

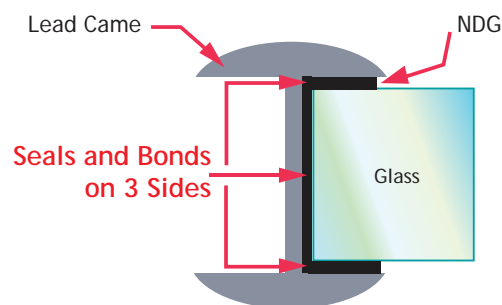
# NDG Pre-Glazed Lead Came



*The glazing material already sits in the lead came*

## Advantages:

- Faster
- Clean and easy
- No physical stress
- Saves time and costs
- Strong, immediately ready to install
- Superior bond strength and sealing
- Designed for both interior and exterior applications
- Non-toxic, no out-gassing, indefinite shelf life
- Available in different sizes and shape lead came



**Pre-glazed lead came** - the unique solvent-free NDG glazing material already sits in the lead came and provides, after curing, a strong and uniform seal around the glass.



A panel that is properly made and cured will be **watertight**. This product eliminates the need for putty, and is applicable for indoor or outdoor, and all weather situations.

If a panel will be used in an interior setting, then water tightness is not essential. Use of the pre-glazed lead came will insure that the panel is **strong**, that the edges of the glass do not reflect, and that the panel will not “rattle” with movement.



NDG Pre-glazed Lead Came is worker friendly, saves time and costs, and allows cleaner assembly of stained glass panels. Easy to use and your panel is immediately ready to install!



**PELI Glass Products B.V.**

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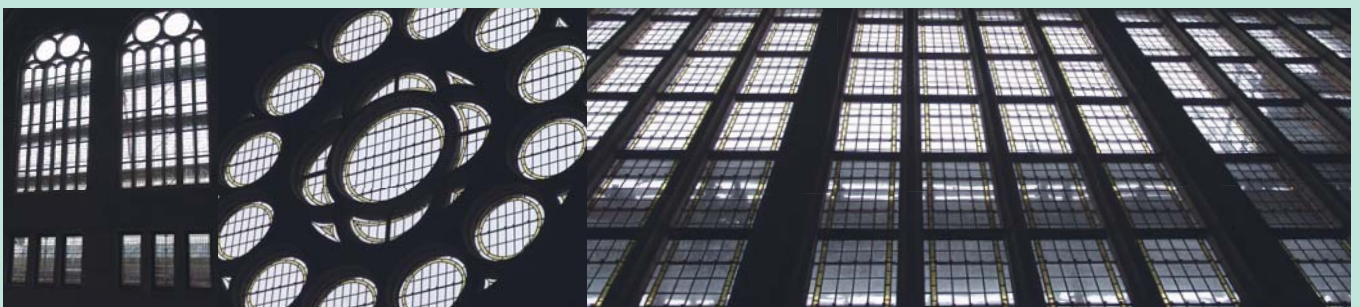
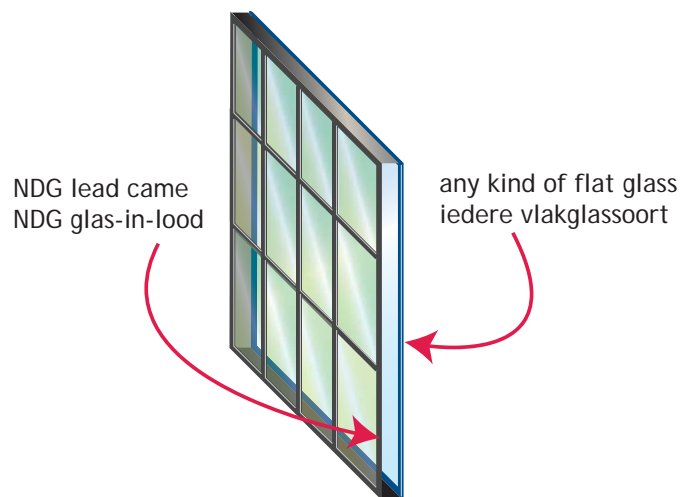


## Applications

Since there is no out-gassing, NDG pre-glazed panels can be used in double glazing, where the stained glass panel is on the inside of the glazing. Normally stained glass is not puttied when it is mounted between glass. But for larger panels the weight of the stained glass can cause sagging. With NDG pre-glazed lead came the panel is strong and stays straight.

PELI Glass has developed a unique double glazing option for restoration work. On the inside: a NDG pre-glazed stained glass panel and aluminum spacers filled with silicacel; and on the outside: antiglare, self-cleaning monumental glass. This means a savings on brass and bronze materials.

double glazing made with NDG Pre-glazed lead came  
isolerende beglazing gemaakt met NDG Voorgekit glas-in-lood profiel



*Church windows with NDG pre-glazed lead came*



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# NDG Pre-Glazed Lead Came



## Instructions

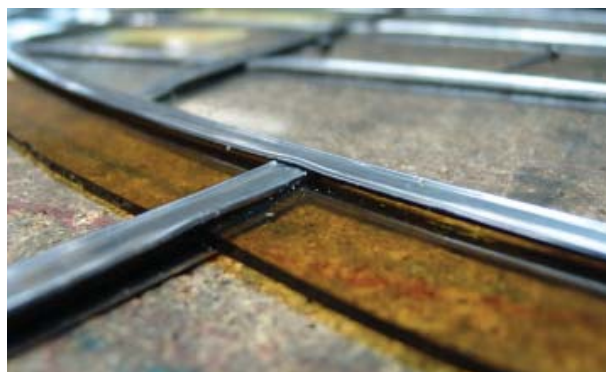
### *How to make a NDG pre-glazed panel*

NDG is an uniquely formulated solvent-free glazing product that provides a strong bond and secure seal between the glass and the lead came. A pre-determined amount of the glazing product already sits in the lead came. Once you make the panel it must be cured to allow the glazing product to melt around the glass and form the bond between the glass and the lead came.

#### ■ Making the panel

Take into account that the kern of the pre-glazed lead came is approximately 1.2 - 1.3 mm (normal lead came is approximately 1.2 mm).

The lead came has been opened during the process of inserting the NDG glazing material, thus you may not need to open it again. If you do need to open it, the NDG glazing material will not be affected. You may find that the tool that you use to open the lead came sticks a bit to the NDG glazing material - holding the tool at a more acute angle will make this easier.



For making a watertight panel it is absolutely essential that the lead intersections touch, otherwise the NDG glazing product will not be able to melt together and form a seal. One piece of lead came must abut up against the perpendicular piece.

Make the panel as you normally do. You will notice that the NDG lead came feels stronger. Once the panel is set, press down the lead came so that it lays flat against the glass, and then solder. If you are using a PELI curing station, make your solder joints as flat as possible for optimal warming under the curing station.

#### ■ Curing the panel



It is the experience of PELI Glass that a panel must be cured at 120°C for 30 minutes on each side of the panel. PELI Glass has developed CE-mark curing stations to be used with the pre-glazed came that provide for optimal uniform heating and are preset to 120°C. It is also possible to use a heat gun or hair dryer to cure the panel - but be advised that this treatment may result in uneven curing and the panel may not be watertight.

Solder as flat as possible. The curing station functions best when it has as much direct contact with the lead came as possible.

First allow the curing station to reach 120°C. Place the stained glass panel on a flat surface and lay the PELI curing station on top of it. Allow the curing station to remain on top of the panel for 30 minutes. Please be advised that curing station has a temperature meter but not a time meter, thus you must time the 30 minutes yourself. After 30 minutes remove the panel from under the curing station and

allow it to cool to room temperature (approx. 10 minutes). If it must be watertight, turn the panel over, again place the PELI curing station on top of the panel and cure once again for 30 minutes at 120°C.



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# NDG Pre-Glazed Lead Came



## Instructions

PELI Glass has found that the heat from curing may cause the lead came to slightly open up. For best results, once curing is complete but while the lead came is still warm, press the lead came down on both sides of the panel.

If you use a hand-held warming apparatus please be aware that these have different heating temperatures so you may have to experiment. Keep the hand-held apparatus constantly moving. As the NDG material melts it will become shiny and you should be able to see this. Once it has melted, that area is ready.



### ■ Cooling the panel

Once the panel is cooled it can be cleaned if necessary. Because of the unique formulation of the NDG material it is not expected to leak out from under the lead came. If that does happen, perhaps by warming the panel for too long, use a razor or sticker-cleaning solvent to clean the panel. The panel can be installed immediately after curing and cooling.

### ■ Watertight test

Once the panel is cooled, you can check if it is waterproof. Place the panel horizontally on something that will hold it several centimeters above a table, such as plastic containers. Spray water onto the panel, completely covering all the solder joints. Wait a few minutes and see if any water comes through. If it leaks, place it once again under the curing station for an additional 30 minutes.

PELI Glass has adapted the method developed by Streuter Technologies Inc. to guarantee watertightness. But if the panel has extreme wavy or circular lines and must be watertight, we recommend that you putty those areas on one side of the panel to insure watertightness.

### ■ Repairs on pre-glazed lead came

Since heat was used to cure the panel, heat must also be used to remove glass from the panel and perform repairs. For localized repairs, use a heat gun or a hair dryer to heat up the area to be repaired and remove / replace glass as necessary.



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