

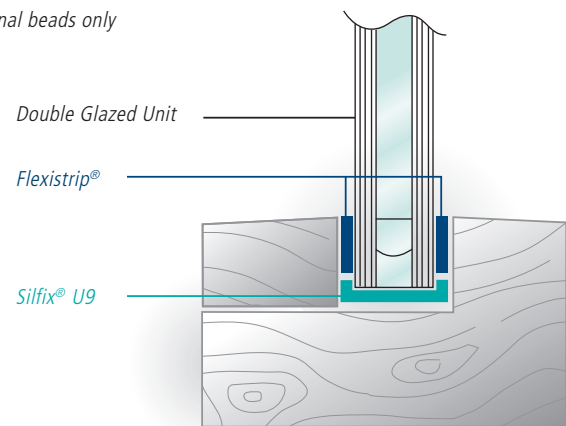
THE B6 HEEL BEAD SEAL SECURITY GLAZING SYSTEM

DESCRIPTION

The B6 Heel Bead Seal Security Glazing System is suitable for installing all types of single glass and double glazed units into nondrained (fully bedded) timber window and door frames. It is also suitable for reglazing of existing timber frames with double glazed units (see page 32). First developed by Hodgson, the system has a proven record of performance stretching back over many years and is widely specified and approved for use by leading housebuilders, housing associations and window manufacturers. The system comprises of Flexistrip® load bearing glazing strip and Silfix® U9 neutral cure silicone sealant. Both products have undergone extensive testing with all major edge sealant manufacturers to ensure absolute compatibility and total peace of mind.



This diagram illustrates external beads only



EXPOSURE/WEATHERTIGHTNESS RATING

- Tested to BS 6375: Part 1: 1989 and achieved a weathertightness classification of 2000 Pa (Special)

SECURITY RATING

Successfully tested in accordance with BS 7950: 1997 Specification for Enhanced Performance of Casement and Tilt/Turn Windows for Domestic Applications (Annex A5 Glazing Removal Test).

INDUSTRY STANDARDS COMPLIANCE

- BS 6262 Reference 9.3.3.5
- BS 8000 Reference 3.4.2.3
- GGF Manual Section 4.2 Reference IG7
- Zurich New Build Guarantee Ref 2.59
- HAPM CLM
- NHBC Chapter 6.7 Clauses D7, D4, M7, M4
- Secured By Design

FRAME COATING SYSTEM SUITABILITY

Can be overcoated immediately with solvent and water borne paint and woodstain which will adhere well.

WHY CHOOSE THE B6 HEEL BEAD SEAL SECURITY GLAZING SYSTEM

- Has excellent durability and movement accommodation
- Improves resistance to unauthorised entry
- Provides a neat and professional finish at the sightline after trimming
- Suitable for glazing all glass types either on site or in the factory
- More suitable for site glazing than systems using closed cell foam (dry) glazing tapes

SPECIFICATION CLAUSE

Hodgson B6 Heel Bead Seal Security Glazing System Glazed In Accordance With The Method Statement For The B6 Glazing System.

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GLAZING SYSTEM B6 METHOD STATEMENT

MATERIALS REQUIRED

- Flexistrip® - sized according to rebate upstand height and method of application
- Method 1:- Flexistrip® Jumbo 15 only
- Method 2:- Flexistrip®
- Silfix® U9 silicone sealant
- Setting blocks and location blocks sized to suit the unit thickness and edge clearance
- Sheradised glazing pins 28mm & 30mm

USEFUL TOOLS & ACCESSORIES

- Hand held moisture meter
- Glazing shovel
- High powered skeleton gun
- Flexistrip® trimming knife
- Curved trimming blades
- Glass cleaner

MEASURING THE FRAME OPENING

In order to allow the unit to be fully bedded in glazing material, each frame opening must be measured, the unit size calculated and the minimum required edge clearance (3mm) taken into account as described below. Ensure that protective edge tapes do not overlap by more than 1mm onto the face of the glass.

CALCULATING THE UNIT SIZE

The spacer bar of the unit should ideally be at or slightly below the sightline. For units with 12mm depth of edge sealant and spacer bar, calculate the unit size as follows:-

*Example: For 16mm upstand required unit size = tight rebate size minus 6mm.
For larger upstand more than 6mm can be subtracted from the tight size.*

PREPARATION

1. Check that the moisture content of the window does not exceed 17% as per NHBC Chapter 6.7.
2. Remove all beads from the window.
3. Remove all dust, grease and loose material from the rebate. Any moisture on the timber should be wiped off using a clean paper towel or other absorbent material to give a dry surface.
4. Check the condition of any primer or stain on the frame, especially the rebate and glazing surfaces of the beads. Any section which has been partially missed or is considerably weathered should be reprimed or stained before glazing.
5. Check that the unit fits into the frame and can be centralised when standing the unit on the setting blocks so that there is a 3mm edge clearance at the bottom of the unit (see picture A).
6. Apply Silfix® U9 to joints in midrails and horizontal bars.



PREPARATION OF THE DOUBLE GLAZED UNIT

1. Inspect the double glazed unit for obvious defects and cut off any excess edge sealant present on the face of the glass. Wipe any dust or loose material off the unit.

APPLICATION METHOD 1:

Applying Flexistrip® Jumbo 15 To The Double Glazed Unit.

With the unit laid horizontally on a non-scratch surface, apply Flexistrip® around the perimeter face of the unit as follows:-

1. Starting at one corner, apply Flexistrip® to the face of the unit with the bottom edge of the backing paper aligned with the unit edge (see picture B). Cut the end of Flexistrip® and the backing paper flush with the end of the unit using a sharp blade. Fold back approximately 5cm of the backing paper from each end to expose the strip sealant.
2. Begin the application of the second length of Flexistrip® by forming a butt joint against one of the exposed sections of Flexistrip® already applied (see picture C). Do not overlap the strip or leave gaps between adjacent sections of strip and do not make indentations at the joint. Continue by aligning the backing paper with the edge of the unit and cut the Flexistrip® and backing paper as before.
3. Continue to apply Flexistrip® along the perimeter of the unit as described above until you reach the final joint. When the fourth



FULLY BEDDED FRAMES

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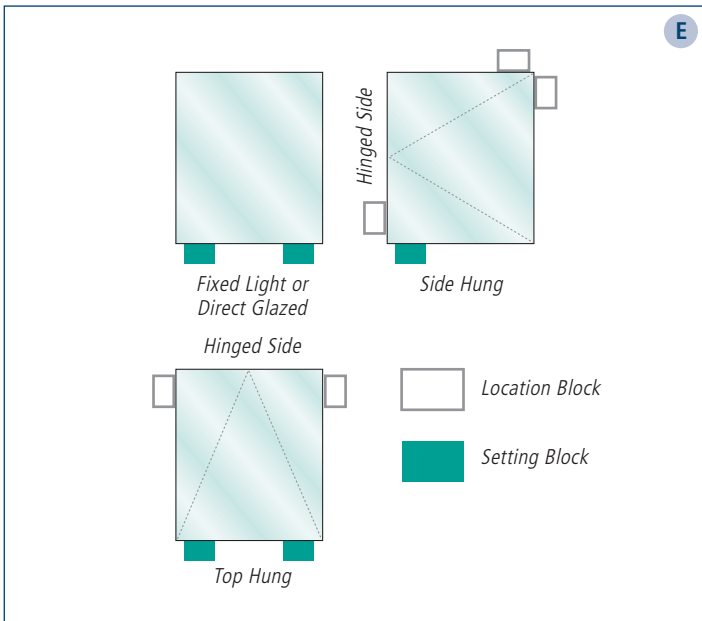
length reaches the exposed section of the first length, fold the strip back on itself and cut through the backing paper and strip at the crease so as to form a neat joint (see picture D).



- Replace the backing paper onto the strip at the four corners. Carefully turn the unit over and apply strip to the face of the unit following the same method used for the first side.
- If the units are to be transported to site or stored prior to installation, they should be stacked at a slight incline from the vertical with suitable pads to prevent the strip from being squashed or otherwise deformed.

GLAZING OF FRAMES

- All double glazed units must be positioned on setting blocks. If the window has an opening sash, each unit will need to have its weight supported by location blocks in addition to the setting blocks. The position of setting and locations blocks depends on the way the



sash is hung. Check picture E above to select the correct position of location and setting blocks appropriate to the window to be glazed.

- Apply a heel bead of Silfix® U9 to the angle of the rebate.
- Position the setting block(s) on the bottom rail as near the quarter points as possible as shown on the diagram (see picture E). Where more than one unit per window is to be glazed, start by glazing the bottom unit(s).

- Carefully remove the backing paper from the strip sealant on one side of the unit only. Examine the strip on the pre-taped units and replace with fresh material if damaged.

- Position the bottom of the unit on the setting block(s). Using a glazing shovel inserted at the side of the unit to control and guide the unit, ease it back a little so that the unit can be centralised in the frame before the Flexistrip® makes contact with the rebate upstand. Guide the unit back until the strip sealant touches the rebate upstand on all sides (see picture F).



- If glazing an opening sash, insert location blocks around the sides of the unit as shown in Picture E.

- Apply Silfix® U9 around the edge of the unit to completely fill the perimeter void, finishing flush with the edge of the unit.

- Remove the backing paper from the strip sealant on the face of the unit.

- Apply a bead of Silfix® U9 against the existing perimeter filling on which to bed the bead to the rebate platform and unit.

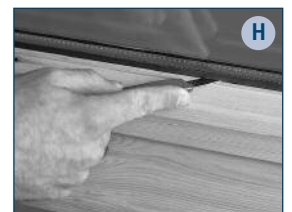
- First bed the bottom bead onto the fillet of Silfix® U9, rebate platform and strip sealant. Apply as much pressure as is safely possible to compress the strip sealant between the bead and the glass.

- Position the pins at right angles on the top surface of the bead. They should be no more than 50mm from either end and not more than 150mm apart. Apply pressure on the bead to ensure good contact with the Flexistrip® and pin the bead. There should always be at least two pins for every bead (see picture G).



- Fix the side and top beads by positioning them onto the rebate platform and apply pressure to ensure full contact with the Flexistrip®. Pin as described above.

- Using a trimming knife with a curved blade, trim off the excess strip sealant above the sightline at a slight angle so that water will be shed away from the glass (see picture H).



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The B6 Glazing System is suitable for both restoration work and newbuild.

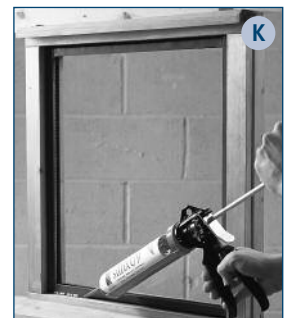
FRAME DECORATION & MAINTENANCE

The frame and sealant may now be painted with water/solvent borne paint or woodstain. Regular maintenance of the frame is essential to ensure maximum performance of the glazing system and double glazed unit.

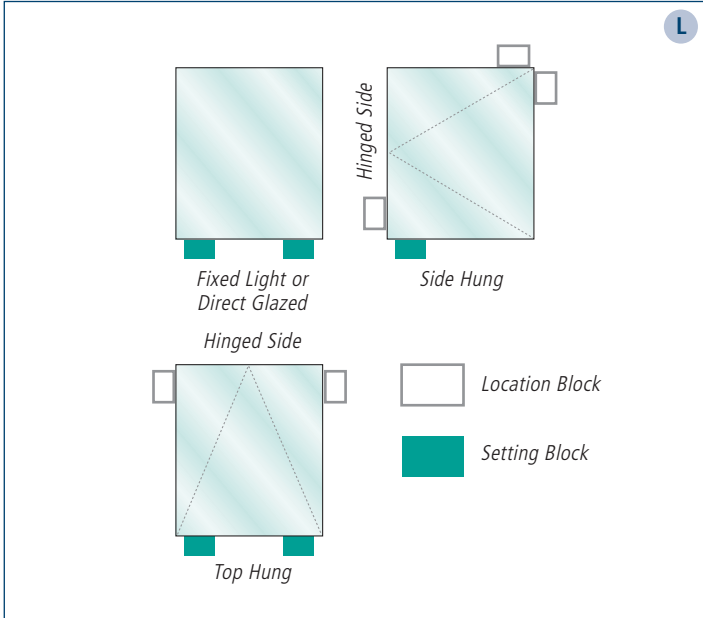
APPLICATION METHOD 2: Using Flexistrip® Applied Direct to the Rebate Upstand.

GLAZING OF FRAMES

1. Apply Flexistrip® to the bottom rebate upstand by running the edge of the paper along the rebate platform so that the Flexistrip® finishes 1mm - 2mm above the sightline. Fold back approximately 5cm of the backing paper from each end to expose the strip sealant.
2. Start the application of the second length of Flexistrip® by forming a butt joint against one of the exposed sections of Flexistrip® already applied (see picture I). Do not overlap the strip or leave gaps between adjacent sections of strip and do not make indentations at the joint. Apply a length to each side and then the top (see picture J).
3. Remove the backing paper from the Flexistrip®.
4. Apply a heel bead of Silfix® U9 below the Flexistrip® to form part of the perimeter bedding (see picture K).
5. All double glazed units must be positioned on setting blocks. If the window has an opening sash, each unit will need to have its weight supported by location blocks in addition to the setting blocks. The position of setting and locations blocks depends on the way the sash is hung. Check picture L to select the correct position of location and setting blocks appropriate to the window to be glazed.
6. Position the setting blocks on the bottom rebate as near to the quarter points as possible as shown on picture L. Where more than one unit per window is to be glazed, start by glazing the bottom unit(s).
7. Position the bottom of the unit on the setting block(s). Using a glazing shovel inserted at the side of the unit to control and guide the unit, ease it back a little so that the unit can be centralised in the frame before the Flexistrip® makes contact with the rebate



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pressure on the bead to ensure good contact with the Flexistrip® and pin the bead. There should always be at least two pins for every bead.

- 14. Fix the side and top beads by positioning them onto the rebate platform and apply pressure to ensure full contact with the Flexistrip®. Pin as described above.
- 15. Using a trimming knife with a curved blade, trim off the excess strip sealant at the sightline at a slight angle so that water will be shed away from the glass.



The B6 Glazing System can be used for unusual projects as well as newbuild housing projects.

FRAME DECORATION & MAINTENANCE

The frame and sealant may now be painted with water/solvent borne paint or woodstain. Regular maintenance of the frame is essential to ensure maximum performance of the glazing system and double glazed unit.

upstand. Guide the unit back until the strip sealant touches the rebate upstand on all sides.

- 8. Press firmly all the way around the edge of the unit to ensure that Flexistrip® is compressed between the unit and the rebate upstand (see picture M).



- 9. If glazing an opening sash, insert location blocks around the sides and top of the unit as shown in Picture L.
- 10. Apply Silfix® U9 around the perimeter of the unit to completely fill the perimeter void, finishing flush with the unit.
- 11. Apply a length of Flexistrip® horizontally to the bottom face of the unit by running the edge of the paper along the rebate platform. The Flexistrip® should be in line with the back bedding and 1mm - 2mm above the bead sightline. Apply lengths to the side faces of the unit and finally the top face as described in 2 on the previous page. Remove the backing paper.
- 12. Apply Silfix® U9 around the edge of the unit to completely fill the perimeter void, finishing with a fillet to bed the bead to the unit and the platform.

- 13. Place the bottom bead on the platform. Position the pins at right angles to the surface of the bead (see picture N). They should be no more than 50mm from either end and not more than 150mm apart. Apply

