

Glass for glazing —

Part 2: Terminology for work on glass

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British Ceramic Research Association	Institute of Quality Assurance
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British Precast Concrete Federation Ltd.	National Council of Building Materials Producers
British Woodworking Federation*	National Federation of Building Trades Employers
Consumer Standards Advisory Committee of BSI*	National Federation of Roofing Contractors
Convention of Scottish Local Authorities	Royal Institute of British Architects*
Department of the Environment (Building Research Establishment, Princes Risborough Laboratory)	Royal Institution of Chartered Surveyors*
Department of the Environment (Housing and Construction)*	Scottish Development Department
Department of the Environment (PSA)*	Trades Union Congress

The organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard:

Aluminium Window Association	Flat Glass Manufacturers' Association
Architectural Aluminium Association	Institution of Municipal Engineers
Chief and Assistant Chief Fire Officers' Association	Metal Window Federation of Great Britain
Department of the Environment (Building Research Establishment)	National Association of Shopfitters
Department of the Environment (Building Research Establishment, Fire Research Station)	National House-building Council
	Patent Glazing Conference
	Sealant Manufacturers' Conference
	Union of Construction, Allied Trades and Technicians

This British Standard, having been prepared under the direction of the Elements and Components (of Diverse Materials) for Buildings Standards Committee, was published under the authority of the Executive Board and comes into effect on 30 April 1980

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Foreword

The first edition of BS 952 was published in 1941, revised in 1953, and again in 1964 under the authority of the Glass Industry Standards Committee.

The present revision, now under the direction of the Elements and Components (of Diverse Materials) for Buildings Standards Committee, has been published in two separate Parts of which this is Part 2. Part 1 "Classification" was published in 1978.

Part 1 classifies soda-lime-silica glasses for building purposes and gives details of nominal thickness, maximum sizes, approximate weights and tolerances.

These glasses are intended for use in accordance with the recommendations of CP 152 "*Glazing and fixing of glass for buildings*".

This Part 2 includes illustrated definitions of terms in general use relating to the cutting, working and decorating of glass for building purposes.

It is intended to publish, in due course, a Part 3, which will include a more detailed technical specification for glass in building in line with an EEC Directive currently being prepared.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 12 and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This Part of this British Standard provides descriptions and illustrations of types of work on glass. The main processes, comprising cutting, obscuring and the various decorating processes, are described.

2 Cutting processes

2.1 Edge work and bevelling. Details of edge work and bevelling are given in Table 1.

2.2 Brilliant cutting. A decorative process employed for cutting designs on glass whereby various types of cut (V cuts, edge cuts, panel cuts, round cuts, and decorative motifs such as punts and hollows) are made. The cuts may be subsequently smoothed and polished. The different types of cut are illustrated in Figure 1.

2.3 Finger slotting. A feature obtained on the surface of the glass by allowing the edge of a smooth stone wheel to penetrate the surface. The typical detail of a finger slot is shown in Figure 2.

A finger slot (also known as a “cut sunk finger grip”) is a purely functional surface treatment in glass of virtually all types to facilitate easy sliding of glass doors. Since finger slots are made by the controlled grinding of a wheel into one side of the glass, they vary dimensionally according to the diameter and width of the wheel. However, a typical size is 65 mm × 20 mm × 3 mm. Finger slots are usually smooth ground, but can be polished.

2.4 Engraving. A decorative process, usually applied to hollow glassware, but sometimes also to flat glass, whereby the surface of the glass is cut by a small revolving wheel with or without an abrasive. The cut may or may not be polished.

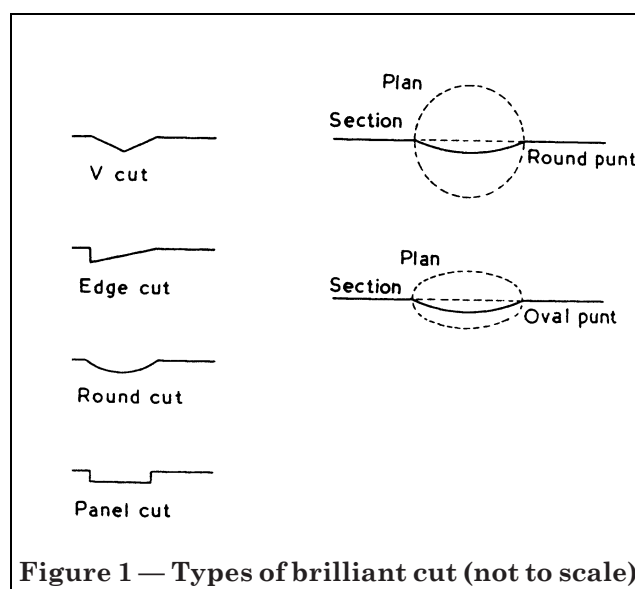


Figure 1 — Types of brilliant cut (not to scale)

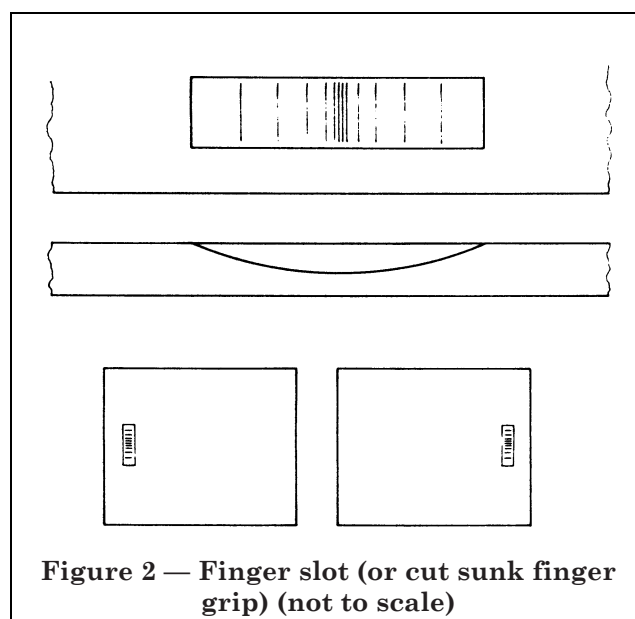
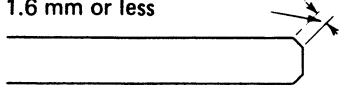
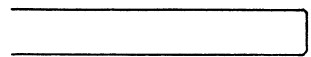
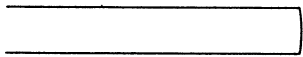
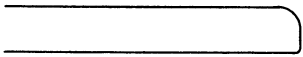
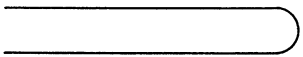
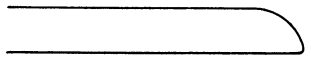
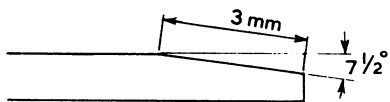
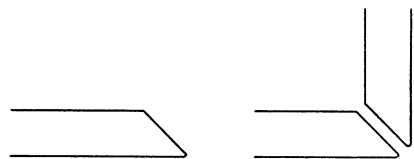
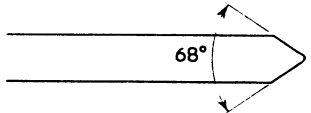


Figure 2 — Finger slot (or cut sunk finger grip) (not to scale)

Table 1 — Edge work and bevelling

Term	Form	Finish	Illustration
1. Arris edge	A small bevel of width not exceeding 1.6 mm at an angle of approximately 45° to the surface of the glass	Ground, smoothed or polished	1.6 mm or less 
2. Flat edge	The cut edge of the glass is flat and the surface edges are slightly arrised	Ground, smoothed or polished	
3. Round edge	The cut edge of the glass is slightly curved to form an arc of a circle	Ground, smoothed or polished	
4. Half round	Half of the cut edge of the glass is rounded approximately in the form of a quarter circle. The remaining surface edge is slightly rounded	Ground, smoothed or polished	
5. Full round	The cut edge of the glass is rounded approximately in the form of a semi-circle	Ground, smoothed or polished	
6. Thumb or bullnose	The surface edge of the glass is curved in a shape resembling the profile of a thumb	Ground, smoothed or polished	
7. Bevel	The surface edge of the glass is bevelled to 3 mm or more in width as required. The angle formed by the intersection of the plane of the bevel with the face of the glass is about $7\frac{1}{2}^\circ$	The bevel is polished unless otherwise specified. The nose of the bevel is left as cut	
8. Mitre bevel	The cut edge of the glass is bevelled to an angle of approximately 45° (unless otherwise specified); the extreme point is slightly arrised. If required the knife edge can be slightly radiused to form an arc of a circle when in contact with the corresponding edge of another plate	Ground, smoothed or polished	
9. Mitre bevel, both sides	Both surface edges of the glass are bevelled and, unless otherwise specified, the complete angle will be approximately 68° . The extreme point is slightly rounded	Ground, smoothed or polished	
10. Steep bevel	Any bevel where the angle of bevel is more than $7\frac{1}{2}^\circ$ and less than 45°	Ground, smoothed or polished	