

Technical Data Sheet – Ultra Mirror 11/2011

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1 INTRODUCTION

This Technical Datasheet gives information about the range of coated glass Ultra Mirror: Ultra Clear Mirror and Ultra Grey mirrors.

These information's are related to stock sizes.

2 NORMATIVE REFERENCES

Ultra Mirror products conform to:

- EN 1096-1 – Glass in building – Coated glass – Part 1: Definitions and classification
- EN 1096-2 - Glass in building – Coated glass – Part 2: Requirements and test methods for class A, B and S coatings
- EN 1096-4 - Glass in building – Coated glass – Part 4: Evaluation of conformity/Product Standard.

All Ultra Mirror are produced in factories being ISO 9001 certified.

3 COMPOSITION AND PROPERTIES OF THE GLASS

The basis glass used for Ultra Mirror production is float glass conform to EN 572-1 & 2. The properties of the float glass are listed hereunder.

3.1 CHEMICAL COMPOSITION

The EN 572-1 defines the magnitude of the proportions by mass of the principal constituents of float glass is as following.

SiO ₂	69 to 74 %
Na ₂ O	10 to 16 %
CaO	5 to 14 %
MgO	0 to 6 %
Al ₂ O ₃	0 to 3 %
Others	0 to 5 %

3.2 MECHANICAL PROPERTIES

- Weight (at 18°C): $\rho = 2\,500\text{ kg/m}^3$
- Density: 2,5
- Young's Modulus (modulus of Elasticity): $E = 70\,000\text{ N/mm}^2$
- Poisson Ratio: $\mu = 0,2$
- Shear Modulus: $G = E / [2 (1+\nu)] \approx 29\,166\text{ N/mm}^2$
- Knoop Hardnes: 6 GPa
- Mohs Hardness: 6
- Characteristic bending strength: 45 N/mm^2

3.3 THERMAL PROPERTIES

- Softening point: $\approx 600\text{ }^\circ\text{C}$
- Fusion temperature: $\approx 1500\text{ }^\circ\text{C}$
- Linear expansion coefficient: $\alpha = 9.10^{-6}/\text{K}$ (between 20° and 300°)
- Specific heat capacity: $C = 720\text{ J}/(\text{kg.K})$

3.4 OPTICAL PROPERTIES

Refractive index N to visible radiation (380 to 780 nm):

- air/glass: 0,67
- glass/air: 1,50

3.5 ELECTRICAL PROPERTIES

- Specific resistance: $5.10^7\ \Omega.m$ at 1 000 Hz and 25°C
- Dielectric constant: 7,6 at 1 000 Hz and 25°C

4 DURABILITY OF ULTRA MIRROR COATINGS

Ultra Mirror coatings are class A following EN 1096-1. They succeed the durability test following EN 1096-2:

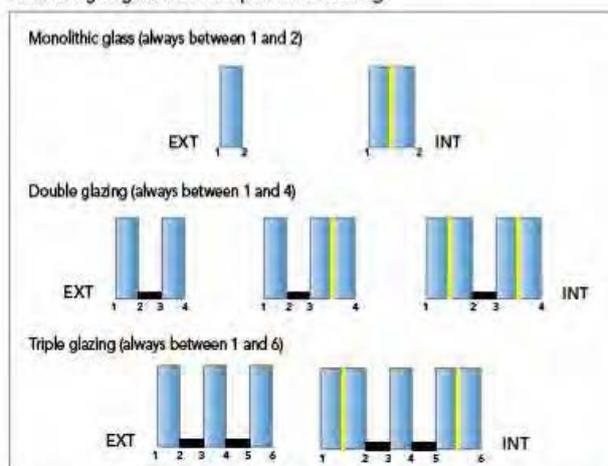
- Resistance to condensation: 21 days
- Resistance to acid: 5 cycles
- Neutral salt spray: 21 days
- Resistance to abrasion: 500 cycles

5 LIGHT, SOLAR AND THERMAL PROPERTIES

5.1 CONVENTION FOR COATING POSITION

The following conventions are used for the numbering of the glass faces and the position of the coating.

Numbering of glass faces and position of coatings



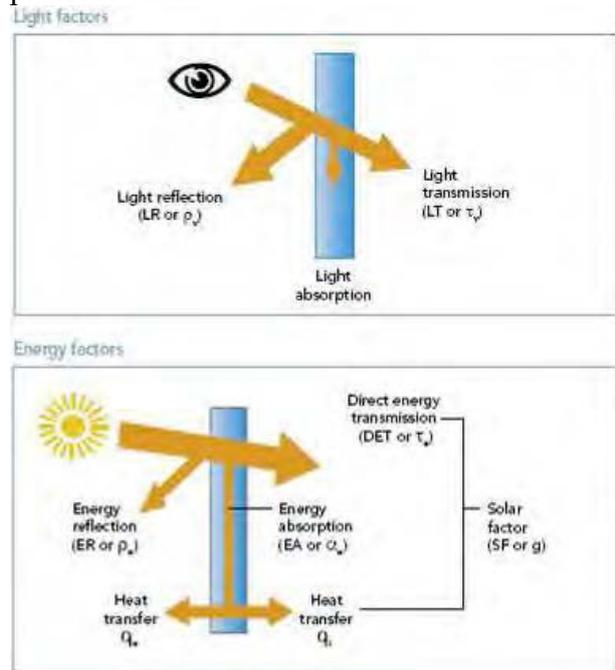
5.2 TOLERANCES ON LIGHT AND SOLAR PROPERTIES

The light and solar properties are calculated using spectral measurement that conforms to standards EN 410 and WIS/WINDAT. The following properties are given:

- $LT (\tau_v)$: Light transmission
- $LR (\rho_v)$: Light reflection on coating side
- $LR' (\rho'_v)$: Light reflection on glass side
- $DET (\tau_e)$: Direct energy transmission
- $ER (\rho_e)$: Energy reflection on coating side
- $ER' (\rho'_e)$: Energy reflection on glass side
- $EA (\alpha_e)$: Energy absorption
- $SF (g)$: Solar factor
- SC : Shading coefficient

The tolerances on the values LT , LR , LR' , DET , ER , ER' are $\pm 3\%$.

Notes: they are no direct tolerances on SF, SC and EA as these values are calculated from the previous ones.



5.3 TOLERANCES ON THERMAL PROPERTIES

The thermal transmittance U_g (W/m^2K) is calculated according EN 673. The emissivity measurement complies with EN 673 and EN 12898.

Note: Ultra Mirror coatings have no emissivity (normal emissivity $\epsilon_n = 0,89$).

5.4 PERFORMANCES OF ULTRA MIRROR PRODUCTS

The table lists the light, solar and thermal properties of the Ultra Mirror products of 6 mm thickness.

	LT	LR	LR'	DET	ER	ER'	en
6 mm Ultra Mirror S Clear	63	35	34	64	27	24	0,89
6 mm Ultra Mirror S Grey	29	34	11	34	27	10	0,89

6 ACOUSTIC PROPERTIES

The table lists the acoustic properties.

	Rw (C, Ctr)	Rw + C	Rw + Ctr
4	30 (-2, -4)	28	26
5	30 (-1, -2)	29	28
6	31 (-2, -3)	29	28
8	32 (-1, -2)	31	30

10	34 (-2, -3)	32	31
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7 TOLERANCES ON DIMENSIONS

The same tolerances than for the float used as support of the coating apply. This information relates to stock sizes.

7.1 THICKNESS

The actual thickness shall be the average of four measurements, taken to the nearest 0,01 mm, one taken at the centre of each side. The actual thickness rounded to the nearest 0,1mm shall not vary from the nominal thickness by more than the tolerances shown in the table.

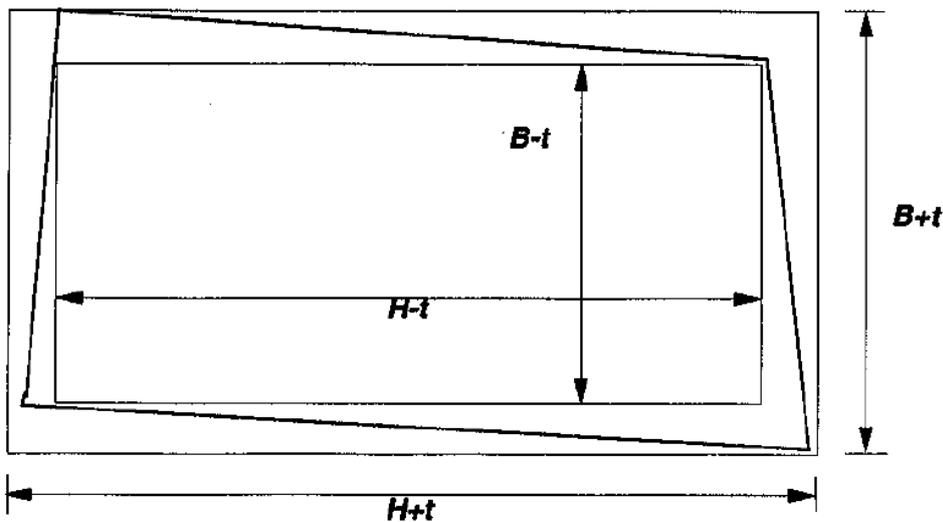
Minimum (mm) Maximum (mm)

	Minimum (mm)	Maximum (mm)
6	5,8	6,2

7.2 LENGTH AND WIDTH

The tolerances on nominal dimensions length H and width B are respectively ± 3 mm and ± 2 mm.

The limit of squareness is described by the difference between diagonals. The difference is maximum 5 mm.



8 QUALITY REQUIREMENTS

8.1 INTRODUCTION

The defect affecting appearances are:

- Specific from the float glass: see the Technical Datasheet "Planibel"
- Specific to the coating: see hereunder.

If a defect specific to the glass substrate is more visible because of the coating, it will be treated as a coating defect.

8.2 DEFINITIONS OF DEFECTS

The following definitions apply:

Uniformity defect: Slight visible variation in colour, in transmission or reflection, within a coated glass pane or from pane to pane

Stain: Defect in the coating larger than punctual defect, often irregularly shaped, partially of mottled structure.

Punctual defect: Punctual disturbance of the visual transparence looking through the glass and of the visual reflectance looking at the glass

Note: Spot, pinhole and scratch are types of punctual defect.

Spot: Defect that commonly looks dark against the surrounding coating, when viewed in transmission

Pinhole: Punctual void in the coating with partial or total absence of coating and normally contrasts clear relative to the coating, when viewed in transmission

Scratch: Variety of linear mark, whose visibility depends on their length, depth, width, position and arrangement

Cluster: Accumulation of very small defects giving the impression of stain.

8.3 DETECTION OF DEFECTS

8.3.1 GENERAL

The defects are detected visually by an observation of the coated glass in transmission and/or reflection. An artificial sky or daylight may be used as the source of illumination.

8.3.2 ARTIFICIAL SKY

The artificial sky is a plane emitting diffuse light with a uniform brightness and a general colouring index Ra higher than 70. It is obtained by using a light source whose correlated color temperature is in the range between 4000 K and 6000 K. In front of the arrangement of light sources is a light scattering panel, without spectral selectivity. The illuminance level, on the glass surface shall be between 400 lx and 20000 lx.

8.3.3 DAYLIGHT ILLUMINATION

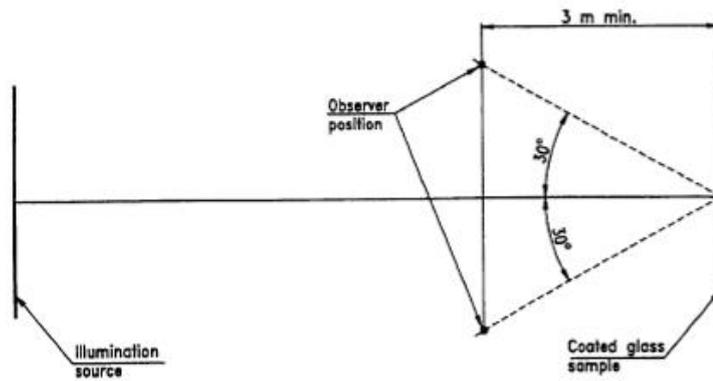
Daylight illumination is a uniform overcast sky, without direct sunlight.

8.4 CONDITION OF OBSERVATION OF DEFECTS

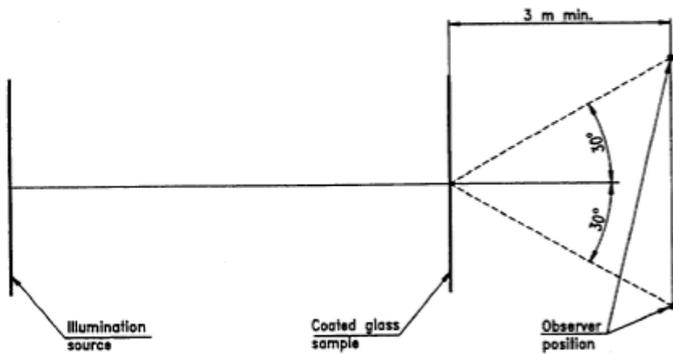
8.4.1 GENERAL

Coated glass may be examined in stock size or in finished sizes ready for installation. The examination may be undertaken in the factory or on site when glazed.

The pane of coated glass being examined is viewed from a minimum distance of 3 m. The actual distance will be dependent on the defect being considered and which illumination source is being used. The examination of the coated glass in reflection is performed by the observer looking at the side which will be the outside of the glazing. During the examination the angle between the normal to the surface of the coated glass and the light beam proceeding to the eyes of the observer after reflection or transmission by the coated glass shall not exceed 30° (see figure).

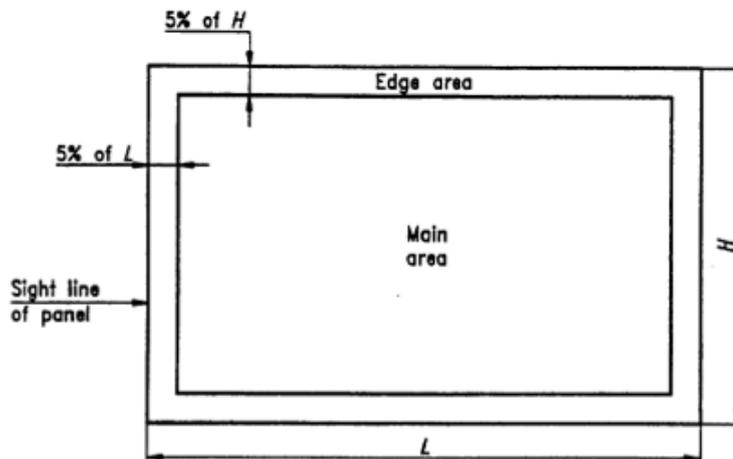


a) Reflection



b) Transmission

For panes of coated glass in finished sizes ready to be installed, both main area and edge area of the pane shall be examined (see figure).



Each examination will take no more than 20 s.

8.4.2 UNIFORMITY DEFECTS AND STAINS

Under the condition of examination given in 8.4.1, note any coating variations either within on pane or between neighbouring panes which are visually disturbing.

8.4.3 PUNCTUAL DEFECTS

Under the conditions of examination given in 8.4.1, note any spots, pinholes and/or scratches that are visually disturbing.

For spots/pinholes, measure the size and note the number relative to the size of the pane. If there are any clusters found, their position relative to the through vision area shall be determined.

For scratches, determine whether or not they are in the main or edge area. Measure the length of any scratches noted. For scratches > 75 mm long, determine the distance between adjacent scratches. For scratches ≤ 75 mm long, note any area where their density produces visual disturbances.

8.5 ACCEPTANCE CRITERIA OF COATINGS GLASS DEFECTS

The acceptance criteria for the defects of coating glass are given in the table.

Defects types	Acceptance criteria	
	Pane/Pane	Individual pane
UNIFORMITY/STAIN	Allowed as long not visually disturbing	Allowed as long not visually disturbing
PUNCTUAL Spot/pinholes > 3 mm > 2 mm and ≤ 3 mm	Not applicable	Main area
		Edge Area
		Not allowed
		Max 1 by m ²
		Not allowed
Clusters	Not applicable	Not allowed
		Allowed as long as not in area of through vision
Scratches > 75 mm	Not applicable	Not allowed
≤ 75 mm		Allowed as long as local density is not visually disturbing
		Allowed as long as local density is not visually disturbing

8.6 COLOR DIFFERENCE IN FAÇADES

8.6.1 METHOD AND CONDITION OF OBSERVATION

When coated glasses are installed on façades, some variations of color can appear between the panes. The document of Glass for Europe "Code of practice for in-situ measurement and evaluation of the color of coated glass used in façades" (available at www.glassforeurope.com/images/cont/91_19807_file.pdf) describes the way to measure and evaluate these differences of color.

8.6.2 REQUIREMENTS

The values of ΔL^* , Δa^* and Δb^* determined in accordance with 8.6.1 shall met the following requirement.

ΔL^*	≤ 4,0
Δa^*	≤ 3,0
Δb^*	≤ 3,0