# Stormsure Window Glazing Instructions

CE – On the 1st July 2013, the Construction Products Directive (CPD) became the Construction Products Regulations (CPR), making it mandatory in law for all glazed windows to be CE marked. All JELD-WEN factory glazed windows from 1st July 2013 will carry the CE mark in line with these requirements.

Where unglazed windows are supplied, it is the responsibility of the person glazing the window to provide a "Declaration of Performance" (DoP) for the glazed window and therefore CE mark the finished product accordingly.

## Re-Glazing

In the event of a breakage, glass units must be replaced with compatible insulating glass units to maintain the thermal performance of the building. Please check with JELD-WEN for glass unit specification to ensure the correct units are provided by your glazing contractor.

## Insulating Glass Units

IGUs should comply with BS EN 1279.

## Safety Glazing

Where glazing is vulnerable to human impact, it should be designed to resist breaking or if it breaks it should break safely.

Further advice on safety glazing can be obtained from;

England - Approved Document K: 2013 (now combines Approved document N: Glazing and also some overlapping guidance that is in Approved Document M: Access to and use of buildings respectively. Approved Document K 2013 also applies to building work carried out on excepted energy building in Wales as defined in the welsh Ministers (Transfer of Functions) (No.2) Order 2009.

Wales -Approved Document N: 1998 edition incorporating 2010 amendments

Scotland – BS6262: Part4: 2005

Northern Ireland, Technical Booklet V: 2000 and amendment booklet AMD3:2006

Toughened glass should be marked BS 6206 class A or B or BS EN 12150 class 1 or 2.

Laminated glass should be marked BS 6206 class A or B or BS EN 14449 class 1 or 2.

Glazing should be in accordance with BS 6262:1982

BS8000: Part 7:1990 and BRE Digest 453.

## Preparation

Remove all beads from the window making a mark on the inside of the rebate and corresponding bead which will help you to replace them in the same position when you glaze the window.

Pencil mark each bead on the outside with the fixing pin positions at no more than 50mm from each end and spaced at a maximum of 150mm along the length of the bead.

The larger "hockey stick" bead must always be fitted to the bottom rebate on 5mm bead packers leaving clear drainage and ventilation space.

Place the "hockey stick" bead on the platform and make a corresponding mark on the rebate platform. These pencil marks will show you where to position the bead packers and the pins when pinning the bead.

Remove all dust, grease and loose materials from the rebate. Any moisture on the timber should be wiped off using a clean paper towel or other absorbent material to give a dry surface.

Check the condition of any primer or basecoat stain on the frame, in particular the rebate and glazing surfaces of the beads. If the window has been exposed to the elements and shows signs of weathering, the frame including the rebate and beads should be re-primed or stained before glazing.

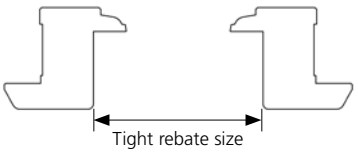
Check that the unit fits into the frame and can be centralised by standing the unit on the setting blocks so that there is a 5mm clearance at the bottom of the unit.

The spacer bar should ideally be slightly below the sightline.

## IGU size

- The Insulating Glass Unit (IGU) should be sized such that there is a nominal 5mm clearance between the edge of the IGU and the glazing rebate platform all around.
- To determine the correct size for the IGU, measure the tight rebate size in both height and width and deduct 10mm from both.

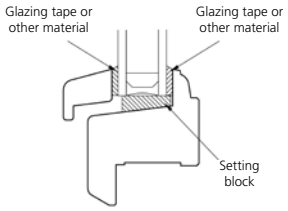
**Width**



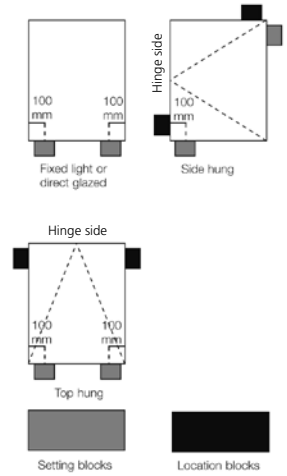

**Height**


**Setting and location blocks**

- To maintain the 5mm clearance around the IGU and the rebate platform the IGU should be supported on setting blocks at the bottom and positioned using location blocks in other places.




- When properly fitted setting and location blocks must be a tight fit between the edge of the IGU and the rebate platform.




**Glazing Seals**

- The width of the glazing rebate is such as to allow up to 3mm of glazing material either side of the IGU. This glazing material can be either load bearing foam or mastic tapes or non-load bearing sealants. Non-load bearing materials will require distance pieces to maintain the correct thickness of sealant throughout the glazing process.
- The glazing material should be applied to both both faces of the IGU (i.e. between the rebate upstand and the IGU and between the IGU and the bead.)
- Some types of glazing material can be applied in-line with the top of the rebate upstand or bead while others will need to have excess material trimmed or cleaned away so as to shed water.
- Place 5mm bead packers on the bottom rebate platform at the fixing points.
- Place the bottom bead in position first and apply pressure while pinning the bead to compress the glazing material.
- Fix the bead in position with non rusting pins at no more than 50mm from each corner and at no more than 150mm between pins.
- Place the side and then top beads and fix as above.

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