Pyroguard
A Saverto Company

Operating Procedure

Edge taping

OCTOBER 2026 EDITION

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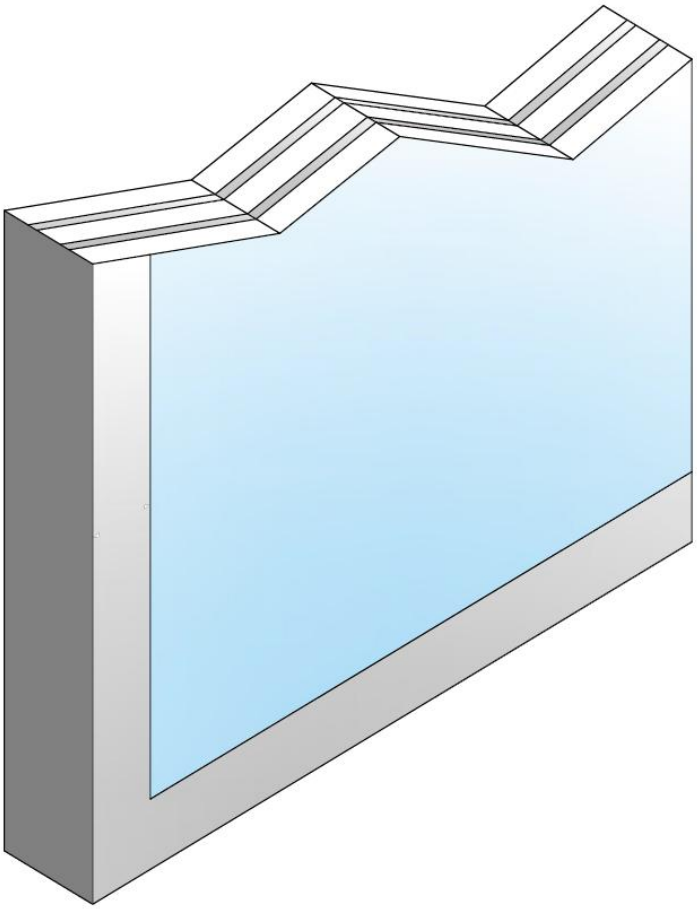
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1 Introduction

The purpose of this operating procedure is to provide detailed information of the application of tape to the edges of Pyroguard glazing according to the requirements of the Pyroguard License Holder Manual (available to all Licensed processors of Pyroguard). Some Pyroguard cuttable products require edge taping in order to maintain the integrity of the interlayer in normal use. For ***all*** cuttable Pyroguard products if there is any chance that the glass edge may be in contact with moisture or in a high humidity environment, such as a swimming baths, saunas or tropical countries, an aluminium foil edge tape should be applied to all edges before glazing.



1.1 Abbreviations used in this manual

DGU	Double Glazing Unit
IGU	Insulating Glass Unit
PAL	Polyester Aluminium Laminate
PPE	Personal Protective Equipment
VI	Insulated Glazed Unit (IGU, DGU)
TVI	Triple Glazed Unit (TGU)

2 Choosing the correct tape

If applicable Pyroguard recommend the use of aluminium tape, specifically water vapour resistant polyester aluminium laminate tape (PAL tape).

Suitable tapes are listed below:

Product reference	**Manufacturer**
FL1740	Flowstrip® Limited
K-Aludense	KMB Klebetechnik GmbH
NOTE: VITOMINIUM PET 230 S002 removed from use with Pyroguard Advance, other tapes previously listed from Klebetechnik GmbH are no longer manufactured	

3 Operating procedure for the edge taping of fire-resistant glass units

3.1 Safe operating – mandatory requirements

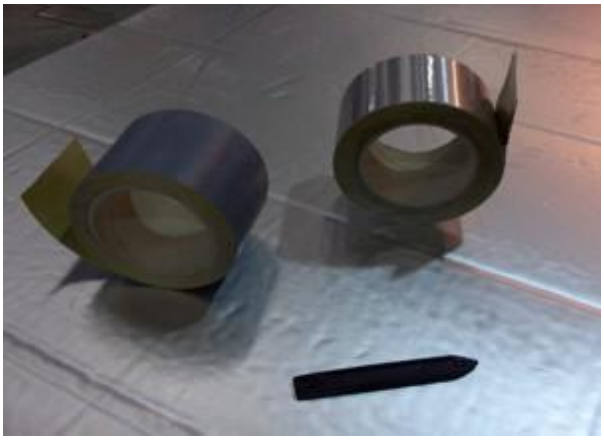


PPE must be worn at all times whist carrying out this procedure:

- Safety glasses
- Safety boots
- Wrist guards
- Safety gloves

Note: site specific safety procedures may exceed these requirements.

3.2 Equipment list

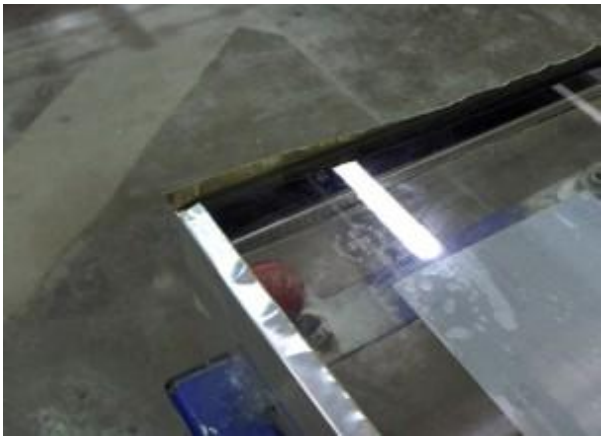


The equipment required for edge taping the fire resistant glass unit:

- Water vapour resistant Polyester Aluminium Laminate tape (PAL tape)
- Plastic smoothing tool; such as a soft plastic spatula or a decorators seam roller
- Safety blade tool
- Mechanical lifting equipment if required
- Glass cleaning solution used sparingly, keeping the glass edges dry

Ensure work area is clean and tidy and all equipment is available prior to start.

3.3 Preparation

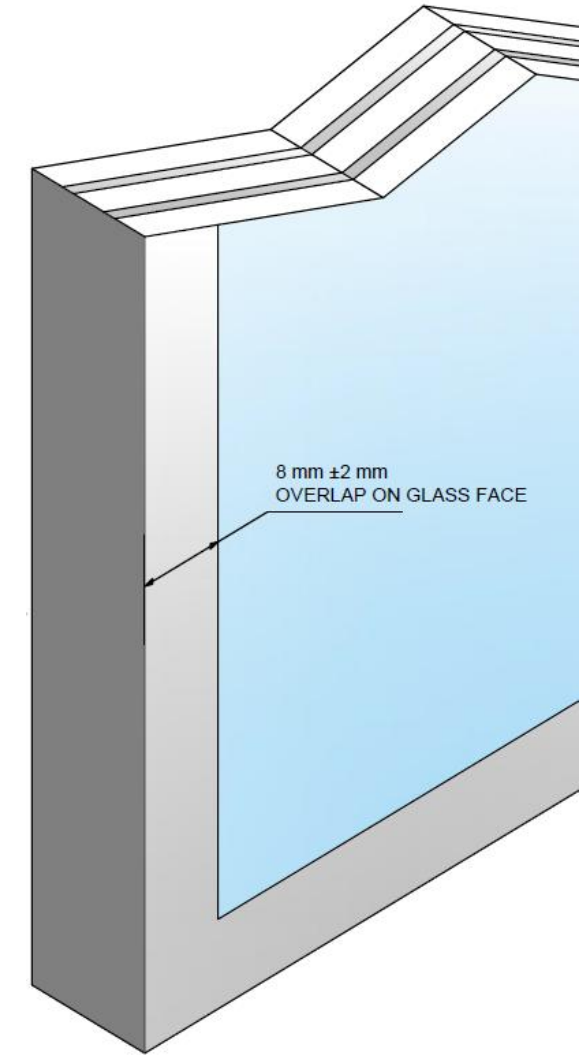
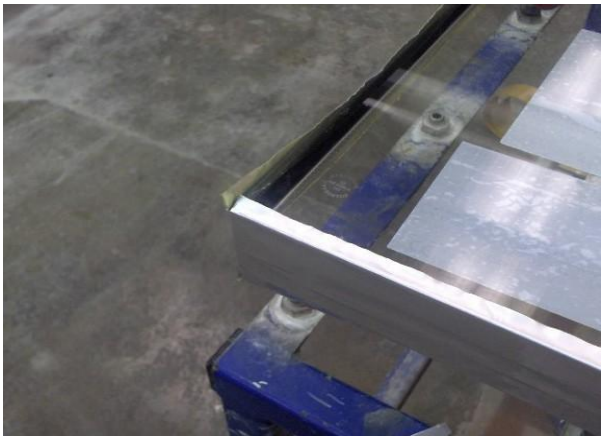


The face of the pane is dried and cleaned. In the case of an IGU or Pyroguard Balustrades, any protruding sealant is trimmed flush with the edge of the unit.

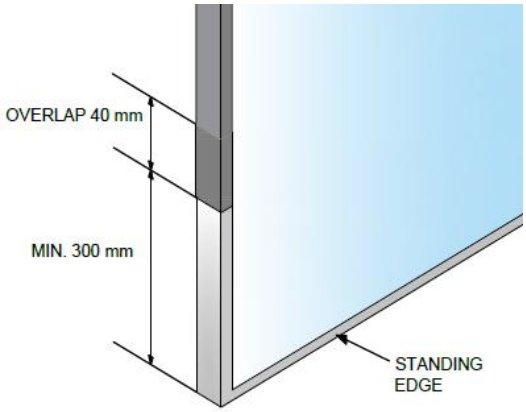
Do not get any liquid on the edge of the unit.

The glass edge must be completely clean and dry before taping.

3.4 Procedure

	The PAL tape must be 15 mm to 20 mm wider than the unit thickness to give the correct overlap onto the face of the unit. Overlap onto face is 8 mm +/- 2 mm. (see Annex 4.1)
	The correct width PAL tape is applied to the edge of the unit, ensuring that has an even overlap for the top/bottom face. The tape is cut at the corners (overlap edges only).





The ends of the PAL tape must overlap by a minimum of 40 mm on the upper third of the height of one of the side edges.

The edge overlap must be downwards facing (according to the glass orientation as it will be installed, see Annex 4.2). This is to prevent water ingress to the tape joint.



The PAL tape is then pressed onto the top face of the unit using the plastic smoothing tool. Care should be taken not to damage the tape in this process.

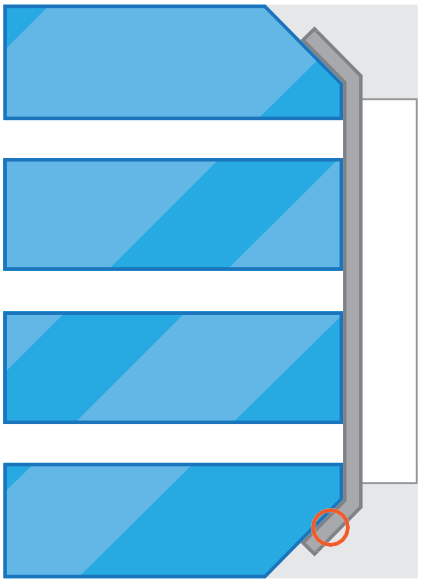
If the edge is roughly cut it is possible that the tape will be damaged by using a smooting tool too agressively.

The PAL tape must be pressed onto the top face evenly along the whole length (no creases or air bubbles).

On both the edge and glass surface, the tape must be pressed with considerable force to fully “wet-out” the adhesive and provide the appropriate bond. Force from fingers or a cloth is not sufficient. A hand tool such as a spatula or decorators seam roller is required.

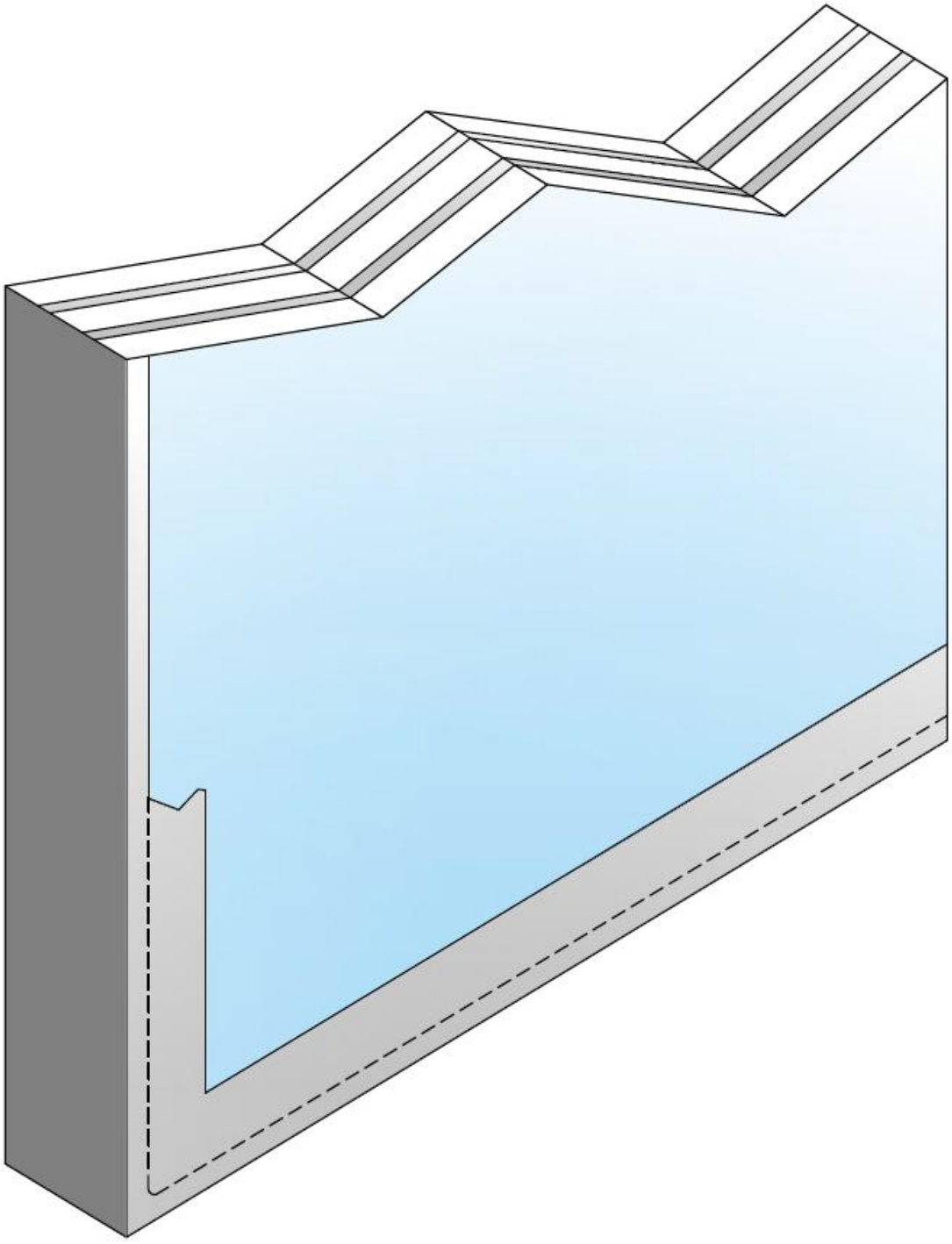
	Flip the glass, taking care to respect manual handling rules. The PAL tape is then pressed onto the bottom face of the unit using the plastic smoothing tool. The PAL tape must be pressed onto the bottom face evenly along the whole length. On all places of contact there must be no creases or air bubbles.
	The taped unit is lifted (using vacuum suckers if required). The unit is placed onto trolley or stillage. Care must be taken when lowering the unit that the edge tape is not damaged by either the trolley/stillage or a unit already loaded.
	If working with an IGU that is made with two fire resistant glasses, then extra care must be taken. Fire resistant glasses are heavy due to their thickness so the glass unit can be very heavy for its size. Fire resistant glass units represent a considerable product value for its size. When transporting glass units strapped to stillages, in addition to the rubber/carpet strips on the base bearers, a compliant material such as fibre block should be used.

3.5 Pyroguard EI SWS ‘butt-joint’ edge tape

	When applying PAL tape to Pyroguard Infinity butt-joint glass, ensure that the tape covers the polished edge of the unit “**O**”, allowing protection of the fire resistant interlayers.

3.6 Pyroguard insulating glazing units (VI and TVI)

Where the product requires taping, the glazing tape should be paired back on IGU face 3 (the side facing the inside of the unit) prior to building up the IGU. This is in order to allow good adhesion of the primary and secondary seal to the pane.



3.7 Pyroguard Balustrades

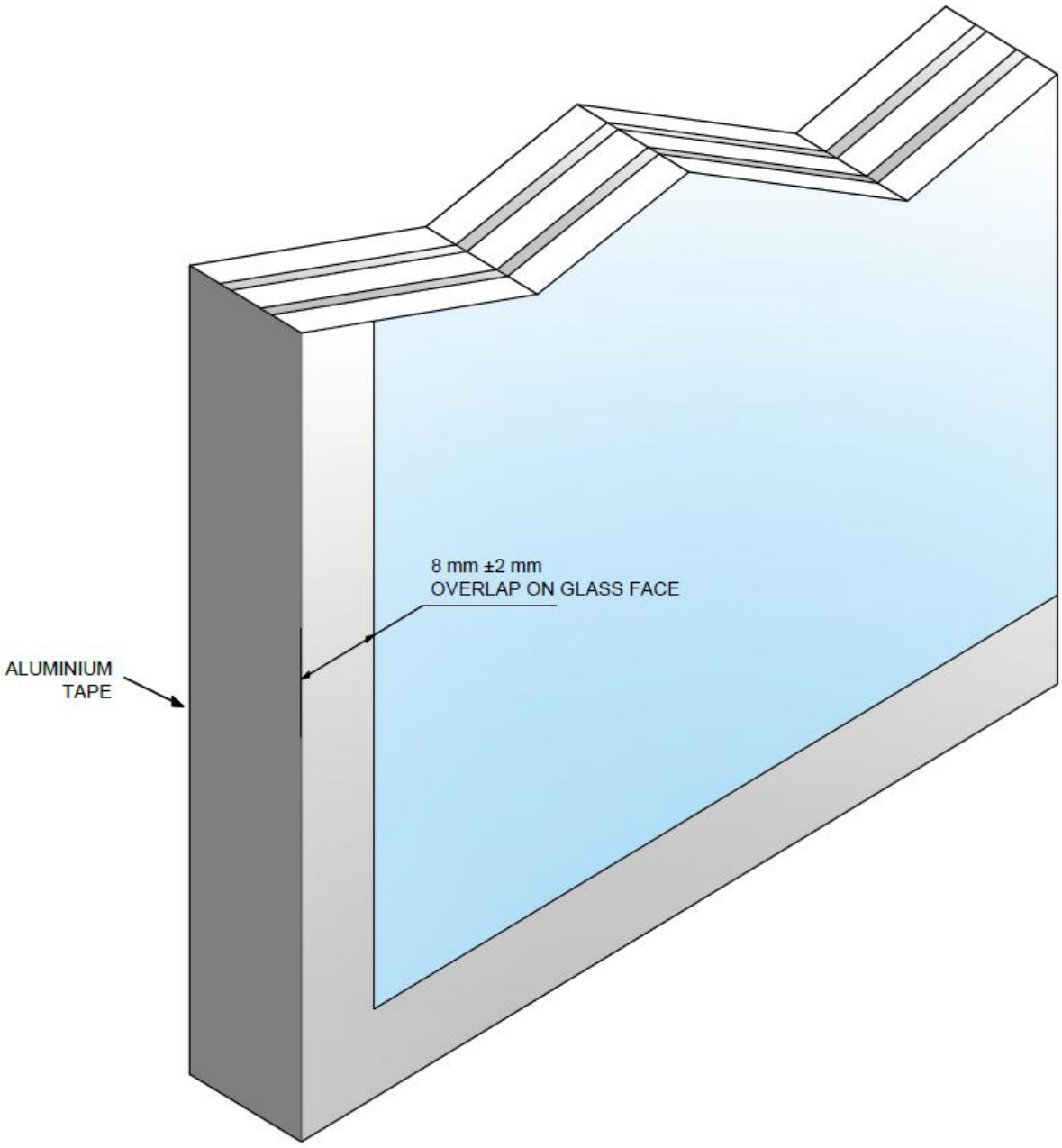
Consult the Pyroguard Balustrades guidance document for further information. This is available on our website as a download: www.pyroguard.eu/downloads.

3.8 Pyroguard glass taping crib sheet

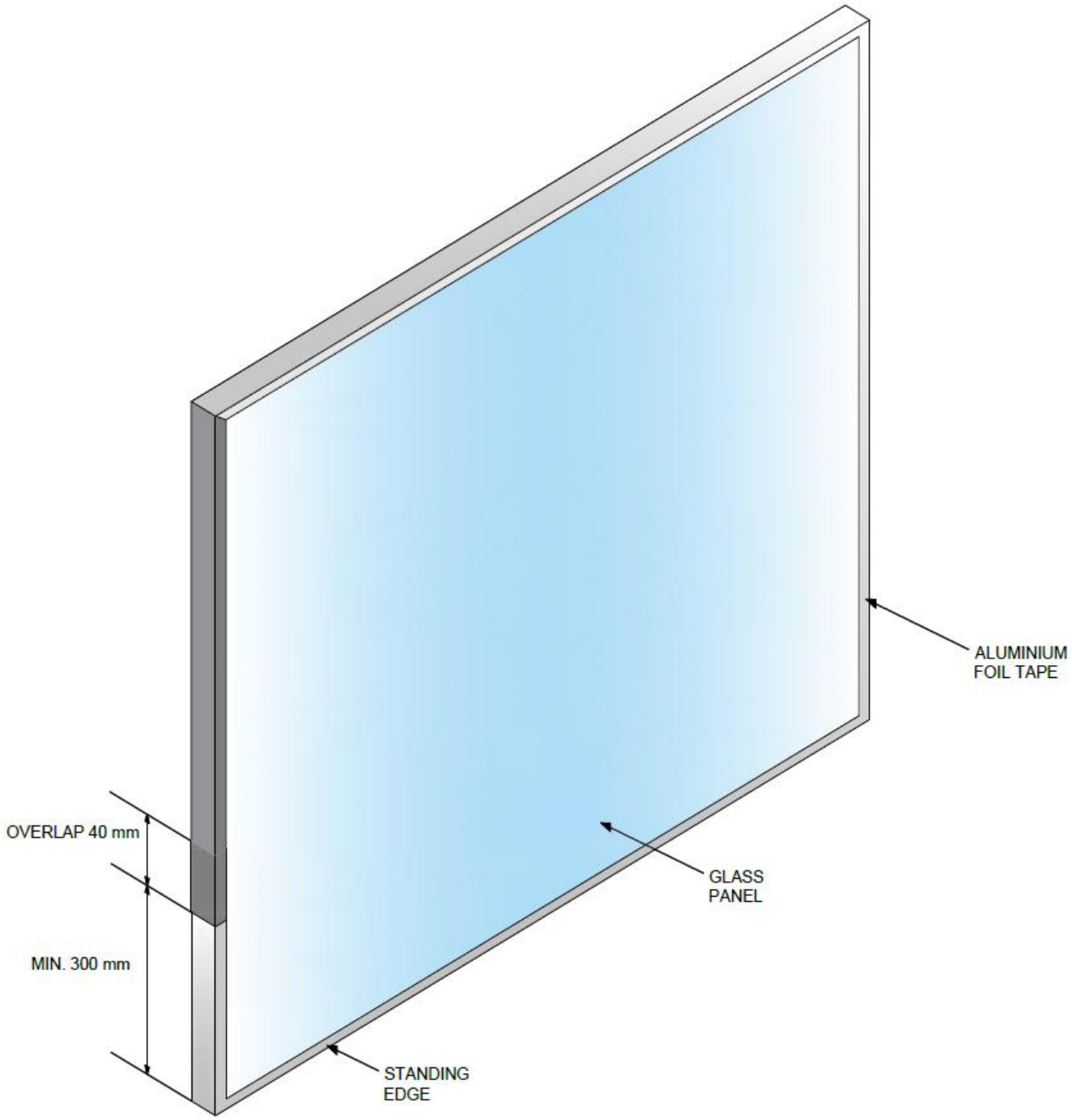
Pyroguard Rapide	Pyroguard EW30 Impact (7 mm)	No tape
	Pyroguard EW30 Maxi (11 mm)	No tape
	Pyroguard EW60 (11 mm)	No tape
Pyroguard Rapide Plus	Pyroguard EI30 INT (15 mm)	35 mm PAL tape
	Pyroguard EI30 EXT (19 mm)	35 mm PAL tape
	Pyroguard EI60 INT (23 mm)	45 mm PAL tape
	Pyroguard EI60 EXT (27 mm)	45 mm PAL tape
Pyroguard Infinity	Pyroguard EI30 INT SWS (15 mm)	35 mm PAL tape
	Pyroguard EI30 EXT SWS (19 mm)	35 mm PAL tape
	Pyroguard EI60 INT SWS (23 mm)	45 mm PAL tape
	Pyroguard EI60 EXT SWS (27 mm)	45 mm PAL tape
Pyroguard Advance	Pyroguard 2-EW30/7-1 (7 mm)	18 mm PAL tape
	Pyroguard 2-EW30/8-1 (8 mm)	18 mm PAL tape
	Pyroguard 2-EW30/8-1 VF P1A (12 mm)	25 mm PAL tape
	Pyroguard 2-EW30/11-2 (11 mm)	25 mm PAL tape
	Pyroguard 2-EW60/11-2 (11 mm)	25 mm PAL tape
	Pyroguard 2-EI30/16-3 (11 mm)	35 mm PAL tape
*Tape must be paired back and retained prior to IGU manufacture		

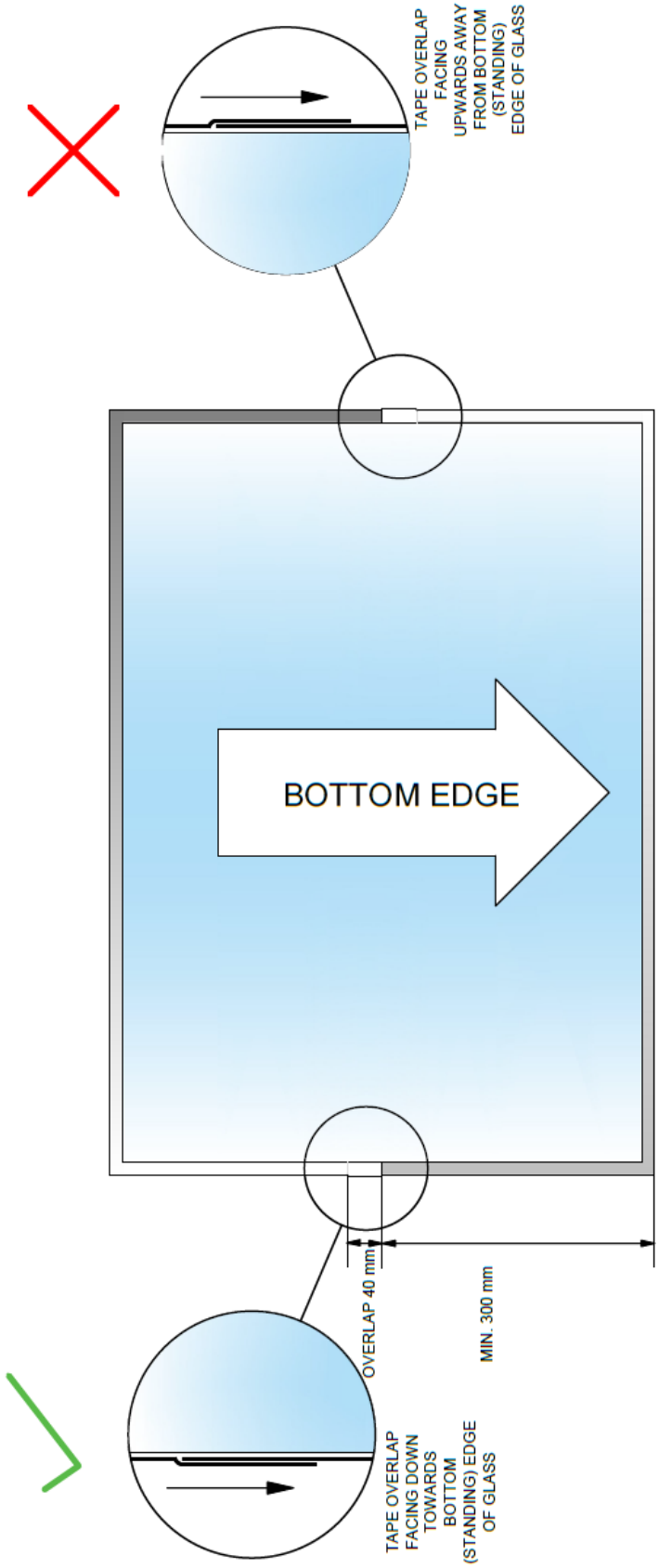
4 Annex

4.1 Overlap tape 8 mm on glass face



4.2 Overlap tape 40 mm at the joint




TAPE OVERLAP FACING UPWARDS AWAY FROM BOTTOM (STANDING) EDGE OF GLASS
BOTTOM EDGE
OVERLAP 40 mm
MIN. 300 mm
TAPE OVERLAP FACING DOWN TOWARDS BOTTOM (STANDING) EDGE OF GLASS

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