>D</sup>

<sup>A</sup> The central area is an area formed by an oval or circle whose axes or diameters, when centered, do not exceed 80 % of the overall dimension. The outer area is the area outside of the central area.

<sup>B</sup> Not applicable.

<sup>C</sup> CE = covered edge of glass edge bite and

EE = exposed edge. (If CE or EE is unknown use EE tolerance.)

<sup>D</sup>Medium Intensity—Noticeable at 1 m (39 in.) but not at 3 m (10 ft).

TABLE 3 Length and Width Tolerances for Rectangular Shapes of Symmetrically Laminated Glass Including Mismatch<sup>A</sup>

Laminate Thickness Designation, t	Tolerances, mm (in.) <sup>B,C</sup>		
	Transparent Glass	Patterned and Wired Glass	Heat Strengthened and Tempered Glass
t ≤ 6.4 (t ≤ 1/4)	+4.0, -1.6 (+ 5/32, -1/16)	+7.9, -3.2 (+ 5/16 -1/8)	+5.6, -2.4 (+7/32 -3/32)
6.4, t ≤ 12.7 (1/4 < t ≤ 1/2)	+ 6.4, -1.6 (+ 1/4, -1/16)	+ 7.9, -3.2 (+ 5/16, -1/8)	+ 6.4, -3.2 (+ 1/4, -1/8)
12.7 < t ≤ 25.4 (1/2 < t ≤ 1)	+ 6.4, -3.2 (+1/4, -1/8)	+ 7.9, -3.2 (+5/16, -1/8)	+ 7.9, -3.2 (+5/16, -1/8)

<sup>A</sup> For nonsymmetrical laminated glass contact the laminator for size tolerances.

<sup>B</sup> Size includes cutting and fabrication tolerances and mismatch (see 8.5.1)

<sup>C</sup> For exposed edge applications, consult the supplier to determine their capabilities.

7.10 Visual Inspection—All visual inspections shall be made with 20/20 vision (normal or corrected eye). The viewer shall look at the sample at an angle of 90° (perpendicular) to the surface using the following lighting unless otherwise specified: daylight (without direct sunlight) or other uniform diffused background lighting that simulates daylight, with a minimum luminance of 1700 lux (160 foot-candles) measured at the surface of the glass facing the light source.

7.10.1 Laminated Vertical Glazing—Inspect glazing in the vertical position at a distance of 1 m (39 in). If a blemish is readily apparent under these viewing conditions, refer to Table 1 for acceptable criteria.

7.10.2 Laminated Overhead Glazing—Inspect glazing in the vertical position at a distance of 3 m (10 ft). If a blemish is readily apparent under these viewing conditions, refer to Table 2 for acceptable criteria.

7.11 Transmittance—Using Practice E 308, measure transmittance by illuminating each laminated specimen at normal incidence with light having the spectral composition of International Commission on Illumination (CIE) illuminant C.

Measure the ratio of transmittance to incident luminous flux by calculating from the spectral distribution of illuminant C as defined by Practice E 308.

## 8. Fabrication Requirements

8.1 All dimensional fabrication, such as cutting to overall dimensions, edgework, drilling, notching, grinding, sandblasting and etching, on laminates incorporating heat-strengthened, chemically strengthened, or fully tempered glass shall be performed prior to strengthening or tempering. After the glass has been strengthened or tempered, it shall not be modified except as recommended by the fabricator.

8.2 Edge—An edge shall be cut, sawed, ground, sanded to remove sharp edges only, seamed, ground and polished, beveled, or mitered as specified.

### 8.3 Marking:

8.3.1 Each laminate, as supplied by the manufacturer, shall bear the manufacturer's name, or trademark, or both, unless otherwise specified.

8.3.2 Laminated glass intended for safety glazing applications specified by building codes, shall be permanently marked as required by the applicable safety glazing standard.

8.4 Thickness—For thickness tolerances consult the laminator. Nominal thickness tolerance computation guidelines are as follows:

8.4.1 Minimum Thickness Tolerance—Minimum thickness tolerance shall be the summation of the values for the minimum thickness of each glass ply obtained from Specification C 1036 and the minimum interlayer thickness obtained from the laminator.

### 8.4.2 Maximum Thickness Tolerance:

8.4.2.1 Annealed Glasses—The summation of the values for the maximum thickness of each glass ply obtained from Specification C 1036 and the maximum interlayer thickness obtained from the laminator.

**TABLE 4 Maximum Allowable Overall Bow and Warp for Laminated other than Annealed Transparent Glasses<sup>A</sup>**

Edge Dimension, in. (mm)		Laminate Make-up Two Glass Lites of, mm (in.):				
		3 to 5 (1/8 to 3/16)	6 (1/4)	8 (5/16)	10 (3/8)	12 to 22 (1/2 to 7/8)
0 to 460	(0 to 18)	3.2 (1/8)	1.6 (1/16)	1.6 (1/16)	1.6 (1/16)	1.6 (1/16)
over 460 to 910	(Over 18 to 36)	4.8 (3/16)	3.2 (1/8)	2.4 (3/32)	2.4 (3/32)	1.6 (1/16)
over 910 to 1220	(Over 36 to 48)	7.1 (9/32)	4.8 (3/16)	4.0 (5/32)	3.2 (1/8)	2.4 (3/32)
over 1220 to 1520	(Over 48 to 60)	9.5 (3/8)	7.1 (9/32)	5.6 (7/32)	4.8 (3/16)	3.2 (1/8)
over 1520 to 1830	(Over 60 to 72)	12.5 (1/2)	9.5 (3/8)	7.1 (9/32)	6.4 (1/4)	4.8 (3/16)
over 1830 to 2130	(Over 72 to 84)	15.9 (5/8)	12.7 (1/2)	8.7 (11/32)	7.9 (5/16)	6.4 (1/4)
over 2130 to 2440	(Over 84 to 96)	19.0 (3/4)	15.9 (5/8)	11.1 (7/16)	9.5 (3/8)	7.1 (9/32)
over 2440 to 2740	(Over 96 to 108)	22.2 (7/8)	19.0 (3/4)	14.3 (9/16)	12.7 (1/2)	9.5 (3/8)
over 2740 to 3050	(Over 108 to 120)	25.4 (1.0)	22.2 (7/8)	17.5 (11/16)	15.9 (5/8)	12.7 (1/2)
over 3050 to 3350	(Over 120 to 132)	...	25.4 (1.0)	20.6 (13/16)	19.0 (3/4)	15.9 (5/8)
over 3350 to 3660	(Over 132 to 144)	...	28.6 (1 1/8)	23.8 (15/16)	22.2 (7/8)	19.0 (3/4)
over 3660 to 3960	(Over 144 to 156)	...	31.8 (1 1/4)	27.0 (11/16)	25.4 (1.0)	22.2 (7/8)

<sup>A</sup> See 7.8 for measurement method.

8.4.2.2 *Heat Treated Glasses*—Add 0.031 in. (0.79 mm) to the overall maximum thickness of the laminate for each ply of the heat treated glass in the laminate.

#### 8.5 Length and Width:

8.5.1 Length and width tolerances of symmetrically laminated glass shall be in accordance with Table 3 when measured in accordance with 7.9.

8.5.2 The listed tolerances of overall laminate size include the cutting tolerances of the individual lites as well as the mismatch of the glass lites after the laminating process.

8.5.3 For some laminated applications, such as, point supported glass and balustrades, where the edges of the laminate are exposed, tighter length and width tolerances may be requested by the customer. Consult the supplier to determine their capabilities.

#### 8.6 Flatness:

8.6.1 For laminated glass using annealed transparent glass, the overall bow and warp shall not exceed 1.6 mm (1/16 in.) per 300 mm (12 in.) of length when measured in accordance with 7.8.

8.6.2 Because of the nature of the processes used in manufacturing heat-strengthened, rolled, tempered, or wired glass, these glasses may not be as flat as annealed transparent glass. The deviation from flatness of laminated glass depends on glass type, thickness, width, length, laminating process, and other factors. For other than annealed transparent glasses the overall bow/warp shall not exceed the values shown in Table 4 when measured in accordance with 7.8.

8.6.3 Localized warp for rectangular laminated glass shall not exceed 1.6 mm (1/16 in.) in any 300 mm (12 in.) span of edge.

8.7 *Blemishes*—Maximum allowable laminating process blemishes shall not be greater than those listed in Table 1.

### 9. Keywords

9.1 annealed; blast resistant; bullet resistant; hurricane resistant; glass; heat-treated; interlayer; laminated; safety; security

## APPENDIX

### (Nonmandatory Information)

#### X1. GLASS SELECTION

X1.1 *Visual Mockups*—Viewing full-size mockups under typical site conditions and surrounding landscape is highly recommended for evaluation of reflected and optical distortion.

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