

# GLASS QUALITY STANDARDS

## INSULATING GLASS UNITS (IGU)



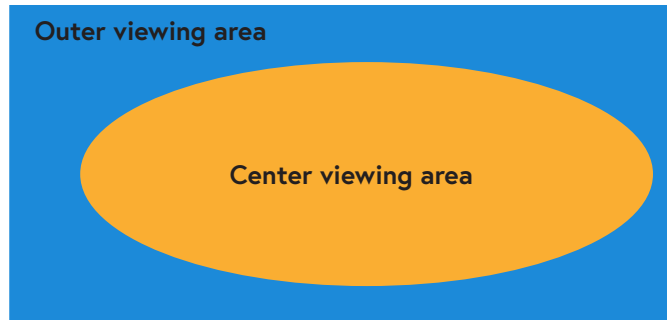
### Visual Quality of Glass Surfaces

All insulating glass units supplied to SoftLite are expected to be clean and free of cosmetic defects that interfere with or detract from the view when looking through a window.

Because windows are viewed through during varying lighting conditions ranging from cloudy overcast days to bright sunny days, it is necessary to review and inspect based on good lighting conditions designed to replicate natural sun light. Considerations shall be given to bright sunny conditions. Windows should not be inspected in direct sunlight.

#### Test Method

The viewer shall clean (if necessary) and inspect the unit in a vertical position. The unit shall be inspected from a distance of 40" and at angles normally used when viewing through a window (no greater than 45 degree angle). Any defect or blemish inside the center viewing area not visible from 40" is considered acceptable. Defects or blemishes in the outer viewing area shall be rejected when visible at a distance of 72". Inspections shall not take more than 10 seconds on units up to 48" x 48" and not more than 15 seconds on units greater than 48" x 48". Industry standards views glass defects at 11 feet.



### Low-E and Tempered Glass

Under natural or artificial light, Low-E glass shall exhibit a detectable reflected color compared to clear glass. This shall be considered representative of the purchased product and not an imperfection or flaw in the product. Slight variations in reflected color may also occur and shall be deemed acceptable. The Low-E coating on the glass must be on the inside of the IGU.

Tempered glass may appear distorted due to the heat-treating process. It may appear wavy or with ripples across the glass surface. This does not indicate a defect .

Type B Glazing Industry Standards*		
Imperfection	Maximum Allowable Size	
	Central Area	Outer Area
Round or Elongated Bubbles	1/2"	3/4"
Surface Cavities (open bubbles)	1/4"	1/4"
Embedded Imperfections	1/16"	1/8"
Deep Short Scratches	1/2"	3/4"
Scratches and Rubs	<i>Shall not be detectable at distances greater than 11 ft</i>	
Lightly Pitted Area	1/2"	3/4"
	<i>Shall not be detectable at distances greater than 11 ft</i>	