

Inspection Guide SEALED UNITS

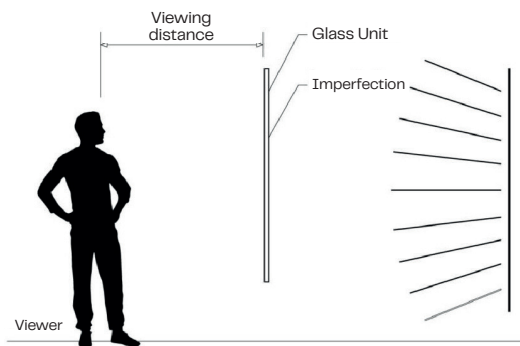


Over the years, we have witnessed industry standards evolve, adapting to the specific applications and environments where the products are used. This IG Standards and Inspection Guide outlines our internal inspection processes and demonstrates how our practices align with, and in many cases exceed, industry standards for both commercial and residential applications.

1. Inspection Method

Here are the steps to follow for the quality inspection of sealed units:

- Always begin the inspection from a distance of **3 meters (10 feet)**,
 - ↳ then **2 meters (6 feet)**,
 - ↳ and **1 meter (3 feet) to finish.**
- Move closer, almost touching the glass, to measure any defects and compare them with the chart.
- If you need a second opinion, ensure that the person starts the inspection in the same way (from 3 meters) and not from where they are currently standing (typically much closer).
- Make sure to wear your glasses if your vision is not 20/20.
- The background will vary from one location to another, it is recommended to inspect at various angles to ensure proper conclusions.

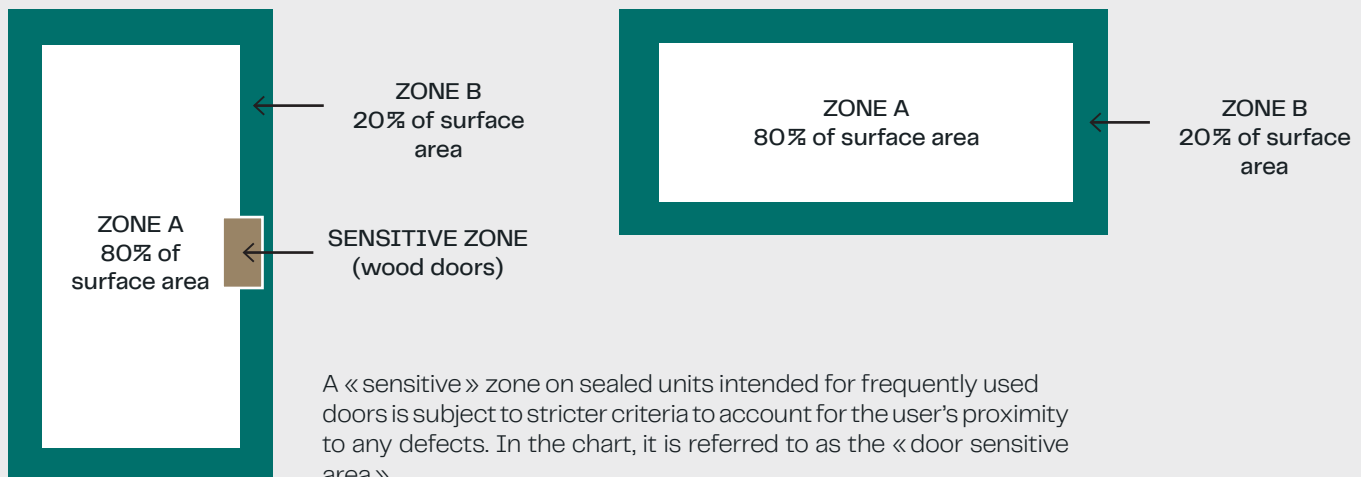


For the first inspection, remain perpendicular to the glass.

Exterior conditions should be normal, without direct sun exposure.

No additional lighting (such as a flashlight or cellular phone) should be used.

2. Designated Zones for Inspection



3. Established Standards for Quality Control at the factory and on jobsites

DEFECTS	< 40 sq.ft. Zone A	< 40 sq.ft. Zone B	> 40 sq.ft Zone A	> 40 sq.ft Zone B	With laminated glass (no surface area specified) Zone A	With laminated glass (no surface area specified) Zone B	Door sensitive area
Bubbles, fish eyes, contaminants, dirt, etc.	1 mm (1/32 in)	1.5 mm (1/16 in)	1.5 mm (1/16 in)	2.5 mm (3/32 in)	1 mm (1/32 in)	1.5 mm (1/16 in)	None acceptable if detected at 6 in or more away from glass
Light scratch (max length) Not visible at 1 m (3 ft)	Acceptable	Acceptable	Acceptable	Acceptable	Acceptable	Acceptable	
Medium scratch Visible at + 1 m but not 3 m (10 ft)	12 mm (1/2 in)	25 mm (1 in)	50 mm (2 in)	75 mm (3 in)	12 mm (1/2 in)	25 mm (1 in)	
Deep scratch Visible at + 3 m (10 ft)	Not acceptable						
Light linear defect Hair, fibre (one thread)	Undetected at 1 m (3 ft)	Undetected at 3 m (10 ft)	Undetected at 1 m (3 ft)	Undetected at 3 m (10 ft)	Undetected at 1 m (3 ft)	Undetected at 3 m (10 ft)	
Minimum distance between two defects	600 mm (24 in)						
Optical distortion (tempering waves)	Rejected if aesthetically shocking						
Scratch on spacer	None detectable at 1 m (3 ft)						
Different height of spacers in a triple sealed units	Allowable up to 3 mm (1/8 in)						
Internal muntins waving	Allowable as long as internal grills do not touch the glass						
Visible light (depth) behind SDL variability	Visible light between glass and SDL components						
Sightline infringement <i>*variation not visible at 3 m (10 ft or more)</i>	Maximum 1 mm (1/32 in)		Maximum 2 mm (1/16 in)		Maximum 2 mm (1/16 in)		None acceptable if detected at 6 in or more away from glass
Infringement of sealant in corners	3 mm radius (1/8 in)						
Rattling of muntins	Acceptable						