



Standard Test Method for Structural Performance of Glass in Windows, Curtain Walls, and Doors Under the Influence of Uniform Static Loads by Nondestructive Method¹

This standard is issued under the fixed designation E 998; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method is a nondestructive test procedure to establish the nature of stresses induced in glass in windows, curtain walls, and doors subjected to uniform static loads. A procedure is provided for using this stress information to estimate the probability of failure of the glass.

1.2 This test method is applicable to glass of various degrees of temper; for example, annealed, heat-strengthened, fully tempered, laminated, insulated, and combinations thereof.

1.3 This test method describes a process of applying specific test loads to glass. The test may be conducted using the standard test frame specified herein or a test frame of the user's design.

1.4 The values stated in inch-pound units are to be regarded as standard.

1.5 *This standard does not purport to address all of the safety problems, 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.* For specific precautionary statements see Section 6.

2. Terminology

2.1 *aspect ratio*—a ratio of long side to short side of glass plate.

2.2 *average breaking stress (ABS)*—the average maximum principal tensile stress (MPTS) at failure, representative of the glass under test. The ABS is dependent on a number of factors including geometry, time history of load, surface condition, etc. Glasses with residual surface stresses, such as heat-strengthened or fully tempered, must have their residual stresses added to the state of stress at the specified load. As defined for use in the standard, the ABS is for annealed glass.

2.3 *coefficient of variation*—the ratio (decimal fraction) of the standard deviation of the maximum principal tensile stress (MPTS) at failure to the ABS.

2.4 *equivalent design load*—a magnitude of a 60-s duration uniform load selected by specifying authority to represent design loads.

2.5 *glass specimen*—the glass to be tested, for example, a single pane, an insulating glass unit, laminated glass, etc. (does not include test frame).

2.6 *maximum principal tensile stress (MPTS)*—a maximum calculated tensile stress based on strain gage measurements.

2.7 *negative load*—a load that results in the indoor side of a glass specimen being the high-pressure side.

2.8 *permanent set of test frame*—a load-induced permanent displacement from an original position of the test frame.

2.9 *positive load*—a load that results in the outdoor side of a glass specimen being the high-pressure side.

2.10 *probability of failure*—the probability that a glass specimen fails when tested at a given equivalent design load. General industry practice to express probability as lights per 1000 lights.

2.11 *residual stress*—an initial, state of stress on unloaded, unglazed glass resulting from manufacturing process (heat-strengthening, tempering).

2.12 *specifying authority*—the professional or professionals responsible for determining and furnishing the information required to perform this test method as described in Section 9.

3. Summary of Test Method

3.1 This test method consists of:

3.1.1 Glazing the test specimen into a test frame that is mounted on or against a test chamber.

3.1.2 Supplying or exhausting air from the chamber at a rate required to maintain test-pressure difference across the test specimen.

3.1.3 Measuring and observing deflections, deformations, specimen strains, and the nature of any failures.

3.1.4 Recording the results in an orderly manner.

3.2 Methods of loading to nondestructive levels are provided.

3.3 Test data are used to predict glass structural performance characteristics.

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4. Significance and Use

4.1 This test method is a standard procedure to determine a stress pattern and estimate a probability of failure of glass tested under uniform static loads.

4.2 Loads on glass in windows, curtain walls, and doors may vary greatly in magnitude, direction, and duration. An understanding of wind loads on the building is desirable for selection of test loads and interpretation of results with respect to expected exposure at a particular site.

4.3 The strength of glass varies with many different factors including surface condition, load duration, geometry, relative humidity, and temperature (1, 2, 3, 4).²

4.4 A thorough understanding of the variations of the strength of glass and the nature of loading is required to interpret results of this test method.

4.5 The proper use of this test method requires a knowledge of the principles of pressure, deflection and strain measurement, stress/strain relationships, and statistical estimating techniques.

5. Apparatus

5.1 The description of apparatus is general in nature. Any equipment capable of performing the test procedure within the allowable tolerances is permitted.

5.2 Major Components:

5.2.1 *Test Frame*, in which glass specimens are mounted for testing. The test frame shall provide either standardized support conditions or specified support conditions. Specifications of standardized support conditions are presented in Annex A1.

5.2.2 *Test Chamber*, sealed, with an opening in which or against which the test frame is installed. At least one static pressure tap shall be provided to measure the test chamber pressure and shall be so located that the reading is minimally affected by the velocity of the air supply to or from the test chamber or any other air movement. The air supply opening into the test chamber shall be arranged so that the air does not impinge directly on the glass specimen with any significant velocity. A means of access into the test chamber may be provided to facilitate adjustments and observations after the specimen has been installed.

5.2.3 *Air System*, a controllable blower, compressed air supply, exhaust system, reversible blower or other device designed to apply the equivalent design load to the glass specimen with required control.

5.2.4 *Pressure Measuring Apparatus*, to record continuously the test chamber pressure within an accuracy of $\pm 2\%$.

5.2.5 *Deflection-Measuring System*, for measuring deflections within an accuracy of ± 0.01 in. (0.25 mm).

5.2.5.1 The deflection indicator shall be mounted so that deflection of the test chamber or test frame is not included in the deflection gage reading. Provisions shall be made to ensure that readings can be made from a safe location.

5.2.6 *Strain Gage Measurements*—Appendix X1 describes apparatus and techniques required for proper strain measurements on glass.

5.2.7 *Temperature Measuring Apparatus*, to measure the ambient temperature within an accuracy of $\pm 1^\circ\text{F}$ (0.6°C).

5.2.8 *Relative Humidity Measuring Apparatus*, to measure the relative humidity within an accuracy of $\pm 2\%$.

6. Safety Precautions

6.1 Proper precautions to protect observers in the event of glass specimen failure should be observed. At the pressures used in this test method, considerable energy and hazard are involved. In cases of failure, the hazard to personnel is less with an exhaust system, as the specimen will tend to blow into rather than out of the test chamber. No personnel should be permitted in such chambers during tests. All reasonable precautions should be exercised during conduct of the test.

7. Sampling and Glass Specimens

7.1 Surface condition, cutting, fabrication and packaging of the glass specimens to be tested shall be representative of the glass whose strength is to be evaluated.

7.2 All glass specimens shall be visually inspected for edge or surface irregularities prior to testing, and all questionable glass specimens shall not be tested. All questionable glass specimens shall be reported to the specifying authority.

7.3 Glass specimens shall be handled carefully at all times because the strength of glass is influenced by its surface and edge conditions.

8. Calibration

8.1 Pressure-measuring systems, deflection-measuring devices, and strain gages should be routinely checked. If calibration is required, the manufacturer's recommendations or good engineering practice shall be followed.

9. Required Information

9.1 The specifying authority shall provide the magnitude of the equivalent design load (positive or negative) and the allowable probability of failure for the glass specimens.

9.2 The specifying authority shall state whether the glass specimens shall be glazed in a standard test frame or in a test frame designed to simulate a specific glazing system. If the test frame is to simulate a specific glazing system, complete glazing details and support conditions shall be provided by the specifying authority.

10. Procedure

10.1 Measure and record ambient temperature and the relative humidity.

10.2 Install strain gages to the low pressure side of the glass specimen according to procedures in Annex A2.

10.3 Install glass specimens in the test frame in accordance with recommendations in Annex A1 for standard support conditions or as specified for a specific glazing system.

10.4 Record reference strain reading at no-load conditions.

10.5 Load specimen to low level pressure, 20 % of design load for 1 min. Release load. Allow 3 to 5-min gage and restoration time.

10.6 Apply one half of the design load to the glass specimen. Take initial set of pressure, deflection, and strains at one half of design load. Reduce the test pressure to 0, and vent the

² The boldface numbers in parentheses refer to the references listed at the end of this test method.

test chamber for a period of 3 to 5 min before pressure-measuring apparatus is adjusted to zero.

10.6.1 If air leakage around the test specimen is excessive, tape may be used to cover any cracks and joints through which the leakage is occurring. Tape shall not be used when there is a probability that it may significantly restrict differential movement between the glass and test frame.

10.7 Apply load to the glass specimen in increments of 20 % of design load, recording strain gage readings at each increment. Maintain the load at each increment of design load until all strain gage readings are taken. For each increment, the load should not be applied for a period under 1 min or longer than 5 min in duration. Continuous load-time records shall be kept for the duration of the loading.

10.8 If specimen fails prior to design load, check for permanent set of test frame and chamber damage. Test another gaged specimen if necessary.

11. Report

11.1 The report shall include the following information:

11.1.1 Date of the test, the date of the report, the ambient temperature, and the relative humidity.

11.1.2 Identification of the glass specimens (manufacturer, source of supply, dimensions, both nominal and measured, manufacturer's designation, materials, and other pertinent information).

11.1.3 Detailed drawings of the glass specimen, test frame, test chamber, a complete description of pressure-measuring apparatus, all other instrumentation, and a statement that the test was conducted using a standard test frame or a test frame of the user's design.

11.1.4 Records of pressure differences exerted across each glass specimen during the test with each specimen being properly identified.

11.1.5 Probability of failure (Z_o) as calculated in Section 12 (Analysis).

11.1.6 Identification or description of any applicable specification.

11.1.7 A statement that the tests were conducted in accordance with this test method, or a full description of any deviations.

12. Analysis

12.1 An analysis of the structural performance of the glass specimen(s) shall be made.

12.2 *Procedure A:*

12.2.1 Calculate maximum principal stress from strain gage data (see Appendix X1).

12.2.2 *Average Breaking Strength of Glass (ABS)*—The *ABS* is a necessary value for use in analyzing the structural

performance of the glass. For new glass, the *ABS* should be obtained from the appropriate glass manufacturer for the glass in question. For glass that have been in service, or treated by others (weathered, altered, damaged, scratched, or mechanically altered) engineering judgement should be used or a glass technologist consulted to determine the *ABS*. The area of the glass light and the duration of imposed load affect the *ABS*. The magnitude of the load duration effect can be roughly approximated by using Eq X1.1 in Appendix X1.

12.3 *Probability of Failure*—Once glass *ABS* is established (Procedure A), the normal probability distribution function is used to predict probability of failure. The probability of failure for glass is calculated as follows:

$$\text{Area} = Pr(Z \geq z_o) \quad (1)$$

$$Z_o = \frac{X - ABS}{CV \times ABS}$$

where:

X = maximum glass tension stress resulting from specified or test wind load, psi (MPa),

ABS = glass *ABS*, psi, (MPa),

CV = coefficient of variation, 0.22 for annealed glass, and

Z_o = standard normal variable (see Table X1.2).

Using the standard normal distribution table, the area to the right of the Z_o indicates the probability of failure at that level (see Table X1.2).

NOTE 1—Glasses with residual surface stresses, such as heat-strengthened or fully tempered, must have their residual stresses added to the state of stress at the specified load. For example, the state of stress of a heat-strengthened glass surface is 5000 psi (35 MPa) at design load, if the glass has a residual compressive stress on the surface of -3500 psi (24 MPa), the resulting tensile stress component is 1500 psi (10 MPa) at design load.

NOTE 2—Load/stress relationships for large deflections in glass may be adequately defined by finite-element computer techniques. The values obtained by this technique will be useful for defining probability of failure estimates at various load/glass stress combinations.

13. Precision and Bias

13.1 No statement is made about either the precision or the bias of this test method for measuring the structural performance of glass since the result merely states whether the probability of failure of the glass specimens is significantly greater than the specified probability of failure or not.

14. Keywords

14.1 curtain walls; doors; glass performance; nondestructive testing; performance testing; strain gages; structural performance; uniform static loads; windows

(Mandatory Information)

A1. STANDARD GLASS TEST FRAME

A1.1 Introduction

A1.1.1 The standard test frame shall be designed to support a rectangular glass specimen in a vertical plane and expose it to a positive (inward-acting) load. The test frame consists of two primary systems: a structural support system and a glazing system. The structural support system shall be designed to resist applied loads with limited deflections and provide an interface between the test chamber and the glazing system. The glazing system shall be designed to limit lateral displacements of the glass specimen edges while minimizing rotational and in-plane restraints of the glass specimen edges. This annex presents pertinent details relating to the design and construction of a standard test frame.

A1.2 Structural Support System

A1.2.1 The structural support system consists of four main structural members arranged as shown in Fig. A1.1. The inside rectangular dimensions, a and b , of the support system shall be found by subtracting 1 in. from the corresponding dimensions of the glass specimens. These dimensions shall be maintained within a tolerance of $\pm 1/16$ in. (1.6 mm).

A1.2.2 The structural members shall be selected from available American Standard channels with flange widths greater than or equal to $1\frac{3}{4}$ in. (44 mm). The structural members are to be designed to withstand the appropriate proof load without permanent deformations. In addition, the structural members shall be designed to meet the following deflection criteria:

A1.2.2.1 The maximum lateral deflection (referenced to glass specimen) of the structural members shall not exceed $L/750$ where L is the length of the shorter side of the glass specimen,

A1.2.2.2 The maximum rotation of the structural members shall not exceed 1° , and

A1.2.2.3 The maximum in-plane deflection (referenced to the glass specimen) of the structural members shall not exceed $L/2000$.

A1.2.3 The corner connections of the support system shall be designed using angle braces and bolts to minimize racking or twisting during testing.

A1.2.4 In addition to the above criteria, the following fabrication tolerances shall be met:

A1.2.4.1 The maximum out-of-plane offset at the corners shall not exceed $1/64$ in. (0.4 mm) (see Fig. A1.1),

A1.2.4.2 The maximum planar variation of the outside edges of the structural members shall not exceed $1/16$ in. (1.6 mm).

A1.2.4.3 The maximum difference in the measured diagonals of the interior rectangular opening shall not exceed $1/8$ in. (3.2 mm), and

A1.2.4.4 The depth of the structural members shall be sufficient to allow unimpaired lateral displacements of the glass specimens during the test.

A1.2.5 Finally, holes shall be provided as required in the flanges of the structural members for fasteners.

A1.3 Glazing System

A1.3.1 The glazing system, which attaches to the vertical structural support system, consists of the following major components (see Fig. A1.2, Fig. A1.3 and Fig. A1.4):

A1.3.1.1 Inside and outside glazing stops,

A1.3.1.2 Aluminum spacers,

A1.3.1.3 Inside and outside neoprene gaskets,

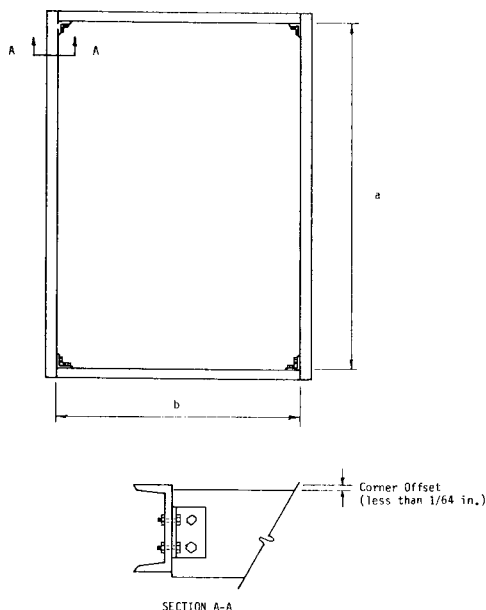


FIG. A1.1 Structural Support System

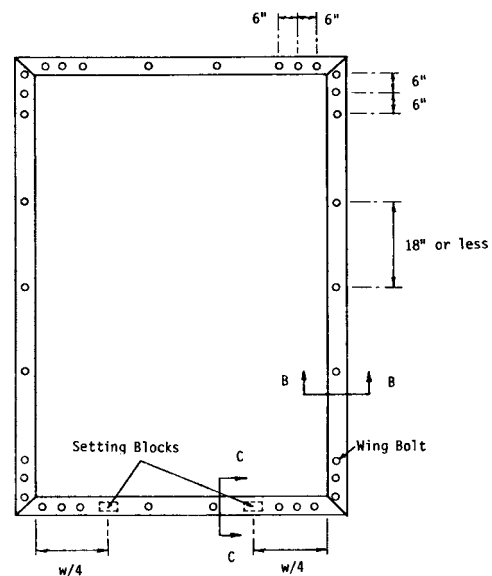


FIG. A1.2 Standard Glazing System

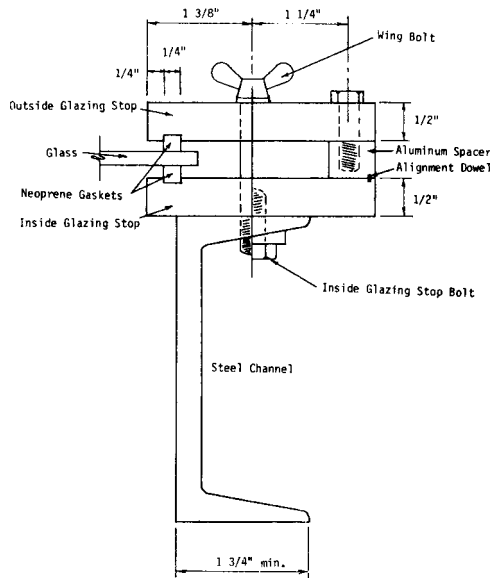


FIG. A1.3 Section B-B of Standard Glazing System

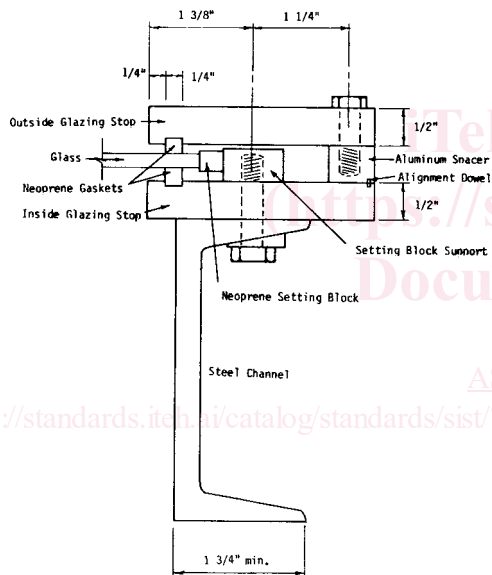


FIG. A1.4 Section C-C of Standard Glazing System

A1.3.1.4 Structural fasteners, and

A1.3.1.5 Neoprene setting blocks.

A1.3.2 The glass specimen rests on two neoprene setting blocks (85 ± 5 shore A durometer) as shown in Fig. A1.4. The glass specimen is laterally supported around its perimeter with neoprene gaskets (65 ± 5 shore A durometer). The glass specimen shall be centered within the glazing system to a tolerance of $\pm 1/16$ in. (1.5 mm). A minimal clamping force (4 to 10 lbf/in. (700 to 1750 N/m)) is applied to the edge of the glass specimen by loosely tightening the wing bolts that are spaced around the specimen perimeter.

A1.3.3 The glazing stops shall be fabricated using $1/2$ by 3-in. (13 by 76-mm) aluminum bar stock (6061 T6511) in sections no shorter than 24 in. (610 mm) or the smaller

rectangular glass specimen dimension. A $1/8$ by $3/8$ -in. (3.2 by 9.5-mm) rectangular slot shall be machined in the glazing stops as shown in Fig. A1.3. At each corner the glazing stops are to be mitered and fitted as shown in Fig. A1.2.

A1.3.4 The inside glazing stop shall be fastened to the top flange of the structural support members using $1/4$ -in. (6.4-mm) diameter bolts. These bolts pass through a clear hole in the channel flange into a threaded hole in the inside glazing stop. These bolts are not to extend above the surface of the inside glazing stop. These bolts shall be spaced no further than 24 in. (610 mm) apart with no fewer than two bolts per glazing stop section.

A1.3.5 The outside glazing stop shall be secured to the support system using $3/8$ -in. (9.5-mm) diameter wing bolts. These bolts pass through the outside glazing stop, through the inside glazing stop, and into a threaded hole in the support channels. In the corner areas there shall be three wing bolts spaced at 6-in. (152-mm) intervals as shown in Fig. A1.2. Between these corner bolts, the bolts shall be spaced no further than 18 in. (457 mm) apart with a minimum of two bolts per glazing stop section.

A1.3.6 The rectangular aluminum spacers shall be fabricated using $3/4$ -in. (19-mm) wide aluminum bar stock. The depth of the spacers shall be equal to the thickness of the glass plus $3/8$ in. (9.5 mm). This dimension shall be maintained within a tolerance of $\pm 1/32$ in. (0.8 mm). The lengths of the spacers shall correspond to the lengths of matching outside glazing stop sections. In corner areas the spacers shall extend no further than 1 in. (25.4 mm) past the corner of the installed glass specimen. The spacers shall be fastened to the outside glazing stops using $1/4$ -in. (6.4-mm) diameter bolts. These bolts pass through the outside glazing stop into a threaded hole in the spacer. These bolts shall be spaced no further than 24 in. (610 mm) apart with no fewer than 2 bolts per glazing stop section.

A1.3.7 Two neoprene (85 ± 5 shore A durometer) setting blocks shall be centered at the quarter points of the glass specimen as shown in Fig. A1.2. Appropriate supports, fastened through the inside glazing stop to the support channels, shall be provided. The required length of a setting block (in inches (in millimetres)) is found by multiplying the glass specimen area (square metres) (square feet) by 0.10. However, in no case shall the setting block length be less than 4 in. (102 mm). The width of the setting block shall be $1/16$ in. (1.6 mm) greater than the specimen thickness so that continuous support across the thickness of the specimen is provided.

A1.3.8 The neoprene gaskets shall be fabricated using $5/16$ -in. (7.9-mm) thick neoprene (65 ± 5 shore A durometer) to fit snugly into the glazing stop slots. These gaskets shall be placed so that continuous support of the glass specimen perimeter is achieved. The gaskets may be held in place using an appropriate glue or cement. However, the neoprene surface in contact with the glass specimen shall be kept free of all foreign materials.

A1.3.9 Silicone sealant or other appropriate material may be used to seal joints against leakage. However, under no circumstances is a sealant to contact the glass specimen.

A2. INSTALLATION OF STRAIN GAGES

A2.1 Glass Surface Preparation Safeguards and Cleaning Recommendations

A2.1.1 *Glass Surface Preparation Safeguards*—The purpose of surface preparation is to develop a chemically clean surface appropriate to the strain-gage installation. Cleanliness is vital throughout the surface preparation process. It is important to guard against recontamination of a once-cleaned surface by:

A2.1.1.1 Never touching or placing dirty or contaminated objects on a clean area to be strain-gaged.

A2.1.1.2 Protecting the area to be strain-gaged from airborne contaminants in unclean areas if glazing is delayed by covering the cleaned area with plastic film.

A2.1.2 *Glass Cleaning Recommendations*—It is usually advisable to thoroughly clean the entire surface of a plate to be strain-gaged (if plate area ≤ 30 to 40 ft²) to avoid transfer of contaminants from an uncleaned adjacent area to the area being strain-gaged. A variety of cleaning agents can be used for providing a chemically clean surface. A 1:1 solution of isopropyl alcohol and demineralized or distilled water applied with clean, untreated cotton gauze, or paper towels has been found to be an effective final cleaning practice. For extremely dirty glass substrates, degreasing to remove oils, greases, organic contaminants, and chemical residues may be necessary. A variety of solvents and techniques are available for this cleaning operation. Caution and care must be exercised in their selection and use to preclude bodily injury or harm and possible damage to coated glass substrates.

A2.2 Strain Gage Lay-Out Lines Application

A2.2.1 Perform a general cleaning of the glass surface(s) to be strain-gaged in accordance with A2.1.2.

A2.2.2 Using India ink reservoir pens, overhead projection pens (both water soluble and permanent inks), or other similar markers, draw perpendicular crossing strain gage location lay-out lines on the glass surface at the specific location and orientation (direction of strain measurement) where the strain gages are to be placed.

NOTE A2.1—Layout lines are usually left on the substrate until the gage position and orientation are established. Gages are typically installed such that the longitudinal and transverse gage axes markings are aligned with the layout lines on the substrate. The line portions where the gages are bonded to the substrate are removed just prior to application of the bonding cement.

A2.3 Strain Gage Installation Methods, Techniques, and Tips

A2.3.1 *Test Environment and Duration of Test*—The type of strain gage and bonding cement will in large part be predicated by the test environment and duration of test. If the test is to be performed in wet, rainy, high humidity or high temperature conditions, or combination thereof, or if the test exceeds several weeks in duration, the strain gage manufacturer should be contacted for specific bonding cement recommendations.

A2.3.2 *Strain Gage Application:*

NOTE A2.2—Strain gage application techniques should also be available from the strain-gage supplier.

A2.3.2.1 On a clean portion of the test plate, away from the gage locations, adhere 1 in. wide by 6 in. long (25 mm wide by 152 mm long) cellophane tape strips, one piece for each of the strain gages to be installed. If wrinkles, loops, or twists appear in any of the tape pieces, replace them. Fold the ends back, adhesive to adhesive, for about ¼ in. (6.4 mm) to simplify lifting the tape in subsequent steps.

A2.3.2.2 Remove strain gages from the packaging material, handling strain gages individually with clean tweezers. Care shall be taken not to damage the gage by crimping, bending, or cutting by using tweezers with irregular contact surfaces.

A2.3.2.3 Pull back one end of one cellophane tape piece to near the central region.

A2.3.2.4 Orient the strain gage so that the gage axes correspond to preferred orientation on the plate layout lines, and center the strain gage on the tape prior to adhering to the cellophane tape. The strain gage grid and solder connections must be toward the tape adhesive. Repeat for all gages being installed.

A2.3.2.5 Re-adhere the tape and the gage to the glass plate, observing the precautions in A2.3.2.1. Repeat for all strain gages.

A2.3.2.6 Carefully and accurately mark strain gage axes on the cellophane tape using a magnifier, a straight-edge, and a marker used for plate layout. Fine lines are preferable and should extend the length and width of the tape. Repeat for all strain gages.

A2.3.2.7 *Grasp* one piece of cellophane *tape at both ends* (to restrain curling, rolling, and twisting), and carefully lift the tape and gage from glass plate.

A2.3.2.8 Superimpose cellophane tape gage axes lines over the glass plate layout lines at the desired location.

A2.3.2.9 Press the tape to the plate when lines are satisfactorily superimposed. Repeat for all strain gages.

A2.3.2.10 Grasp one end of tape and carefully lift at a shallow angle ($\sim 30^\circ$) until the gage has been lifted from plate contact. Continue lifting the tape until it is free from the plate approximately 1 in. (25 mm) beyond the strain gage. The glass plate layout lines at the strain gage should be exposed.

A2.3.2.11 Pull the lifted end of the tape over the adhered end, exposing the strain gage and the tape mastic, and adhere the lifted end of the cellophane tape to the glass. This forms a loop in the tape with the mastic side up and the strain gage exposed.

A2.3.2.12 Using a clean cotton cloth or paper towel and a non-residue cleaning solvent, for example, 1:1 solution of isopropyl alcohol and water, carefully and thoroughly clean area where the strain gage will bond to the glass plate, removing only the glass layout lines that are beneath and immediately adjacent to the strain gage site. The paper towel or cotton cloth used should be clean, untreated, or free of soapy materials, or combination thereof.