

**DIMENSIONS**

Size	H [mm] +/- 0.3	W [mm] +/- 0.3
DP 10 X 20	21.2	9.5
DP 10 X 24	25.2	9.5
DP 10 X 30	31.2	9.5
DP 12 X 20	21.2	11.5
DP 12 X 24	25.2	11.5
DP 12 X 30	31.2	11.5

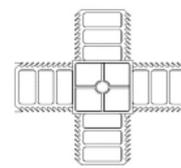
**MATERIAL**

Thermoplastic glass fiber reinforced

Thickness: SW = 1.25 mm (+/- 0.1) /  
 SH = 1.15 mm (+/- 0.1)

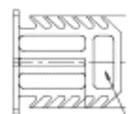
**ACCESSORIES**

**Crosses**



Plastic/Nylon

**Ends**



Plastic/Nylon

Other accessories, like flexible corners, available on request

**COLOURS**

<b>WHITE</b> ≈ RAL 9016	<b>LIGHT GREY</b> ≈ RAL 7035	<b>TITAN GREY</b> ≈ RAL 9023
		
<b>BLACK</b> ≈ RAL 9004	<b>LIGHT BROWN</b> ≈ RAL 8003	<b>BARK BROWN</b> ≈ RAL 8016
		

**EN1279 Normative test references and other methods**



**Rectitude from production**

Sideways max. 5 mm/m  
 Up/down max. 10 mm/m



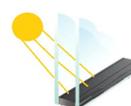
**Thermal linear expansion**

$T_{\alpha \text{ DPS}} = 1.83 \times 10^{-5} \text{ 1/K}$   
 Thermal linear expansion at 80°C is 1 mm/m, imperial value



**Volatile elements / Fogging**

EN 1279  
 $M_v < 0.3\%$  / No fogging 60°C and 80°C



**UV stability**

EN ISO 4892-2 / A  
 3,000 hours of radiation with no significant color change

## QUALITY ASPECTS

### Quality management

EN ISO 9001:2015 for quality

### Tests of the product

Processes and routines are established to secure the quality of the delivered material. During production the spacers are continuously monitored through systematic and random checks. Data will be available for a period of 10 years.

## CUSTOMER FOCUS AND WARRANTY

On all spacers we offer a 5 years' product warranty. The warranty covers free exchange of spacers in case of a defect. The warranty does not cover any other cost than the mere exchange of the defect spacers, and the warranty expressly does not cover installation of the spacers. The spacers must have been stored, installed and used according to present norms and technical standards. Special solutions and **usage** that **are not standardized** will need prior approval in writing from us in order to be covered. Related to temperature standardized condition for IG is  $-30^{\circ}\text{C}/+70^{\circ}\text{C}$ .

### Storage and use

To secure the performance of the spacers, the stock conditions must be acceptable. Broken packaging, humidity and variation in temperature will have an effect on the spacer in general. Make sure the spacer is conditioned at room temperature before use.

Preferred conditions will be temperatures over  $15^{\circ}\text{C}$  and humidity RH of minimum 45%.

To avoid deformation, the profiles have to be stored horizontally and straight.

Avoid having an environment with high concentration of dust.

### System performance

The user (the IG producer) must secure the whole system consisting of spacer, connector/corner key, bending machine, desiccant, butyl and sealant works well together in the chosen setup. Focus on compatibility, adhesion, dust and corner quality.

After handling and transport of the frames, it's important to check if the connector/corner keys are still in the correct position.

### Cleaning the plastic surface

If for some reason, the plastic surface is defiled by dust from other materials it can be cleaned again by use of water or air. Dust can easily be removed with antistatic loaded compressed air or a moist cloth. Solvent based cleaners are not recommended, but if used, it is recommended to test influence on products.

Wear gloves to avoid soiling.

Standard detergents such as acetone or ethyl alcohol can be used for cleaning.

Remove dust regularly with cleaned compressed air (with oil separation technology). Plastic can become statically charged and attract dirt more readily.

Rubbing with a dry cloth leads to static electricity and makes the soiling worse.

*It is recommended to investigate and control all the specific points above.*

## ADDITIONAL SPECIFICATIONS AND INSTRUCTIONS

### Packaging, volumes and options

DOUBLE PLASTIC SPACER						
Product	Length in mm	High in mm	Bar's length in meters and filling quantity for packing unit		Accessories	
			Carboard box	5 meter	Cross	Ends
			5 meter		Plastic	Plastic
<b>Plastic Double Spacer</b> Rectangular plastic cover strip with a thickness of 1.2 mm. Made with colours similar RAL 7035, 7040, 9004 e 9016 8003 8016.	9,5	21,2	590		500	1.000
	9,5	25,2	480		500	1.000
	9,5	31,2	400		500	1.000
	11,5	21,2	480		500	1.000
	11,5	25,2	390		500	1.000
	11,5	31,2	325		500	1.000
<b>Accessories per Plastic Double Spacer</b> (Pieces for box) Ends in transparent or black plastic and crosses in grey or black plastic.						

## PROCESSING RACCOMANDATIONS

### SAWING AND STAPLING

A suitable hardened metal saw-blade is necessary to make perfect cuts and minimise wear of the blade. The saw must be earthed.

All possibly existing residues (saw mill waste, dust, etc.) inside and outside of the muntin bars have to be removed before fixing. The cleaning of the interior of the bar is required in particular when using joining elements, which do not completely seal the cross section.

It is possible to fix Double plastic spacer into spacer frames using customary fixing methods - insertion or screwing in as for conventional spacers.

We recommend, however, that connectors be screwed on, as incorrect end pinning can result in cracking of the plastic.

In the case of bars with a length greater than 150 cm, screwing on the connectors is always the better connection method to use.

End pins must have a flat bottom to provide enough counter pressure and avoid splintering of the plastic material. If necessary, adjust the pressure of the stapling guns and use thin staples (wire dimension 0.91x 0.70 mm or thinner). The back width of the staples should be chosen as large as possible.

**Do not double-staple end pins!**

## RECOMMENDED PRODUCTION SIZES

Because of the different characteristics of thermal expansion of the materials of a double insulating glass unit, we generally advise against muntin bars longer than 2 m.

Please do not use Double plastic spacer with a thickness of

- 9.5 mm in gaps between panes of less than 12 mm
- 11.5 mm in gaps between panes of less than 14 mm.

For horizontal installation of Plastic Double Spacer inside an insulating glass without additional support by muntin bars in cross direction, the following maximum span widths are suitable:

Double plastic spacer 21.2 x 9.5 maximum 120 cm

Double plastic spacer 25.2 x 9.5 maximum 130 cm

Double plastic spacer 31.2 x 9.5 maximum 150 cm

Double plastic spacer 21.2 x 11.5 maximum 130 cm

Double plastic spacer 25.2 x 11.5 maximum 140 cm

Double plastic spacer 31.2 x 11.5 maximum 160 cm

Exceeding these recommended maximum spans can cause irreversible deformation of the profiles due to their own weight.

For vertical installation of muntin bars, maximum lengths of 2 m are possible. Please note the following important information about transportation and storage

## TRANSPORTATION AND STORAGE

If vertically mounted bars are laid horizontal for transportation in insulating glass or windows, please note the following:

If the bar length exceeds the above recommended maximum dimensions for horizontal mounting, there is a danger of deflection taking place due to its own weight. This type of bar length must remain in a vertical position during storage and transport of the insulating glass and/or window units.

Please also inform your customers about these demands during transportation and storage of such insulating glass or window units.

In the case of vertically installed bars, complaints will only be recognised if the above- mentioned maximum lengths for horizontally positioned bars are not exceeded.