



**Technical Bulletin
11/30/04**

Fabrication of Tempered Glass

Holes, notches and cut-outs can be fabricated prior to tempering glass. Limitations of those types of fabrications are listed below.

- 1) Spacing of Holes
The minimum distance from the edge of the glass to the rim of the hole is 2 times the thickness of the glass but not less than ¼".

The minimum distance from the rim of one hole to the rim of another hole is 2 times the thickness of the glass but not less than 3/8".
- 2) Dimensions of Holes
Holes must have a minimum diameter of the thickness of the glass, but not less than ¼". The maximum diameter of a hole must not exceed 1/3 the width of the glass.
- 3) Holes near Corners
Holes near corners must be located so that the nearest edge of the hole from the tip of the corner is at least 6.5 times the thickness of the glass.
- 4) Notches and Cut-Outs
Notches and cut-outs must have fillets in the interior corners whose radii are equal to or greater than the thickness of the glass.

Refer to ASTM C 1048 – 04 for tolerances of any glass fabrication. Due to the weakening effects of holes, Vitro America does not recommend more than 6 holes in one lite of glass.

Holes and cut-outs always weaken glass. As a matter of standard procedure, I must note that Vitro America **does not warrant glass against breakage from any cause.**

