

**FHS**

## PRODUCT BULLETIN: HEAT SOAKING

**SECURITY:** Heat soaking is a process that potentially exposes critical NiS inclusions in fully tempered glass. At Garibaldi Glass we have the ability with our “Heat Soak Oven” to meet all heat soak job requirements at current E.U. standards. Heat soaking will provide our customers with an additional defined level of confidence where required with your existing project.

## HEAT SOAKING

### HEAT SOAKING PROCESS:

Heat soaking is a potential destructive test.

- Standard heat soak testing requires more than ten hours of thermal treatment including 1 to 6 hours to heat large quantities of glass to 290 C followed by a temperature plateau at these temperatures for 3–12 hours before cooling down slowly to ambient temperature.
- This causes glass containing nickel sulfide inclusions to break in the heat soak chamber, thus reducing the risk of potential field breakage.

Glass without detrimental inclusions will retain proper temper properties and will have minimal risks of spontaneous breakage in the field.

While Heat soaking is not 100% effective it will reduce the probability of breakage from a standard 8 in 1,000 to 5 in 1,000

### HEAT SOAK OVEN CAPABILITIES:

- Max Glass sheet size = 104” x 204”
- 3–19 mm
- Max load = 24 sheets or 10,000 lbs

### HEAT SOAK OVEN SPECIFICATION:

- Manufacturer—Precision Quincy
- Cycle times
  - Approx. 6hr soak time (varies depending on size, weight, # pieces, glass thickness).
  - Approx. 1.5hr change over time
  - Total cycle time = 8 hr per load
- Garibaldi Glass currently heat soaks to the European standard for heat soaking EN 14179–1:2005 (HST).
- Currently there is no North American standard for heat soaking.



At Garibaldi Glass we're more than just state-of-the art fabrication processes and techniques. We're constantly looking for **INNOVATIVE SOLUTIONS** to meet our customer needs. At Garibaldi Glass, we don't say no – we ask how.

**Single Lite Orders to Infrastructure & Retrofit Projects to Custom Glass Fabrication to Residential & Commercial Towers.**

**Contact your Account Representative or Call and speak to a Product Specialist at 604-420-4527 or 1-800-665-3787**

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