



Syracuse Glass Company

Product Offerings and Capabilities

SGC-PRO-001

Origination Date: 9/6/23

Latest Revision Date: 9/8/23

Current Revision: 1

General Notes

- **SIZE ORIENTATION = Width x Height**
- **VIEWING ORIENTATION = Outside Looking In**
- **ANNEALED GLASS = supplied with clean cut edges unless ordered with seamed or polished edges**
- **HEAT TREATED GLASS = supplied with seamed edges unless ordered with polished edges**
- **Glass is annealed by default. Heat-treating or laminating is to be ordered accordingly**
- **All Glass Storefronts, Railings, and Shower Enclosure measurements are to be provided in CENTERLINE dimensions**
- **All dimensions should be provided in increments of 1/16"**

Tempering / Heat Strengthening

Glass Thickness	Minimum Size	Maximum Size
1/8" DST (3.2mm)	6" x 12"	40" x 80"
5/32" (4mm)	4" x 10"	60" x 84"
3/16" (5mm)	4" x 10"	76" x 126"
¼" (6mm)	4" x 10"	94" x 140"
3/8" (10mm), ½" (12mm)	4" x 10"	94" x 138"

- **500-pound weight limit**
- Use table above for cut to size annealed size limits also.
- Any glass size over 50 square feet requires Tempering or Heat Strengthening.
- Excludes soft-coated low-e products which cannot be shipped monolithically
- Short dimension (height) over 85" cannot be shipped on covered flatbeds
- Over 94" width cannot be produced "roller wave parallel to sill" as our furnace size is 96" wide.
- **Tempered or Heat Strengthened orders are fabricated with a LOGO unless specified "NO LOGO"**
- Heat Strengthening available for 1/8" DST, 5/32", 3/16" and ¼" only.

Edgework

Edgework Type	Minimum Size	Thickness	Maximum Size
Straight Edges - Flat Ground, Flat Polished, Mitered or Beveled	6" x 6" OR 4" x 12"	3/16"	60" x 84"
		¼"	84" x 110"
		3/8", ½"	84" x 125"
Curved Edges- Flat Ground, Flat Polished	Covers 11" Diameter Circle	3/16"	Within 50" Diameter Circle
		¼"	Within 72" Diameter Circle
		3/8", ½"	Within 60" Diameter Circle

Polished edges must be long enough so that the glass is able to safely be supported standing upright by the polishing machinery

- Clipped Corners – subject to curved edges size limits above.
- No Shaped Beveling
- Subject to 500-pound maximum weight if short dimension exceeds 36"
- Subject to 250-pound maximum weight if short dimension is 15" to 36"
- Subject to 150-pound maximum weight if short dimension is less than 15"
- Minimum width to polish short dimensions:
 - 5" if long dimension is 72" or less
 - 15" if long dimension is greater than 72" (with maximum length being subject to **maximum size** above)



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Fabrication – CNC Notches, Holes, Cut Outs

- Maximum size 60" x 144" subject to 500-pound maximum weight
- Minimum size 7" x 12" for anything requiring CNC work, holes or cut outs

Hole Placement:

- Holes, notches, internal cut outs and locations are to comply with ASTM C1048 specifications.
 - Hole diameter must be the greater of 1) 1/4" or 2) the glass thickness.
- The minimum distance from edge of the glass to the nearest point on the rim of the nearest hole must be greater than 1) 1/4" or 2) two times the glass thickness
- The minimum distance between the rims of holes must be the greater of 1) 3/8" or 2) twice the glass thickness
- The minimum distance from the corner to the rim of a hole must be 6.5 times the thickness of the glass
- The minimum leg remaining on glass with a corner notch must be at least 10% of the total width or length and 25% of the total glass area.
- We do not offer countersunk holes.

Glass - Plastic Wrapping:

- One dimension must be less than 60" / Maximum weight = 150 pounds
- Glass for Shower Enclosures are wrapped if above criteria are met.
- Additional products can be wrapped by request if above size and weight criteria is met.

Mirrors – Safety Backing:

- Safety backing of mirrors available upon request.

Laminated Glass

Equipment Capabilities	96" x 144" Maximum Size	7" x 14" Minimum Size	<u>WEIGHT</u>
Components	1/2" Maximum Thickness	1/8" DST (3.2mm) Minimum Thickness	700 Pounds
Finished Laminate	2" Maximum Thickness		1000 Pounds

For maximum Laminated sizes / weight (Monolithic or Insulated, refer to Shipping Capabilities (page 7))

Stock Interlayers

PVB – Kuraray Trosifol BG Clear	.030 = 84" roll	.060 = 48", 84", 96" rolls
PVB – Kuraray Trosifol BG White	.030 = 60", 84" rolls	.060 white is made with .030 white + .030 clear interlayers unless otherwise specified

Ionoplast – Kuraray SentryGlas Clear is ordered cut to size from Curbell Plastics.
60" x 120" @ .060" thick sheets are stocked for small orders

- Maximum short dimension with .090" PVB interlayer is 84 inches.
- Sentry glass interlayer thickness minimum that we will produce is .060"
- Exposed edges of Laminated Glass with SentryGlas interlayer must be identified at time of quotation and order.
- The exposed edges of heat-treated laminated glass will not have the same appearance as that of monolithic glass. All project specific aesthetic requirements need to be addressed before glass fabrication to ensure project requirements and fabrication capabilities are aligned.
- Other Colors are available and must be optimized at time of quote and order.



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Insulating Glass Units (IGU's)

IG Production Capabilities

Minimum Size	Maximum Size	Component Maximum	Assembled Maximum	Component Maximum Thickness	Unit Maximum Assembled Thickness
7" x 14"	94" x 137"	500 pounds	500 pounds	½"	2"
Shape IG minimum size = 7" x 14"		Shape IG maximum size is shape dependent. Check with customer service		Assembled maximum weight 500 pounds	

CAPABILITIES ABOVE ARE SUBJECT TO THE FOLLOWING TABLES BELOW WHICH ARE THE MAXIMUM SIZE RECOMMENDATIONS FOR VERTICALLY AND SLOPED GLAZED APPLICATIONS

IG GLASS STRENGTH SIZE LIMITS IN SQUARE FEET (sf) – IG UNITS TO BE GLAZED VERTICALLY

Non-Laminated Component Lites – Annealed, Heat Strengthened or Tempered

↓ Spacer ↓	3/32"	1/8" (3.2mm)	5/32" (4mm)	3/16" (5mm)	¼" (6mm)
½" or greater	10 sf	18 sf	30 sf	38 sf **	70 sf *
3/8" or 7/16"	10 sf	18 sf	25 sf	30 sf	35 sf **
3/16" – 5/16"	10 sf	15 sf	18 sf	18 sf	18 sf

Laminated Component Lites – Annealed (AN), Heat Strengthened (HS) or Tempered (T)

	2.7mm / .030"	3.2DST / .030"	3.2DST / .060"	5/32" / .030"	5/32" / .060"	3/16" / .030"	3/16" / .060"	¼" / .030"	¼" / .060"
	AN	AN	AN/HS/T	AN	AN/HS/T	AN	AN/HS/T	AN	AN/HS/T
↓ Spacer ↓	¼" **	5/16"	5/16"	5/16"	3/8"	7/16"	7/16"	9/16"	9/16"
½" or greater	20 sf	20 sf (12)	30 sf (25)	25 sf (18)	30 sf (25)	35 sf ** (18)	40 sf ** (35) **	50 sf ** (25)	60 sf ** (40) **
3/8" or 7/16"	18 sf	18 sf	25 sf	25 sf	25 sf	30 sf	30 sf	35 sf **	35 sf **
3/16" – 5/16"	15 sf	15 sf	15 sf	18 sf	18 sf	18 sf	18 sf	18 sf	18 sf

- Numbers in Parentheses are for Sloped Glazing Applications.** These are conservative and a technical review based on specific job requirements may enable larger sizes.
- * = Units over 50 Square Feet MUST be Heat Strengthened or Tempered**
- ** = Units over 35 Square Feet SHOULD be Heat Strengthened or Tempered**
- No warranty on units with 3/16" spacer or sizes above these recommendations
- These size recommendations are not engineered or project specific. They are reasonable for low rise buildings not located in high wind regions.
- These recommendations are for regular "double" insulating glass. Triple IG units require a technical review.



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IG OPTIONS

CATEGORY	DEFAULT	OPTIONS
Primary / Secondary Seal	Black PIB / Silicone	None
Sightline	7/16" (+/- 1/8") for glass 3/16" and thinner	None
	1/2" (+/- 1/8") for glass 1/4" and thicker	9/16" (+/- 1/8"), 5/8" (+/- 1/8")
Seal Depth	3/16" for glass 3/16" and thinner	None
	1/4" for glass 1/4" and thicker	5/16", 3/8"
Spacer – Anodized Aluminum	Clear Aluminum	Black, Bronze
Spacer - Technoform Warm Edge		Light Gray, Black
Cavity Fill	Air	Argon
Glazing Application System	Conventional Glazing	*Structural Silicone Glazing*
Logo for Tempered, HS, Lami	Yes	No Logo
Rollerwave Orientation	Parallel to Sill Up to 94" Glass Width Dimension	None
Shipping / Glazing Elevation	Below about 3000 feet above sea level	High Altitude Provisions
Packaging	Loose on rack with cork dots	Wood A-Frames or Crates

CUSTOMER MUST NOTIFY SGC OF STRUCTURAL SILICONE GLAZING APPLICATIONS AT TIME OF QUOTE AND ORDER

IG SPACER & GRID (MUNTIN BAR) OFFERINGS AND OPTIONS

Nominal Thickness	Actual Thickness	Anodized Aluminum			Actual Thickness	Technoform (TGI) Warm Edge	
		Clear	Black	Bronze		Fraction	Light Gray
Fraction / Inches	Fraction / Decimal						
*3/16"	3/16" (.187")	√					
1/4"	7/32" (.216")	√	√	√	*1/4"		
5/16"	9/32" (.295")	√	√	√	*5/16"		
3/8"	11/32" (.335")	√	√	√	*3/8"		
7/16"	13/32" (.406")	√	√	√	13/32"	√	√
*1/2"	1/2" (.492")	√	√	√	*1/2"	√	√
9/16"	17/32" (.531")	√	√	√			
5/8"	19/32" (.598")	√	√	√			
11/16"	21/32" (.649)	√					
3/4"	23/32" (.728")	√	√	√			
13/16"	25/32" (.767")	√					

* PIB primary seal adds 1/32" to double IGU thickness, and adds 1/16" to triple IGU thickness.

- Most spacers are supplied 1/32" under nominal thickness to accommodate PIB except for the 3/16" and 1/2" aluminum and all Technoform thicknesses except 7/16"
- No warranty on any IGU made with customer supplied materials.



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Grid/Muntin Color & Style Offerings - Shapes and Custom Grid Placement Must be Evaluated and Custom Quoted

- Standard Flat Grids (3/16" x 5/8") = available in aluminum, white, bronze, green, tan, and black colors. These grids are notched by a machine that interfaces with our Fenevision software.
 - Rectangles ordered as # Verticals x # Horizontals Receive Standard Pricing
 - Max size limit for units for grids = 25 square feet
 - Minimum air space thickness is 3/8" for flat grids. Grid bumpers available upon request.
 - Grid requests that do not meet these rules (IE. Custom grid layout, grids that must match adjacent lights, require production review, approval and quotation as these orders are hand fabricated).
- Contoured muntins (5/16" x 11/16") = available in white, bronze and tan colors. These grids are not notched. They are manually cut and joined by cross shaped exposed manual connectors that match the color of the grids.
 - Max configuration = up to 4 verticals X 4 horizontals.
 - Contour muntins in larger units may result in excessive bow/warp on the muntin.
 - Minimum air space thickness is 7/16" for contoured grids

CAPILLARY TUBES / BREATHING TUBES

- Recommended for units being shipped to or through high elevations (over about 3000 feet above sea level) and available at customer request.

OFFSET UNITS - Single Sided Offsets are available ONLY, No Double sided or multi sided offsets.

- The offset is typically 3/4" with a maximum offset of 2"
- Normally the outside light is longer than the inside, to be glazed at an "outside corner" of the building. However, an offset can be used in an "inside corner" as well which would require the inside light to be longer than the outside corner.
- Glass used in an offset unit must be heat strengthened or tempered. Sealant in an offset must be SILICONE, because the sealant in the offset side is exposed to sunlight.



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PAINTED GLASS

- SGC can supply painted glass for commercial applications for building spandrel areas and for interior wall cladding, not for residential kitchen back splash applications. Painted glass is not intended for use in vision areas.
- Painted glass is recommended on #2 Surface for monolithic glass, #4 Surface for IG units.
- The painted surface is not suitable to be an exposed finish wall.

OPACI-COAT 300®

- SGC is a certified Factory Fabricator of OPACI-COAT 300® Silicone Paint.
- Glass thicknesses of 3.2 mm through ¼" can be painted.
- Maximum size approved for painting = 60" x 120"
 - Larger sizes can be requested and require approval by Production Management
- Fallout Protection is an available option.
- OPACI-COAT 300® Colors Stocked: Black, Harmony Gray, Warm Gray, Harmony Bronze, Light White
- It is RECOMMENDED that gasket and setting blocks be:
 - Silicone OR
 - Listed on ICD's current compatible glazing material list available at their [ICD website](#) OR
 - Sent to ICD for a 30-day compatibility test with a successful outcome.
- This is REQUIRED for use with Light, White or Pastel Colors.
 - An additional option = customer can request that we apply Bond Breaker Tape which is a 2" wide tape around the perimeter of the unit on the painted surface.
 - This is not an option for Structural Silicone Glazing applications.
- OPACI-COAT 300® can be used in Structural Silicone Glazing applications as follows:
 - Structural Silicone Glazing must be identified at time of quotation and order as **two-sided** or **four-sided**.
 - **Two-Sided** Structural Glazing = Painted units can be installed using Dow 995 Glazing Silicone which allows for complete coverage of the paint on the number 4 surface.
 - Customer can request that two sides have no paint from the edge to a specified distance (edge deleted).
 - **Four-Sided** Structural Glazing requires elevation drawings and glazing details be submitted to ICD for approval. NO EXCEPTIONS.
 - OPACI-COAT 300® will have to be edge deleted to a specified distance on all four sides.
 - Four-Sided Structural Glazing may be better served by a ceramic paint option.

Guardian Deco HT®

- SGC is approved by Guardian Industries to fabricate Deco HT® Ceramic painted glass
 - Available on ¼" clear glass 96" x 130" in Black, White and Warm Gray Colors
 - Subject to availability from Guardian. This is not a stock item at SGC



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Shipping

	Maximum Size	Maximum Weight
Rack truck shipped loose	115" x 144" Rack Size	500 Pounds
NOTE – CUSTOMER MUST AGREE TO UNLOAD ALL LOOSE GLASS OVER 300 POUNDS WITHOUT OUR DRIVER ASSISTING		
Flatbed Using A-Frames	85" x 136" (secured by side strap)	2500 Pounds approx. per A-Frame
Flatbeds have 96" Top Tarp Height	60" x 144" (secured by top strap)	2500 Pounds approx. per A-Frame
Flatbed weight capacity (48' trailer)	Approximately 12 A-Frames	Approximately 34,000 pounds
Flatbed weight capacity (24' trailer)	Approximately 6 A-Frames	Approximately 24,000 pounds
Rack Trucks		12,000 pounds

- NOTE: Larger sizes must be approved by shipping & production
- Wood A-Frames are to be disposed of by customer OR can be returned to SGC at our option / discretion only.

APPENDIX I - GLASS THICKNESS AND WEIGHT

TRADE NAME	IMPERIAL	METRIC	DECIMAL	THICKNESS RANGE	WEIGHT PER SQUARE FOOT
Single (SS)	3/32"	2.5mm	.094"	.085" - .101"	1.2
Lami	7/64"	2.7mm	.109"	.102" - .114"	1.4
Double (DS)	1/8"	3.0mm	.125"	.115" - .134"	1.6
*Double (DST)	1/8"	3.2mm	.125"	.120" - .134"	1.6
	5/32"	4mm	.156"	.149" - .165"	2.0
	3/16"	5mm	.188"	.180" - .199"	2.4
	¼"	6mm	.250"	.219" - .244"	3.0
	5/16"	8mm	.312"	.292" - .332"	4.0
	3/8"	10mm	.375"	.355" - .406"	5.0
	½"	12mm	.500"	.469" - .531"	6.4
	5/8"	16mm	.625"	.595" - .656"	8.1
	¾"	19mm	.750"	.719" - .781"	9.8

- Lami, 5/16", 5/8" thickness is not stocked to order
- *Double Strength for Tempering (DST) is the minimum thickness for Heat Treating (Heat Strengthening or Tempering) and for Custom Laminating.

APPENDIX II – TRIM AND BREAKOUT DEDUCTIONS FROM STOCK SHEETS

To calculate maximum dimensions, reduce stock sheet sizes by the following

GLASS THICKNESS	SHEET TRIM	BREAKOUT	TOTAL REDUCTION
3/32" – ¼"	2"	2"	4"
3/8" – ½"	3"	3"	6"
5/8" – ¾"	6"	6"	12"

IE. ¼" clear stock sheet is 108" x 144." Maximum cut size is 104" x 140"



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APPENDIX III – FLOAT GLASS OPTIONS

GENERIC GLASS	GLASS MANUFACTURER TRADE NAME		
TYPE AND COLOR	VITRO	GUARDIAN	PILKINGTON
CLEAR	Clear	Clear	Optifloat™ Clear
ULTRA-CLEAR OR LOW-IRON	Starphire® Acuity™		Optiwhite™
		Ultra Clear™ (formerly UltraWhite™)	
TINTS - Bronze	Solarbronze®		Optifloat™ Bronze
Gray	Solargray®	Gray	Optifloat™ Grey
Green	Solexia	Green	Optifloat™ Green
Blue-Green			Optifloat™ Blue-Green
Dark Gray	GrayliteII®		SuperGrey™
Light Gray	Optigray	CrystalGray™	
Dark Green	Atlantica™		EverGreen™
Light Blue	Solarblue™		
Blue			Arctic Blue™
Dark Blue	Pacifica™		
Aqua-Blue	Azurja™		
COATED - Soft Coat Solar Control Low-E	Solarban® Coatings (see catalog) Solarban 60 on Clear, Tints, etc. Solarban 70 on Clear, Tints, etc. Solarban 90 on Clear, Tints, etc. Solarban 67 on Clear, Tints, etc. Solarban R77 on Clear, Tints, etc. Solarban R100 on Clear, Tints, etc.	SunGuard® Coatings (see catalog) SN-68, Clear, Tints, etc. SNX-62/27, Clear, Tints, etc. SNX-51/23, Clear, Tints, etc. SN-54, Clear, Tints, etc. SNR-50, Clear, Tints, etc. SNR-43, Clear, Tints, etc.	
		ClimaGuard™ Coatings (Residential)	
Passive Solar Low-E	Sungate 400		Energy Advantage™ (Hard Coat)
		Neutral 78/65	
Interior Surface Low-E			Energy Advantage™ (Hard Coat)
	ThermL®	ClimaGuard IS20	
Hard Coat Solar Control Low-E			Eclipse Advantage Gray, Bronze, etc. Solar E™ Clear, Gray, etc.
Hard Coat Reflective	Solarcool® Bronze, Gray, etc.		
Hard Coat Subtle Reflective	Vistacool™ Azuria, Pacifica		
Transparent Mirror			Mirropane™ (Gray Substrate)
	WALKER GLASS		
ACID ETCHED - Single Surface	Textures Velour, Satin, Opaque		
PAINTED SPANDREL GLASS		Satin Deco HT (white, light grey, black)	

Stocked items indicated in red. Items in black letters are brought in for specific projects and are not stocked to order.

Products in the same rows are equal performers. Uncoated products can be mixed on a project with the exception of white or light colored OpaciCoat

Additional coatings not listed are available for specific job requirements as SGC has access to the full line product offerings from Vitro, Guardian & Pilkington

Coated products should not be mixed within one project

UNCOATED TINTS CAN BE INSULATED WITH THE FOLLOWING LOW-E INBOARD LITES:

Pilkington Energy Advantage, SB60, SN68, SB70, SNX62/27, SB67, SB90



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APPENDIX IV – FLOAT GLASS - STOCK SIZES, THICKNESSES & PACK QUANTITIES

Glass Stock Sizes - Rev 7-11-23						
Glass Type	mm	Tk	Size	Qty lites / pk	Back up	Qty lites / pk
Clear	2.2	3/32"	96 x 130	54		
Clear	3.2	1/8"	96 x 130	28		
Clear	4	5/32"	102 x 144	24	108 x 144	22
Clear	5	3/16"	108 x 144	15	102 x 144	16
Clear	6	1/4"	108 x 144	13		
Clear	10	3/8"	108 x 144	8		
Clear	12	1/2"	108 x 144	6		
Clear	19	3/4"	96 x 130	4		
Gray / Bronze / Solex	3.2	1/8"	96 x 130	30		
Gray / Bronze	5	3/16"	96 x 130	15		
Gray / Bronze / Solex / Artic Blue / SolarBlue	6	1/4"	108 x 144	14	96 x 130	16
Gray / Bronze	10	3/8"	96 x 130	8		
Gray / Bronze	12	1/2"	96 x 130	6		
Solarcool Bronze / Gray	6	1/4"	96 x 130	16		
Graylite II	3	1/8"	96 x 130	28		
Graylite II	6	1/4"	96 x 130	16		
Low -E	3.2	1/8"	96 x 130	30		
Low -E	5	3/16"	102 x 130	18		
Low -E	6	1/4"	102 x 130	14		
SB 60 Annealed	3	1/8"	96 x 130	16		
SB 60 Annealed	6	1/4"	100 x 144	14	96 x 130	16
SB 60 VT	4	5/32"	96 x 130	17		
SB 60 VT	6	1/4"	100 x 144	14	96 x 130	16
SB 70	6	1/4"	100 x 144	14		
SB 70 VT	6	1/4"	100 x 144	14		
SB 60VT on Optigray	6	1/4"	96 x 130	16		
SB 60VT on Solargray	6	1/4"	96 x 130	16		
Starphire	3.2	1/8"	96 x 130	28		
Starphire	5	3/16"	96 x 130	19		
Starphire	6	1/4"	100 x 144	14		
Starphire	10	3/8"	96 x 130	9		
Starphire	12	1/2"	96 x 130	7		
Shower Guard	10	3/8"	96 x 130	10		
Shower Guard	12	1/2"	96 x 130	7		
SN68 Ann	6	1/4"	102 x 130	15		
SN68HT	6	1/4"	102 x 130	15		
SNX 62/27 HT	6	1/4"	102 x 130	15		
Clear Mirror	6	1/4"	96 x 130	15		
MirrorPane	6	1/4"	96 x 130	16		
Velour Acid Etch	3	1/8"	96 x 130	26		
Velour Acid Etch	6	1/4"	96 x 130	15		
Velour Acid Etch	10	3/8"	96 x 130	9		
Velour Acid Etch	12	1/2"	96 x 130	8		
Clear 015 Lami	3	1/8"	48 x 84	75		
Clear 030 Lami	6	1/4"	72 x 120	20		
Clear 030 Lami	6	1/4"	84 x 120	20		
Clear 030 Lami	6	1/4"	84 x 130	20		
Clear 030 Lami	10	3/8"	88 x 130	13		
Clear 030 Lami	12	1/2"	72 x 96	12		
Clear 060 Lami	8	5/16"	72 x 130	18		
Clear 060 Lami	8	5/16"	88 x 126	16		
Solex 030 Lami	6	1/4"	48 x 84	50		
White 030 Lami	6	1/4"	48 x 84	50		
Firelite NT	5	3/16"	36 x 96	36		
Firelite NT	5	3/16"	48 x 96	36		
Firelite NT	8	5/16"	48 x 96	24		
Neoceram / Robax	5	3/16"	43" x 77"	40		



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APPENDIX V – Equipment Sizes and Weight Ranges – Quick Summary

Department	Equipment	Size Max	Size Min	Weight
Material Handling	#1 Stoce / Crate Unloading Crane, Spreader Bar, Slings	108x144		4000 lbs.
	#2 Stoce / Crate Unloading Crane, Spreader Bar, Slings	108x144		5000 lbs.
	#1 Bromer Storage Racks, Shuttles, Free Fall Loaders (Loads cutting tables 1 and 2 @ 3/32" – 3/4" glass)	108x144	96x130	
	#2 Bromer Storage Racks, Shuttle, Suction Loader (Loads Cutting Table 3 @ 3/32" – 3/4" glass)	108x144	72x130	
Cutting	#1 Lisec Table Edge Deletes and Scores Sequentially	108x144		
	#2 Lisec Table Edge Deletes and Scores Simultaneously	108x144		
	#3 Lisec Table Scores Float, Cuts Annealed Laminated	108x144		
	#1, #2 Tenon Automatic Seamer (5/32" to 1/2" glass)	96x144	10x16	
	Double Belt Manual Seamers (3/32" to 1/2" glass)	60x60	4x10	
Tempering	#1 Glaston FC 500 Furnace (3/16" to 3/4" glass)	96x168	4x10	
	#2 Uniglass Furnace	84x144	4x10 (5/32" – 3/4" Glass) 6x12 (1/8" glass)	
	Double Sided Plastic Film Wrapper	60" Wide Maximum		150 lbs.
Laminating	Lisec Soft Coat Washer, Layup, Nip Rolls, Autoclave	96x144	14x14	
		1/2" max. component thickness		700 lbs.
		2" max finished thickness		1000 lbs.
Insulating	#1 Lisec Line with Gas Filling	96x137	7x14	
		1/2" max. component thickness		500 lbs.
		2" max finished thickness		500 lbs.
	#2 Lisec Line Without Gas Filling	79x137	7x14	
		1/2" max. component thickness		500 lbs.
		2" max finished thickness		500 lbs.
Painted Glass	Opaci Coat 300	60x120	4x10	500 lbs.
	Guardian Deco HT®	60x120	4x10	500 lbs.
Edgework	#1 Matodi Straight Edge Polisher/Miterer #2 Matodi Straight Edge Polisher	60x84 (3/16" glass)	6x6 or 4x12	500 lbs. max. Less for short dimension ranges
		84x110 (1/4" glass)		
		84x125 (3/8, 1/2" glass)		
	Bavelloni SB10 Manual Shape Edger/Beveler	3/16" glass = within 50" diameter circle	Covers 11" diameter circle	75 lbs. (1 person lift)
		1/4" glass = within 72" diameter circle		
3/8", 1/2" glass = within 60" diameter circle				
Bavelloni Straight Edge Beveler (no shaped beveling)	Same as edge polish	6x6 or 4x12	500 lbs.	
Fabrication	Forvet Horizontal Water Jet Cutter	60x144	ASTM & tempering limits	500 lbs.
	Top Drill Vertical CNC			



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APPENDIX VI – PATTERNS / DXF FILES

Although DXF or DWG files are preferred for receiving patterns, we recognize that not everyone has access to AutoCAD and cannot give the required files. If physical patterns meet the standards below, we can accept them.

INFORMATION NEEDED:


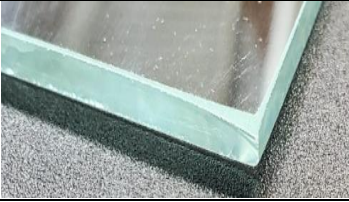


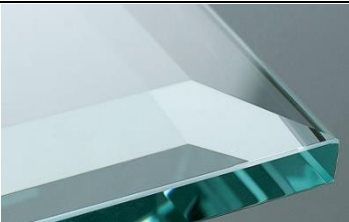

- **Company Name, Job Name and/or P.O. Number**
- **Type of Glass (color, thickness, etc.) Fabrication**
- Mark which side requires polishing/mitering/etc.
- Mark each hole and notch location along with the dimensions of each
- Mark the location and size of any internal cutouts such as mail slots/plug cutouts/ etc.
- Mark the logo location on the pattern (*or note if **no logo is desired***)
- Mark “surface” required for pattern or coated glass (IE. Reflective, Low-E, Rain, Satin Etch)

PATTERN EXPECTATIONS:

- The following materials **will not be** accepted: Glass, Eureka-board, Hardie-board, Sheetrock, and Plywood
 - We **DO NOT** accept pieces of glass to be used as physical patterns under any circumstances.
- All curved patterns must be approved by Production. Please send picture of pattern or drawing to customer service for review.
- We will not make curved shaped Insulating Glass Units from patterns.
- Our drivers will not pick up any patterns with any types of screws and/or nails, staples, etc. poking out.
- We **DO NOT** accept patterns thicker than ¼” overall nor larger than 60” x 60” block size unless preapproved by Production.
- **ALL** patterns must be done with all markings in **thick, black marker** so we can see the lines and any fabrication needed from **at least** 6 feet away. No pencils or ballpoint pens, etc.
- Mark whether the shape should be cut from the inside, outside, or center of the lines on the pattern.
- **NO “Frankenstein” Patterns** - No patterns pieced together with tape or any other material.
- **Partial Patterns** are **not accepted**; must be the full size of the pattern needed and we will not add to a pattern.
- No warped, bowed or bubbled patterns (bubbling occurs when taping two pieces of paper together). All patterns must be able to lay flat.
- Shower patterns must be pre-approved by production before we will accept.
- **NOTE - If the patterns fall outside any of the above criteria, it is to be sent back for correction before entering for production. Customer is to be contacted before returning a rejected pattern.**

APPENDIX VII – EDGEWORK OPTIONS

DISCLAIMER: Information provided below is a combination of recognized specifications from ASTM C1036 & ASTM C1048 as well as Syracuse Glass Company internally created guidelines, capabilities and offerings to which Syracuse Glass Company produces finished goods to.

Edge Type - Picture	Description	Comments	Suitable Exposed Edge?	ASTM C1036 Edge Chips Allowed?
	CLEAN CUT	No edgework. Standard edge treatment of stock sheets, cut size glass, annealed insulating glass. Holes in annealed glass also have clean-cut edges.	NO	YES
	SEAMED	Glass sharp edges are removed with a double belt seamer. This is standard edge treatment for tempered or heat strengthened glass.	NO	YES
	FLAT GROUND	A small amount of the glass edge is removed and two chamfers are added. Edge surfaces are not polished, leaving a “frosty” appearance. This is standard edge treatment for notches and CNC internal cut-outs. Holes over 4” also flat ground edges.	NO	NO
	FLAT POLISHED	A small amount of glass is removed from the edge, two chamfers are added, and all surfaces are polished. Polished edges are provided when requested. Recommend for all exposed and butting glass edges.	YES	NO
	BEVEL	Glass is removed from one surface of a glass or mirror and the surface is polished. Standard edge treatment for 1/8” - 1/4” glass and mirrors are a ground pencil edge. For 3/8” and 1/2” glass, standard edge treatment is flat polished.	YES	NO
	MITER	Glass edge is removed at a designated angle (i.e., 22-1/2°, 45°, etc.) and the surface is polished. About 2/3 of the edge is removed leaving about 1/3 as a flat polished surface and a polished chamfer.	YES	NO



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APPENDIX VIII – CONVERSION CHART: FRACTION / DECIMAL / MILLIMETER

Chart is for reference only. SGC does not produce to 1/64" or 1/32" increments

fraction	decimal	mm		fraction	decimal	mm		fraction	decimal	mm
1/64	0.0156	0.3969		1 1/64	1.0156	25.7969		2 1/64	2.0156	51.1969
1/32	0.0313	0.7938		1 1/32	1.0313	26.1938		2 1/32	2.0313	51.5938
3/64	0.0469	1.1906		1 3/64	1.0469	26.5906		2 3/64	2.0469	51.9906
1/16	0.0625	1.5875		1 1/16	1.0625	26.9875		2 1/16	2.0625	52.3875
5/64	0.0781	1.9844		1 5/64	1.0781	27.3844		2 5/64	2.0781	52.7844
3/32	0.0938	2.3813		1 3/32	1.0938	27.7813		2 3/32	2.0938	53.1813
7/64	0.1094	2.7781		1 7/64	1.1094	28.1781		2 7/64	2.1094	53.5781
1/8	0.125	3.175		1 1/8	1.125	28.575		2 1/8	2.125	53.975
9/64	0.1406	3.5719		1 9/64	1.1406	28.9719		2 9/64	2.1406	54.3719
5/32	0.1563	3.9688		1 5/32	1.1563	29.3688		2 5/32	2.1563	54.7688
11/64	0.1719	4.3656		1 11/64	1.1719	29.7656		2 11/64	2.1719	55.1656
3/16	0.1875	4.7625		1 3/16	1.1875	30.1625		2 3/16	2.1875	55.5625
13/64	0.2031	5.1594		1 13/64	1.2031	30.5594		2 13/64	2.2031	55.9594
7/32	0.2188	5.5563		1 7/32	1.2188	30.9563		2 7/32	2.2188	56.3563
15/64	0.2344	5.9531		1 15/64	1.2344	31.3531		2 15/64	2.2344	56.7531
1/4	0.25	6.35		1 1/4	1.25	31.75		2 1/4	2.25	57.15
17/64	0.2656	6.7469		1 17/64	1.2656	32.1469		2 17/64	2.2656	57.5469
9/32	0.2813	7.1438		1 9/32	1.2813	32.5438		2 9/32	2.2813	57.9438
19/64	0.2969	7.5406		1 19/64	1.2969	32.9406		2 19/64	2.2969	58.3406
5/16	0.3125	7.9375		1 5/16	1.3125	33.3375		2 5/16	2.3125	58.7375
21/64	0.3281	8.3344		1 21/64	1.3281	33.7344		2 21/64	2.3281	59.1344
11/32	0.3438	8.7313		1 11/32	1.3438	34.1313		2 11/32	2.3438	59.5313
23/64	0.3594	9.1281		1 23/64	1.3594	34.5281		2 23/64	2.3594	59.9281
3/8	0.375	9.525		1 3/8	1.375	34.925		2 3/8	2.375	60.325
25/64	0.3906	9.9219		1 25/64	1.3906	35.3219		2 25/64	2.3906	60.7219
13/32	0.4063	10.3188		1 13/32	1.4063	35.7188		2 13/32	2.4063	61.1188
27/64	0.4219	10.7156		1 27/64	1.4219	36.1156		2 27/64	2.4219	61.5156
7/16	0.4375	11.1125		1 7/16	1.4375	36.5125		2 7/16	2.4375	61.9125
29/64	0.4531	11.5094		1 29/64	1.4531	36.9094		2 29/64	2.4531	62.3094
15/32	0.4688	11.9063		1 15/32	1.4688	37.3063		2 15/32	2.4688	62.7063
31/64	0.4844	12.3031		1 31/64	1.4844	37.7031		2 31/64	2.4844	63.1031
1/2	0.5	12.7		1 1/2	1.5	38.1		2 1/2	2.5	63.5
33/64	0.5156	13.0969		1 33/64	1.5156	38.4969		2 33/64	2.5156	63.8969
17/32	0.5313	13.4938		1 17/32	1.5313	38.8938		2 17/32	2.5313	64.2938
35/64	0.5469	13.8906		1 35/64	1.5469	39.2906		2 35/64	2.5469	64.6906
9/16	0.5625	14.2875		1 9/16	1.5625	39.6875		2 9/16	2.5625	65.0875
37/64	0.5781	14.6844		1 37/64	1.5781	40.0844		2 37/64	2.5781	65.4844
19/32	0.5938	15.0813		1 19/32	1.5938	40.4813		2 19/32	2.5938	65.8813
39/64	0.6094	15.4781		1 39/64	1.6094	40.8781		2 39/64	2.6094	66.2781
5/8	0.625	15.875		1 5/8	1.625	41.275		2 5/8	2.625	66.675



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fraction	decimal	mm		fraction	decimal	mm		fraction	decimal	mm
41/64	0.6406	16.2719		1 41/64	1.6406	41.6719		2 41/64	2.6406	67.0719
21/32	0.6563	16.6688		1 21/32	1.6563	42.0688		2 21/32	2.6563	67.4688
43/64	0.6719	17.0656		1 43/64	1.6719	42.4656		2 43/64	2.6719	67.8656
11/16	0.6875	17.4625		1 11/16	1.6875	42.8625		2 11/16	2.6875	68.2625
45/64	0.7031	17.8594		1 45/64	1.7031	43.2594		2 45/64	2.7031	68.6594
23/32	0.7188	18.2563		1 23/32	1.7188	43.6563		2 23/32	2.7188	69.0563
47/64	0.7344	18.6531		1 47/64	1.7344	44.0531		2 47/64	2.7344	69.4531
3/4	0.75	19.05		1 3/4	1.75	44.45		2 3/4	2.75	69.85
49/64	0.7656	19.4469		1 49/64	1.7656	44.8469		2 49/64	2.7656	70.2469
25/32	0.7813	19.8438		1 25/32	1.7813	45.2438		2 25/32	2.7813	70.6438
51/64	0.7969	20.2406		1 51/64	1.7969	45.6406		2 51/64	2.7969	71.0406
13/16	0.8125	20.6375		1 13/16	1.8125	46.0375		2 13/16	2.8125	71.4375
53/64	0.8281	21.0344		1 53/64	1.8281	46.4344		2 53/64	2.8281	71.8344
27/32	0.8438	21.4313		1 27/32	1.8438	46.8313		2 27/32	2.8438	72.2313
55/64	0.8594	21.8281		1 55/64	1.8594	47.2281		2 55/64	2.8594	72.6281
7/8	0.875	22.225		1 7/8	1.875	47.625		2 7/8	2.875	73.025
57/64	0.8906	22.6219		1 57/64	1.8906	48.0219		2 57/64	2.8906	73.4219
29/32	0.9063	23.0188		1 29/32	1.9063	48.4188		2 29/32	2.9063	73.8188
59/64	0.9219	23.4156		1 59/64	1.9219	48.8156		2 59/64	2.9219	74.2156
15/16	0.9375	23.8125		1 15/16	1.9375	49.2125		2 15/16	2.9375	74.6125
61/64	0.9531	24.2094		1 61/64	1.9531	49.6094		2 61/64	2.9531	75.0094
31/32	0.9688	24.6063		1 31/32	1.9688	50.0063		2 31/32	2.9688	75.4063
63/64	0.9844	25.0031		1 63/64	1.9844	50.4031		2 63/64	2.9844	75.8031
1	1	25.4		2	2	50.8		3	3	76.2