

**ANSI/AAMA/NWWDA 101/I.S.2-97
TEST REPORT**

Rendered to:

EARTHWISE GROUP LLC

SERIES/MODEL: 143.191CA

PRODUCT TYPE: PVC Casements

Summary of Results				
Title	Test Specimen #1	Test Specimen #2	Test Specimen #3	Test Specimen #4
Rating	C-LC20 108 x 78	C-LC25 72 x 78	C-C45 48 x 60	C-C55 48 x 60
Air Infiltration	0.06 cfm/ft ²	0.04 cfm/ft ²	N/A	N/A
Water Resistance Test Pressure	9.75 psf	N/A	N/A	N/A
Uniform Load Deflection Test Pressure	±20.0 psf	±25.0 psf	±45.0 psf	±55.0 psf
Uniform Load Structural Test Pressure	±30.0 psf	±37.5 psf	±67.5 psf	±82.5 psf
Forced Entry Resistance	Grade 10	Grade 10	Grade 10	Grade 10

Reference should be made to ATI Report No. 56638.04-201-47 for complete test specimen description and data.

ANSI/AAMA/NWWDA 101/I.S.2-97 TEST REPORT

Rendered to:

EARTHWISE GROUP LLC
107 Pierce Road
Clifton Park, New York 12065

Report No.: 56638.04-201-47
Test Date: 02/16/05
Through: 03/28/05
Original Report Date: 04/27/05
Revised Report Date: 05/20/05
Expiration Date: 02/16/09

Project Summary: Architectural Testing, Inc. (ATI) was contracted by Deceuninck North America, LLC to witness testing on four Deceuninck Series/Model 141.194, casement windows at Deceuninck North America, LLC test facility in Monroe, Ohio. The samples tested successfully met the performance requirements for the following ratings: Test Specimen #1: C-LC20 108 x 78; Test Specimen #2: C-LC25 72 x 78; Test Specimen #3: C-C45 48 x 60; Test Specimen #4: C-C55 48 x 60. This report is a reissue of Report No. 56638.01-201-47. This report is reissued in the name of Earthwise Group LLC through written authorization of Deceuninck North America, LLC. Test specimen description and results are reported herein.

General Note: *An asterisk (*) next to the performance grade indicates that the size tested for optional performance was smaller than the Gateway test size for the product type and class.*

Test Specification: The test specimens were evaluated in accordance with ANSI/AAMA/NWWDA 101/I.S.2-97, *Voluntary Specifications for Aluminum, Vinyl (PVC) and Wood Windows and Glass Doors.*

Test Specimen Description:

Series/Model: 143.191CA

Product Type: Various PVC Casements

Test Specimen #1: C-LC20 108 x 78

Overall Size: 9' 0" wide by 6' 6" high

Sash Size (2): 2' 11" wide by 6' 4-3/8" high

Fixed Sash Size: 2' 11" wide by 6' 4-3/8" high

Test Specimen Description: (Continued)

Test Specimen #1: C-LC20 108 x 78 (Continued)

Glazing Details: The window utilized a nominal 3/4" thick insulating glass fabricated from two nominal double-strength annealed sheets separated by an aluminum-butyl composite spacer system. The glass was set from the exterior against a silicone back bedding; vinyl glazing beads were used on the exterior.

Reinforcement: The sash stiles were reinforced with aluminum reinforcement (Deceuninck North America, LLC Part Drawing No. 10500006). The sill was reinforced with three aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10202004). The common frame stiles were reinforced with aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10300028-A).

Test Specimen #2: C-LC25 72 x 78

Overall Size: 6' 0" wide by 6' 6" high

Sash Size (2): 2' 11" wide by 6' 4-3/8" high

Glazing Details: The window utilized a nominal 3/4" thick insulating glass fabricated from two nominal double-strength annealed sheets separated by an aluminum-butyl composite spacer system. The glass was set from the exterior against a silicone back bedding; vinyl glazing beads were used on the exterior.

Reinforcement: The sash stiles and rails were reinforced with aluminum reinforcement (Deceuninck North America, LLC Part Drawing No. 10500006). The sill was reinforced with three aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10202004). The common frame stiles were reinforced with aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10300028-A).

Test Specimen #3: C-C45 48 x 60

Overall Size: 4' 0" wide by 5' 0" high

Sash Size (2): 1' 10-7/8" wide by 4' 10-3/8" high

Glazing Details: The window utilized a nominal 3/4" thick insulating glass fabricated from two nominal double-strength annealed sheets separated by an aluminum-butyl composite spacer system. The glass was set from the exterior against a silicone back bedding; vinyl glazing beads were used on the exterior.

Reinforcement: None.

Test Specimen Description: (Continued)

Test Specimen #4: C-C55 48 x 60

Overall Size: 4' 0" wide by 5' 0" high

Sash Size (2): 1' 10-7/8" wide by 4' 10-3/8" high

Glazing Details: The window utilized a nominal 3/4" thick insulating glass fabricated from two nominal double-strength annealed sheets separated by an aluminum-butyl composite spacer system. The glass was set from the exterior against a silicone back bedding; vinyl glazing beads were used on the exterior.

Reinforcement: The sash stiles were reinforced with aluminum reinforcement (Deceuninck North America, LLC Part Drawing No. 10500006). The sill was reinforced with three aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10202004). The common frame stiles were reinforced with aluminum reinforcements (Deceuninck North America, LLC Part Drawing No. 10300028-A).

The following descriptions apply to all specimens.

Finish: All PVC was white.

Weatherstripping:

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
3/8" co-extruded vinyl leaf	1 Row	Sash perimeter
Co-extruded vinyl bulb	1 Row	Sash perimeter

Frame Construction: All frame members were miter-cut and welded.

Sash Construction: All sash members were miter-cut and welded.

Hardware:

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
Roto-operator	2	Sill (one per sash)
Dual-arm casement hinges	4	Head and sill (two per sash)

Test Specimen Description: (Continued)

Hardware: (Continued)

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
Multi point lock with single bar actuator	2	Frame jamb with lock points at 5", 25-1/2", 46-1/2" and 67" from sill with keepers adjacent on the sash (one per sash)
Snubbers (Test Specimens 1, 2, and 3)	4	Hinge jamb, 15" from head and sill (two per sash)
Snubbers (Test Specimen 4)	6	Hinge jamb, 15" from head and sill, and midspan (three per sash)

Installation: The test units were installed within a wood test buck with #10 x 5/8" screws through the nail flange spaced 3" from each corner and 6" on center. The nail flange was sealed to the buck with silicone.

Test Results:

The results are tabulated as follows:

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
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Test Specimen #1: C-LC20 108 x 78

2.1.2	Air Infiltration per ASTM E 283 1.57 psf (25 mph)	0.06 cfm/ft ²	0.30 cfm/ft ² max.
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Note #1: *The tested specimen meets (or exceeds) the performance levels specified in ANSI/AAMA/NWDA 101/I.S.2-97 for air infiltration.*

2.1.3	Water Resistance per ASTM E 547 (See Note #2)		
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Note #2: *The client opted to begin at a pressure higher than the minimum required. Those results are listed under "Optional Performance."*

Test Results: (Continued)

Test Specimen #1: C-LC20 108 x 78 (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
2.1.4.1	Uniform Load Deflection per ASTM E 330 (Deflections reported were taken on the common frame mullion) (Loads were held for 52 seconds)		
	20.0 psf (positive)	0.83"	See Note #3
	20.0 psf (negative)	1.15"	See Note #3
<i>Note #3: The Uniform Load Deflection test is not a requirement of ANSI/AAMA/NWWDA 101/I.S.2-97 for this product designation. The deflection data is recorded in this report for special code compliance and information only.</i>			
2.1.4.2	Uniform Load Structural per ASTM E 330 (Permanent sets reported were taken on the common frame mullion) (Loads were held for 20 seconds)		
	30.0 psf (positive)	0.05"	0.30" max.
	30.0 psf (negative)	0.08"	0.30" max.
2.1.7	Welded Corner Test	Meets as stated	Meets as stated
2.1.8	Forced Entry Resistance per ASTM F 588		
	Type: C	Grade: 10	
	Lock Manipulation Test	No entry	No entry
	Test C1 through C3	No entry	No entry
	Lock Manipulation Test	No entry	No entry
2.2.5.6.1	Vertical Deflection Test 60 lbs	0.47"	0.73" max.
2.2.5.6.2	Hardware Load Test 6.24 lbs/ft ²	No damage	No damage
<u>Optional Performance</u>			
4.3	Water Resistance per ASTM E 9.75 psf	No leakage	No leakage

Test Results: (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
<u>Test Specimen #2:</u> C-LC25 72 x 78			
2.1.2	Air Infiltration per ASTM E 283 (See Note #1) 1.57 psf (25 mph)	0.04 cfm/ft ²	0.30 cfm/ft ² max.

Optional Performance

4.4.1	Uniform Load Deflection per ASTM E 330 (Deflections reported were taken on the common frame mullion) (Loads were held for 52 seconds) 25.0 psf (positive) 25.0 psf (negative)	1.12" 1.54"	See Note #3 See Note #3
4.4.2	Uniform Load Structural per ASTM E 330 (Permanent sets reported were taken on the common frame mullion) (Loads were held for 10 seconds) 37.5 psf (positive) 37.5 psf (negative)	0.07" 0.13"	0.30" max. 0.30" max.

Test Specimen #3: C-C45 48 x 60

Optional Performance

4.4.1	Uniform Load Deflection per ASTM E 330 (Deflections reported were taken on the common frame mullion) (Loads were held for 52 seconds) 45.0 psf (positive) 45.0 psf (negative)	0.63" 0.69"	See Note #3 See Note #3
4.4.2	Uniform Load Structural per ASTM E 330 (Permanent sets reported were taken on the common frame mullion) (Loads were held for 10 seconds) 67.5 psf (positive) 67.5 psf (negative)	0.04" 0.09"	0.23" max. 0.23" max.

Test Results: (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
<u>Test Specimen #4:</u> C-C55 48 x 60			
<u>Optional Performance</u>			
4.4.1	Uniform Load Deflection per ASTM E 330 (Deflections reported were taken on the common frame mullion) (Loads were held for 52 seconds)		
	55.0 psf (positive)	0.67"	See Note #3
	55.0 psf (negative)	0.82"	See Note #3
4.4.2	Uniform Load Structural per ASTM E 330 (Permanent sets reported were taken on the common frame mullion) (Loads were held for 10 seconds)		
	82.5 psf (positive)	0.04"	0.23" max.
	82.5 psf (negative)	0.02"	0.23" max.

Note: A lead check swab test was performed on all polymeric profiles. The test result was negative for the presence of lead (Pb).

This report is reissued in the name of Earthwise Group LLC through written authorization of Deceuninck North America, LLC to whom the original report was rendered. The original Deceuninck North America, LLC Report No. is 56638.01-201-47.

Detailed drawings, representative samples of the test specimen, and a copy of this report will be retained by ATI for a period of four years from the original test date. The above results were secured by using the designated test methods and they indicate compliance with the performance requirements of the above referenced specification. This report does not constitute certification of this product, which may only be granted by the certification program administrator. This report may not be reproduced, except in full, without the approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, INC:

Eric J. Schoenthaler
Technician

Daniel A. Johnson
Regional Manager

EJS:vlm

Attachments (pages):

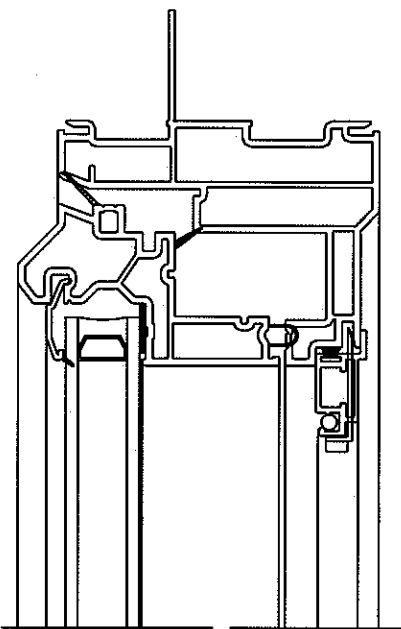
Appendix A: Drawings (14)

Revision Log

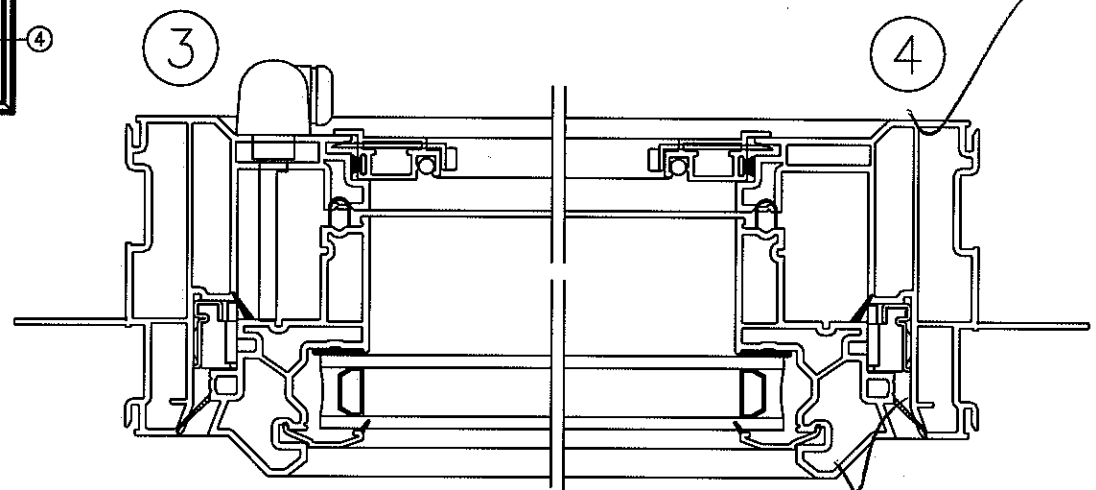
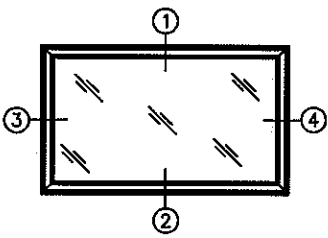
<u>Rev. #</u>	<u>Date</u>	<u>Page(s)</u>	<u>Revision(s)</u>
1	05/16/05	2 and 3	Revisions made were correcting the sash height dimension - Reissue Report No. 56638.01-201-47 in the name of Earthwise Group LLC
2	05/20/05	Cover	Revisions made were correcting the design pressures of unit #3

Appendix A

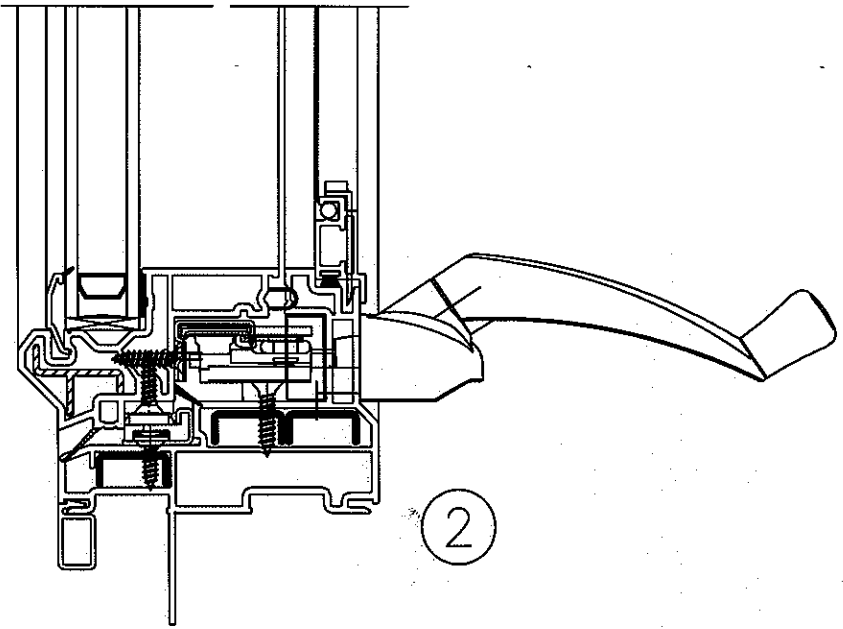
Drawings



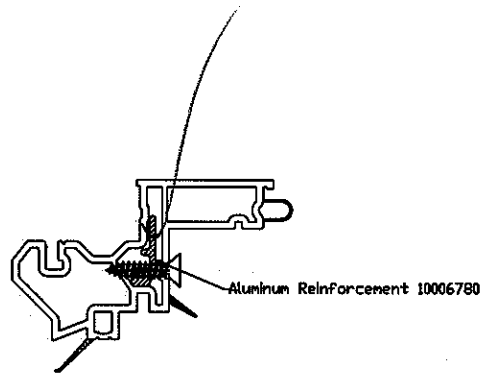
1



Multi-Point Lock



2

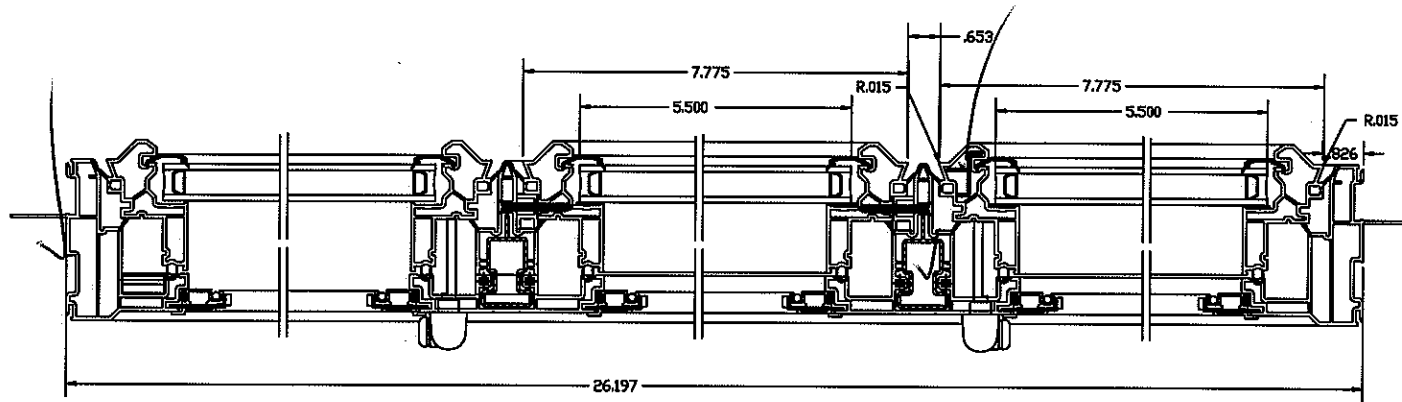
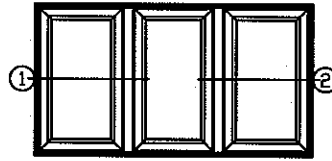


Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 54638
Date 2-16-05 Tech [Signature]
3-28-05

DAYTON TECHNOLOGIES	
<small>MONROE, OHIO Copyright 1999</small>	
NAME	Model 141.194 Casement
DRAWN BY	RH DATE 7/19/99
CHECKED BY	DATE
SCALE 1:1 "C"	PART 141194CA-F



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 56638

Date 2-16-05 / 3-26-05 Tech [Signature]

DAYTON TECHNOLOGIES	
<small>MEMPHIS, OHIO</small>	<small>Copyright 2000</small>
Model 141194 Casement XDX	
DRAWN BY: RH	DATE: 3/28/00
CHECKED BY:	DATE:
SCALE: 1/2" = 1'-0"	PART NO. 141194CA-XDX


141.194 CA - BILL OF MATERIALS (Roto Hardware)

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
1	HEAD	1	P8056	P8056F17	A
2	SILL	1	P8056	P8056F18	A
3	LOCK JAMB	1	P8056	P8056F19	A
4	HINGE JAMB	1	P8056	P8056F03	A
5	TOP RAIL	1	P5484	P5484F09	A
6	BOTTOM RAIL	1	P5484	P5484F10	A
7	KEEPER STILE	1	P5484	P5484F11	A
8	HINGE STILE	1	P5484	P5484F05	A
9	GLAZING BEAD	4	P5473	P5473F01	A
10	OPTIONAL "J" ACCESSORY	4	P8287	P8287F01	A
11	SASH REINFORCEMENT	As Req'd	10500006	10500006F01	OOO
12	FRAME REINFORCEMENT	OPT.	10202004	10202004F01	OOO
13					
14	3/4" INSULATED GLASS	1			R
15	GLAZING TAPE	AS REQ'D	V982 (3/8" WIDE)		EE
16	SETTING BLOCKS	AS REQ'D	1/8" x 3/4"		W
17	(REFER TO IG SUPPLIER GUIDELINES)				
18					
19	SCREEN ASSEMBLY	1	TBD	TBD	TBD
20					
21	SNUBBER	2 or 4	31496		G
22	SNUBBER SCREW (Frame)	2 or 4	#8 x 1/2 PPH		B, Z
23	SNUBBER SCREW (Sash)	2 or 4	#8 x 3/4 PPH		B, Z
24	SASH LIFT BLOCK	1	11780		D
25	SASH LIFT BLOCK SCREW	1	#7 x 3/4 PPH		B, Z
26	SCREW HOUSING (Optional)	4	10300033		A

Rev	Date	Description	By

PRELIMINARY

DAYTON TECHNOLOGIES	
MONROE, OH	COPYRIGHT 2000
NAME:	141194CA (Roto Hardware)
DWN BY:	RH 8/24/2000
CHKD BY:	
DWG NO:	141194CA_ROT0


Architectural Testing
 Test sample complies with these details.
 Deviations are noted.

Report# 56638
 Date 2-16-05 Tech Q
3-28-05

141194 CA - BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
27	OPERATOR (Frames Widths : 24" To 40")				G
28	MAXIM DUAL ARM OPERATOR ✓	1	50.00.XX.XXX Left Hand or Right Hand		
29	#8 X 3/4 PFH (Operator)	6	19218		
30	GASKET	1	31882		
31	STUD BRACKET	1	10680 Left Hand / 10681 Right Hand		
32	#8 X 3/4 PFH (Stud Bracket)	3	19218		
33	TRACK & SLIDER ASSEMBLY	1	11576.92		
34	#8 X 3/4 PFH	3	19218		
35	HANDLE KNOB S/A	1	11454		
36	WASHABILITY HINGE (Lower Left / Upper Right)	1	14.97.XX.XXX		
37	WASHABILITY HINGE (Upper Left / Lower Right)	1	14.97.XX.XXX		
38	#7 X 1/2 PFH UNDERCUT (S.S.) (Hinge Track)	8	19070		
39	#7 X 5/8 PFH (Hinge Sash Arm)	8	19060		
40	SPLINE CAP	1	21306		
41					
42					
43					
44	LOCK				G
45	LOCK ASSEMBLY	1	24-33		
46	SUPPORT PLATE	2	21132		
47	#8-32 X 3/8 PPH SELF THREADING SCREW	2	19545		
48	TIE BAR GUIDE	2 OR 3	40726		
49	#8 X 1 PPH (Tie Bar Guide)	4 OR 6	19230		
40	KEEPER	2 OR 3	31415 Left Hand / 31414 Right Hand		
51	#8 X 1 PPH (Keeper)	4 OR 6	19230		
52	TIE BAR ASSEMBLY	1	REFER TO FAB P5484F04		
53					

Rev	Date	Description	By
A	8/29/2000	REVISED LOCK ASSEMBLY	CRB

Note:
Use RH Operator with LH Bracket & Vice Versa

DAYTON TECHNOLOGIES	
MONROE, OH	COPYRIGHT 1998
NAME:	141194 CASEMENT
DWN BY:	RH 11/17/1999
CHKD BY:	
DWG NO:	141194CA



Test sample complies with these details.
Deviations are noted.

Report# 51638
Date 2-16-05/3-28-05 Tech [Signature]


141194 CA - BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
54	OPERATOR (Recommended : 16" to 24")				G
55	MAXIM DYAD OPERATOR	1	50.50.XX.XXX Left Hand or Right Hand		
56	#8 X 3/4 PFH (Operator)	6	19218		
57	GASKET	1	31882		
58	STUD BRACKET	1	10680 LH / 10681 RH		
59	#8 X 3/4 PFH (Stud Bracket)	3	19218		
60					
61					
62	HANDLE KNOB S/A	1	11454		
63	HINGE W/90 DEGREE STOP (Lower Left / Upper Right)	1	14.97.XX.XXX		
64	HINGE W/90 DEGREE STOP (Upper Left / Lower Right)	1	14.97.XX.XXX		
65	#7 X 1/2 PFH UNDERCUT (S.S.) (Hinge Track)	6	19070		
66	#7 X 5/8 PFH (Hinge Sash Arm)	8	19060		
67	SPLINE CAP	1	21306		
68					
69	FRAMES 13" To 16" USE 714. SERIES (Application Dependant)		50.70.XX.XXX		
70	STUD BRACKET		11674		
71	(Uses Same Lock System as Wider Casement)				
72					
73					
74					
75					
76					
77					
78					
79					
80					

Rev	Date	Description	By

Note:
Use RH Operator with LH Bracket & Vice Versa

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MONROE, OH	COPYRIGHT 1998
NAME:	141194 CASEMENT
DWN BY:	RH 11/17/1999
CHKD BY:	
DWG NO:	141194CA


Architectural Testing
 Test sample complies with these details.
 Deviations are noted.

Report# 56636
 Date 2-16-05/32805 Tech [Signature]

141194 CA - BILL OF MATERIALS

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
81	MULTIPLE LITE ACCESSORIES				
82	CENTERBAR (VERTICAL)	AS REQ'D	P5739	P5739F01	A
83	HEAD & SILL FAB 2 LITE	AS REQ'D	P8056	P8056F09	A
84	HEAD & SILL FAB 3 LITE	AS REQ'D	P8056	P8056F10	A
85	HEAD & SILL FAB 4 LITE	AS REQ'D	P8056	P8056F11	A
86	HEAD & SILL FAB 5 LITE	AS REQ'D	P8056	P8056F12	A
87	HEAD & SILL FAB 6 LITE	AS REQ'D	P8056	P8056F13	A
88					
89	FIXED LITE SASH	AS REQ'D	P5484		A
90	FIXED LITE SPACER	AS REQ'D	P1200		A
91					
92	CENTERBAR REINFORCEMENT	AS REQ'D	10300028		OOO
93	FIXED LITE MOUNTING SCREWS	AS REQ'D	#8 x 1 1/2" PPH & PFH		B, Z
94	CENTERBAR MOUNTING SCREWS	AS REQ'D	#8 x 3" PPH (SS)		B, Z
95	CENTERBAR MOUNTING SCREWS	AS REQ'D	#8 x 2" PPH		B, Z
96					
97					
98					
99					
100					
101					
102					
103					
104					
105					
106					
107					

Rev	Date	Description	By
A	5/2/2000	Changed Length Of 94 & 95 Per Request - (Fab. Will Change)	RH
B	5/3/2000	Changed Length Of 95 Per Request - (Fab. Will Change)	RH
C	6/5/2000	Added Dwg. # For 84, 85, 86, 87	RH

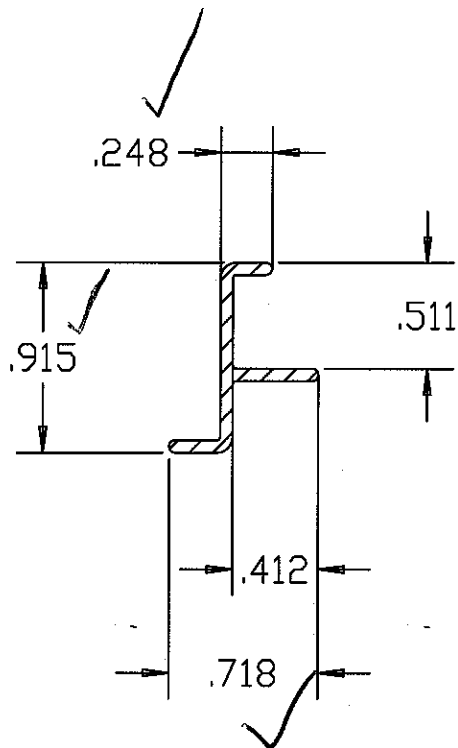
Note:

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MONROE, OH	COPYRIGHT 1998
NAME:	141194 CASEMENT
DWN BY:	RH 5/1/2000
CHKD BY:	
DWG NO:	141194CA



Test sample complies with these details.
Deviations are noted.

Report# 56638
 Dated 2-16-05/3-23-05 Tech AD



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 50638
Date 2-16-05 / 13-28-05 Tech RH

NOTES:

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2. DAYTON TECHNOLOGIES reserves the right to change specifications.

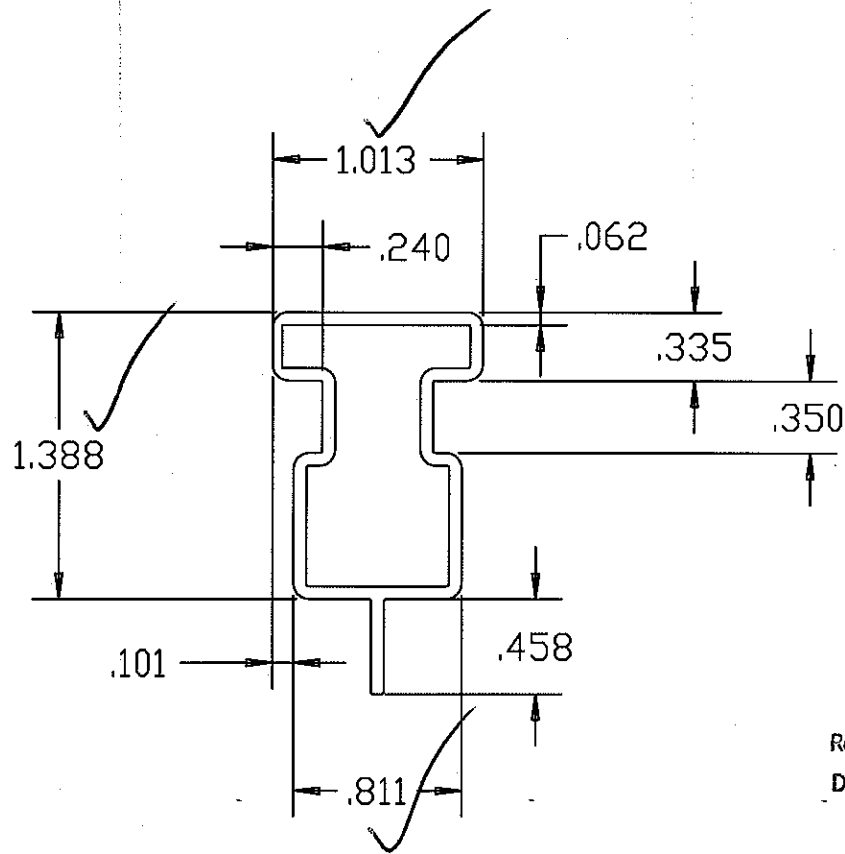
DAYTON TECHNOLOGIES

MONROE, OHIO

Copyright 1999

NAME:		10500006	
DWN BY:	RH	DWG NO:	10500006-A
AUTH:		AUTH. DATE:	
DATE:	12/1/99	SCALE:	1 : 1 "A"
PART NO:	10500006	DIE NO:	-----

				AREA:	.102 Sq. In.
				WEIGHT	.122 Lb / Ft.
A	2/16/00	Corrected Scale	RH	Standard Commercial Tolerances	
Rev.	Date	Description	By	Apply Unless Otherwise Noted	



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 56638
Date 2-16-05 Tech [Signature]
3-28-05

NOTES:

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2. DAYTON TECHNOLOGIES reserves the right to change specifications.
3. Material = 6063-T5 Aluminum.

DAYTON TECHNOLOGIES

MONROE, OHIO

Copyright 1999

NAME: Center Bar Reinforcement	
DWN BY: RH	DWG NO: 10300028-A
AUTH:	AUTH. DATE:
DATE: 1/20/00	SCALE: 1 : 1 "A"
PART NO: -	DIE NO: 59928

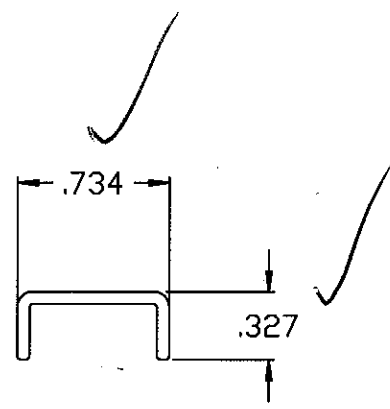
AREA:	.327 Sq. In.			
WEIGHT	.394 Lb / Ft.			
A	2/7/00	Added Die Number	RH	Standard Commercial Tolerances Apply Unless Otherwise Noted
Rev.	Date	Description	By	



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# SL638
Date 2-16-03 Tech [Signature]
3-28-05



NOTES:

1. Wall Thickness = .060
2. Unspecified Radii = .015
3. Material to be 6063-T5 Alum.

DAYTON TECHNOLOGIES

MONROE, OHIO

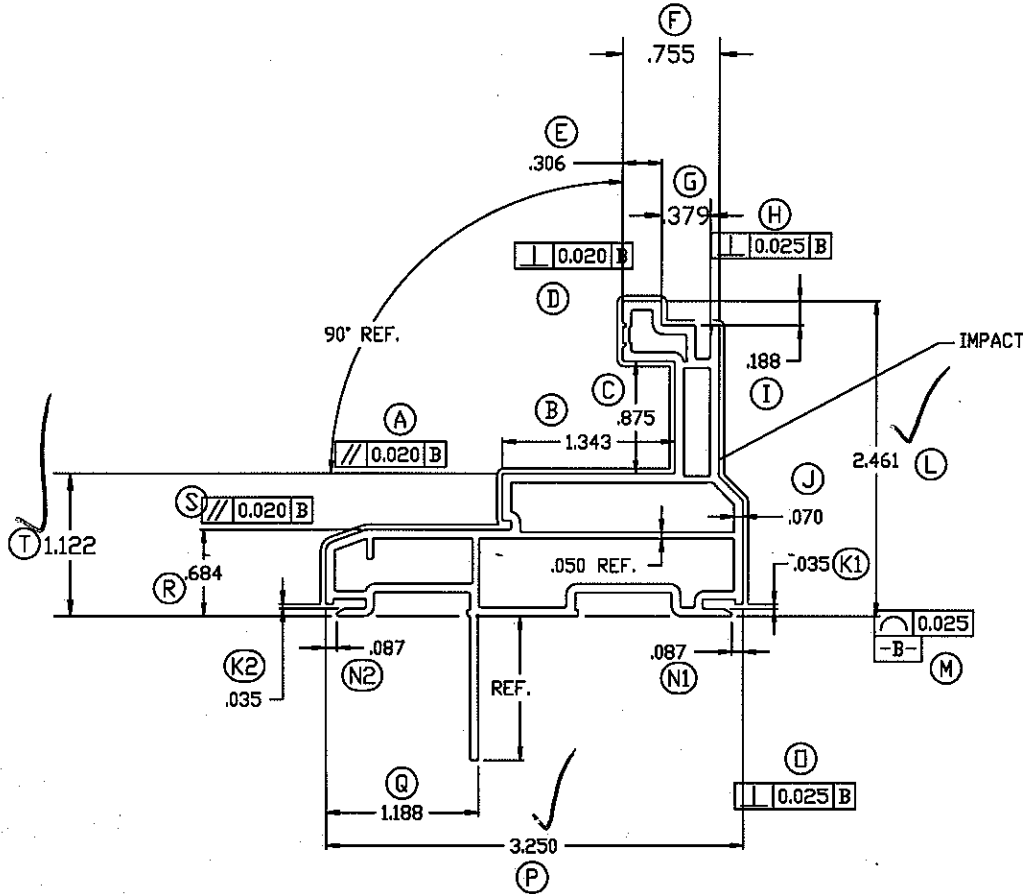
Copyright 1999

NAME: STIFFENER	
DWN BY: RH	DWG NO: A10202004-A
AUTH:	AUTH. DATE:
DATE: 7/26/99	SCALE: 1 : 1 "A"
PART NO: 10202004	DIE NO: -----

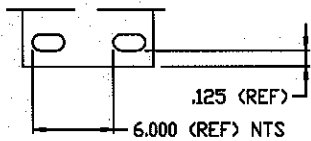
				AREA:	.073 Sq. In.
				WEIGHT	.087 Lb / Ft.
A	8/12/99	Material from Steel to Aluminum	RH	Standard Commercial Tolerances	
Rev.	Date	Description	By	Apply Unless Otherwise Noted	

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .100 ± .005 1.001 - 1.500 ± .020
 .101 - .500 ± .010 1.501 - 2.000 ± .025
 .501 - 1.000 ± .015 2.001 - & UP ± .030
 UNSPECIFIED ANGLES ± 1° - WOODGRAIN SURFACES ADD .007

—— = EXPOSED SURFACE ——— = WOODGRAIN SURFACE



NAILING FIN HOLE PUNCH DETAIL



Architectural Testing

Test sample complies with these details.
 Deviations are noted.

Report# 51638

Date 2/14/99 Tech 13/8/05

REV.	DATE	DESCRIPTION	BY
A	9/13/99	CORRECTED K,N, & T DIM.	CRB
B	02/18/00	MODIFIED 'I' TOL'S	DAS

FITS WITH P8056
 DIV CLASS: A IMPACT AREA NOTED

CONTROL DIMENSIONS

DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	V	0.020	B	X					
B	V	1.323	1.343	1.363	Y				
C	V	.860	.875	.890	Z(2)				
D	V	0.020	B	AA					
E	V	.296	.306	.316	BB				
F	V	.740	.755	.770	CC				
G	V	.369	.379	.389	DD				
H	V	0.025	B	EE					
I	V	.168	.188	.208	FF				
J	V	.063	.070	.077	GG				
K2	V	.025	.035	.045	HH				
L	V	2.436	2.461	2.486	II				
M	V	0.025	B	JJ					
N2	V	.050	.087	.090	KK				
O	V	0.025	B	LL					
P	V	3.225	3.250	3.275	MM				
Q	V	1.168	1.188	1.208	NN				
R	V	.669	.684	.709	OO				
S	V	0.020	B	PP					
T	V	1.102	1.122	1.142	QQ				
U					RR				
V					SS				
W					TT				

Part Wt. (Lbs/Ft)	Rigid	Cap	Flex	Alum	Total
.703	---	---	---	---	.703

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MONROE, OHIO Copyright 1999

NAME:	MAIN FRAME - CA		
DRAWN BY:	RH	DATE:	7/19/99
CHECKED BY:		DATE:	
SCALE:	1 : 1 "B"	COLOR:	<input type="checkbox"/> WH <input type="checkbox"/> BLS <input type="checkbox"/> GR <input type="checkbox"/> CLR <input type="checkbox"/> OTH
CUST. PART NO:	P8056	PART DWG. NO:	P8056-B

NOTES:

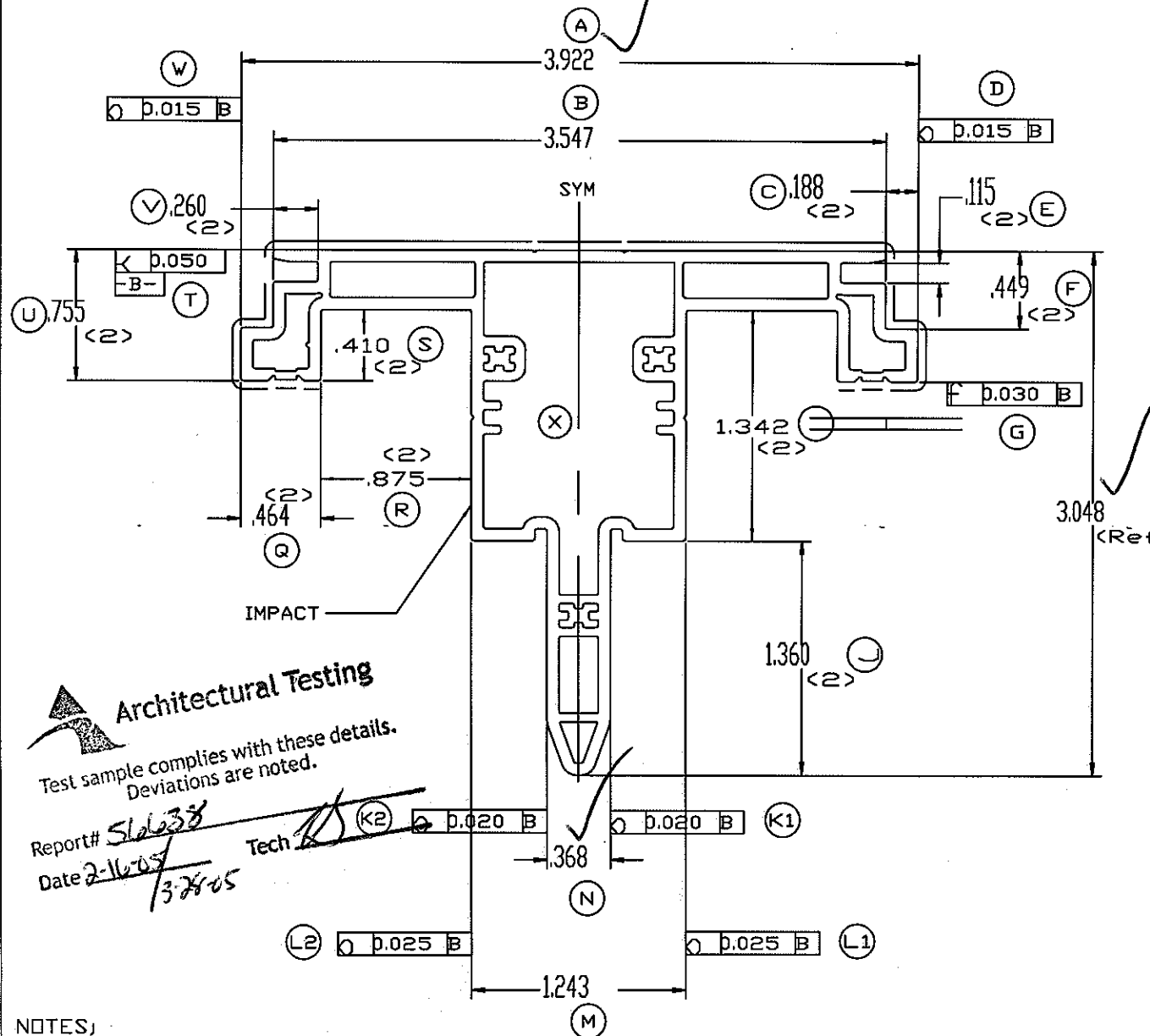
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UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .100 .005 1.001 - 1.500 .020
 .101 - .500 .010 1.501 - 2.000 .025
 .501 - 1.000 .015 2.001 - & UP .030
 UNSPECIFIED ANGLES 1° - WOODGRAIN SURFACES ADD .007"
 = EXPOSED SURFACE = WOODGRAIN SURFACE

COLOR	o WH & DS	o EB	o EW & DTH	Pearl White		
PART WT. (LBS/FT)	RIGID	CAP	FLEX	ALUM	STEEL	TOTAL
	.803	---	---	---	---	.803

PROFILE: P5739

REVISIONS			
REV	DESCRIPTION	DATE	ENG.
1	----	---	---



FITS WITH: A IMPACT AREA NOTED

CONTROL DIMENSIONS									
DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	V	3.892	3.922	3.952	U ₂	V	.740	.755	.770
B	V	3.517	3.547	3.577	V ₂	V	.250	.260	.275
C ₂	V	.178	.188	.198	W	V	o p.015 B		
D	V	o p.015 B			X	V	GAUGE 10300028		
E ₂	V	.105	.115	.125	Y	---	---	---	---
F ₂	V	.439	.449	.459	Z	---	---	---	---
G	V	F p.030 B			AA	---	---	---	---
H	---	---	---	---	BB	---	---	---	---
I ₂	V	1.322	1.342	1.362	CC	---	---	---	---
J ₂	V	1.340	1.360	1.380	DD	---	---	---	---
K ₂	V	o p.020 B			EE	---	---	---	---
L ₂	V	o p.025 B			FF	---	---	---	---
M	V	1.223	1.243	1.263	GG	---	---	---	---
N	V	.358	.368	.378	HH	---	---	---	---
O	---	---	---	---	II	---	---	---	---
P	---	---	---	---	JJ	---	---	---	---
Q ₂	V	.454	.464	.474	KK	---	---	---	---
R ₂	V	.860	.875	.890	LL	---	---	---	---
S ₂	V	.400	.410	.420	MM	---	---	---	---
T	V	K p.050			NN	---	---	---	---

Architectural Testing
 Test sample complies with these details.
 Deviations are noted.

Report# 516238
 Date 2-16-07 Tech [Signature]
3-28-05

- NOTES:
1. Part Is Symmetrical.
 2. Wall Thk = .070.
 3. Internal Wall Thk = .050.

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 351 N. GARVER RD.
 MONROE, OHIO 45050

NAME: Center Bar

DRAWN BY: V.H. DATE: 01/19/00

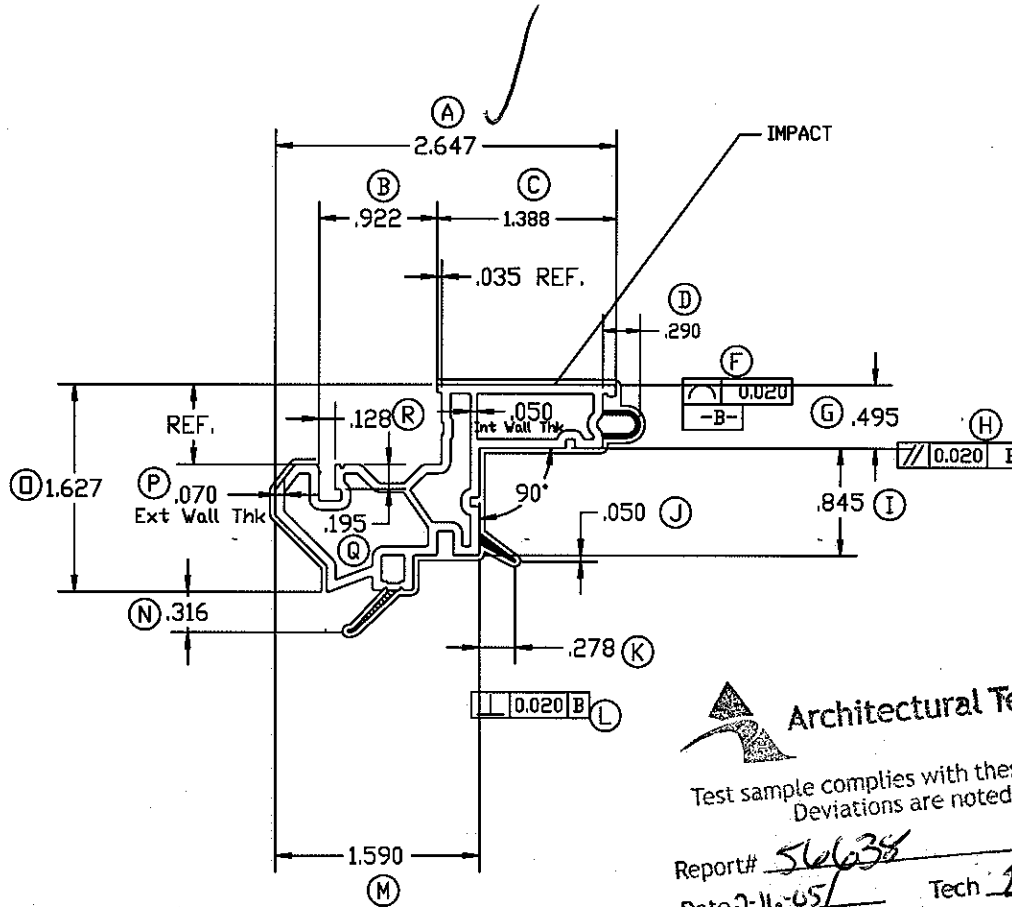
CHECKED BY: DATE:

FILENAME: /pd/ug/profiles/p5739.prt

SCALE: 1 : 1 DWG NO: p5739.prtA

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .100 ± .005 1.001 - 1.500 ± .020
 .101 - .500 ± .010 1.501 - 2.000 ± .025
 .501 - 1.000 ± .015 2.001 - & UP ± .030
 UNSPECIFIED ANGLES ± 1° - WOODGRAIN SURFACES ADD .007

— = EXPOSED SURFACE — = WOODGRAIN SURFACE



Architectural Testing

Test sample complies with these details.
 Deviations are noted.

Report# 516638
 Date 2-16-05 Tech JD
3-25-05

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REV.	DATE	DESCRIPTION	BY
C	12/2/99	"C" and "N" Updated (see prev rev)	RH
D	1/19/00	Added Optical Gauge For J, K, N	RH
E	1/11/01	CHANGED "D" MIN. BACK TO .155 HAVING FIELD PROBLEMS.	CRB
F	1/15/01	ADDED DIM. "D" TO OPTICAL GAUGE	CRB
G	02/09/30	INCREASE "J" & "K" TOLERANCES LOWER BOTH MIN. INCREASE "I" MAX	JOE L
-	YY/MM/DD	---	---

FITS WITH 5473, 5484

BOV CLASS A IMPACT AREA NOTED

CONTROL DIMENSIONS									
DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	V	2.622	2.647	2.672	S	--			
B	V	.907	.922	.937	T	--			
C	V	1.373	1.388	1.403	U	--			
D	OP	P5484OP-1-D			V	--			
E	-				V	--			
F	V	.020			X	--			
G	V	.485	.495	.505	Y	--			
H	V	.020			Z(2)	--			
I	V	.835	.845	.855	AA	--			
J	OP	P5484OP-1-D			BB	--			
K	OP	P5484OP-1-D			CC	--			
L	V	.020			DD	--			
M	V	1.565	1.590	1.615	EE	--			
N	OP	P5484OP-1-D			FF	--			
O	V	1.602	1.627	1.652	GG	--			
P	V	.060	.070	.080	HH	--			
Q	V	.185	.195	.205	II	--			
R	V	.118	.128	.138	JJ	--			

Part Wt. (Lbs/Ft)	Rigid	Cap	Flex	Alum	Total
	.453	----	----	.018	----
----	----	----	----	----	----

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MONROE, OHIO

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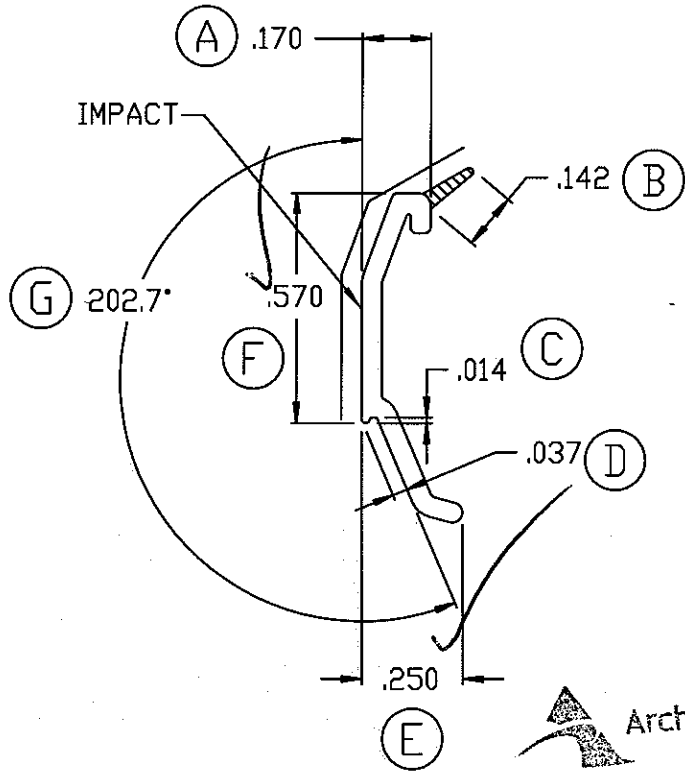
NAME: MAIN SASH - CA	
DRAWN BY: RH	DATE: 7/19/99
CHECKED BY:	DATE:
SCALE: 1 : 1 "B"	COLOR: <input type="checkbox"/> BW <input type="checkbox"/> DS <input type="checkbox"/> CF <input type="checkbox"/> EV <input type="checkbox"/> OTH
CUST. PART NO: P5484	PART DWG NO: P5484-G

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY

.001 - .100	.005	1.001 - 1.500	.020
.101 - .500	.010	1.501 - 2.000	.025
.501 - 1.000	.015	2.001 - & UP	.030

UNSPECIFIED ANGLES 1 - WOODGRAIN SURFACES ADD .007

— = EXPOSED SURFACE
 — = WOODGRAIN SURFACE



Architectural Testing
 Test sample complies with these details.
 Deviations are noted.

Report# 566355
 Date 2-16-05 / 13-28-05 Tech [Signature]

PROFILE P5473

REV.	DATE	DESCRIPTION	BY
A	7/19/99	Updated Dimensions	RH
B	04/04/03	DIM A, B, C, D, E OPTICAL MEASUREMENTS	CRB

FITS WITH:
 BOW CLASS: B IMPACT AREA: --

CONTROL DIMENSIONS									
DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	DC	P5473-0P-01			P				
B	DC	P5473-0P-01			Q				
C	DC	P5473-0P-01			R				
D	DC	P5473-0P-01			S				
E	DC	P5473-0P-01			T				
F	DC	.555	.570	.585	U				
G	DC	200.7	202.7	204.7	V				
H					W				
I					X				
J					Y				
K					Z				
L					AA				
M					BB				
N					CC				
O					DD				

COLOR	WH	DS	EB	EW	OTH	Pearl White
PART WT. (LBS/FT)	RIGID	CAP	FLEX	ALUM	TOTAL	
	.032	--	.002	--	.034	

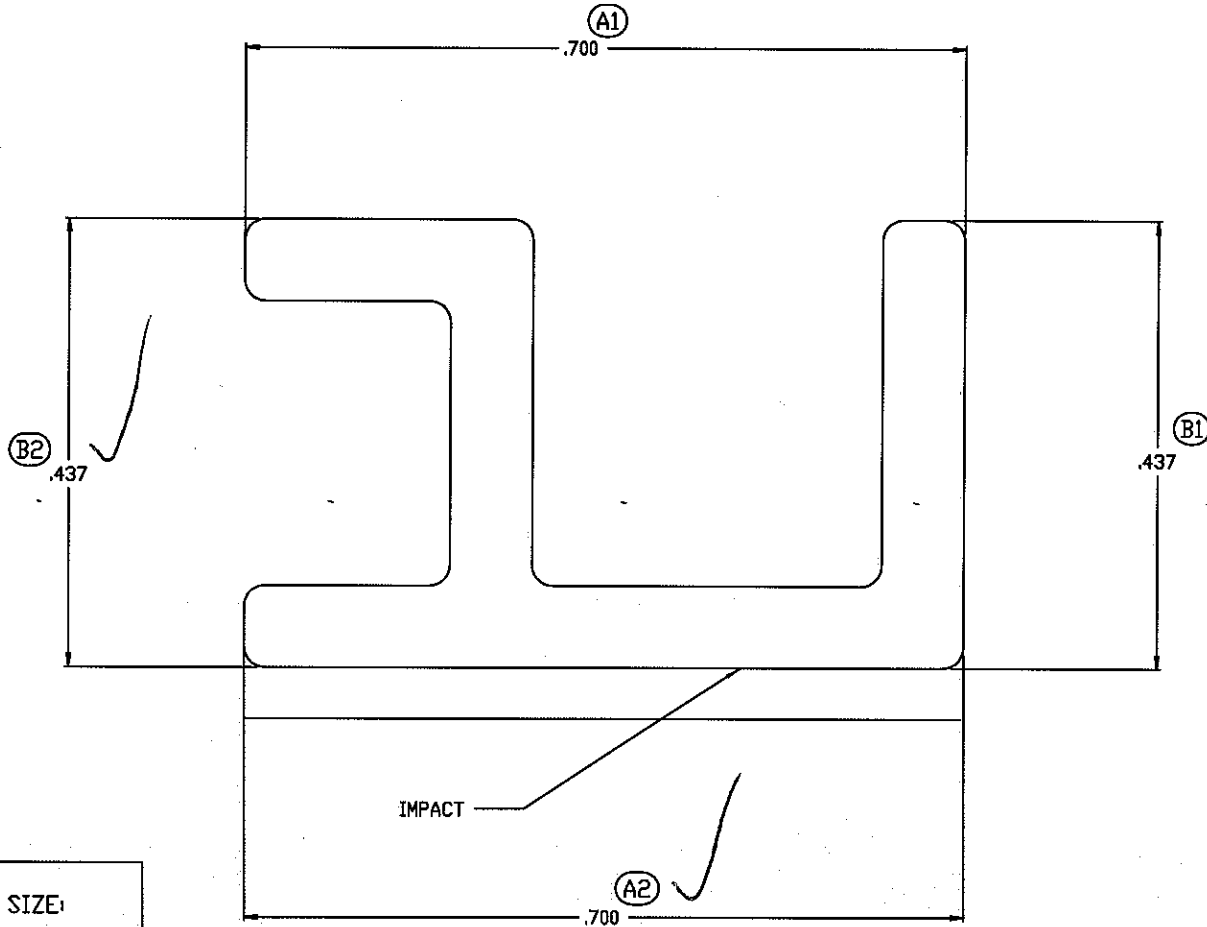
Dayton Technologies
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 351 N. GARVER RD.
 MONROE, OHIO 45050

PART NAME:	Glazing Bead				
DRAWN BY:	PJA	DATE:	6/25/99		
CHECKED BY:		DATE:			
DWG NO:	P5473	FILENAME:	pd/cad/parts/P5473-B		
DIE/CAL NO:	R867	SCALE:	2 : 1		

NOTES
 1. Wall Thickness - .050

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .100 ± .005 1.001 - 1.500 ± .020
 .101 - .500 ± .010 1.501 - 2.000 ± .025
 .501 - 1.000 ± .015 2.001 - & UP ± .030
 UNSPECIFIED ANGLES ± 1° - WOODGRAIN SURFACES ADD .007

—— = EXPOSED SURFACE —— = WOODGRAIN SURFACE



ACTUAL SIZE:



Architectural Testing

Test sample complies with these details.
 Deviations are noted.

Report# 56635
 Date 2-16-05 Tech [Signature]
13-24-05

REV.	DATE	DESCRIPTION	BY
A	9/28/95	NEW TITLE BLOCK	CRB

FITS WITH: N/A

ROW CLASS: B IMPACT AREA: NOTED

CONTROL DIMENSIONS									
DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	C-D	.670	.700	.730	X				
B	C-D	.422	.437	.452	Y				
C					Z				
D					AA				
E					BB				
F					CC				
G					DD				
H					EE				
I					FF				
J					GG				
K					HH				
L					II				
M					JJ				
N					KK				
O					LL				
P					MM				
Q					NN				
R					OO				
S					PP				
T					QQ				
U					RR				
V					SS				
W					TT				

Part Wt. (Lbs/Ft)	Rigid	Cap	Flex	Alum	Total
	.081	----	----	----	----
----	----	----	----	----	----

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NAME: CASEMENT PICTURE WINDOW SPACER

DRAWN BY: MTC DATE: 2/14/90

CHECKED BY: DATE:

SCALE: 8 : 1 "B" COLOR: WH BR BL GR TH

CUST. PART NO: 1200 PART DWG NO: P1200-A