

# Highseal Manufacturing Company

Quality windows, doors and conservatories to the trade

## Manufacturing Parameters

As with any manufacturing process, we work to a strict set of parameters in order to ensure that our products arrive with you, the customer, in the best possible condition. The manufacturing parameters are in three tables to make the ordering process as simple as possible for both you and our sales team. Please use these tables as reference when outing your orders together.

### Insulating Glass Unit Production

Glass Thickness	Glass Type	Max Dimension	Max m2
4mm	Annealed	1300 x 1300	2.5
4mm	Toughened	1300 x 1300	2.5
4mm	Pattern	1300 x 1300	2.5
6mm	Annealed	3210	4
6mm	Toughened	3210	5.5
6mm	Pattern	1310 x 2140	5.5
6.4mm/6.8mm/7.5mm	Laminate	3210	4
8mm	Toughened	3210	6.5
8.8mm/9.5mm	Laminate	3210	5
10.8mm/11.5mm	Laminate	3210	7
12.8mm/13.5mm	Laminate	3210	7+

### Manufacturing Capabilities

	Size	Thickness
Max Size for In-house Glass stock	3210 x 2550/2250/2000	4mm to 11.5mm
Max Size for Pattern In-house Glass stock	1320 x 2140	4mm to 6mm
Max Size for In-house Cutting Facility	3210 x 2550/2250/2000	4mm to 11.5mm
Max Size for In-house Toughened Plant	2000 x 4000	4mm to 12mm
Max Size for IGU Auto line with Super Spacer bar	3200 x 1800	32mm O/A
Max Size for IGU Auto line with Aluminum Spacer bar	4500 x 2400	47MM O/A
Max Size for Triple Glazed Units (4mm thick panes)	1300 x 1300 or 2.5m2	44M O/A
Max size for In-house Silicone Edge Sealing	3200 x 2000	Max 20mm Cavity
Max size for In-house Painting Facility	3000 x 1900	4mm to 19mm

Registered in England • Company Registered Number 06581087  
26 Hebden Road • Scunthorpe • North Lincolnshire • DN15 8DT  
Telephone 01724 859326 • Fax 01724 845576

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Max size for In-house Sandblasting	3200 x 1500	4mm to 12mm
FAN HOLES: Max dimension from edge of glass to edge of hole	Annealed/Tough = 100mm	3210
Laminate = 150mm	4mm to 10mm	3210
IGU Aspect Ratio = 8:1	(The ratio of the longer side of a pane to its shorter side)	
Minimum Toughening Size	210mm x 210mm (under IGU aspect ratio)	

## Minimum Spacer Size Guide

Mm	100	1250	1500	1750	2000	2250	2500	2750	3000	3250+
<b>1000</b>	6mm	6mm	8mm	10mm	12mm	12mm	14mm	16mm	16mm	16mm
<b>1250</b>	6mm	6mm	8mm	10mm	12mm	12mm	14mm	16mm	16mm	16mm
<b>1500</b>	8mm	8mm	10mm	12mm	12mm	12mm	14mm	16mm	16mm	16mm
<b>1750</b>	10mm	10mm	12mm	12mm	14mm	14mm	14mm	16mm	16mm	16mm
<b>2000</b>	12mm	12mm	12mm	14mm	16mm	16mm	16mm	16mm	16mm	16mm
<b>2250</b>	12mm	12mm	12mm	14mm	16mm	16mm	16mm	16mm	16mm	16mm
<b>2500</b>	14mm	14mm	14mm	14mm	16mm	16mm	16mm	16mm	16mm	16mm
<b>2750</b>	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm
<b>3000</b>	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm
<b>3250+</b>	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm	16mm

If you are unsure about your requirements, feel free to contact our knowledgeable Sales Team who will be able to advise and point you in the right direction. 01724 859326

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