

GED Integrated Solutions, Inc 31100 Diamond Pkwy Glenwillow, OH 44139			Document No.: ED-0019	Date: 09/23/2026
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T) Added Opti-Close fastener info	ER 03964		BB	11/04/15
U) Added Supplier to ULTRA material	ER 04839		BB	01/10/17
V) Updated Company Address and Supplier Contacts	ER 04965		TBM	06/29/18
W) Updated Supplier Listings, Add Scrivet	ER 05146		BB	03/18/19
X) Updated Blackline Supplier Listing	ER 05193		BB	05/06/19
Y) Updated Supplier Listings	ER 05201		BB	06/03/19
Z) Add Ulbrich, Upd Berlin contact	ER 05386		BB	08/05/20
AA) Add Jadtis	ER 05730		BB	02/28/22
AB) Add SBMS (NAS) Sealants	ER 05996		TBM	09/07/23
AC) Add Extreme & update suppliers	ER 06338		KJH	06/05/26
AD) Add Berlin Metals as supplier for Blackline ULTRA material			TES	09/21/26

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OVERVIEW

This document contains the raw material specifications for Intercept® IG Spacer Frames. This edition supersedes any previously published specifications, and is intended to clarify the specifications, rather than change material requirements.

PURCHASING MATERIAL

When purchasing steel, *make sure all the specifications are met exactly*. Check the size, packaging, and coating. Make sure the edges of the material are not damaged. Material that does not meet these specifications will cause machine malfunction and/or damage. *Use of material that fails to meet these specifications will void the machine warranty.*

This document lists several approved companies that supply raw materials. They may or may not be exclusive suppliers. All companies listed here have demonstrated the ability to deliver quality materials that meet these specifications. NOTE: Ashland Products is the exclusive producer of muntin end clips and Contour Grid Joiners under license.

HANDLING MATERIAL

Proper handling of coils and reels promotes worker safety maintains the integrity of the coils and reels.

- ☐ Do NOT remove Extreme coils from their corrugated reels.
- ☐ Non-Extreme coils weigh over 200lbs and should only be lifted using an assist device. Extreme reels weigh about 80lbs and can be handled by two people or an assist device.
- ☐ Mount coils/reels on uncoiler before removing strapping or banding.
- ☐ Do not remove tape from the end of the coil until the outer Coil Guard is fixed in place.
- ☐ Partial Extreme reels should remain on the uncoiler to maintain the coil integrity. The nature of the strip being thicker in the center means the coil will tend to widen if not held.
**GED recommends using a separate uncoiler to eliminate unloading and reloading Extreme materials to minimize damage to the coil.
- ☐ Partial coils/reels should have the end taped down when not in use.
- ☐ If removing a partial coil, secure the coil with banding or reinforced tape BEFORE removing it from the uncoiler.

STORING MATERIAL

Make sure the material is stored properly. Improper storage will damage the material, making it unusable.

- ☐ Do NOT remove Extreme coils from their corrugated reels.
- ☐ Use smooth, dry chipboard between non-Extreme coils. (The corrugated reels for Extreme serve the same function)
- ☐ Keep the coils wrapped in a rust-resistive plastic bag (Cortec or equivalent) to protect the material from moisture and prevent rust during shipment and storage. This also prevents dust from collecting between the layers..
- ☐ Do not use shrink wrap. The pressure can induce camber in the coil and damage the corrugated reels resulting in uncoiling issues.
- ☐ Keep the material in a clean, dry room under a constant temperature.
- ☐ Keep the material away from moisture.
- ☐ Rewrap and cover any unused material.

FOR FURTHER ASSISTANCE

If you have any questions, contact the GED Integrated Solutions Customer Service Department at (330) 963-5401.

Intercept Extreme ULTRA & Extreme Blackline Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.) Berlin Metals Stainless Steel type Intercept ULTRA.

Material Thickness	0.0076" + 0.0008"/- 0.0000"
Strip Width Tolerance	+ 0.001" / - 0.008" Burr allowance 10% of M.T.
Coil Core Size (I.D)	16"
Coil O.D.	36" maximum
Coil Weight of 1 inch wide material	80 lb. (approximate)
Linear feet/coil	2800 ft. (approximate)

Blackline Optional Surface Coating

Paint Manufacturer	Specialty Coatings Company (Becker Industrial Coatings)
Product	Specialty Super Series 3000 Polyester
Product Code	408-1-K1030
Color & Finish	Gloss Black
Coating Thickness per Side (Ref.)	0.0006" to 0.0007"
Hardness (Ref.)	F Eagle Turquoise
Solvent Resistance (Ref.)	50+ Double Rubs, MEK
Flexibility (Ref.)	0T Bend

Both sides of the material are coated using identical material. The requirements for substrate pre-treatment, coating thickness, flexibility, hardness, adhesion and chemical resistance are specified and controlled by Specialty Coatings Technical Data Sheets. Values contained on this table are for reference purposes only.

Strip Width Specifications, Intercept Extreme ULTRA & Extreme Blackline

Strip Width Specifications – English Measurements	
Standard Profile (.300" side wall height)	
Spacer Width (+/- 0.005")	Strip Width (+ 0.001/ - 0.008")
7/32"	Not Applicable †
1/4"	Not Applicable †
9/32"	Not Applicable †
5/16"	Not Applicable †
11/32"	Not Applicable †
3/8"	Not Applicable †
13/32"	Not Applicable †
7/16"	Not Applicable †
15/32"	1.131"
1/2"	Future *
17/32"	1.193"
9/16"	1.225"
19/32"	1.257"
5/8"	1.288"
21/32"	Future *
11/16"	Future *
23/32"	1.383"
3/4"	Future *
25/32"	Future *
13/16"	Future *
27/32"	Future *
7/8"	Future *

† Size not compatible with 3mm thermal break

* Size to be developed as market requires

Intercept ULTRA & Blackline ULTRA Stainless Steel Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.) Berlin Metals Stainless Steel, type Intercept ULTRA.

Material Thickness	0.0076" + 0.0008"/- 0.0000"
Cut Slit Width Tolerance	+ 0.000" / - 0.005" Burr allowance 10% of M.T.
Coil Core Size (I.D)	16"
Coil O.D.	36" maximum
Coil Weight of 1 inch wide material	232 lb. (approximate)
Linear feet/coil	8500 ft. (approximate)

Blackline Optional Surface Coating

Paint Manufacturer	Specialty Coatings Company (Becker Industrial Coatings)
Product	Specialty Super Series 3000 Polyester
Product Code	408-1-K1030
Color & Finish	Gloss Black
Coating Thickness per Side (Ref.)	0.0006" to 0.0007"
Hardness (Ref.)	F Eagle Turquoise
Solvent Resistance (Ref.)	50+ Double Rubs, MEK
Flexibility (Ref.)	0T Bend

Both sides of the material are coated using identical material. The requirements for substrate pre-treatment, coating thickness, flexibility, hardness, adhesion and chemical resistance are specified and controlled by Specialty Coatings Technical Data Sheets. Values contained on this table are for reference purposes only.

Intercept ThinPlate Steel Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.)

Material Thickness	Nominal 0.0077", Range 0.0069"- 0.0085"
Weight	70# per base box (0.0077") thickness
Finish	Matte or bright
Coating	0.25# matte or reflowed electrolytic tin plate
Alternative Coating	0.10# matte or reflowed electrolytic tin plate
Oil Level	ATBC (Acetyl tributyl citrate) oil level 1 or minimum
Chemtreat	CDC-5 450 +/- 100 Micrograms/sq ft.
Coil Core Size (I.D.)	16"
Coil O.D.	36" maximum
Coil Weight	230 lb. (approximate)
Linear feet/coil	8500 ft. (approximate)
Cut Slit Width	+ 0.000" / - 0.005"
Tolerance	Burr free edge
Coils Skidded	2500 lb. maximum

Intercept ThinPlate Blackline Steel Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.)

Material	Black plate steel
Material Thickness (Uncoated)	Nominal 0.0077", Range 0.0069" - 0.0085"
Weight	70# per base box (0.0077") thickness
Finish	#5C finish (AIM 40 to 60 microinches)
Oil Level	ATBC (Acetal tributyl citrate) oil level 1 or minimum
Coil Core Size (I.D.)	16"
Coil O.D.	36" maximum
Coil Weight	230 lb. (approximate)
Linear feet/coil	8500 ft. (approximate)
Cut Slit Width Tolerance	+ 0.000" / - 0.005" Burr free edge
Coils Skidded	2500 lb. maximum

Intercept ThinPlate Blackline Steel (Surface Coating)

Paint Manufacturer	Specialty Coatings Company (Becker Industrial Coatings)
Product	Specialty Super Series 3000 Polyester
Product Code	408-1-K1030
Color & Finish	Gloss Black
Coating Thickness per Side (Ref.)	0.0006" to 0.0007"
Hardness (Ref.)	F Eagle Turquoise
Solvent Resistance (Ref.)	50+ Double Rubs, MEK
Flexibility (Ref.)	0T Bend

Both sides of the material are coated using identical material. The requirements for substrate pre-treatment, coating thickness, flexibility, hardness, adhesion and chemical resistance are specified and controlled by Specialty Coatings Technical Data Sheets. Values contained on this table are for reference purposes only.

Strip Width Specifications, Intercept ULTRA & Intercept ThinPlate

Strip Width Specifications – English Measurements	
Standard Profile (.300" side wall height)	
Spacer Width (+/- 0.005")	Strip Width (+ 0.000/ - 0.005")
7/32"	0.882"
1/4"	0.913"
9/32"	0.944"
5/16"	0.976"
11/32"	1.006"
3/8"	1.038"
13/32"	1.069"
7/16"	1.101"
15/32"	1.131"
1/2"	1.163"
17/32"	1.193"
9/16"	1.225"
19/32"	1.257"
5/8"	1.288"
21/32"	1.319"
11/16"	1.351"
23/32"	1.383"
3/4"	1.413"
25/32"	1.445"
13/16"	1.476"
27/32"	1.507"
7/8"	1.538"

Strip Width Specifications (Metric), Intercept ULTRA & Intercept ThinPlate

Strip Width Specifications – Metric Measurements	
Standard Profile (7.62mm side wall height)	
Spacer Width (+/- 0.13mm)	Strip Width (+ 0.00/ 0.13mm)
6.0 mm	22.87 mm
6.5 mm	23.37 mm
7.0 mm	23.87 mm
7.5 mm	24.37 mm
8.0 mm	24.87 mm
8.5 mm	25.37 mm
9.0 mm	25.87 mm
9.5 mm	26.37 mm
10.0 mm	26.87 mm
10.5 mm	27.37 mm
11.0 mm	27.87 mm
11.5 mm	28.37 mm
12.0 mm	28.87 mm
12.5 mm	29.37 mm
13.0 mm	29.87 mm
13.5 mm	30.37 mm
14.0 mm	30.87 mm
14.5 mm	31.37 mm
15.0 mm	31.87 mm
15.5 mm	32.37 mm
16.0 mm	32.87 mm
16.5 mm	33.37 mm
17.0 mm	33.87 mm
17.5 mm	34.37 mm
18.0 mm	34.87 mm
18.5 mm	35.37 mm
19.0 mm	35.87 mm
19.5 mm	36.37 mm
20.0 mm	36.87 mm
20.5 mm	37.37 mm
21.0 mm	37.87 mm
21.5 mm	38.37 mm
22.0 mm	38.87 mm
22.5 mm	39.37 mm

Intercept Tin Plate Steel Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.)

Material Thickness	Nominal 0.0105", Range 0.0097"- 0.0110"
Weight	95# per base box (0.0105") thickness
Temper	T - 4 (AIM 58 - 64) RW 30-T Continuous Annealing Process
Finish	#5 finish (AIM 45 +/- 15 microinches)
Coating	0.25# matte or reflowed electrolytic tin plate
Alternative Coating	0.10# matte or reflowed electrolytic tin plate
Oil Level	ATBC (Acetal tributyl citrate) oil level 1 or minimum
Chemtreat	CDC-5 450 +/- 100 Micrograms/sq ft.
Coil Core Size (I.D.)	16"
Coil O.D.	36" maximum
Coil Weight	230 lb. (approximate)
Linear feet/coil	6900 ft. (approximate)
Cut Slit Width Tolerance	+ 0.000" / - 0.005" Burr free edge
Coils Skidded	2500 lb. maximum

Intercept Blackline Steel Specifications

Material Description

(The metal must be clean and dry. Make sure the edges are not damaged.)

Material	Black plate steel
Material Thickness (Uncoated)	Nominal 0.0097", Range 0.0087" to 0.0107"
Weight	88# per base box (0.0097") thickness
Temper	T - 4 (AIM 58 to 64) RW 30-T Continuous Annealing Process
Finish	#5C finish (AIM 40 to 60 microinches)
Oil Level	ATBC (Acetal tributyl citrate) oil level 1 or minimum
Coil Core Size (I.D.)	16"
Coil O.D.	36" maximum
Coil Weight	230 lb. (approximate)
Linear feet/coil	6900 ft. (approximate)
Cut Slit Width Tolerance	+ 0.000" / - 0.005" Burr free edge
Coils Skidded	2500 lb. maximum

Intercept Blackline Steel (Surface Coating)

Paint Manufacturer	Specialty Coatings Company (Becker Industrial Coatings)
Product	Specialty Super Series 3000 Polyester
Product Code	408-1-K1030
Color & Finish	Gloss Black
Coating Thickness per Side (Ref.)	0.0006" to 0.0007"
Hardness (Ref.)	F Eagle Turquoise
Solvent Resistance (Ref.)	50+ Double Rubs, MEK
Flexibility (Ref.)	0T Bend

Both sides of the material are coated using identical material. The requirements for substrate pre-treatment, coating thickness, flexibility, hardness, adhesion and chemical resistance are specified and controlled by Specialty Coatings Technical Data Sheets. Values contained on this table are for reference purposes only.

Strip Width Specifications: Tin Plate & Blackline Steel

Strip Width Specifications – English Measurements			
Standard Profile Spacers (.300" side wall height)		Low Profile Spacers (.250" side wall height)	
Spacer Width (+/- 0.005")	Strip Width (+ 0.000/- 0.005")	Spacer Width (+/- 0.005")	Strip Width (+ 0.000/- 0.005")
7/32"	0.862"	7/32"	.762"
1/4"	0.893"	1/4"	.793"
9/32"	0.924"	9/32"	.824"
5/16"	0.956"	5/16"	.856"
11/32"	0.986"	11/32"	.886"
3/8"	1.018"	3/8"	.918"
13/32"	1.049"	13/32"	.949"
7/16"	1.081"	7/16"	.981"
15/32"	1.111"	15/32"	1.011"
1/2"	1.143"	1/2"	1.043"
17/32"	1.173"	17/32"	1.073"
9/16"	1.205"	9/16"	1.105"
19/32"	1.237"	19/32"	1.137"
5/8"	1.268"	5/8"	1.168"
21/32"	1.300"	21/32"	1.200"
11/16"	1.331"	11/16"	1.231"
23/32"	1.363"	23/32"	1.263"
3/4"	1.393"	3/4"	1.293"
25/32"	1.425"	25/32"	1.325"
13/16"	1.455"	13/16"	1.356"
27/32"	1.487"	27/32"	1.387"
7/8"	1.518"	7/8"	1.418"

Strip Width Specifications (Metric): TinPlate & Blackline Steel

Strip Width Specifications - Metric Measurements			
Standard Profile Spacers		Low Profile Spacers	
Spacer Width (+/- .13 mm)	Strip Width (+.00/ .13 mm)	Spacer Width (+/- .13 mm)	Strip Width (+.00/ -.13 mm)
6.0 mm	22.35 mm	6.0 mm	19.85 mm
6.5 mm	22.85 mm	6.5 mm	20.35 mm
7.0 mm	23.35 mm	7.0 mm	20.85 mm
7.5 mm	23.85 mm	7.5 mm	21.35 mm
8.0 mm	24.35 mm	8.0 mm	21.85 mm
8.5 mm	24.85 mm	8.5 mm	22.35 mm
9.0 mm	25.35 mm	9.0 mm	22.85 mm
9.5 mm	25.85 mm	9.5 mm	23.35 mm
10.0 mm	26.35 mm	10.0 mm	23.85 mm
10.5 mm	26.85 mm	10.5 mm	24.35 mm
11.0 mm	27.35 mm	11.0 mm	24.85 mm
11.5 mm	27.85 mm	11.5 mm	25.35 mm
12.0 mm	28.35 mm	12.0 mm	25.85 mm
12.5 mm	28.85 mm	12.5 mm	26.35 mm
13.0 mm	29.35 mm	13.0 mm	26.85 mm
13.5 mm	29.85 mm	13.5 mm	27.35 mm
14.0 mm	30.35 mm	14.0 mm	27.85 mm
14.5 mm	30.85 mm	14.5 mm	28.35 mm
15.0 mm	31.35 mm	15.0 mm	28.85 mm
15.5 mm	31.85 mm	15.5 mm	29.35 mm
16.0 mm	32.35 mm	16.0 mm	29.85 mm
16.5 mm	32.85 mm	16.5 mm	30.35 mm
17.0 mm	33.35 mm	17.0 mm	30.85 mm
17.5 mm	33.85 mm	17.5 mm	31.35 mm
18.0 mm	34.35 mm	18.0 mm	31.85 mm
18.5 mm	34.85 mm	18.5 mm	32.35 mm
19.0 mm	35.35 mm	19.0 mm	32.85 mm
19.5 mm	35.85 mm	19.5 mm	33.35 mm
20.0 mm	36.35 mm	20.0 mm	33.85 mm
20.5 mm	36.85 mm	20.5 mm	34.35 mm
21.0 mm	37.35 mm	21.0 mm	34.85 mm
21.5 mm	37.85 mm	21.5 mm	35.35 mm
22.0 mm	38.35 mm	22.0 mm	35.85 mm
22.5 mm	38.85 mm	22.5 mm	36.35 mm

Approved Suppliers for Intercept Spacer Material

Approved Suppliers Extreme Ultra and Extreme Blackline

Technoform North American, Inc.

1755 Enterprise Pkway, Ste. 300
Twinsburg, OH 44087 U.S.A.
Tel: (330) 487-6600
Alexandra Blackeslee
www.technoform.com
Info.us@technoform.com

Approved Suppliers, Steel – ThinPlate and TinPlate

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

Berlin Metals

3200 Sheffield Ave.
Hammond, IN 46327
Tel: (800) 754-8867 x29
Pete Wilson

Colonial Metals

2350 Quality Lane
Hermitage PA 16148
Tel: (724) 346-5550
Will Thomas

Jadtis Industries

13365 Branch View Lane
Farmers Branch, TX 75234
Tel: (214) 334-2403
Bill Sultzbaugh

Approved Suppliers, Stainless Steel ULTRA

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

Ulbrich

12340 South Laramie Ave.
Alsip, IL 60803
Tel: (800) 323-7035, (708) 489-9500
Pete Wilson

Colonial Metals

2350 Quality Lane
Hermitage PA 16148
Tel: (724) 346-5550
Will Thomas

Jadtis Industries

13365 Branch View Lane
Farmers Branch, TX 75234
Tel: (214) 334-2403
Bill Sultzbaugh

Berlin Metals

3200 Sheffield Ave.
Hammond, IN 46327
Tel: (800) 754-8867 x29
Pete Wilson

Approved Suppliers, Blackline ThinPlate, TinPlate and Stainless Steel ULTRA

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

Colonial Metals

2350 Quality Lane
Hermitage PA 16148
Tel: (724) 346-5550
Will Thomas

Berlin Metals

3200 Sheffield Ave.
Hammond, IN 46327
Tel: (800) 754-8867 x29
Pete Wilson

Sealant and Desiccant Matrix

Suppliers

HB Fuller Co. and Kömmerling

5220 Main Street Northeast
Minneapolis, MN 55421
Tel: (800) 328-7307

Fenzi North America

11 Dansk Ct.
Toronto, Ontario M9W 5N6
Canada
Tel: (416) 674-3831

SBMS

1610 Nationale, Terrebonne
(Quebec) J6W 0E2, Canada
Tel: 514-609-6707
450-477-6707
1-888-430-4481
Laurent Chatagneau
laurent@s-b-m-s.com

GED Scrivets

Material Description

Zinc plated steel screw

Size \ Color	<u>Standard Scrivet Part #</u>		<u>Cap. Tube Scrivet Part #</u>	
	Silver/Gray	Blackline	Silver/Gray	Blackline
#8-32	3-34679-1	3-34679-2	3-36244-1	3-36244-2
#10-32	3-32979-1	3-32979-2	3-33150-1	3-33150-2

Supplier**GED Integrated Solutions, Inc.**

31100 Diamond Pkwy.
Glenwillow, OH 44139
Tel: (330) 963-5401
Fax: (216) 539-0677
Web: store.gedusa.com

Screws

Material Description

Screw sizes:

- #8-32 (0.125")
- #10-32 (0.157")
- 1/4-28 (0.205")

Suppliers

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

Rivets

Material Description

Closed-end Sealing Rivets without gaskets
3 mm and 4 mm

Suppliers

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

McKeegan Sales

811 Ronda Dr.
Canton, MI 48187
Tel: (734) 459-5870
3 mm rivet - Part # 4253
4 mm rivet - Part # 4255

S. W. Anderson Company

Downers Grove, IL
Tel: (630) 964-2600
3 mm rivet - Part # R-4242
4 mm rivet - Part # R-4243

Opti-Close

(*See Note*)

Material Description

4mm X 12mm slotted-hole closure

*Note: Contact supplier for compatibility

Suppliers

Leading Edge Distribution

140 E. Ascot Ln.
Cuyahoga Falls, OH 44223-3743
Tel: (440) 786-2444
Dave Thoman

Muntin End Clips and Joiners

Material Description

Clip sizes from 7/32" - 23/32" spacer width, in 1/16" increments.

Clip sizes from 6mm to 22.5mm spacer width, in 0.5mm increments.

Grid Joiners for 25x8mm, 18x8mm, 3/4x3/16, 1-1/4x0.130

Approved Supplier

AmesburyTruth

Tel: 800-866-7887
innovations@amesburytruth.com
www.amesburytruth.com/products/windows/hung/grid-clips
www.amesburytruth.com/products/windows/hung/grid-joiners

Laser & Ink-Jet Spacer Marking Systems

Laser Marking Systems

For maintenance and service:

VideoJet Systems

1500 Mittel Blvd
Wood Dale, IL 60191
Tel: (630) 860-7300 Sales/Corporate Office
Tel: (800)843-3610 Service

Ink-Jet Printers

For maintenance, ink refills and service:

VideoJet Systems

1500 Mittel Blvd.
Wood Dale, IL 60191
Tel: (630) 860-7300 Sales/Corporate Office
Tel: (800) 843-3610 Service

Domino

1290 Lakeside Drive
Gurnee, IL 60031
Tel: (513) 574-0883
Tel: (800) 444-4512

For More Information

Vitro

www.vitro.com

Tel: (412) 820-8507
Fax: (412) 820-4904

Brad Boone
bboone@vitro.com

GED Integrated Solutions, Inc.

www.gedusa.com

31100 Diamond Pkwy.
Glenwillow, OH 44139
Tel: (330) 963-5401
Fax: (216) 539-0677