

	GED Integrated Solutions, Inc 31100 Diamond Pkwy Glenwillow, OH 44139	Document No.: ED-0059	Date: 01/07/20
		Revision: K	
Description: Intergrid, Contourgrid & Contour Cross Muntin Bar Raw Material Specification			
Written By: M. Gardner			
Approved By: T. McGlinchy			
Revision History:		Changed By:	Date:
G) Added ¼ X ¾ and ¼ x 5/16. Add anodized raw mat'l.		P. Hofener	10/05/00
H) Added 8mm X 25mm. Add bright gold painted mat'l. ER#02695		B. Briese	09/05/01
I) Approve AISI 3025 alloy ER#04441		B. Briese	11/03/11
J) Update paint spec's & suppliers, Rmv 3025 alloy Slit tol. was .0025" ER#04781		B. Briese	02/10/16
K) Added Contour Cross 4.5mm x 17.5mm ER#05294		B. Briese	01/07/20

This document specifies raw materials to be used with the GED Intergrid, Contourgrid and Contour Cross muntin process.

Raw Material – Painted Stock

Grade: Aluminum AISI 3105
 Hardness: H14 or H24 ("half-hard")
 Chemical: Chrome Pretreatment
 Coating: Fog-Free Paint System

Raw Material – Bright Gold Painted Stock

Grade: Aluminum AISI 3105, "Tube Bright" Finish
 Hardness: H14 or H24 ("half-hard")

Gauge: 0.020" before coating; tolerance +/- 0.001"

Coil Size: 16" I.D. 36" max. O.D.

Performance Specifications: The intended use of the material specified in this document is within an insulating glass unit (IGU), and thus is susceptible to introducing an organic or volatile contaminant within the IGU. Any paint or coating process used for the purposes of fabrication into an Intergrid or Contourgrid bar must be free from oil, grease or other organic contaminants.

Prior to initial approval, IGU including muntin bars fabricated with a specific paint or coating system must demonstrate compliance to one of the below Volatile Fog Testing Standards at an NFRC approved test laboratory:

- ASTM E2189 (USA)
- CAN/CGSB 12.8 (Canada)

Paint Quality: The requirements for hardness, flexibility (0T bend required), surface finish, gloss, solvent resistance and adhesion are specified on the manufacturer's Technical Data sheets.

For aluminum material painted on both sides, paint should be applied equal thickness to both sides of the metal.

Voids in paint that will show through to metal surface, caused by scratching, poor painting or other defects, that are visible (without magnification) from a minimum distance of 12 inches, are not acceptable.

Deposits of rubber, dirt or other contaminants or paint defects on the painted surface that are visible (without magnification) from a minimum distance of 12 inches, are not acceptable.

Metal Quality: The surface of the metal must be free from dings and scratches. The metal must be flat and have no wavy edges, crossbow, center buckles. Camber cannot exceed 0.062" per 4 foot section (refer to the Intergrid or ContourGrid Operator's manual).

Slit Edge Quality: The edge must not have any burrs greater than 0.001". The paint must not be peeled back from the edge greater than 0.001". Sections of material that contain peeling paint should not exceed 5% of the total length in a given coil. The slit edge should not produce any visible (without magnification) flaking of aluminum or paint when passed through the Intergrid or ContourGrid press or roll former.

Packaging: Use cardboard cores. Paper interleaving is not acceptable. Finished coils ("mults") should be separated by fiber spacers. Palletized coils should be wrapped and protected from typical ambient storage conditions such as dirt, moisture etc.

Slit Widths:

FRACTIONAL MUNTIN BAR SIZE	3/16 x 9/16 Intergrid	3/16 x 5/8 Intergrid	1/4 x 5/8 Intergrid	3/16 x 3/4 Intergrid	3/16 x 13/16 Intergrid	1/4 x 3/4 Intergrid
DECIMAL SIZE (INCH)	.190 x .551	.190 x .610	.237 x .625	.190 x .775	.190 x .801	.235 x .765
Slit Width (inch)	1.366	1.483	1.604	1.814	1.866	1.866
Approx. Coil Wt. (Lbs.)	109	119	128	145	149	149
Approx. Linear Feet	3,400	3,400	3,400	3,400	3,400	3,400

FRACTIONAL MUNTIN BAR SIZE	1/4 x 5/16 Intergrid	8mm X 18mm Contourgrid	5.5mm x 18mm Contourgrid	5.5mm x 25mm Contourgrid	8mm x 25mm Contourgrid
DECIMAL SIZE (INCH)	.230 x .312	.314 X .716	.218 x .720	.217 x .984	.315 x .984
Slit Width (inch)	0.949	1.692	1.610	2.160	2.220
Approx. Coil Wt. (Lbs.)	76	135	129	170	173
Approx. Linear Feet	3,400	3,400	3,400	3,400	3,400

FRACTIONAL MUNTIN BAR SIZE	4.5mm x 17.5mm Contour Cross				
DECIMAL SIZE (INCH)	.180 x .689				
Slit Width (inch)	1.515				
Approx. Coil Wt. (Lbs.)	125				
Approx. Linear Feet	3,400				

- All muntin bar height and width shown are nominal +/- tolerance of 0.005".
- All slit widths have a tolerance of +/- 0.003".
- Approx. coil weights & feet are for a full coil or "mult" (16" I.D. X 36" O.D.).

Suppliers:

Leading Edge Distribution
 1333 E Highland Rd Ste C
 Macedonia, OH 44056
 (440) 786-2444
 (440) 786-1099 (Fax)