



Designation: C 1349 – 96

Standard Specification for Architectural Flat Glass Clad Polycarbonate¹

This standard is issued under the fixed designation C 1349; 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 approval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the quality requirements for cut sizes of glass clad polycarbonate (GCP) for use in buildings as security glazing.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 *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 Products²
- C 1036 Specification for Flat Glass²
- C 1048 Specification for Heat-Treated Flat Glass—Kind HS, Kind FT Coated and Uncoated Glass²
- C 1172 Specification for Laminated Architectural Flat Glass²
- D 256 Test Method for Determining the Pendulum Impact Resistance of Notched Specimens of Plastics³
- D 638 Test Method for Tensile Properties of Plastics³
- D 648 Test Method for Deflection Temperature of Plastics Under Flexural Load³
- D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials³
- D 792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement³
- D 1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics³

D 1005 Test Method for Measurement of Dry-Film Thickness of Organic Coatings Using Micrometers⁴

D 1044 Test Method for Resistance of Transparent Plastics to Surface Abrasion³

D 3763 Test Method for High-Speed Puncture Properties of Plastics Using Load and Displacement Sensors⁵

E 308 Practice for Computing the Colors of Objects by Using the CIE System⁴

2.3 ANSI Standard:

Z97.1 Safety Glazing Materials Used in Buildings—Safety Performance Specifications and Methods of Tests⁶

2.4 Federal Document:

CPSC 16 CFR 1201 Consumer Product Safety Commission Safety Standard for Architectural Glazing Materials⁷

2.5 Other Document:

Uniform Building Code Standard 52-4⁸

3. Terminology

3.1 *Definitions*—Refer to the terminology in the ASTM standards referenced in 2.2, as appropriate.

3.1.1 *blemishes in flat glass*—refer to Specification C 1036, as appropriate.

3.1.2 *blemishes in polycarbonate*—refer to Appendix X1.

3.2 *Definitions of Terms Specific to This Standard:*⁹⁶

3.2.1 *adhesion chips*—glass particles or crystalline material that is permanently bonded to the surface of a lite.

3.2.2 *aliphatic polyether urethane*—a thermoplastic interlayer required to bond polycarbonate lite to polycarbonate or glass lite.

3.2.3 *asymmetrical construction*—see *non-symmetrical*.

3.2.4 *blow-in*—a separation of glass or polycarbonate and interlayer at or close to the laminate edge.

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

¹ This specification is under the jurisdiction of ASTM Committee C-14 on Glass and Glass Products and is the direct responsibility of Subcommittee C14.08 on Flat Glass.

Current edition approved July 10, 1996. Published September 1996.

² *Annual Book of ASTM Standards*, Vol 15.02.

³ *Annual Book of ASTM Standards*, Vol 08.01.

⁴ *Annual Book of ASTM Standards*, Vol 06.01.

⁵ *Annual Book of ASTM Standards*, Vol 08.02.

⁶ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

⁷ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁸ Available from International Conference of Building Officials, 5360 South Workman Mill Road, Whittier, CA 90601.

3.2.6 *bond*—adhesion of the glass or polycarbonate ply to the interlayer.

3.2.7 *bow and warp*—a curve, bend, or other deviation from flatness.

3.2.8 *carbon specks*—flakes of carbon inherent in the manufacturing and extrusion of polycarbonate sheets.

3.2.9 *crizzle*—an imperfection in the form of a multitude of fine surface fractures.

3.2.10 *deflection temperature*—the softening temperature as determined by applying heat and load to a material.

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

3.2.12 *discoloration*—areas that are blushed, whitish, or yellow in appearance.

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

3.2.14 *edge boil*—see *boil*.

3.2.15 *elongation*—the increase in length of a material that has been stretched.

3.2.16 *flammability rating*—the rate of burn; a CC-1 rating is based on a rate of burn less than one in./min.

3.2.17 *flexural modulus*—the stiffness/rigidity of a material as determined by bending the material at stresses less than that required to produce permanent deformation.

3.2.18 *fuse*—see *adhesion chips*.

3.2.19 *glass clad polycarbonate (GCP)*—one or more lites of flat glass bonded with an aliphatic urethane interlayer to one or more sheets of extruded polycarbonate in a pressure/temperature/vacuum laminating process. (PVB may be used to bond glass to glass only.)

3.2.20 *hair*—a thin filament resembling thread or animal hair.

3.2.21 *haze*—the percentage of transmitted light that, in passing through a specimen, deviates from incident beam by forward scattering.

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

3.2.23 *instrumented dart*—a test evaluating the puncture properties of plastics over a range of test velocities.

3.2.24 *interlayer*—a material developed specifically for bonding glass lites to glass lites, polycarbonate to polycarbonate, or glass and polycarbonate lites together.

3.2.25 *interlayer scuff*—a dirt streak.

3.2.26 *izod milled notch*—a test evaluating the resistance of plastics to breakage by flexural shock. The notch in the izod specimen serves to concentrate the stress, minimize plastic deformation, and direct the fracture to the part of the specimen behind the notch.

3.2.27 *laminate*—see *glass clad polycarbonate*.

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

3.2.29 *lite*—an assembly of glass clad polycarbonate.

3.2.30 *mismatch*—misalignment of the edges of two or more plies of glass or polycarbonate.

3.2.31 *non-symmetrical*—an assembly for which the thickness and types of glass, polycarbonate, and interlayer are not the same about the thickness center.

3.2.32 *offset*—a mismatch of the edges of two or more glass or polycarbonate plies as part of the design of the laminate.

3.2.33 *ply*—one sheet or panel of glass or polycarbonate in a laminate.

3.2.34 *PVB*—a polyvinyl butyral interlayer used to bond glass to glass.

3.2.35 *scratch*—damage on a glass or polycarbonate surface in the form of a line caused by the relative movement of an object across and in contact with the surface.

3.2.36 *separation*—see *delamination*.

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

3.2.38 *specific gravity*—the ratio of a given volume of a material to the weight of an equal volume of water at standard conditions.

3.2.39 *streak*—a smudging effect in the laminate due to dirt or primers applied during manufacturing.

3.2.40 *surfaces*—surfaces of glass and polycarbonate faces are counted from the exterior (threat) to the interior (protected). If a laminate of glass-interlayer-polycarbonateinterlayer glass is used as an example, the No. 1 surface is the surface that is to the exterior; the Nos. 2 and 3 surfaces are the next glass and polycarbonate surfaces, respectively, separated by and bonded to the interlayer material; the Nos. 4 and 5 surfaces are the following polycarbonate and glass surfaces, respectively, that are separated by and bonded to the interlayer; the No. 6 surface is the surface that is to the interior.

3.2.41 *symmetrical*—an assembly for which the thickness and types of glass, polycarbonate, and interlayers are the same about the thickness center.

3.2.42 *tabor abrasion*—a measure of the effect of a specific type of abrasion; the change in percent haze is measured for transparent materials, and weight loss is measured for opaque materials.

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

3.2.44 *tensile strength*—the load that causes a material to break during elongation/stretching.

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

4. Classification

4.1 *Kinds*—Glass clad polycarbonate furnished under this specification shall be of the following kinds, as specified:

4.1.1 *Kind GCP, Single Core (SC)*—Glass clad polycarbonate consisting of one or more lites of flat glass bonded with an aliphatic urethane interlayer to one sheet (single core) of polycarbonate in a pressure/temperature/vacuum laminating process.

4.1.2 *Kind GCP, Multiple Core (MC)*—Glass clad polycarbonate consisting of one or more lites of flat glass bonded with an aliphatic urethane interlayer to more than one sheet (multiple core) of polycarbonate in a pressure/temperature/vacuum laminating process.

5. Ordering Information

5.1 *Procurement Information*—Purchasers should select the applicable options permitted in this section and include the following information in procurement documents:

- 5.1.1 Title, number, and date of this specification;
- 5.1.2 Kind of GCP, as referred to in this specification (see Section 4);
- 5.1.3 Edgework requirements (see 8.2);
- 5.1.4 Overall nominal thickness of the GCP, including the nominal thickness and treatment of glass plies and the nominal thicknesses of the polycarbonate and interlayer material;
- 5.1.5 Nominal length and width of the GCP;
- 5.1.6 Blueprint, drawing, template, orientation, or other information useful to the manufacturer regarding installation of the product;
- 5.1.7 Color or tint of the GCP laminate (tinted glass, interlayer, polycarbonate, or combinations);
- 5.1.8 Required minimum visible light transmittance of the laminate;
- 5.1.9 Security and safety standards or regulations to which the laminate must conform (see 7.1 and 7.2);
- 5.1.10 Schedule requirements; and
- 5.1.11 All other standards to which the laminate must conform.

5.2 *Packaging Requirements*—Glass and polycarbonate packaging and protection will be standard manufacturers' practices unless otherwise specified. Consult manufacturers before specifying.

6. Other Requirements

- 6.1 Heat-strengthened or fully tempered glass plies shall conform to the requirements of Specification C 1048.
- 6.2 Annealed glass lites shall conform to the requirements of Specification C 1036.
- 6.3 Polycarbonate sheets shall conform to the requirements of Appendix X1.
- 6.4 The aliphatic polyether urethane interlayer shall conform to the requirements of Appendix X2.
- 6.5 The polyvinyl butyral interlayer shall conform to the manufacturer's specifications.
- 6.6 Laminates specified for security glazing shall meet the applicable requirements of the security glazing standards (see 7.1).
- 6.7 Laminates specified for safety glazing shall meet the requirements of the specified safety glazing standards (see 7.2).

7. Test Methods

- 7.1 *Security Tests*—Test and interpret in accordance with tests required by specific jurisdictions, as applicable.
- 7.2 *Impact Test for Safety Glazing*—Test and interpret in accordance with ANSI Z97.1 or CPSC 16 CFR 1201, or both, as applicable.
- 7.3 *Visual Inspection*—Place the specimen in a vertical position. The viewer shall look through the specimen, using daylight without direct sunlight, or using a background light suitable for observing the blemishes. View at 36 in. (914 mm) except where specified otherwise in Table 1.
- 7.4 *Transmittance*—Using Practice E 308, measure transmittance by illuminating each laminated specimen at normal

TABLE 1 Maximum Allowable Overall Bow and Warp^{ABC}

Longest Edge Dimension, in. (mm)	Maximum Allowable Bow and Warp, in. (mm)
0 to 18 (0 to 460)	$\frac{3}{32}$ (2.4)
Over 18 to 36 (over 460 to 910)	$\frac{3}{16}$ (4.8)
Over 36 to 48 (over 910 to 1220)	$\frac{1}{4}$ (6.4)
Over 48 to 60 (over 1220 to 1520)	$\frac{5}{16}$ (7.9)
Over 60 to 96 (over 1520 to 2440)	$\frac{1}{2}$ (12.5)

^A The above table is for GCP of any overall thickness having glass on both sides.

^B For GCP with glass on both sides in a strip condition or for GCP with glass on one side and exposed polycarbonate on the opposing side in a nonstrip condition, the overall bow and warp is to be multiplied by 1.5. Strip condition is defined as a GCP product with a long side to short side ratio of 4 to 1 or greater.

^C For GCP with glass on one side and exposed polycarbonate on the opposing side in a strip condition, the overall bow and warp is to be multiplied by 2.0.

incidence with the light having the spectral composition of the International Commission on Illumination (CIE) illuminate C. Measure the ratio of transmittance to incident luminous flux by calculating from the spectral distribution of illuminate C as defined by Practice E 308.

8. Fabrication Requirements

8.1 *Dimensional Fabrication*—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 must be performed prior to strengthening or tempering. In addition, custom drilling of any GCP, including speakholes and pass-through holes, may invalidate performance capabilities and is not recommended.

8.2 Edge:

8.2.1 Most GCP laminates incorporate heat-strengthened, chemically strengthened, or fully tempered glass. Additional edgework after strengthening or laminating compromises edge strength and is, therefore, not recommended (also see 8.1). Some mismatch can be expected with these laminates.

8.2.2 For GCP made with annealed glass, an edge shall be cut, sawed, ground, sanded to remove sharp edges only, seamed, beveled, or mitered, as specified.

8.3 Marking:

8.3.1 Each laminate shall bear the trademark or name of the GCP manufacturer unless otherwise specified.

8.3.2 GCP intended for safety glazing applications specified by building codes shall be marked permanently with the name or trademark of the GCP manufacturer and the designation of the applicable safety glazing standard.

8.4 *Thickness*—Since there are many possible makeups for GCP, it is essential that the specifier consult with the GCP manufacturer for the minimum and maximum thicknesses for each makeup specified. Typical thicknesses are tabulated in Table 2.

8.5 Mismatch, Length and Width:

8.5.1 The maximum allowable mismatch is $\frac{3}{16}$ in. (4.8 mm). The length and width tolerances of symmetrical laminates shall be in accordance with Table 3 when measured from edge to edge, including flares, mismatches, or offsets.

8.5.2 For non-symmetrical laminates and large or small sized laminates, contact the GCP manufacturer for length and width tolerances.