



**TEST REPORT**

**Report No.:** H2017.01-501-47

**Rendered to:**

ASSOCIATED MATERIALS, INC.  
Cuyahoga Falls, Ohio

**PRODUCT TYPE:** PVC Fixed Window  
**SERIES/MODEL:** 3004 / 3B04 / 03A4

**SPECIFICATION(S):** AAMA/WDMA/CSA 101/I.S.2/A440-08, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

**Test Date(s):** 05/30/17  
**Through:** 05/31/17  
**Report Date:** 06/07/17



### Summary of Results

Title	Summary of Results	
	Test Specimen #1 <i>With 5/32" annealed glass</i>	Test Specimen #2 <i>With 3/16" annealed glass</i>
AAMA/WDMA/CSA 101/I.S.2/A440-08	Class CW-PG50 2438 x 1524 (96 x 60) - FW	Class CW-PG40 1829 x 2134 (72 x 84) - FW
Design Pressure	+2400 Pa (+50.13 psf)	+1920 Pa (+40.10 psf)
Negative Design Pressure	-2400 Pa (-50.13 psf)	-1920 Pa (-40.10 psf)
Air Infiltration	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Canadian Air Infiltration/Exfiltration Level	Fixed	Fixed
Water Penetration Resistance Test Pressure	360 Pa (7.52 psf)	360 Pa (7.52 psf)

Title	Summary of Results	
	Test Specimen #3 <i>With 3/16" annealed glass</i>	Test Specimen #4 <i>With 1/8" annealed glass</i>
AAMA/WDMA/CSA 101/I.S.2/A440-08 and -11	Class CW-PG50 1829 x 1829 (72 x 72) - FW	Class CW-PG50 1829 x 1270* (72 x 50*) - FW
Design Pressure	+2400 Pa (+50.13 psf)	+3360 Pa (+70.18 psf)
Negative Design Pressure	-2400 Pa (-50.13 psf)	-3600 Pa (-75.19 psf)
Air Infiltration	<i>See specimen #2</i>	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Canadian Air Infiltration/Exfiltration Level	<i>See specimen #2</i>	Fixed
Water Penetration Resistance Test Pressure	<i>See specimen #2</i>	360 Pa (7.52 psf)

Title	Summary of Results
	Test Specimen #5 <i>With 1/8" annealed glass</i>
AAMA/WDMA/CSA 101/I.S.2/A440-08 and -11	Class CW-PG50 1524 x 1524 (60 x 60) - FW
Design Pressure	+2640 Pa (+55.14 psf)
Negative Design Pressure	-2640 Pa (-55.14 psf)
Air Infiltration	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Canadian Air Infiltration/Exfiltration Level	Fixed
Water Penetration Resistance Test Pressure	360 Pa (7.52 psf)

**Test Completion Date:** 05/31/17

Reference must be made to Report No. H2017.01-501-47, dated 06/07/17 for complete test specimen description and detailed test results.



**1.0 Report Issued To:** Associated Materials Inc.  
3773 State Road  
Cuyahoga Falls, Ohio 44223

**2.0 Test Laboratory:** Architectural Testing, Inc., an Intertek company ("Intertek-ATI")  
1140 Lincoln Avenue  
Springdale, Pennsylvania 15144  
724-275-7100

**3.0 Project Summary:**

**3.1 Product Type:** PVC Fixed Window

**3.2 Series/Model:** 3004 / 3B04 / 03A4

**3.3 Compliance Statement:** Results obtained are tested values and were secured by using the designated test method(s). The specimens tested successfully met the performance requirements for the following ratings:

Test Specimen(s)	Title	Summary of Results
1	101/I.S.2/A440-08	Class CW-PG50 2438 x 1524 (96 x 60) - FW
2	101/I.S.2/A440-08	Class CW-PG40 1829 x 2134 (72 x 84) - FW
3	101/I.S.2/A440-08	Class CW-PG50 1829 x 1829 (72 x 72) - FW
4	101/I.S.2/A440-08	Class CW-PG50 1829 x 1270* (72 x 50*) - FW
5	101/I.S.2/A440-08	Class CW-PG50 1524 x 1524 (60 x 60) - FW

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

**3.4 Test Date(s):** 05/30/17 - 05/31/17

**3.5 Test Record Retention End Date:** All test records for this report will be retained until May 31, 2021.

**3.6 Test Location:** Associated Materials Inc. test facility in Cuyahoga Falls, Ohio. Calibration of test equipment was performed by Architectural Testing in accordance with AAMA 205-01 "In-Plant Testing Guidelines for Manufacturers and Independent Laboratories".

**3.7 Test Specimen Source:** The test specimen(s) were provided by the client. Representative samples of the test specimen(s) will be retained by Intertek-ATI for a minimum of four years from the test completion date.

**3.0 Project Summary:** (Continued)

**3.8 Drawing Reference:** The test specimen drawings have been reviewed by Intertek-ATI and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek-ATI per the drawings located in Appendix C. Any deviations are documented herein or on the drawings.

**3.9 List of Official Observers:**

<u>Name</u>	<u>Company</u>
Marsh Fernbaugh	Associated Materials Inc.
Rob Cutlip	Associated Materials Inc.
Joseph Allison	Intertek - ATI

**4.0 Test Specification(s):**

AAMA/WDMA/CSA 101/I.S.2/A440-08, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

**5.0 Test Specimen Description:**

**5.1 Product Sizes:**

**Test Specimen #1:**

Overall Area: 3.7 m <sup>2</sup> (40.0 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2438	96	1524	60

**Test Specimen #2:**

Overall Area: 3.9 m <sup>2</sup> (42.0 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	1829	72	2134	84

**Test Specimen #3:**

Overall Area: 3.3 m <sup>2</sup> (36.0 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	1829	72	1829	72

**Test Specimen #4:**

Overall Area: 2.3 m <sup>2</sup> (25.0 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	1829	72	1270	50

**5.0 Test Specimen Description: (Continued)**

**5.1 Product Sizes: (Continued)**

**Test Specimen #5:**

Overall Area: 2.3 m <sup>2</sup> (25.0 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	1524	60	1524	60

*The following descriptions apply to all specimens.*

**5.2 Frame Construction:**

Frame Member	Material	Description
Head, sill, jambs	PVC	Extruded

	Joinery Type	Detail
All corners	Mitered	Thermally welded

**5.3 Reinforcement:** No reinforcement was utilized.

**5.4 Weatherstripping:** No weatherstripping was utilized.

**5.5 Glazing:** *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

**Test specimen #1:**

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
13/16" IG	"U" shaped steel, single sealed	5/32" annealed	5/32" annealed	The glass was set from the interior against a double-sided adhesive tape and secured with rigid vinyl glazing beads.

**Test specimens #2 and #3:**

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
13/16" IG	"U" shaped steel, single sealed	3/16" annealed	3/16" annealed	The glass was set from the interior against a double-sided adhesive tape and secured with rigid vinyl glazing beads.

**5.0 Test Specimen Description: (Continued)**

**5.5 Glazing: (Continued)**

**Test specimens #4 and #5:**

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
13/16" IG	'U" shaped steel, single sealed	1/8" annealed	1/8" annealed	The glass was set from the interior against a double-sided adhesive tape and secured with rigid vinyl glazing beads.

Location	Quantity	Daylight Opening		Glass Bite
		millimeters	inches	
Specimen #1 frame	1	2305 x 1391	90-3/4 x 54-3/4	1/2"
Specimen #2 frame	1	1695 x 2000	66-3/4 x 78-3/4	1/2"
Specimen #3 frame	1	1695 x 1695	66-3/4 x 66-3/4	1/2"
Specimen #4 frame	1	1695 x 1137	66-3/4 x 44-3/4	1/2"
Specimen #5 frame	1	1391 x 1391	54-3/4 x 54-3/4	1/2"

**5.6 Drainage:**

Drainage Method	Size	Quantity	Location
Weephole	11/16" wide by 3/16" deep	2	Exterior sill face, one at each end draining the cavity below the glazing leg

**5.7 Hardware:** No hardware was utilized.

**6.0 Installation:**

The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/8" shim space. The exterior and interior perimeters of the window were sealed with a silicone sealant, with the exception of a 4" long void at each interior sill corner.

**Test specimen #1, #2 and #3:**

Location	Anchor Description	Anchor Location
Jambs	#8 x 2-1/2" long pan head screw	Three per jamb, one 4" in from each end and one at midspan
Head	#8 x 2-1/2" long pan head screw	Two per head evenly spaced at 1/3 points

**6.0 Installation:** (Continued)

**Test specimen #4:**

<b>Location</b>	<b>Anchor Description</b>	<b>Anchor Location</b>
Jambs	#8 x 2-1/2" long pan head screw	Two per jamb, one 4" in from each end
Head	#8 x 2-1/2" long pan head screw	Two per head evenly spaced at 1/3 points

**Test specimen #5:**

<b>Location</b>	<b>Anchor Description</b>	<b>Anchor Location</b>
Jambs	#8 x 2-1/2" long pan head screw	Two per jamb, one 4" in from each end
Head	#8 x 2-1/2" long pan head screw	One at midspan

**7.0 Test Results:** The temperature during testing was 22°C (70°F). The results are tabulated as follows:

**Test Specimen #1:**

Title of Test	Results	Allowed	Note
<b>Air Leakage,</b> Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Air Leakage,</b> Exfiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Canadian Air Infiltration/Exfiltration Level</b>	Fixed	N/A	
<b>Water Penetration,</b> per ASTM E 547	N/A	N/A	4
<b>Uniform Load Deflection,</b> per ASTM E 330	N/A	N/A	4
<b>Uniform Load Structural,</b> per ASTM E 330	N/A	N/A	4
<b>Forced Entry Resistance,</b> per ASTM F 588, Type: D - Grade: 40	Pass	No entry	
<b>Thermoplastic Corner Weld</b>	Pass	Meets as stated	
<b>Optional Performance</b>			
<b>Water Penetration,</b> per ASTM E 547 at 360 Pa (7.52 psf)	Pass	No leakage	2
<b>Uniform Load Deflection,</b> per ASTM E 330 Deflections taken at the sill +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	2.5 mm (0.10") 4.0 mm (0.16")	14.0 mm (0.55") max. 14.0 mm (0.55") max.	5, 6, 7
<b>Uniform Load Structural,</b> per ASTM E 330 Permanent sets taken at the sill +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	0.3 mm (0.01") 0.8 mm (0.03")	7.4 mm (0.29") max. 7.4 mm (0.29") max.	6, 7



**7.0 Test Results: (Continued)**

**Test Specimen #2:**

Title of Test	Results	Allowed	Note
<b>Air Leakage,</b> Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Air Leakage,</b> Exfiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Canadian Air Infiltration/Exfiltration Level</b>	Fixed	N/A	
<b>Water Penetration,</b> per ASTM E 547	N/A	N/A	4
<b>Uniform Load Deflection,</b> per ASTM E 330	N/A	N/A	4
<b>Uniform Load Structural,</b> per ASTM E 330	N/A	N/A	4
<b>Forced Entry Resistance,</b> per ASTM F 588, Type: D - Grade: 40	Pass	No entry	
<b>Thermoplastic Corner Weld</b>	Pass	Meets as stated	
<b>Optional Performance</b>			
<b>Water Penetration,</b> per ASTM E 547 at 360 Pa (7.52 psf)	Pass	No leakage	2
<b>Uniform Load Deflection,</b> per ASTM E 330 Deflections taken at the sill +1920 Pa (+40.10 psf) -1920 Pa (-40.10 psf)	2.5 mm (0.10") 4.0 mm (0.16")	10.4 mm (0.41") max. 10.4 mm (0.41") max.	5, 6, 7
<b>Uniform Load Structural,</b> per ASTM E 330 Permanent sets taken at the sill +2880 Pa (+60.15 psf) -2880 Pa (-60.15 psf)	0.3 mm (0.01") 0.8 mm (0.03")	5.6 mm (0.22") max. 5.6 mm (0.22") max.	6, 7

**7.0 Test Results: (Continued)**

**Test Specimen #3:**

Title of Test	Results	Allowed	Note
<b>Optional Performance</b>			
<b>Uniform Load Deflection,</b> per ASTM E 330 Deflections taken at the sill +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	2.8 mm (0.11") 3.3 mm (0.13")	10.4 mm (0.41") max. 10.4 mm (0.41") max.	5, 6, 7
<b>Uniform Load Structural,</b> per ASTM E 330 Permanent sets taken at the sill +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	0.3 mm (0.01") 0.5 mm (0.02")	5.6 mm (0.22") max. 5.6 mm (0.22") max.	6, 7

**Test Specimen #4:**

Title of Test	Results	Allowed	Note
<b>Air Leakage,</b> Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Air Leakage,</b> Exfiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Canadian Air Infiltration/Exfiltration Level</b>	Fixed	N/A	
<b>Water Penetration,</b> per ASTM E 547	N/A	N/A	4
<b>Uniform Load Deflection,</b> per ASTM E 330	N/A	N/A	4
<b>Uniform Load Structural,</b> per ASTM E 330	N/A	N/A	4
<b>Forced Entry Resistance,</b> per ASTM F 588, Type: D - Grade: 40	Pass	No entry	
<b>Thermoplastic Corner Weld</b>	Pass	Meets as stated	

**7.0 Test Results:** (Continued)

**Test Specimen #4:** (Continued)

<b>Optional Performance</b>			
<b>Water Penetration,</b> per ASTM E 547 at 360 Pa (7.52 psf)	Pass	No leakage	2
<b>Uniform Load Deflection,</b> per ASTM E 330 Deflections taken at the sill +3360 Pa (+70.18 psf) -3600 Pa (-75.19 psf)	3.3 mm (0.13") 4.0 mm (0.16")	10.4 mm (0.41") max. 10.4 mm (0.41") max.	5, 6, 7
<b>Uniform Load Structural,</b> per ASTM E 330 Permanent sets taken at the sill +5040 Pa (+105.26 psf) -5400 Pa (-112.78 psf)	0.3 mm (0.01") 0.3 mm (0.01")	5.6 mm (0.22") max. 5.6 mm (0.22") max.	6, 7

**Test Specimen #5:**

<b>Title of Test</b>	<b>Results</b>	<b>Allowed</b>	<b>Note</b>
<b>Air Leakage,</b> Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Air Leakage,</b> Exfiltration per ASTM E 283 at 75 Pa (1.57 psf)	<0.1 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Canadian Air Infiltration/Exfiltration Level</b>	Fixed	N/A	
<b>Water Penetration,</b> per ASTM E 547	N/A	N/A	4
<b>Uniform Load Deflection,</b> per ASTM E 330	N/A	N/A	4
<b>Uniform Load Structural,</b> per ASTM E 330	N/A	N/A	4
<b>Forced Entry Resistance,</b> per ASTM F 588, Type: D - Grade: 40	Pass	No entry	
<b>Thermoplastic Corner Weld</b>	Pass	Meets as stated	

**7.0 Test Results:** (Continued)

**Test Specimen #5:**

<b>Optional Performance</b>			
<b>Water Penetration,</b> per ASTM E 547 at 360 Pa (7.52 psf)	Pass	No leakage	2
<b>Uniform Load Deflection,</b> per ASTM E 330 Deflections taken at the sill +2640 Pa (+55.14 psf) -2640 Pa (-55.14 psf)	1.3 mm (0.05") 2.0 mm (0.08")	8.6 mm (0.34") max. 8.6 mm (0.34") max.	5, 6, 7
<b>Uniform Load Structural,</b> per ASTM E 330 Permanent sets taken at the sill +3960 Pa (+82.71 psf) -3960 Pa (-82.71 psf)	0.3 mm (0.01") 0.3 mm (0.01")	4.6 mm (0.18") max. 4.6 mm (0.18") max.	6, 7

*Note 1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440 for air leakage resistance.*

*Note 2: Test Date 05/30/17 (Air Note Only)*

*Note 3: Without insect screen.*

*Note 4: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.*

*Note 5: The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation. The deflection data is recorded in this report for special code compliance and information only.*

*Note 6: Loads were held for 10 seconds.*

*Note 7: Tape and film were not used to seal against air leakage during structural testing.*



Intertek-ATI will service this report for the entire test record retention period. Test records such as detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation, will be retained by Intertek-ATI for the entire test record retention period.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimen(s) tested. This report may not be reproduced, except in full, without the written approval of Intertek-ATI.

For ARCHITECTURAL TESTING, Inc.

Digitally Signed by: Zachary Miller

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Zachary Miller  
Technician

Digitally Signed by: Joseph E. Allison

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Joseph E. Allison  
Laboratory Supervisor

ZM:sld

Attachments (pages): This report is complete only when all attachments listed are included.

- Appendix-A: Alteration Addendum (1)
- Appendix-B: Location of Air Seal (1)
- Appendix-C: Drawing(s) (5)



## Appendix A

### Alteration Addendum

**Note:** *No alterations were required.*



## Appendix B

**Location of Air Seal:** The air seal between the test specimen and the test wall is detailed below. The seal is made of foam weatherstripping and is attached to the edge of the test specimen buck. The test specimen buck is placed against the test wall and clamped in place, compressing the weatherstripping and creating a seal.



Architectural Testing Test Report No.: H2017.01-501-47  
Report Date: 06/07/17

## **Appendix C**

### **Drawing(s)**



MODEL: Mezzo 3004 PW

UNIT SIZE	
Unit Width:	60.000
Unit Height:	60.000

Weld Burn-off Factor	0
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GENERAL DESCRIPTIONS		FINISHED SIZES	COMMENT
Unit Width	Unit Width	60	
Unit Height	Unit Height	60	
Glass Width	Glass Width	55 13/16	
Glass Height	Glass Height	55 7/8	

ITEM #	PART DESCRIPTIONS	PRODUCT CODE / DWG	VENDOR / PART NUMBER	CUT LENGTH	QTY	Wt / Ft	Weight #s	COMMENT	UOM
	Frame Top	UI0076	PBP-2180	60.000	1	0.703	3.515		LB
	Left Jamb	UI0076	PBP-2180	61.500	1	0.703	3.515		LB
	Right Jamb	UI0076	PBP-2180	61.500	1	0.703	3.515		LB
	Sill	UI0076	PBP-2180	62.000	1	0.703	3.515		LB
	Head Expander	UI0050	Premium - 5800	60.000	0	0.271	0.000		LB
	Sill Angle	UI0040	Adept - 5004-18650B	60.000	0	0.061	0.000		FT
	Top Glazing Bead	UI0090	Adept-4044	56.500	1	0.080	0.377		FT
	Top Glazing Bead	UI0090	Adept-4044	56.500	1	0.080	0.377		FT
	Left Glazing Bead	UI0090	Adept-4044	54.813	1	0.080	0.365		FT
	Right Glazing Bead	UI0090	Adept-4044	54.813	1	0.080	0.365		FT

Total Vinyl Weight # 15.544

**Reinforcement**

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**WEATHERSTRIPPING, BULB SEALS, SETTING BLOCKS and FOAM**

				Length	UOM				Convert
	Glazing Tape	US079210	Secon Rubber & Plastic	220.625	IN	N/A	N/A	1/16" x 3/8"	FT
	13/16" x 13/16" x 1/8" Setting Block	UM010700	Secon Rubber & Plastic	8	ea	N/A	N/A	1/8X13/16X13/16	EA

**HARDWARE**

	Weep Hole Cover	US0040	Vision 1226-BEW		2	N/A	N/A		EA
	Installation Screw Pack	UZ0060	Merchants		1	N/A	N/A		EA

**LABELS**

	AAMA Gold Label	UN024400	Moore Wallace		1	N/A	N/A		EA
	NFRC Labels	UN024300	Moore Wallace		2	N/A	N/A		EA
	Warranty Label	UN034500	Moore Wallace		1	N/A	N/A		EA
	White Label (1x6)	UN023000	Moore Wallace		1	N/A	N/A		EA
	Yellow Shipping Label	UN030406	RR Donnelley		1	N/A	N/A		EA

**PACKAGING**

	1/2" Polystrap (9000'/roll)	UN041400	Xpedx		8E-04	N/A	N/A		Roll
	1/2 Polystrap Buckle	UN042700	Xpedx		1	N/A	N/A		EA
	Foam Block	UN068700	PCA		2	N/A	N/A		EA
	Corrugated Corner	UN039100	PCA		4	N/A	N/A		EA
	Stretch Film-20"x5500'	UN043200	Xpedx		0.010	N/A	N/A		Roll
	2 x 110yd Clear Tape	UN043300	Xpedx		0.048	N/A	N/A		Roll

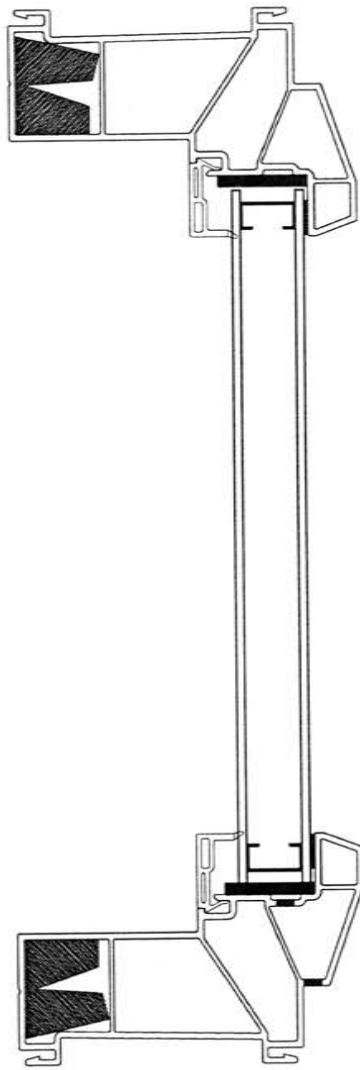
**GLASS**

	IG with DS Glass			21.66		N/A	N/A	CI-CI, Non-Metallic Spcr, Arg, Sealar	SQFT
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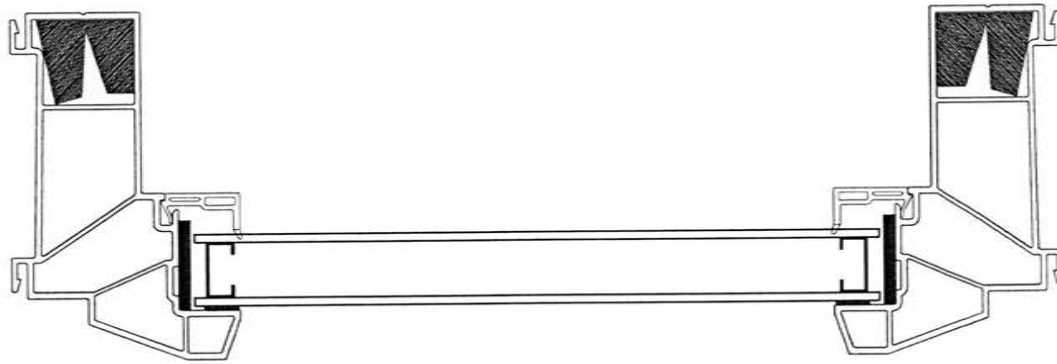
**OPTIONAL PARTS:**

	Coved Glazing Bead - 15/16" IG	UI0091	Adept-3936	56.500	2	0.037	0.174	TIG-15/16" Option	LB
	Coved Glazing Bead - 15/16" IG	UI0091	Adept-3936	54.813	2	0.037	0.169	TIG-15/16" Option	LB

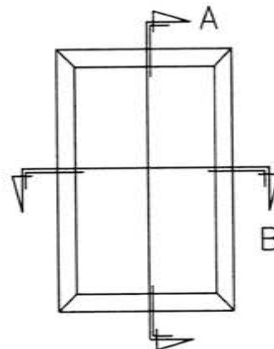
	Report #:	H2017.01-501-47
	Date:	06/09/2017
	Verified by:	<i>Joseph E. Altman</i>



SECTION - A



SECTION - B

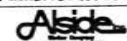


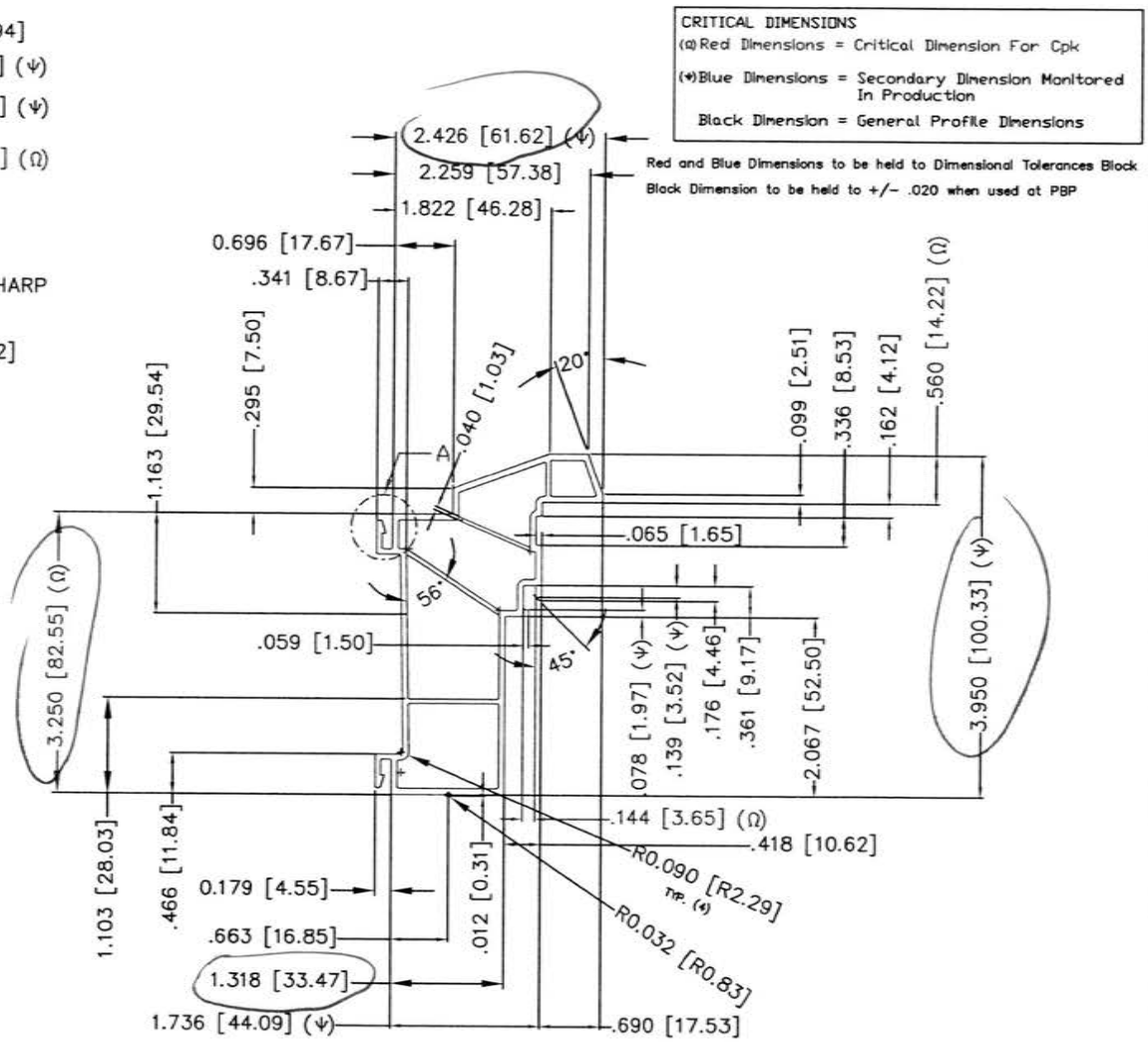
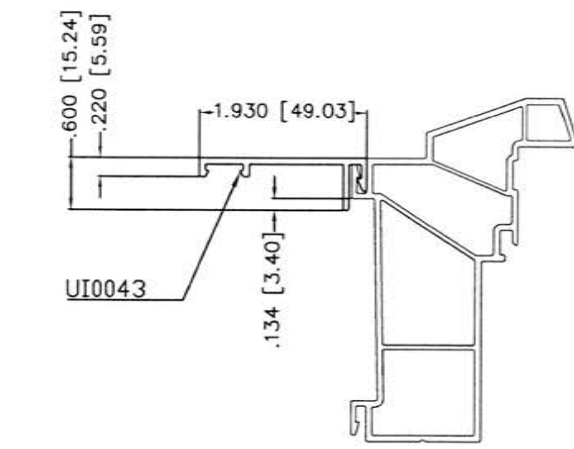
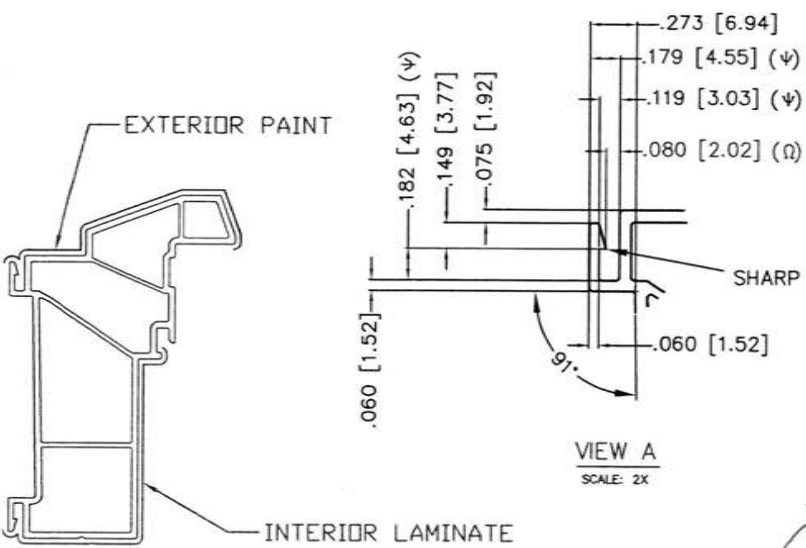
EXTERIOR ELEVATION



 Report #: H2017.01-501-47  
 Date: 06/09/2017  
 Verified by: *Joseph C. Allison*

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5.	Revised Frame Foam	SRH	7/31/13							 3004/3B04 3A04/3AB4 03A4/03S4 ASSEMBLY 13/16" IG
4.	Added TG Seal.	SRH	7/19/13							
3.	Revised frame extrusion.	SRH	2/11/13	DR'N.	S.HARP	CLASS				
2.	Revised extrusions. Converted to 15/16" / 1-1/8"	SRH	1/14/13	DATE	12/10/12	AREA				
1.	Revised extrusions. converted to 13/16" / 1"	SRH	2/23/12	DWG #	3937	WT./FT.				
NO.	ECN	REVISIONS	BY/DATE	SCALE	FULL	MATL				DRAWING/PART NO. 3937



REFERENCE DRAWING #3970 & #3993 FOR NAIL-FIN VERSIONS

Premium #: 2180

UNSPECIFIED WALL THICKNESS: EXTERIOR: .070 <sup>+0.07</sup> [-.18mm] <sub>-.065</sub> [-.13mm]  
 INTERIOR: .050 <sup>+0.07</sup> [-.18mm] <sub>-.045</sub> [-.13mm]  
 ALL CORNERS .020R UNLESS NOTED

**DIMENSIONAL TOLERANCES (UNLESS NOTED OTHERWISE)**  
 0" - 0.999" = +/- 0.008 [20mm]  
 1.000" - 2.999" = +/- 0.011 [30mm]  
 3.000" - 5.999" = +/- 0.016 [41mm]  
 6.000"+ = +/- 0.020 [51mm]  
 INTERNAL WALL LOCATIONS: +/- Interior Wall Width  
 ANGLES = +/- 1°  
 EXTRUSION BOW TOLERANCE: 0.039"/39.370" (1mm/Meter)

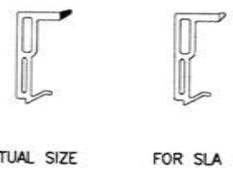
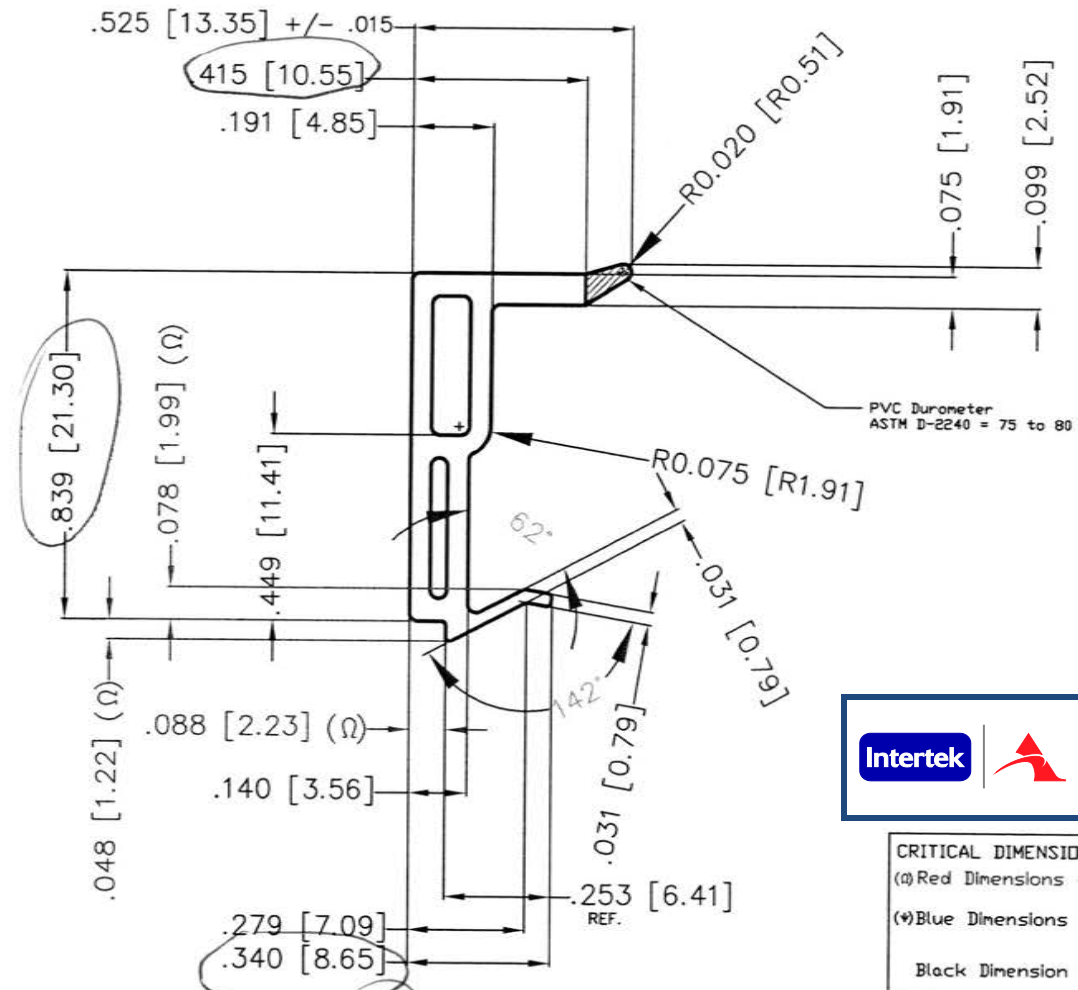
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**Intertek**  
 Report #: H2017.01-501-47  
 Date: 06/09/2017  
 Verified by: *Joseph C. Allison*

9.			4.	Added UIC-43 Detail	WJN	4/23/13			
8.			3.	273 was .546, wrong diameter used.	SR4	3/19/13			
7.			2.	Revised internal wall at drain trough. Angled to level.	SR4	2/8/13			
6.	Revised Multiple Dim Reference to start from Frame Body	WJN	CO 28	1.	Revised center support leg on particular per M. Lusk. Angled glass support leg location toward the actuator.	SR4	1/27/13		
5.	Added Critical Dim	WJN							
NO.	REVISIONS	BY/DATE	ECN No.	NO.	REVISIONS	BY/DATE	ECN No.	SCALE	FULL MAT'L

**Alside**  
 P.O. Box 2060  
 Akron, Ohio 44320-2060 Phone: (330) 822-6300  
 DR'N S.HARP CLASS H  
 DATE 12/10/12 AREA 1.123  
 DRWG# 3954 WT./FT. 0.707

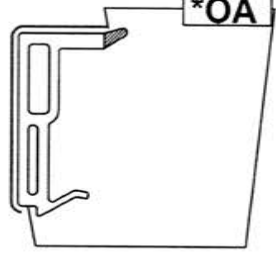
3004/3B04 FIXED  
 3A04/3AB4 FIXED  
 MAINFRAME  
 PRODUCT CODE UI0076XX




 Report #: H2017.01-501-47  
 Date: 06/09/2017  
 Verified by: *Joseph E. Altman*

**CRITICAL DIMENSIONS**  
 (Ω) Red Dimensions = Critical Dimension For Cpk  
 (∅) Blue Dimensions = Secondary Dimension Monitored In Production  
 Black Dimension = General Profile Dimensions

**\*OA**



PAINT / LAMINATE DETAIL

\*OA - Overspray Acceptable

UNSPECIFIED WALL THICKNESS: EXTERIOR: .050 <sup>+.007</sup> <sub>-.005</sub> [.18mm / .13mm]  
 INTERIOR: .040 <sup>+.007</sup> <sub>-.005</sub> [.18mm / .13mm]  
 ALL CORNERS .020R UNLESS NOTED  
**DIMENSIONAL TOLERANCES (UNLESS NOTED OTHERWISE):**  
 0" - .999" = +/- .010  
 1.000" - 2.999" = +/- .015  
 ANGLES = +/- 1°  
 EXTRUSION BOW TOLERANCE: 0.039"/39.370" (1mm/Meter)

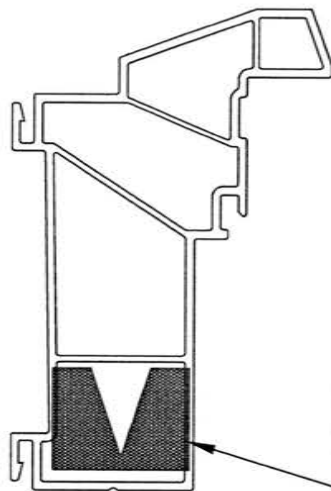
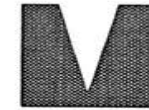
Adept #: 27784-EXT

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		<b>Alside</b> P.O. Box 2010 Akron, Ohio 44309-2010 • Phone: (330) 922-5300		3004/3B04/3A04/3AB4 03A4/03S4	
DR'N.	S.H.A.R.P.	CLASS	H	GLAZING BEAD 13/16" IG	
DATE	3/25/13	AREA	0.128		
DRWG#	4044	WT./FT.	0.080	PRODUCT CODE UI0090xx	
NO.	REVISIONS	BY/DATE	ECN No.		

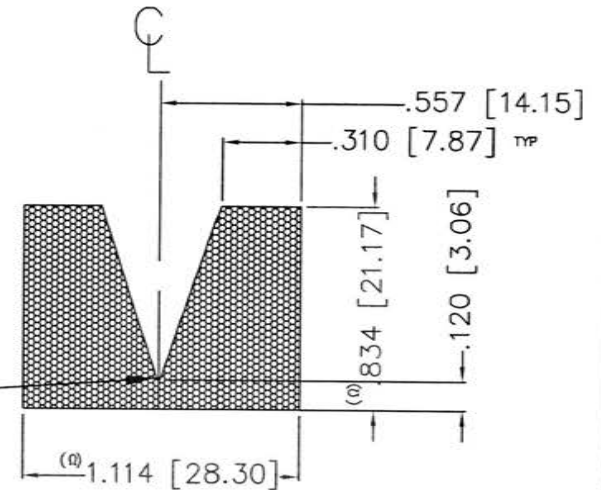
Foam Lengths = 48"

Full Size



Foam drawing shown is an interference compression fit; foam compressed upon installation..

Wire cut radius shown: 0.000 to 0.070.



CRITICAL DIMENSIONS

(R) Red Dimensions = Critical Dimension For Cpk  
 (B) Blue Dimensions = Secondary Dimension Monitored  
 Black Dimension = General Profile Dimensions

**Intertek** |  Report #: H2017.01-501-47  
 Date: 06/09/2017  
 Verified by: *Joseph E. Allison*

All Dimensions +- .030" unless noted  
 All angles are +- 1 deg  
 Color: Grey  
 Voids: all pin holes/voids no large than 1/8 dia"

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				<b>Alside</b> <small>Inc.</small> Akron, Ohio 44309-1365 • Phone: (330) 922-5300		MODEL 3004 (E2) Picture Window Foam
2				DR'N. WJNowak	AREA	
1.	Added v notch	7-23-13	ML	DATE 04.19.11	MAT'L	PRODUCT CODE US0312XX
NO.	REVISIONS	BY/DATE	ECN No.	DRWG# 4050	ASTM C578 Cellular Polystyrene 1# Neopor	
				SCALE 2 = 1		