

RECOMMENDATIONS
Glassupply.com CONCERNING TEMPERED HOLES
ACCORDING TO ASTM C-1048

1) Hole position

a) For all glass thicknesses, the minimum distance from the edge of the hole to the nearest edge of the glass should be the greater distance between:

- i. 6 mm ($\frac{1}{4}$ ")
- or
- ii. 2 times the thickness of the glass

(see table 1)

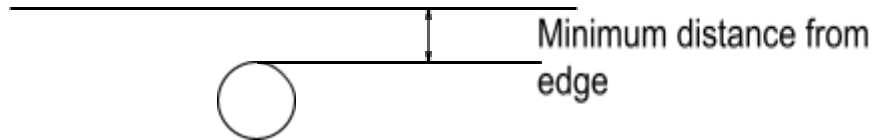


TABLE 1

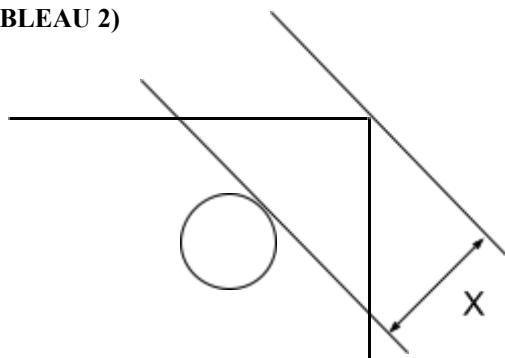
Thickness	Minimum distance
3.3 mm	6 mm or $\frac{1}{4}$ "
4 mm	8 mm or $\frac{5}{16}$ "
5 mm	10 mm or $\frac{3}{8}$ "
6 mm	12 mm or $\frac{1}{2}$ "
8 mm	16 mm or $\frac{5}{8}$ "

Thickness	Minimum distance
10 mm	20 mm or $\frac{13}{16}$ "
12 mm	24 mm or $\frac{15}{16}$ "
15 mm	30 mm or $1 \frac{3}{16}$ "
19 mm	38 mm or $1 \frac{1}{2}$ "

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- b) The minimum distance from the edge of the hole to a corner of the glass should be 6.5 times the thickness of the glass when the corner is 90 ° and more.

(VOIR TABLEAU 2)



X = minimum corner

distance

TABLE 2

Thickness	Minimum distance
3.3 mm	21.5 mm or 7/8"
4 mm	26 mm or 1"
5 mm	32.5 mm or 1 1/4"
6 mm	39 mm or 1 1/2"
8 mm	52 mm or 2"

Thickness	Minimum distance
10 mm	65 mm or 2 9/16"
12 mm	78 mm or 3"
15 mm	97.5 mm or 3 7/8"
19 mm	123.5 mm or 4 7/8"

2) Minimum distance between holes

- a) For all glass thicknesses, the minimum distance between the holes is the greatest distance between :
- i. Y = 10 mm
 - or
 - ii. 2 * E



Y = minimum distance

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E = glass thickness

3) Round hole dimension⁽¹⁾

For all glass thicknesses, the minimum dimension of the hole must be the largest diameter between:

- i. 6 mm
- or
- ii. the thickness of the glass

(VOIR TABLEAU 4)

TABLEAU 4

Thickness	Minimum diameter
3.3 mm	6 mm
4 mm	6 mm
5 mm	6 mm
6 mm	6 mm
8 mm	8 mm

Thickness	Minimum diameter
10 mm	10 mm
12 mm	12 mm
15 mm	15 mm
19 mm	19 mm

4) Notches, Letter Passes, and Holes that are not Round

All corners should be rounded with a radius equal to or greater than the thickness of the glass.



5) Dimensional tolerances for holes

- a) Hole diameter : ± 1.6 mm
- b) Center of the circle in relation to its edge : ± 1.6 mm

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- c) Distance between the centers of 2 holes: ± 1.6 mm
 - d) Maximum chip size on the edge of the hole: ± 1.6 mm
- 6) Dimensional tolerances for notches
- a) For glass less than 12mm : ± 1.6 mm
 - b) For glass less than 12mm : ± 3 mm
 - c) For all thicknesses, the inner surface of the notches should be polished or with a soft chamfer

Hole size available

Hole drill bit size available (in mm) :

5-6-7-8-9-10-11-12-13-14-15-16-17-19-20-21-22-24-26
28-30-32-35-38-40-44-48-51-54-57-64-66

Polishing and tempering min. requirement

To perform a flat polish on all 4 sides, each side must be at least 4" minimum, if one side is smaller than 4", only 2 short sides and one long side can be polished.

For Glass tempering :

5 mm thick glass and over = min 12" diagonal

Round Glass = min 16" diagonal