

Storage and handling

Pyroguard products: guidelines for users

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1 Introduction

This section provides details on handling and processing Pyroguard fire safety glass products to maintain product quality and maintain the warranty.

1.1 Storage

Pyroguard stock sheets should always be stored in their original end-cap case or, when unpacked, on suitable racking as used throughout the glass industry. Particular attention should be given to the bottom/resting edge to ensure it is not in contact with an uneven or hard surface. Care should be taken when handling the glass remembering that, until glazed, the individual thin glass layers may be damaged by small edge impacts.



All glass products should be stored indoors in dry conditions out of direct sunlight.

For manual handling, appropriate PPE should be worn and training should be given and recorded on a training matrix, as is standard practice for CE Marking in the glass industry. Care should be taken with the heavier weight of larger and thicker sheets.

Other handling guidance can be found via the GGF website in their publications Code of Practice Glass Handling, Storage and Transport <https://www.ggf.org.uk/>

1.2 Loading and unloading

1.2.1 Loading and distribution of stock packs

Once the pack is ready for distribution then, prior to loading, an outer label should be applied with the correct customer details. This label should bear the CE Mark and/or the UKCA Mark and should be kept with the pack until all the glass in the pack has been used. The information contained within the label must be passed on through the individual cut sizes to the point of installation.

Check lifting points and end-cap conditions prior to the lift. End-caps should be banded or suitably restrained individually to allow them to be withdrawn one at a time. Whilst unloading glass from a single end-cap it should be placed on a case or block supports set at 4-5° lean. Care should be taken when removing metal banding from end-caps. Eye protection and gloves should be worn by the person cutting the banding and no-one should be near enough to be struck by the strap whipping when cut.

1.2.2 Unloading a pack with HIAB

- Glass should be unloaded by the HIAB driver
- Store at an angle of 7°(minimum) before removing end-cap
- Secure pack with banding or suitable device if transporting
- Before lifting, ensure no-one is stood within 4 metres of the load

1.2.3 Unloading normal

- Before removing banding, ensure that the pack is secured by crane and all other packs are still banded to the A-frame
- Glass should be carried at a low Level
- Do not leave pack free-standing
- Store at an angle of 7° (minimum) before removing end-cap
- Before lifting, ensure no-one is stood within 4 metres of the load

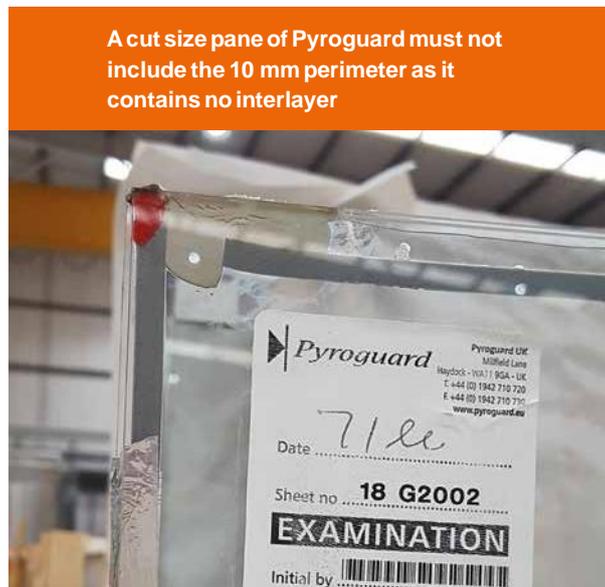
1.3 Cutting

1.3.1 Considerations

Pyrostem and all single Pyroguard laminates can be cut on a laminated glass cutting table or by scoring the glass by hand on each side and then snapping through. In some climatic conditions the interlayer may need the application of additional heat to separate the cut. There will be a 10 mm wide

area around the perimeter of stock sheet sizes of Pyroguard laminates which contains a tape and no interlayer, this must be removed and discarded.

For safety reasons it is recommended that Pyroguard Advance is cut on a semi-automated cutting table in order to cut the top and bottom of the laminate simultaneously. Best results will be found with reduced pressure on the cutting wheel and 'breaking' out gently rather than 'snapping'.



Pyroguard Rapide, Pyroguard Rapide Plus and Pyroguard Advance multi-laminates must be cut with a diamond-tipped saw blade, normally on a specialist-built vertical saw, with cooling water to avoid thermal cracks.

For best results the glass should be against the saw with the glass fully supported to prevent vibration.

All Pyroguard Advance glass products, especially those which have been saw-cut, should be washed and dried as soon as possible after cutting to remove any chance of surface damage. It is recommended to use the minimal amount of water when saw cutting and it is not advised to put panes through a washing machine, rather it is recommended to clean the residue left after cutting by hand, using a suitable glass cleaner.

Poor cutting edge quality can lead to breakages during handling and shipping.

Pyroguard EW30 Maxi Impact, EW30 Maxi Satin Impact, EW60 Impact and EW60 Satin Impact require the edges of the cut glass to be polished as do SWS products. This is an essential processing step that must be carried out.

For Pyroguard Advance and Pyroguard Rapide Plus, use a waterjet cutting tool with caution, interlayer residue can spoil the glass surface and is difficult to remove. This is especially true when using a horizontal bed. Avoid placing recently cut panes on stillages with damp or absorbent material at the base of the glass.

1.3.2 Summary of cutting considerations

Product range	Non-laminated	Single laminates	Multi-laminates
Pyroguard Advance		<p>Cut on a semi-automated cutting table in order to cut the top and bottom of the laminate simultaneously.</p> <p>Best results will be found with reduced pressure on the cutting wheel, compared to that used for Pyroguard Rapide, and 'breaking' out gently rather than 'snapping'.</p>	<p>Diamond-tipped saw blade, normally on a specialist-built vertical saw, with cooling water to avoid thermal cracks.</p> <p>Wash and dry as soon as possible after cutting to remove any chance of surface damage.</p> <p>Minimal amount of water when saw cutting.</p> <p>After cutting, clean the residue left by hand using a suitable glass cleaner.</p> <p>Use a waterjet cutting tool with caution, interlayer residue can spoil the glass surface and is difficult to remove. This is especially true when using a horizontal bed.</p>
Pyroguard Rapide		<p>Cut on a laminated glass cutting table or by scoring the glass by hand on each side and then snapping through. In some climatic conditions the interlayer may need the application of additional heat to separate the cut.</p>	<p>Diamond-tipped saw blade, normally on a specialist-built vertical saw, with cooling water to avoid thermal cracks.</p> <p>Processors favour extra water to reduce dust.</p> <p>Water washing is suitable to clear cutting residue.</p>
Pyroguard Rapide Plus			<p>Diamond-tipped saw blade, normally on a specialist-built vertical saw, with cooling water to avoid thermal cracks.</p> <p>Wash and dry as soon as possible after cutting to remove any chance of surface damage.</p> <p>Minimal amount of water when saw cutting</p> <p>After cutting, clean the residue left by hand using a suitable glass cleaner.</p> <p>Use a waterjet cutting tool with caution, interlayer residue can spoil the glass surface and is difficult to remove. This is especially true when using a horizontal bed.</p>
Pyrostem	<p>Pyrostem can be cut on a laminated glass cutting table or by scoring the glass by hand and then snapping through.</p>		

1.3.3 Traceability

Once the glass sheet has been placed on the cutting table, it should not be moved as there will be a risk of scratches on the glass.

Once the cutting has started, each cut must be completed without interruption, as the cutting fluid (water) may dissolve components of the interlayer and will subsequently produce stains on the surface of the glass.

It is good practice to clamp the glass at the top of the cut once the blade is halfway through the vertical cut. This will prevent vibration along the cut edge and prevent venting into the body of the glass. The clamp should only be applied at 'finger-tight' pressure.

The saw blade must be cooled by cutting fluid (water) during the sawing process. During this operation, the temperature of the water should not show a difference exceeding about 8-10°C with the ambient temperature. If the temperature is lower, there is a risk that cracks may appear in the glass during the cutting.

Pyroguard advise that the type of saw blades to be used are:

- Diamond discs WI-400-10-3, 6-7
- Diamond discs WI-350-10-3, 2-7

Once the glass has been cut, it is important to dry the edges and clean away any residue marks on the glass. The residue marks can be removed by using a general glass cleaning fluid and a fine grade steel wool ('type 0000').

1.3.4 Cutting using a water-jet cutter

Before cutting, the glass should be checked for any bowing. If the glass is bowed it should be stored horizontally for approximately 8 hours. The supporting table must be flat.

Polystyrene sheets should be placed on the water cutting bed to support the glass and prevent any scratches to the surface.

The water-jet cutter should be run at a pressure of 3100 bar at a feed of between 0.9 – 0.6 m/min depending on the glass thickness (i.e. 15 mm @ 0.9 m/min, 27 mm @ 0.6 m/min).

When cutting is complete, all surfaces of the glass should be cleaned and dried. After this initial clean, the glass should be washed in a washing machine and then thoroughly dried prior to any taping process.

1.3.5 Recommendations when taping the edges

Edge taping is not generally required for the finished size glass for Pyroguard Rapide providing the glazed edges will always remain dry (such as in interior glazing or in a drained or fully bedded external application).

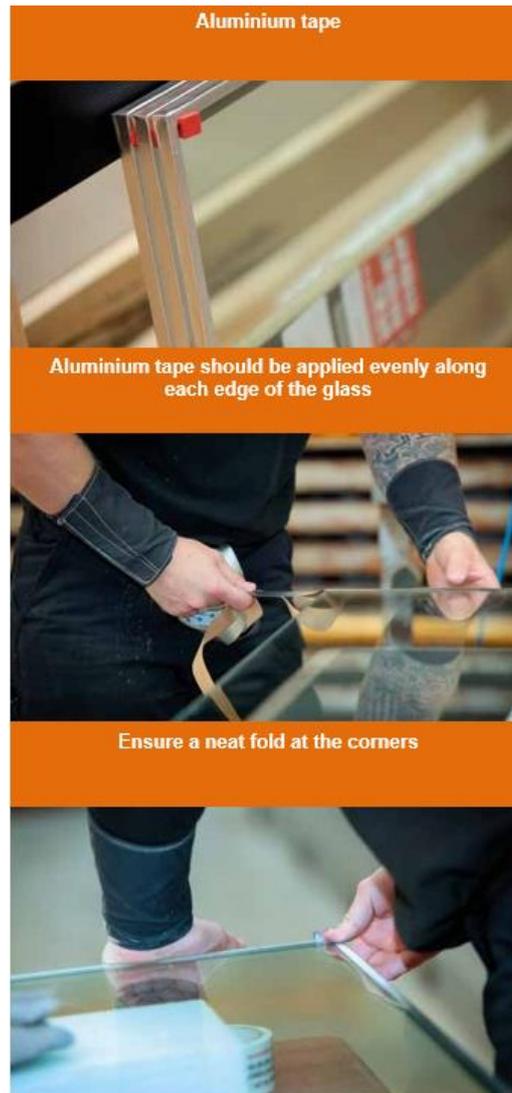
If there is any chance that the glass edge may be in contact with moisture or in high humidity, such as swimming baths or tropical countries, a metal foil edge tape should be applied to all edges before glazing.

Pyroguard Advance does not need to be edge-taped for use in internal applications. It should be edge-taped for external applications. It is recommended that it is edge-taped if cut-to-size glass is to be shipped where there is a risk of exposure to condensation and moisture. Only Pyroguard recommended aluminium tape should be used to tape the edges of the cut sized glass.

Tape must always be applied to Pyroguard Rapide Plus in transport and in normal installation use of the product. Only Pyroguard recommended aluminium tape should be used to tape the edges of the cut sized glass.

All edges must be thoroughly dried before any taping takes place to ensure good adhesion of the tape.

Fold and apply the aluminium tape carefully onto the glass. The aluminium tape should be applied evenly along each edge of the glass and pressed smooth sealing all open creases. The corners of the tape should be 'nibbed' with a blade to allow a neat fold at the corners. If the glass is to be used for an IGU, cut the aluminium tape back on one side up to approximately 3 mm overlap. Note: CNC milling type machines are not recommended for cutting Pyroguard products.



1.4 Storage and handling of Pyroguard Protect to ensure quality

Pyroguard Protect glass products should always be stored in their case or when unpacked on suitable racking as used throughout the glass industry. Particular attention should be given to the bottom/resting edge to ensure it is not in contact with any uneven or hard surfaces.

All glass should be stored in dry indoor conditions out of direct sunlight. Glass should be stored between -10 and +45°C. Care should be taken when handling the glass remembering that, until glazed, the individual glass layers may be damaged by small edge impacts.

For manual handling PPE should be worn, as normal in the glass industry, and care should be taken with the heavier weight of larger and thicker sheets.

2 Shipping

2.1 Pyroguard stock sizes

Pyroguard stock sheets are shipped in end caps. Further distribution of sheets should be in similar packaging or on appropriate A or L frames.

2.2 Stillage / Cases

Glass will often be transported by land, air and sea. The packaging required must allow for the risk of damage and in turn the safety of operators handling glass. Pyroguard must be secured to a frame or packed securely prior to shipping. Usually, a stillage or a case is used. Packaging should guard against heavy vibration by setting the glass on soft materials. It should guard against direct impact during shipping and protect against rainfall usually by wrapping in a film. The stillage selected should be larger in face dimensions than the glass to be shipped to avoid direct impact with the glass during shipping.

Frails shall have an angle of lean of at least 4°, if the vehicle is parked on horizontal ground under the most unfavourable loading conditions for loading or unloading single plates or glass units, the frail shall be provided with a device which indicates to the operator that the angle of lean is maintained correctly.

Protect against tipping of the package by having wide based stillage or cases to prevent excessive stress on the glazing.

2.3 Glass retention devices

Provisions shall be made for retaining the glass. If retention devices are not part of the equipment, appropriate instructions shall be included in the accompanying documentation. The design of glass retention devices shall demonstrate sufficient resistance to the glass; the mass of the glass to be transported, the dynamic forces and the friction forces which can occur under extreme operating conditions, therefore, take into account the following:

- a. Prevention of damage to the glass;
- b. Measures against failures or the unintended release of the retention devices.

The design of glass retention devices shall demonstrate sufficient resistance to the glass; the mass of the glass.

2.4 Belts / Straps

Belts or straps are manufactured in accordance with the requirements of EN 13246. Glass should be strapped to the case or stillage to avoid it moving independently of the packaging. The supplier will ensure that the banding used is suitable to retain the glass in transit. Consideration should be given to the movement of the stillage and decanting where additional banding may be required. Panes can be banded or suitably restrained individually to allow them to be withdrawn from the stack one at a time.

Avoid excessive stress on the glazing. Glass should be lightly strapped, and edge protectors used to avoid glass and strap contact.

2.5 Edge protectors

Edge protectors are manufactured to EN 13393 in a wide variety of forms and sizes, which are categorised as follows;

- Flat: Flat or strip form used for product protection, normally folded or wrapped around the edge during application of the strap
- Corner protectors: Small molded cut or formed pieces (up to 100 mm in length) used as edge protectors where no additional packaging strength is provided
- Profiles: Pre-formed lengths (greater than 100 mm in length) used for edge protection or reinforcement

2.6 Pads

Due to the nature of glass transportation, there is a risk that a vacuum can be created between sheets. The supplier shall ensure that appropriate transit pads have been fixed to protect the glass and reduce the risk of injury when unpacking whereby a vacuum could cause a breakage of glass.

2.7 Shipping

Securing the load to the vehicle will be the joint responsibility of the driver and consignor. However, the supplier must ensure that the glass, stillage or packing crate is properly stowed on the vehicle. Information related to the correct storage of packed glass must be passed to the logistics department/company when transport is arranged. Ideally a loading/securing plan needs to be drawn up and agreed by the consignor and logistics provider. Due to its fragile nature and varying sizes, glass must be secured on the vehicle. Using a similar process for stowing glass on a stillage or in a crate, securing straps must be in good condition and of a suitable tensile strength, complete with edge protectors where necessary to secure the pack or stillage from moving in transit.

Anchor points, retaining straps and headboards are common place on flat bed, inloaders and curtain-sided trailers and should be utilised as an integral part of the load securing requirements where and when possible. Anchor points must meet the relevant standards. For example, eye bolts to BS 4278-19846 and shackles to BS 35517 must be used to attach straps prior to departure. The supplier shall satisfy themselves that the glass is properly secured for transport before permitting its departure.

It is advised not to ship Pyroguard IGU by air due to problems of pressure equalization. The conditions of transport should be considered to avoid subjecting the Pyroguard glass to conditions beyond its capability.

At the destination product should be arranged to be stored undercover and safely away from construction vehicles and moving equipment to avoid site damage. The conditions of storage should be considered to avoid subjecting Pyroguard fire safety glass to conditions beyond its capability.

3 Glazing

3.1 Unpacking from shipping packaging

Check lifting points, stillage and case conditions prior to the lift. The size and configuration of these units must have already been agreed between supplier and principal contractors before dispatch, therefore an agreed method, and equipment to be used, should be in place before the consignment arrives on site. Stillages and cases should be banded or suitably restrained individually to allow them to be withdrawn from the stack one at a time. Whilst unloading, use appropriate restraints to retain remaining cases in position to prevent any movement due to wind, impact or other actions. Do not overload frames or racking when unloading single cases, chocks must be used under them to give the required angle and prevent forward movement of individual sheets or the case. Cases that can lean on 'A' frames or other purpose-built racking that can support the materials in a stable manner at a lean of 3-6° from vertical is commonly recommended. 5-6° is recommended for transportable racks, pallets and stillages.

3.2 Installing

Unless stated otherwise hardwood or non-combustible setting blocks (Vermiculite, Promatect H, Supalux, etc.) should be used to position the glass in the aperture in order to give sufficient edge cover, to ensure room for thermal expansion, good fire performance, stable positioning, elevation of the glass in the rebate and to hide any edge sealant.

In doors, glasses are often glazed heel-toe with four setting blocks at a diagonal to ensure that the glass does not move.

The following table lists typical edge cover allowance for Pyroguard products.

Range	Type	Edge cover*
VI, TVI (IGU, TGU)		≥13 mm
Pyroguard Protect	Toughened nanocomposite gel	≥13 mm
Pyroguard Firesafe	Toughened-monolithic (and VF variants)	6-10 mm
Pyroguard Rapide	Cutable resin	≥10 mm
Pyroguard Rapide Plus	Cutable sodium silicate	≥10 mm
Pyroguard Advance	Cutable nanocomposite gel	≥10 mm
*please request specific guidance when planning testing		



TECHNICAL FIRE SAFETY GROUP

Pyroguard UK Ltd

Headquarters - International House
Millfield Lane - Haydock - St. Helens
Merseyside - WA11 9GA - United Kingdom

T: +44 (0) 1942 710 720

F: +44 (0) 1942 710 730

E: info@pyroguard.eu

www.pyroguard.eu

 twitter.com/pyroguard

 linkedin.com/company/pyroguard

 facebook.com/pyroguarduk

 instagram.com/pyroguard

Pyroguard France SARL - Parc d'activités communautaire n°1

145 rue des Roseaux - 57455 Seingbouse - France

T: +33 (0)3 87 00 28 15 **F:** +33 (0)3 87 00 28 11 **E:** info.france@pyroguard.eu

Pyroguard Netherlands B.V. - Luchthavenweg 81.125

5657 EA Eindhoven - The Netherlands

T: +31 (0) 40 2888 525 **E:** info.nl@pyroguard.eu

Pyroguard Iberia - Bahia Space, C/ Bahía de Pollensa,

5 28042 - Madrid - Spain

T: +34 91 737 82 12

Pyroguard India - Kanakia Wall Street (4th floor) - Chakala, Andheri Kurla Road
Andheri East - Mumbai - Maharashtra 400093 - India