Tempered/Toughened Glass                        Meeting Your Aesthetics Needs

Tempered/Toughened safety glass®

Safety glass: protect yourself from injury for complete peace of mind

Description

Chinastar safety glass is a thermally toughened safety glass, the toughening process provides a significantly increased resistance to mechanical and thermal stresses than conventional annealed glass, if fragments safely into small pieces with dulled edges.

Appliance

- Doors: Chinastar safety glass can be used for various types of internal and external and glazed doors.
- Glass assemblies: the sheets of glass are joined together
- Using metal elements to create glass assemblies for the following applications:
  - Doors
  - Shop windows
  - Commercial entrances
● Chinastar safety glass is required for use in table tops, shelving, furniture etc. in the home to reduce the risk of breakage and injury.

● Street furniture: telephone boxes, bus shelters, signs etc. can also be built using safety glass.

● Facades, overhead glazing, spandrel panels: some applications require the use of safety glass, Roughened glass for safety reasons or to provide resistance against thermal and mechanical stresses.
Advantage

- **Fragmentation:**
  If the glass break, Chinastar safety glass considerably reduces the risk of injury as it fragments into small pieces with dulled edges.

- **Increased resistance to metrical Stresses:** the impact resistance and bending strength of Chinastar safety glass is 5 times that of ordinary annealed glass of the same thickness.

- **Increased resistance to stresses:** Chinastar provides greater resistance to thermal stresses than annealed glass.

- **Large glass assemblies:** Chinastar safety glass, joined together using metal elements, can be used for large glazed areas, to minimize the appearance of support structures.

- **Transparency:** Chinastar safety doors help improve lighting in corridor or rooms that are far from external window.

  Chinastar has the same spectrophotometer prophetic as the base product of the same thickness, prior to undergoing heat treatment.

Range

If no information is given as to the type of glass used for producing Chinastar safety glass, the base product is assumed to be Chinastar clear float glass. Otherwise the name of the base product is added after the name (for example: made using is called Chinastar safety glass, Most CHINASTAR GLASS products can be toughened or are available in a toughened version, except for:

- Blown glass or certain drawn glasses
- Certain references in the Chinastar decorative glass range
- Products for which toughening intrinsically changes the characteristics and performance of the produce
(e. g. the toughened versions of Chinastar safety glass have different levels of resistance to certain types of impact from the no toughened version).

Chinastar Safety Glass®
Chinastar Heat-soak Testing

To reduce the risk of toughened glass spontaneously breaking due to the presence of critical nickel sulphide (NIS) inclusions in the sheets of glass, it is advisable to put the toughened glass though an additional heat treatment known as the Heat-soak Test (BSEN14179). This is a destructive test which eliminates the majority of glass that is at risk. However in its current state the technique cannot eliminate 100% of the glass which is at risk. The risk of spontaneous breakage is however considerably reduced.

This treatment is recommended for all situations where the stability of the structure, the maintenance of the barrier and the safety of users may be risk from breakage of the toughened glass.

<table>
<thead>
<tr>
<th>Thickness (mm)</th>
<th>Maximum dimensions (mm)</th>
<th>Minimum dimensions (mm)</th>
<th>Maximum weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>length</td>
<td>width</td>
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</tr>
<tr>
<td>4</td>
<td>2400</td>
<td>1200</td>
<td>350</td>
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<tr>
<td>5</td>
<td>3000</td>
<td>2000</td>
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<tr>
<td>6</td>
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</tr>
<tr>
<td>19</td>
<td>4500</td>
<td>2440</td>
<td>350</td>
</tr>
</tbody>
</table>

There are typical possible dimensions available within Chinastar safety glass and may vary depending from one transformation site to another, Please contact us for further information.
Performance

- **Impact resistance:** its enhanced impact resistance enables an 8mm sheet of Chinastar safety glass to withstand a 500g steel ball dropped from a height of 2m. For comparison, the same ball dropped from a height of 0.3 m would break 8mm annealed glass. Chinastar has been tested in accordance with BS EN12600.

- **Bending strength:** Chinastar safety glass is significantly more resistant to flexural stresses than conventional annealed glass. This resistance is characterized by a bending strength in the region of 120 MPa (BS EN 12150).

- **Resistance to thermal stress:** Chinastar can withstand temperature differences of up to 200°C. For comparison, this around 30°C for ordinary annealed glass.

Processed product variations

Chinastar Safety Glass can be

- Sandblasted or acid etched (the maximum permitted stress will differ from that of non-treated products)
- Drilled and notched: this operation must be performed before toughening treatment (see below).
- Coated with a solar control coating, a low-emissive
- Coating or a self-cleaning coating
- Laminated
- Assembled into a double-glazed unit
- Enamede
- Screen-printed

Glass-to-metal contact is prohibited. Cylindrical parts and the edges of notches are not suitable to bear high stress. The toughening process of Chinastar safety glass can introduce a degree of optical imperfection into the glass in the
form of bow or roller wave distortion. These are inherent to the manufacturing principle and cannot be considered as a defect (see BS EN12150).

**CHINASTAR SAFETY Glass® Processing characteristics**

- Tolerances on thicknesses are the same as for Chinastar Clear Float Glass.
- Tolerance on flatness:
  - Over bow = 0.003mm/mm, Local bow = 0.5mm/300mm

**Edge worked**

Chinastar Safety Glass edgeworked is carried out before toughening. This glass cannot be cut or edge worked after the toughening process. The following standard edgework can be performed:

- Beveled edge or arrived edges
- Ground or smooth ground edge
- Smooth ground or flat
- Polished edge
- Beveled
- Drilled holes have a ground edge finish as standard. Larger apertures can be smoothed or polished.
- Other edge working is available on request.
Drilling

The minimum hole diameter must be equal to the glass thickness (t). in addition, the maximum diameter(Φ) (or the total of the Φ) must be:

- 1/4 of the width of the sheet for Chinastar Safety Glass ≤ 6 mm
- 1/3 of the width of the sheet for Chinastar Safety Glass = 8, 10 and 12 mm
- Rules for the positioning of holes
- Holes with Φ ≤ 40 mm Comply with minimum distance in the drawing below.
Processed Product Variations

Holes with $\Phi > 40\text{mm}$ (fig 2) Comply with the minimum distances in the drawing below.

$\Phi =$ diameter of the hole

<table>
<thead>
<tr>
<th>Normal $\Phi$ of the hole</th>
<th>Tolerance in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 to 50 mm</td>
<td>$\pm 1.00$</td>
</tr>
<tr>
<td>$&gt; 100 \text{mm}$</td>
<td>Please contact us</td>
</tr>
</tbody>
</table>

Tolerances on the holes position
Tolerances on holes position side less than 1m: ±2mm

Sawn holes
Holes linked to the edge by a cutting line.
5mm ≤ d ≤ 2t
Tolerance on the holes position

Processed product variations

Tolerance on the holes position
Rectangular or square holes
X ≥ A/2 and y ≥ B/2
For Chinastar Safety Glass 6mm
A ≤ 1/3 and B ≤ w/4
For Chinastar Safety Glass 8mm A ≤ 1/3 and ≤ w/3, r ≥ 10mm
• **Tolerance on sizes**
  
  Side 5 to 50mm ±1mm

  Side 51 to 100: ±2mm

  Tolerance on the hole position

  Tolerance on positing: ±1.5mm

• **Notches**
  
  When the outer edges of the accessory are aligned with the edges of the glass, the clearance between the inner part of the accessory and the glass must always be between 4mm (maximum) and 1mm (minimum)

• **Rules for position of notices (see fig.5)**
  
  Y1 ≤ X1 and Y1 ≤ X2: the height of a notch must not exceed its width.

  B ≥ X1/2: the distance between two notches must be at least half the width of the largest notch.

  a ≥ X1/2 and a ≥ 100mm; the distance between the notch and the edge of the glass must be at least half the width of the notch, and this distance must be greater than 100mm (see fig.6) R ≥ r: the radius of the notch must be at least equal to the thickness of the glass.
• **Rules for position of angled notches (see fig. 7)**

\[ X \leq \frac{B}{3} \text{ and } X \leq 200\text{mm} \]

\[ Y \leq \frac{H}{3} \text{ and } Y \leq 200\text{mm} \]

The width of the notch must not exceed 1/3 the width of the sheet of glass, for flat tempered, the width or height of the notch must not exceed 200mm.

Tolerance on notch position

Tolerance on positioning: ± 2mm
Processed product Variations….

**Special cases**

Trapezoidal sheets

Do not exceed the length/width ratio $< 8$

Where width $=(A+B)/2$ and $B$ must be at least 250mm

Acute angle sheets

The same rules as for trapezoidal sheets apply. Section $B$ (above) cannot be notched, sometimes known as “shortened corner”, and is measure in the following way (in mm):

IF $U =$ the acute angle,(expressed in degrees)

$Y \leq 65^\circ$ : $B_{\text{min}} = 18 - 0.2 \times Y$

$Y \geq 65^\circ$ : $B \geq 5$mm

The guidance given above is indicative and final manufacturing confirmation should be sought from the supplying branch.
Installation Guidelines

Chinastar glass Safety Glass must always be installed in accordance with current national standard and regulations.

The design of as Chinastar Safety Glass assembly must comply with the following guidelines

Attach Chinastar safety tempered glass to the structure and ensure the assembly is rigid using wind bracing, or if necessary metal tie rods.

Ensure the sheets of glass are fully joined together. The installation must withstand all the stresses in the various planes.

Provides sufficiently strong hinges and cross bars to support the glass.

Check the thickness of ceilings or floors for installation of closers, anchoring flanges etc…
Breaking one sheet must not result in all or part of the rest of the installation falling if the height of the installation is less than 3m. For installations higher than 3m, the simultaneous breaking of 2 sheets must not result in all or part of the rest of the installation falling.

The interfaces, support conditions and installation conditions all have a major influence on the maintenance of the mechanical properties of Chinastar safety glass. For this reason, CHINASTAR GLASS has a wide range of parts and accessories for creating combinations and to ensure that the assembly is long-lasting.

**Wind bracing**

Chinastar safety glass assemblies frequently require wind bracing. This ensures the resistance, rigidity and stability of structures and only bears the forces exerted in their plane of inertia. (see fig 9)

A- high (or low) wind bracing in one sheet.

B- Wind bracing across the whole height in two sheets (or more) on one side or overlapping. Minimum width: 30cm,

C- Wind bracing across the whole the whole height in one sheet on one side or overlapping. Minimum width: 30cm
Installation Guidelines

In all cases, the parameters in the table for the range and the manufacturing instructions regarding edgework must be complied with. Chinastar safety glass assemblies must be fitted with wind bracing in the following cases. If one side of the dimensions AR or BR are < 30cm, wind bracing will not be necessary, regardless of the other dimensions.

Installations with doors.

Transom in several parts

Add wind bracing if:

- Metal glazing bead AR + BR > 140cm
- Exposed anchors
- Cement housing AR + BR > 160cm

-piece transom
Add wind bracing if:

Metal glazing bead AR+ BR  >  160cm

Exposed anchors

Cement housing AR+BR  >  180cm

**Installation Guidelines**

Installation without doors
Add wind bracing if:
AP + BP  >  350cm

Installation extended with non-toughened glass
-Wind bracing must be used:
Clearance in the base of channels: ≤ 5mm

Clearance between sheets of glass:
-Fixed: ≤ 3mm
-Moveable: 2mm

Door clearance
-Laterally: 2mm
- At the bottom: 7mm
- At the top
- Ordinary door: 3mm
- Folding door: 7mm

**Standards and Regulations**

For sizing complying with current national regulations, see “Determining the thickness of glass”. For Chinastar safety glass, Chinastar decorative glass and patterned glass, the size and choice of thickness must consider the depth of the pattern on the chosen reference. In some cases, the presence of a deep design will require a thicker glass.

Chinastar safety glass complies with the requirements of standard BS EN 12150. Chinastar safety glass bears permanent marking the processing site and the relative EN standard BS EN 12150, Chinastar safety glass carries the relevant CE marking as required.

**Do you know?**

Toughened glass cannot be drilled or edgeworked in any manner. Sandblasting or other surface treatments should be carried out prior to toughening as per AS1288 - 1994. Deep sandblasted patterns greater than 1mm is not permissible;

Toughened glass ordered to templates must be accompanied with a full scale template made to the correct dimensions. These must be...
made from a rigid material. Orders submitted with complex drawings and sizes to avoid template construction will either be rejected or executed at the customer’s risk;

Minimum edgework finish on toughened glass up to 12mm is a standard arrised edge. Minimum edgework on greater thicknesses should be a flat ground edge;

Slight distortion or bowing may occur after toughening but is largely controllable. It will vary with substance, tint, surface treatment, size and shape of the glass. Ceramic painted, sandblasted or reflective coated glass has a greater tendency to bow and special tolerances would be advised. Flatness will be measured when the glass is standing on edge with a straight edge placed along the full length of the panel and a wedge measurement taken at the centre position. Refer to our technical department for more information.