


|   |  |            |                  |       |
|---|--|------------|------------------|-------|
|  | Document Title:  | Doc No:    | <b>FRM B3-12</b> |       |
|   | <p align="center"><b>IG Certification Program<br/>Getting IG Certified Checklist</b></p> | Rev No: 10 | Page: 1          | Of: 4 |
| Required By: PRO B3-01  |  |            |                  |       |

The getting IG Certified Checklist serves as a step by step guide for program participants to follow, to complete the Certification Process. Contact Keystone Certifications Inspection Department for questions regarding this checklist!

**Existing Keystone Licensees** can add participation in the IG Certification Program simply by forwarding a written request to do so via email. IG Program Policy and Fee Schedule are available after licensee login at keystonecerts.com. Keystone will invoice for the additional IG Program fees.

**IG Manufacturers new to Keystone** shall request a Keystone IG License Agreement Package by phone or email, we'll respond with the IG Certification Program Policy, License Agreement, Fee Schedule and Licensee Profile Form. Return the completed Agreement and Licensee Profile Form with the initial fees (See Fee Schedule).

**Keystone will respond with:**

- the co-executed Licensee Agreement (new Licensees only),
- the IG Quality Manual Template,
- The anticipated inspection/test specimen fabrication witness date

*Keystone Certifications schedules inspections/fabrication witnesses by region to minimize costs!*

If the anticipated inspection date is unsatisfactory, contact Keystone Certifications Inspection Department to discuss "Expedited Inspection" terms.

Review the Qualification Rules below, and consider what IG Details need to be qualified (low e, gas fill, internal components, etc.), then decide how the test specimens will be constructed based on the ASTM E-2190 requirements below:

| Glazing Configuration<br>(per spacer system) | Minimum Glass Thickness | Minimum Spacer Thickness Option 1 | Minimum Glass Thickness Option 2 | Minimum Spacer Thickness Option 2 |
|--|-------------------------|-----------------------------------|----------------------------------|-----------------------------------|
|  | Option 1                |                                   |                                  |                                   |
| Dual Glazed                                  | 5/32" (4mm)             | 1/2" (12mm)                       | 3/16" (5mm)                      | 1/4" (6mm)                        |
| Triple Glazed (Qualifies Duals)              | 5/32" (4mm)             | 1/4" (6mm) / Per Airspace         |                                  |                                   |

ASTM E-2190 states that both the glass and spacer thickness can be **increased** from the minimums listed above, however these increases may result in a more rigorous test. Please note that these component sizes may not be regularly available, and may require contacting component suppliers **AT LEAST** 30 days prior to fabrication witness.


After review of the Qualification Rules below, be prepared to fabricate the following IGUs:

| Item / Component Description   | Dual Glazed               | Triple Glazed             |
|--|---------------------------|---------------------------|
| Sample IG Unit Measurements + / - ¼" (6mm) equal:  | 14" (355mm) x 20" (505mm) | 14" (355mm) x 20" (505mm) |
| Base IG units to be constructed ( <b>per spacer system</b> ):  | 12 Units                  | 15 Units                  |
| If you plan to qualify IG units with internal grids, be prepared to fabricate an additional 3 dual glazed or 5 triple glazed units of "Nine Light" or "3x3 grid pattern" (looks like #). |                           |                           |
| If you plan to qualify IG units with other internal components, be prepared to fabricate an additional 3 dual glazed or 5 triple glazed units containing each component to be qualified. |                           |                           |

**Only one Low E Coating may be employed in any configuration, Triple Glazed Units require the Low E coating to be on the center lite!**

- Select a Keystone Recognized Testing Laboratory, see page 4 of this document for the Insulating Glass Testing Fees.
- Communicate the test specimen fabrication details to the Keystone Inspection Department.
- Complete any necessary maintenance on Insulating Glass fabricating equipment.
- Fabricate the test specimens per your standard process, in the presence of the Keystone Inspector during the initial/subsequent IG Program Inspection.
- Package the test specimens securely for shipment to the laboratory, Keystone suggests using the provided **Crating Details below**.

Upon receipt of test report indicating the successful completion of IG testing, Keystone's approval of submitted Quality Manual, Keystone will perform a validation review and issue an IG Certification Authorization Report.

|   |  |            |                  |       |
|---|--|------------|------------------|-------|
|  | Document Title:  | Doc No:    | <b>FRM B3-12</b> |       |
|   | <b>IG Certification Program</b><br><b>Getting IG Certified Checklist</b> | Rev No: 10 | Page: 2          | Of: 4 |
| Required By: PRO B3-01  |  |            |                  |       |

## IG Qualification Rules

1. Tested glass **layer thickness** qualifies all variations of glass layer thickness.
2. Tested glass **tint** qualifies all variations of glass tint.
3. Tested glass **temper** (typically annealed) qualifies all variations of glass temper.
4. Tested IG **unit size** (width x height) qualifies all IG unit sizes.
5. Tested IG **unit shape** (rectangular) qualifies all IG unit shapes.
6. Testing specified glass from one **supplier** qualifies specified glass from any supplier.
7. Testing non-edge deleted **sputter coated low emissivity glass** qualifies any pyrolytic coated glass, any edge-deleted sputter coated glass, uncoated glass and may qualify other non-edge deleted sputter coated glass.
8. Testing of edge-deleted sputter coated glass qualifies any edge-deleted sputter coated glass, pyrolytic coated glass and uncoated glass.
9. Testing of **pyrolytic coated glass** qualifies uncoated glass.
10. Testing an **airspace** dimension created by the spacer system qualifies all variation of air space dimensions that employ the same spacer system of varying thickness. Hollow spacers employing licensee-applied desiccants must employ the same or greater amount of desiccant per inch of perimeter edge.
11. Testing an airspace containing an inert gas (typically **argon**) content meeting NFRC 706 requirements ("gas-filled IG units") qualifies IG units containing air-filled airspaces and gas-filled IG units containing another inert gas or mixture of inert gasses.
12. Testing **internal grids** (false muntins) of a single profile, pattern and spacer-mating component design qualifies IG units that do not contain internal grids, and IG units with different grid profile and patterns, provided the spacer-mating component design does not change.
13. Testing **triple glazed IG units** shall qualify both triple and dual glazed IG units, ongoing qualification of both triple and dual glazed IG units can be achieved by alternately testing IG units of each configuration during the time of the two-year retest cycle.
14. Testing open **capillary tubes** qualifies IG units containing the same capillary tubes in the open or closed condition. Testing closed **capillary tubes** only qualifies IG units containing the same capillary tubes in the closed condition. Testing open or closed capillary tubes qualifies IG units without capillary tubes.
15. Testing closed **breather tubes** qualifies IG units containing the same closed breather tubes, and qualifies IG units without breather tubes.
16. Testing one **moisture vapor transmission path length** qualifies IG units using the same components with a greater moisture vapor transmission path length.
17. Testing one **spacer system material and componentry** does not qualify IG units with a different spacer system material and componentry, except as specified herein.
18. Testing one **spacer finish** does not qualify IG units containing a different spacer finish.
19. Testing a hollow spacer of one **wall thickness** qualifies the same spacer with a different wall thickness.
20. Testing a hollow spacer of one **seam design** qualifies the same hollow spacer with a different seam design.
21. Testing one supplier's hollow spacer design qualifies spacers of the same design from a different **supplier**.
22. Testing spacers with **cut corner construction** *does not* qualify IG units containing spacers with different cut corner construction, however, testing IG units containing plastic mechanical corner keys and joiners does qualify IG units containing different plastic mechanical corner keys and joiners.
23. Testing a licensee-applied **desiccant from one supplier** qualifies the use of the same generic type of desiccant from another supplier.
24. Testing licensee-applied **desiccant of one particle size** qualifies the use of the same generic type of desiccant of a different particle size.
25. Testing a licensee-applied **desiccant of one generic type** does not qualify IG units containing desiccants of a different generic type.
26. Testing a **single generic sealant type** does not qualify IG units containing any other generic sealant type. (Ex: single-sealed Hot Melt Butyl does not qualify single-sealed Polysulphide.)
27. Testing **multiple generic sealant** types does not qualify IG units containing any single generic sealant type or other combination multiple generic sealant types.
28. Testing a generic sealant type from one manufacturer qualifies IG units containing the same generic sealant type from a different manufacturer.

### Bill of Materials for Insulating Glass Shipping Crate

| Item | Description                  | Location                                      |
|------|------------------------------|---|
| 1    | ½" x ¾" Parting Bead         | Slats to separate IG Units in crate           |
| 2    | ¾" Plywood                   | Base / Frame / Lid                            |
| 3    | 1" Styrofoam Board           | Top and bottom cushion                        |
| 4    | Silicone/Wax Release Paper   | Top and bottom between styrofoam and IG Units |
| 5    | #8 x 1" Coarse Drywall Screw | Fasteners for slats                           |
| 6    | #8 x 2" Coarse Drywall Screw | Fasteners for frame and lid                   |



Document Title:

# IG Certification Program Getting IG Certified Checklist

Doc No:

**FRM B3-12**

Rev No: 10

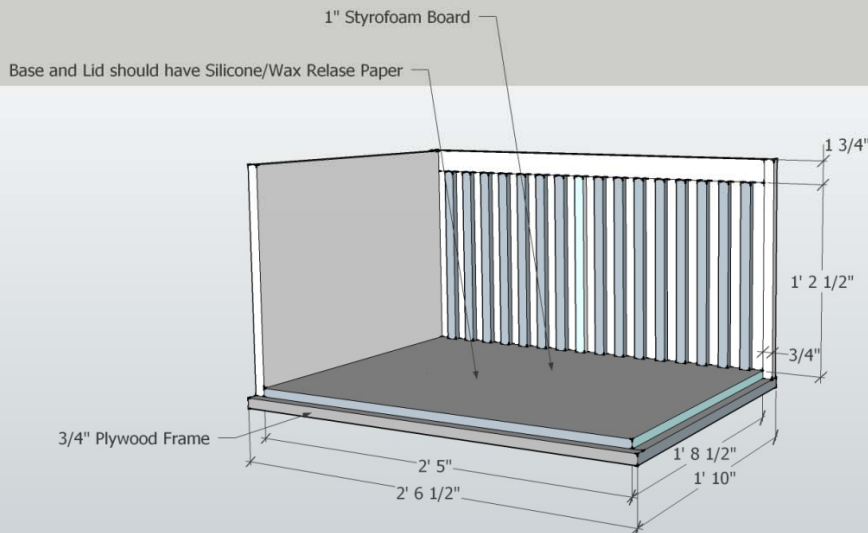
Page: 3

Of: 4

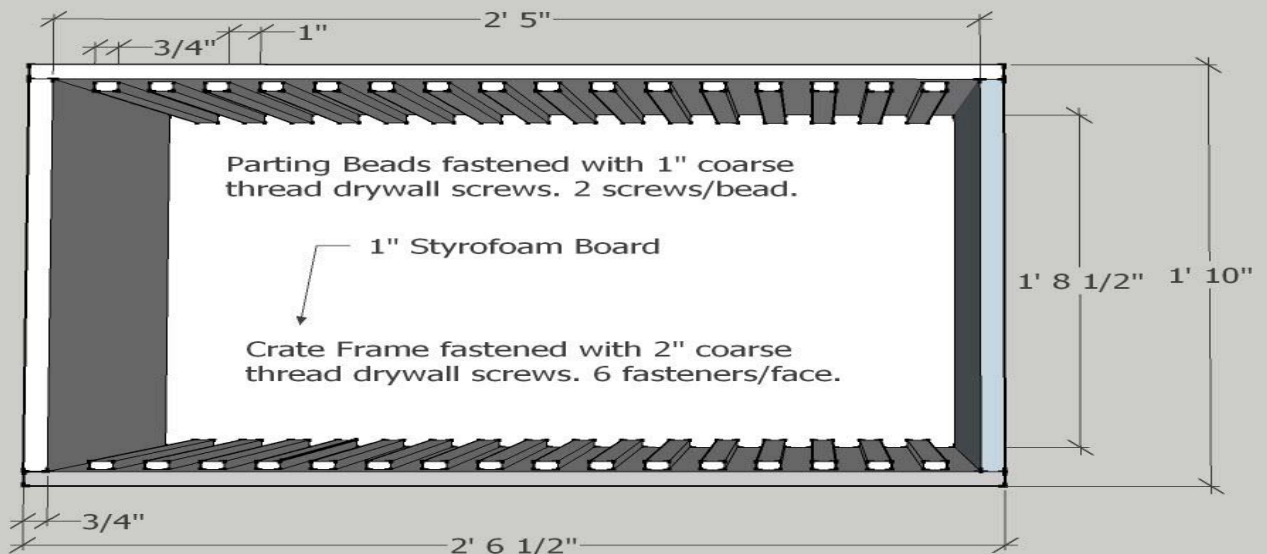
Required By: PRO B3-01

## Crating Construction Details for Insulating Glass Specimens


**Notes:** Crate Base and Lid Constructed in same manner  
Base and Lid fastened with 2" coarse thread drywall fasteners  
Not to Scale



**Notes:** Drawing Not to Scale  
Crate construction based on 1" Overall IG Units  
Parting beads must be adjusted for smaller Overall IG Units  
Crate width shown is based on fabrication of 17 Triple Glazed IG Units  
Crate width must be adjusted based on quantity of IG Units



Keystone Certifications does not guarantee or assume any responsibility for unit damage.

|   |  |            |                  |       |
|---|--|------------|------------------|-------|
|  | Document Title:  | Doc No:    | <b>FRM B3-12</b> |       |
|   | <b>IG Certification Program</b><br><b>Getting IG Certified Checklist</b> | Rev No: 10 | Page: 4          | Of: 4 |
| Required By: PRO B3-01  |  |            |                  |       |

**Insulating Glass Testing Fees**

| Laboratory   | Location         | Configuration | Standard Invoice Amount | With One Additional Fog Set | With Two Additional Fog Sets | Fee per Additional Fog Set |
|--------------|------------------|---------------|-------------------------|-----------------------------|------------------------------|----------------------------|
| ATI-Intertek | Fresno - CA      | Dual          | \$2200                  | 2525                        | \$2850                       | \$325                      |
|              | Kent - WA        |               |                         |                             |                              |                            |
|              | Plano – TX       | Triple        | \$2300                  | \$2875                      | \$3450                       | \$575                      |
|              | St. Paul – MN    |               |                         |                             |                              |                            |
|              | York - PA        |               |                         |                             |                              |                            |
| CanBest      | Brampton - ON    | Dual          | \$1825                  | \$2125                      | \$2425                       | \$300                      |
|              |                  | Triple        | \$2075                  | \$2375                      | \$2675                       | \$300                      |
| Exova        | Mississauga - ON | Dual          | \$1900                  | \$1980                      | \$2280                       | \$300                      |
|              |                  | Triple        | \$2100                  | \$2230                      | \$2580                       | \$350                      |
| FTL          | Medley - FL      | Dual          | \$2000                  | \$2300                      | \$2600                       | \$300                      |
|              |                  | Triple        | \$2000                  | \$2300                      | \$2600                       | \$300                      |
| PRI          | Tampa - FL       | Dual          | \$2150                  | \$2250                      | \$2350                       | \$100                      |
|              |                  | Triple        | \$2150                  | \$2250                      | \$2350                       | \$100                      |
| NCTL         | Everett - WA     | Dual          | \$1850                  | \$2050                      | \$2250                       | \$200                      |
|              | York - PA        | Triple        | \$1850                  | \$2100                      | \$2350                       | \$250                      |

\* All invoice amounts include Keystone IG Administration Fees