



## TGI<sup>®</sup>- SPACER USER GUIDELINES

<b>Storage</b>	TGI <sup>®</sup> -Spacer must be stored in dry conditions and 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 preloading of the desiccant. TGI <sup>®</sup> -Spacer should always be stored horizontally.
<b>Handling</b>	To prevent bending or deformation during handling, TGI <sup>®</sup> -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.
<b>Cutting</b>	A suitable hard metal saw blade must be used to cut TGI <sup>®</sup> -Spacer to length. The same saw blade as used on aluminum spacers may be used for this purpose.
<b>Assembly of frames</b>	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.
<b>Bending of frames</b>	TGI <sup>®</sup> -Spacer must be kept dry and free from grease and dust. It 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° may need to be built into the bending procedure to address spring-back when compared to aluminum box spacer.
<b>Connectors</b>	Straight connectors made of steel, and corner keys made of nylon, are matched according to the geometry of the TGI <sup>®</sup> -Spacer.
<b>Filling of desiccant</b>	TGI <sup>®</sup> -Spacer can be automatically desiccant filled. The drill-hole should be made through the spacer wall to ensure sufficient desiccant per frame. Optimally, it is recommended that frames assembled with spacer widths of 13/32" or greater should have two legs filled. Spacer widths of 3/8" and below should have all 4 legs filled.
<b>Gas-filling</b>	TGI <sup>®</sup> -Spacer may be used in conjunction with gas-filling presses or by manually using a drill-hole procedure.
<b>Primary sealant</b>	TGI <sup>®</sup> -Spacer can be sealed on a manual or automatic butyl extruder. Prior to application of the sealant it must be ensured that sufficient area at the edge of the glass is deleted. Sealants should be applied to the edge-deleted portion of the glass. Sealants must be applied evenly on both sides and be free from gaps in the corner areas.
<b>Sealant materials</b>	TGI <sup>®</sup> -Spacer has been tested with commercially available sealants with positive results. Please contact your Technoform representative for additional information.



## TGI<sup>®</sup> SPACER USER GUIDELINES – page 2

- Secondary sealant**                      Sealing can be performed by automated sealing machines or manual application. 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 of 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.