



I-SPACER™ User guidelines

Date: 5.20.2008

Processing Stage	Recommendation
Storage	I-SPACER must be stored in dry conditions and must not be subjected to moisture in order to prevent corrosion on the metal surface. Air moisture due to temperature differences (inside/outside) can furthermore cause condensation in the cavity of the spacer, which could lead to a pre-loading of the desiccant.
Handling	To prevent bending or deformation during handling, the I-SPACER should only be removed from the box in a bundle and handled by two people. The packing film should only be removed after placing the bundle on the delivery table.
Cutting	A suitable hard metal saw blade must be used to cut I-SPACERS to length. The same saw blade as used on aluminum spacers may be used for this purpose.
Assembly of frames	Cut-and-assembled frames can be made with the Technoform Fixed corner keys. Bent frames can be assembled with stainless steel straight connectors for use with four corner bending.
Bending of frames	I-SPACERS must be kept dry and free from grease and dust. The I-SPACER can be bent in a cold state on all standard benders. Suitable machines and supplementary tooling should be obtained from the machine manufacturers. An additional bend angle of approximately 8° to 10° should be built into the bending procedure to address spring back when compared to aluminum box spacer.
Connectors	Straight connectors made of steel and corner keys made of nylon are matched according to the geometry of the I-SPACER.

Processing Stage	Recommendation
------------------	----------------

Filling of desiccant

The I-SPACER can be desiccant filled automatically. The drill-hole should be made through the wall of the spacer to ensure sufficient desiccant per frame.

Gas-filling

I-SPACER may be used in conjunction with gas-filling presses or by manually using a drill-hole procedure.

Sealing

I-SPACERS can be sealed on a manual or automatic butyl extruder. Because the flex of large I-SPACER frames is higher than on comparable Aluminium spacer frames; frames >5 feet should be sealed manually. Prior to application of the sealant it must be ensured that sufficient area at the edge of the glass is deleted. Sealants must be applied to the edge deleted portion of the glass. Sealants must be applied evenly on both sides and must be free from gaps in the corner areas. Sealant thickness after pressing should be >0.01 inches in the corner areas.

Sealant materials

I-SPACER has been tested with commercially available sealants with positive results. Please contact your Technoform Representative for additional information.

Sealing process

Sealing can be performed by automated sealing machines or manual application. To ensure the gas impermeability of the edge system, the edge sealing should consist of a 0.15" minimum of secondary sealing material. We recommend special attention be given to the area of the spacer connection. The gaps on both sides of the spacer must be filled with the secondary sealant.

Installing Muntins

For the application of Muntin bars, it is possible to use conventional compressed-air clips. Technoform recommends a targeted air pressure that is less than three psi.

Technical information is subject to change

Application technology advice - in particular processing recommendations - is given to the best of our knowledge and does not indemnify the user from the suitability of this advice for the intended procedures and purposes. We accept no liability for advice in application technology. We accept no liability for the factual suitability and deployment of the spacers.