



## SERIES 6000 WINDOWS

PRODUCT SPECIFICATIONS | EXTRUSION DETAILS | TEST REPORTS



## SERIES 6000 2 ½" - 3" THERMAL BREAK ALUMINUM WINDOWS OUTSIDE GLAZE



#### INTRODUCTION

Our Series 6000 (Outside Glazed) product line use 6063 extruded aluminum, age hardened to a T-6 rating for strength and durability. The profiles for this series are extruded as 2 separate parts and are then joined into a single profile using thermal struts. The aluminum extrusions are knurled and then crimped along the thermal profile to ensure a tight grip. The finished profile is thermally broken providing both improved thermal performance as well as improved condensation resistance. We use a 20mm offset thermal strut, although larger or smaller profiles are available upon request. (3" windows use a 31.9 mm strut)

The Series 6000 window line is available in the following finishes:

- Class I Clear Anodized\*\*
- Class I Bronze Anodized\*\*
- Standard White
- Custom Anodized
- 70% Kynar Paint Color

A combination of the above finishes on the Interior vs. Exterior Before the interior and exterior profiles are joined with the thermal strut, they can be painted or anodized with separate colors for a two-toned window.

\*\* Indicates Finishes In Stock.

#### TESTING

Our Series 6000 projected and fixed windows manufactured with a 20mm thermal strut have been tested to AAMA standards as listed below: (Please see test reports located in the back of this section for window sizes)

- Series 6000 Fixed FW-AW80
- Series 6000 Awning AP-AW80
- Series 6000 Casement C-AW80

All Weather has comprehensive files containing all historical testing. Each of the tests in the proceeding list are current, however, our archived testing may be more specific for your particular project and will be provided upon request.

#### CONSTRUCTION

Corners of frame and ventilators are mitered and crimped for structural integrity. Our typical construction uses 2 corner keys per corner in the vent and the frame. We can manufacture the frame and vent with up to 4 corner keys per corner. All muntin and other intermediate bars are firmly attached to their cross joints and their abutting sash sections. The frame sill, vents, and intermediate bars contain weep provisions. Frames are drilled and tapped to receive screen attachment hardware as required. All surfaces to be glazed have a bead retaining notch.

#### HARDWARE

Projected & Casement Windows: Vents shall operate on 4-bar heavy duty stainless steel hinges, and have die cast zinc cam handles with pole ring. brushed nickel hardware is available upon request.

Series 6000 awning and casement alternate: A worm gear rotary control operator with butt hinges and side mounted locking handle is provided for each casement ventilator. Casements can have a multipoint lock system upon request. Awnings can also be equipped with worm gear rotary hardware with loose pin/concealed hinges and locking handles on the jambs.

#### **SCREENS**

Screens are made of painted roll formed aluminum to match the window frame and use charcoal fiberglass mesh with plastic wicket doors. Wire mesh and Ultraview mesh screens are available upon request. The screens are installed and are removable from the inside of the building.

Series 6000 rotary casement and awning windows will have flat screens, also removable from inside the building.



## SERIES 6000 2 ½" - 3" THERMAL BREAK ALUMINUM WINDOWS OUTSIDE GLAZE (CONTINUED)



#### GLAZING

The Series 6000 offer a 1" OA on insulating glass units and 1/2" single glazed.

#### WEATHER-STRIPPING

Our Series 6000 and 6500 fixed, casement, and awning windows are weather stripped with a bulb weatherstrip. It is inserted in an extruded slot at the exterior perimeter of the vent and on the interior perimeter of the frame bar. 2 rows are used to ensure low air infiltration and prevent weather penetration. The bulb seal can be replaced in the field after installation, if necessary, for maintenance purposes.

#### **INSTALLATION GUIDELINES**

- All windows must be installed in prepared openings in accordance with AAMA recommendations and the below-listed manufacturers' recommendations (If shop drawings are required, please refer to approved shop drawings for installation):
- All vent panels must be closed and locked.
- Each unit must be installed level, plumb and square with a <sup>1</sup>/<sub>4</sub>" clearance on the jambs and the header of the window.
- Remove wet plaster, mortar, stucco and cement immediately. (Note: windows should only be cleaned with mild soap and water.)
- Do not set items on the sill.
- In nail-on applications, a bead of caulking material should be applied to the inside nail-on fin just before installation to insure a water tight seal between the building and the window. In an equal leg window a bead of caulking material should also be applied.
- Any attachment screws or bolts should be sealed during the process of installation.
- After installation is complete, building paper and stucco wire (if a stucco application) should overlap the window nail-on flange.

#### **CARE & MAINTENANCE**

- Windows should be kept free of all dust, dirt, paint and plaster.
- The sill should be kept clean at all times. A vacuum cleaner with a crevice attachment is recommended.
- Window should only be cleaned with mild soap and water.
- **Caution:** Damage will occur to the frame finish, and to the sealed glass unit, if solvents, petroleum products, or caustic chemicals such as acetone or paint thinner are used to clean window frames. Damage caused by this type of abuse is not covered under warranty.



#### **675 PANNING FRAME**



**691 NAIL ON FRAME** 





**602 EQUAL LEG FRAME** 

603 VENT / MULLION

606 MULLION









# 620 COMPENSATION CHANNEL

#### 621 COMPENSATION CHANNEL HEAD & JAMB

5622 COMPENSATION CHANNEL SNAP FACE









628 SQUARE BEAD FOR 1/2" OA GLASS

626 SQUARE BEAD FOR 1" OA GLASS







## SERIES 6000 CONFIGURATIONS OUTSIDE GLAZE – TABLE OF CONTENTS





**FIXED** 











5





EQUAL LEG CASEMENT

CSMT HL / CSMT HR









EQUAL LEG CASEMENT

CSMT HL / FIXED / CSMT HR







6





#### **FIXED WITH COMP CHANNEL**









EQUAL LEG AWNING

AWNING / AWNING









**EQUAL LEG AWNING** AWNING / FIXED / AWNING

AWINING / FIXED / AWINING











Intertek Architectural Testing	Intertek Augustation Taking Augustation Taki
TEST REPORT Report No.: DR929.01-301-44	1.0 Report Issued To: All Weather Architectural Aluminum 777 Aldridge Road Vacaville, CA 95688
Rendered to: All Weather Architectural Aluminum Vacaville, CA	2.0 Test Laboratory: Architectural Testing, Inc. 2524 East Jensen Ave. Fresno, CA 93706 559 233 8705
SERIES/MODEL: 6000	3.0 Project Summary:
PRODUCT TYPE: Fixed Window	3.1 Series/Model: 6000
SPECIFICATION: AAMA/WDMA/CSA 101/LS.2/A440-08, NAFS - North American	3.2 Product Type: Aluminum Fixed Window
renestration Standard/Specification for Windows, Doors, and Skyrights	3.3 Compliance Statement: Results obtained are tested values and were secured by using the designated test method(s). The specimen tested successfully met the
Title Summary of Results	(60 x 99in)-Fixed rating.
Primary Product Designator 1524 x 2515 mm (60 x 99 in)-Fixed	3.4 Test Dates: 06/10/2014 - 07/22/2014
Design Pressure         ±4320 Pa (±90.00 psf)           Air Infiltration         <0.1L/s/m² (<0.01 dm/ft²)	3.5 Test Record Retention End Date: All test records for this report will be retained until July 22, 2018.
Water Penetration Resistance Test Pressure 580 Pa (12.11 ps)	3.6 Test Location: Architectural Testing Inc. test facility in Fresno CA.
Test Completion Date: 07/22/2014 Reference must be made to Report No. D8929.01-301-44 dated 08/15/14 for complete test	3.7 Test Sample Source: The test specimen was provided by the client Representative samples of the test specimen will be retained by Architectural Testing for a minimum of four years from the test completion date.
specimen description and detailed test results.	3.8 Drawing Reference: The test specimen drawings have been reviewed by Architectural Testing and are representative of the test specimen reported herein. Test specimen construction was verified by Architectural Testing per the drawings located in Appendix B. Any deviations are documented berein or on the drawings.
	3.9 List of Official Observers:
	Name Company Seamus Porter All Weather Architectural Aluminum David Douglass Architectural Tosting Inc.



AAMA/WDMA/CS Standard/Specific AAMA 910-93, Vo Grade Windows a	A 101/LS.2/A4 ation for Window oluntary "Life Cyc nd Sliding Glass D	140-08, NAFS 8, Doors, and Skyl le" Specifications oors	<ul> <li>North Americ ights</li> <li>and Test Method:</li> </ul>	can Fenestrations for Architectur
5.0 Test Specimen D	escription:			
5.1 Product Size	2			
Overall Area:	Wi	dth	Hei	ght
3.83 m <sup>2</sup> (41.23 ft <sup>2</sup> )	millimeters	inches	millimeters	inches
Overall size	1524	60	2515	99
Head, sill Jambs	Aluminum	Thermally imp aluminum	proved, dual-stru	itted, extruded
Location	Joinery Type	1	Detail	
All corners	Mitered	Sealed and sect keys. The corn corner keys w pan head scree drive pan head	ared using four al aers were attach ith (2) #8 x1-1/- ws and (2) #8 screws	ed through the 2" square drive x1-1/4" square
5.3 Weatherstrip	pping: No weath	erstripping was u	utilized.	

tertek	

In

Test Report No.: D8929.01-301-44 Report Date: 08/13/14 Revision 1 Date: 09/15/14 Record Reteation End Date: 07/22/18 Page 3 of 5

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

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

Type	Spacer	Interior & Exterior	Glazing Method
1" IG	Metal box	1/4" annealed	Exterior glazed against a bead of silicone and secured using aluminum glazing beads with a wedge gasket. A toe bead was applied at the perimeter.

Location	Onantitu	Daylig	ht Opening	Class Bits
Location	Quantity	millimeters	inches	Glass bite
Fixed daylight opening	1	1441 x 2432	56-11/16 x 95-3/4	1/2"

#### 5.5 Drainage:

[	Drainage Method	Size	Quantity	Location
	Weep hole	7/8" x 1/8"	2	Each end of the sill snap in glazing bead.

5.6 Hardware: No hardware was utilized.

5.7 Reinforcement: No reinforcement was utilized.

#### **6.0 Installation:**

\_

The specimen was installed into a Douglas-Fir wood buck. The rough opening allowed for a 1/4" shim space. The exterior perimeter of the window was sealed with sealant.

Anchor Description	Anchor Space	ng
1/4" x 2" square drive pan head screws	3" from each corne approximately 16" o	er and n center
www.archtest.com - www.intertek	.com/building	559.233.8705
	Anchor Description 1/4" x 2" square drive pan head screws www.archtest.com - www.intertek	Anchor Description         Anchor Spacing           1/4" x 2" square drive pan         3" from each come approximately 16" or appro



		Record Retention End Dat	e: 07/22/18 Page 4 of 5
7.0 Test Results: The temperat tabulated as f	ure during testing wa	as 28°C (83°F). The r	results are
Title of Test	Results	Allowed	Note
Seque	ntial testing per AAM.	A 910	
Air Leakage,		051440	1 1
Infiltration per ASTM E 283	<0.1 L/s/m <sup>2</sup>	0.5 L/s/m <sup>2</sup>	
at 300 Pa (6.27 pst)	(<0.01 cfm/ft <sup>2</sup> )	(0.10 cfm/ft²) max.	1
Water Penetration,			1 1
per ASTM E 547 and ASTM E 331	Dage	Me lashage	
at 500 Pa [12.11 psr]	Fass	No leakage	6
Uniform Load Deflection,	Inmb		1 1
+2840 Pa (+80.2 pcf)	0.5 mm (0.02")	2 E mm (0.10 <sup>1</sup> ) max	1 1
-3840 Pa (-80 2 pcf)	0.5 mm (0.02")	25 mm (0.10") max	234
Air Leakage	0.5 mm (0.02.)	2.5 mm (0.10 J max.	4, J, T
Infiltration per ASTM E 283	<0.1L/s/m <sup>2</sup>	0.51./s/m2	1 1
at 300 Pa (6.27 psf)	(<0.01 cfm/ft?)	(0.10 cfm/ft?) max.	1
Water Penetration	( viva cital/ic )	(one child is a more	
per ASTM E 547 and ASTM E 331			1 1
at 580 Pa (12.11 psf)	Pass	No leakage	1 1
Uniform Load Structural.			
per ASTM E 330	Iamb		1 1
+5760 Pa (+120.3 psf)	0.3 mm (0.01")	0.9 mm (0.04") max.	1 1
-\$760 Pa (-120.3 psf)	0.3 mm (0.01")	0.9 mm (0.04") max.	3,4
Forced Entry Resistance,			
per ASTM F 588			1 1
Type: D - Grade: 40	Pass	No entry	
Note 1: The tested specimen AAMA/WDMA/CSA 101/LS.2/A Note 2: The client opted to star	meets (or exceeds) th 440 for air leakage resi t at a pressure higher th	ie performance levels s istance. han the minimum require	pecified in ed.
Note 3: Loads were held for 10	seconds.		
Note 4: Tape and film were not	used to seal against at	r leakage during structu	ral testina.
in the second	and the search against an	and a second and accur	and a second





Intertek	Architectural Testing	Intertek A	Test Report No.: D0932.01-301-44-80 Report Date: 08/14/14 Revision 1 Date: 08/15/14 Record Retention End Date: 07/24/18 Poge 1 of 7	
		L0 Report Issued To: All Weather Arch 777 Aldridge Roa Vacaville, Californ	itectural Aluminum d uia 95688	
TEST REPO	RT	2.0 Test Laboratory: Architectural Tes 2524 East Jensen Fremo, Californis 559-233-8705	ting, Inc. Avenue 93706	
Report No.: D893	.01-301-44	3.0 Project Summary:		
Rendered	to:	3.1 Series/Model: 6000		
ALL WEATHER ADOUTED	TIDAL ALUMINUM	3.2 Product Type: Aluminum Awning W	Tindow	
Vecavile, Cali SERIES/MODE PRODUCT TYPE: Alumina	L: 6000 m Awning Window	3.3 Compliance Statement: Results ob using the designated test method(s performance requirements for a rat 914 (60 x 36) - Awning.	tained are tested values and were secured by . The specimen tested successfully met the ing of Class AW-PG80-Size Tested 1526 x	
SPECIFICATION: AAMA/WDMA/CSA 101/	\$2/4440.08 NAFS North American	3.4 Test Dates: 06/11/2014 - 07/24/2014		
Fenestration Standard/Specification for	Windows, Doors, and Skylights	3.5 Test Record Retention End Date: a until July 24, 2018.	All test records for this report will be retained	
Title	Summary of Paralty	3.6 Test Location: Architectural Testing	, Inc. test facility in Fresno, California.	
	Class AW-PG80-Size Tested	3.7 Test Sample Source: The test specie	nen was provided by the client.	
Design Pressure Air Infiltration	1526 x 914 mm (60 x 36) - Awning ±3840 Pa (±80.20 psf) <0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> ) 580Pa (12 11 psf)	3.8 Drawing Reference: The test a Architectural Testing and are represe Test specimen construction was veri located in Appendix E. Any deviation	pecimen drawings have been reviewed by nutrive of the test specimens reported herein. fied by Architectural Testing per the drawings is are documented herein or on the drawings.	
- And Teneration Resonance Teor Teorate	oovia (1111 pit)	3.9 List of Official Observers:		
	Test Completion Date: 07/24/14	Name Comp	any	
Reference must be made to Report No. D8932.01 specimen description and detailed test results.	301-44 dated 08/15/14 for complete test	Anthony Dan All W Jay Ratliff Archi David Douglass Archi	eather Architectural Aluminum tectural Testing, Inc. tectural Testing, Inc.	
2534.5 Januar August	0 559 233 8205	2524 E. Jersen Avenue	0. 559 233 8705	



I.0 Test Specificatio AAMA/WDMA/CS Standard/Specific	ms:			en 1 Date: 08/15/ End Date: 07/24/ Page 2 o
AAMA/WDMA/CS Standard/Specific				
	SA 101/LS.2/A4 action for Window	40-08, NAFS s, Doors, and Skyl	North America Ights	an Fenestrati
Grade Windows a	oluntary "Life Cyc nd Sliding Glass De	le" Specifications oors	and Test Methods	for Architectur
0 Test Specimen D	escription			
test specialen b	escription.			
5.1 Product Size	5:			
Overall Area:	Wi	dth	Heig	ght
1.39 m <sup>2</sup> (15.0 ft <sup>2</sup> )	millimeters	inches	millimeters	inches
Overall size	1526	60-1/16	914	36
Panel	1499	59	889	35
Member	Material	Extended with	Description	mak
Member Jambs, Head & Sill	Material Aluminum	Extruded, with	Description crimped thermal b	reak.
Member Jambs, Head & Sill Location	Material Aluminum Joinery Type	Extruded, with	Description crimped thermal b Detail	reak.
Member Jambs, Head & Sill Location All corners	Material Aluminum Joinery Type Mitered	Extruded, with Sealed, joined with two #10 self-drilling she square drive p screws.	Description crimped thermal b Detail using corner keys x 1-1/2" square d et metal screws an an head self-drilli	reak. , and fastened rive pan head d two #10 x 1' ng sheet meta
Member Jambs, Head & Sill Location All corners 5.3 Panel Constr	Material Aluminum Joinery Type Mitered	Extruded, with Sealed, joined with two #10 self-drilling she square drive p screws.	Description crimped thermal b Detail using corner keys x 1-1/2" square d et metal screws an an head self-drillin	reak. , and fastense lrive pan hear d two #10 x 1 ng sheet meta
Member Jambs, Head & Sill Location All corners 5.3 Panel Constr Member	Material Aluminum Joinery Type Mitered ruction: Material	Extruded, with Sealed, joined with two #10 self-drilling she square drive p screws.	Description crimped thermal b Detail using corner keys x 1-1/2" square d et metal screws an an head self-drillin Description	reak. , and fastemec lrive pan head .d two #10 x 1 ng sheet meta
Member Jamba, Head & Sill Location All corners 5.3 Panel Constr Member Stiles & Rails	Material Aluminum Joinery Type Mitered Suction: Material Aluminum	Extruded, with Sealed, joined with two #10 self-drilling she square drive p screws.	Description crimped thermal b Detail using corner keys x 1-1/2" square d et metal screws an an head self-drillin Description crimped thermal b	reak. , and fastemec Irive pan heac Id two #10 x 1 ng sheet meta reak.
Member Jambs, Head & Sill Location All corners 5.3 Panel Constr Member Stiles & Rails	Material Aluminum Joinery Type Mitered Suction: Material Aluminum	Extruded, with Sealed, joined with two #10 self-drilling she square drive p screws. Extruded, with	Description crimped thermal b Detail using corner keys x 1-1/2" square d et metal screws an an head self-drillin Description crimped thermal b	reak , and fastenee trive pan hear id two #10 x 1 ng sheet meta reak



Test Report No.: D0932.01-301-44-R0 Report Date: 08/14/14 Revision 1 Date: 08/15/14 Record Retention End Date: 07/24/18 Page 3 of 7

5.0 Test Specimen Description: (Continued)

#### 5.4 Weatherstripping:

Description	Quantity	Location
Hollow bulb rubber	1 row	Frame
Hollow bulb rubber	1 row	Panel

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

Туре	Spacer	Interior & Exterior	Glazing Method
1" IG	Metal box	3/16" annealed	Double-sided adhesive foam tape against interior stop; secured with snap-fit aluminum bead with rubber gasket; corners sealed with silicone sealant.

Location	Quantity	Daylight	Opening	Class Dite
Location	Quantity	millimeters	inches	Glass bite
Panel	1	1372 x 762	54 x 30	9/16"

#### 5.6 Drainage:

Drainage Method	Size	Quantity	Location
Weep notch	1" long	2	Bottom rail weatherstripping, 1" from each corner.
Pressure equalization notch	1" long	2	Stiles weatherstripping, 1" from each top corner.

#### 5.7 Hardware:

Description	Quantity	Location		
Multi-arm steel hinge with snubber	2	Fastened with #10 x 3/4" square drive pan head self-drilling sheet metal screws: 5 in each stile, and 4 in each jamb.		
Sweep lock	2	Fastened to bottom rail using two #10 x 1-1/2" Phillips flat head sheet metal screws.		
Strike plate	2	Fastened to sill using two #10-24 x 5/16" Phillips flat head machine screws.		

#### 5.8 Reinforcement: No reinforcement was utilized.

2524 E. Jensen Avenue Fresno, CA 93706

www.archtest.com . www.intertek.com/building

p. 559.233.8705 f. 717.764.4129



07/24 Page 4	Report No. 1093201 Report Date Revision 1 Date Record Retention End Date		ek Architectural Testing	
			0 Installation:	
open iled v	d test buck. The rough or of the window was se	into a Douglas fir wood . The exterior perimete	The specimen was installed allowed for a 1/4" shim space Silicone sealant.	
	Anchor Spacin	chor Description	Location A	
enter	1" from each corr spaced 12" - 15" on e	4" x 1-1/2" square we pan head screws	Nail fin 1/	
Note	Allowed	Results	Title of Test	
	, 	Initiate motion:		
	Report Only	160 N (36.0 lbf)	Onersting Force	
	135 N (30.3 lbf) max.	107 N (24.1 lbf) Latches:	per ASTM E 2068	
	100 N (22.5 lbf) max.	85 N (19.1 lbf)		
			Air Leakage,	
	0.5 L/s/m <sup>2</sup>	<0.05 L/s/m <sup>2</sup>	Infiltration per ASTM E 283	
1	(0.10 cm/ft <sup>2</sup> ) max.	[<0.01 cfm/ft*]	at 300 Pa [6.27 ps]	
			per ASTM E 547 & ASTM E 331	
2,7	No leakage	Pass	at 580 Pa (12.11 psf)	
	A 910	g (First Half) per AAM	Cyclin	
3	No damage	Pass	Vent Panel:	
4	No damage	Pass	2000 cycles Locking Hardware: 2000 cycles	
	910	use Testing per AAMA	Mis	
	No damage	Page	Ventilator Torsion Test	
	NO GAILING!	1.030	Ventilator Vertical Load Test	
	No damage	Pass	at 670 N (150.6 lbf)	
	1A 910	[Second Half] per AAM	Cycling	
		Pass	2000 cycles	
5	No damage			



\_\_\_\_

Test Report No.: D8932.01-301-44-R0 Report Date: 06/14/14 Revision 1 Date: 00/15/14 Record Retention End Date: 07/24/18 Page 5 of 7

7.0 Test Results: (Continued)

Title of Test	Results	Allowed	Notes
Life Cycle per AAMA 910 (Continued)			
	Initiate motion:		
	191 N (42.9 lbf)	Report Only	
Operating Force,	Maintain motion:		
per ASTM E 2068	102 N (22.9 lbf)	135 N (30.3 lbf) max.	
-	Latches:		
	31 N (7.0 lbf)	100 N (22.5 lbf) max.	
Air Leakage,			
Infiltration per ASTM E 283	<0.05 L/s/m <sup>2</sup>	0.5 L/s/m <sup>2</sup>	
at 300 Pa (6.27 psf)	(<0.01 cfm/ft <sup>2</sup> )	(0.10 cfm/ft2) max.	1
Water Penetration,			
per ASTM E 547 & ASTM E 331			
at 580 Pa (12.11 psf)	Pass	No leakage	2,7
Uniform Load Deflection,			
per ASTM E 330	N/A	N/A	7
Uniform Load Structural,			
per ASTM E 330	N/A	N/A	7
Forced Entry Resistance,			
per ASTM F 588			
Type: B - Grade: 10	Pass	No entry	
Sash/Leaf Torsion			
70 N (15.7 lbf)	44.2 mm (1.74")	44.4 mm (1.75") max.	
	<b>Optional Performance</b>		
Uniform Load Deflection,			
per ASTM E 330	Top rail		
+3840 Pa (+80.20 psf)	4.4 mm (0.18°)	8.6 mm (0.34") max.	
-3840 Pa (-80.20 psf)	0.9 mm (0.04*)	8.6 mm (0.34") max.	7,8,9
Uniform Load Structural,			
per ASTM E 330	Top rail		
+5760 Pa (+120.3 psf)	0.1 mm (0.01")	3.0 mm (0.12") max.	
E760 Pa ( 120 2 ma0	0.2 (0.017)	A A	



ntertek	Intertek	Test Report No.: DH912.01-801-64-80 Report Date: 00/16/14 Revision 1 Date: 07/15/14 Record Reteation End Date: 07/24/18 Page 7 cf 7
<ul> <li>7.0 Test Results: (Continued)</li> <li>Note 1: The tested spectmen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/LS.2/A440 for air leakage resistance.</li> <li>Note 2: Without insect screen.</li> <li>Note 3: Observations: No changes were noted during the first 2000 panel cycles.</li> <li>Note 4: Observations: Faint wore off the locks and strike plates during the first 2000 lock cycles.</li> <li>Note 5: Observations: After second 2000 panel cycles were complete, the friction shoe would no longer hold the panel at intermediate open positions. The friction shoe was adjusted prior to the next operating force measurement.</li> <li>Note 6: Observations: The second 2000 lock cycles ware metal of the locks and strike plates.</li> <li>Note 7: The client opted to start at a pressure higher than the minimum required.</li> <li>Note 6: Loads were held for 10 seconds.</li> <li>Note 9: Tape and film were used to seal against air leakage during structural testing. In the opinion of the test lab, the tape and film did not influence the results of the test.</li> </ul>	Architectural Testing, will serv Test records that are retain samples of test specimens, or Architectural Testing, Inc. for th This report does not constitution by this laboratory. It is the ac only to the specimen(s) readed the written approval of Archite For ARCHITECTURAL TESTING David Douglass Project Manager DD: ms Attachments (pages): This report is a Approxity. B. Drawlagr (8)	Alec this report for the entire test record retention period ed such as detailed drawings, datasheets, representative other pertinent project documentation will be retained by he entire test record retention period. • certification of this product nor an opinion or endorsement withive property of the client so named herein and relates •. This report may not be reproduced, except in full, without etural Testing, Inc. •. •. •. Inc. •. •. •. •. •. •. •. •. •. •. •. •. •.
	This report produced from controlled	l document template AYI 50434, inned D3/27/13.

p. 559.233.8705

£ 717.764.4129



Intertek	Intertek Archaectural Itating Archaectural Itating Test Report No.: D8931.01-301-44-R0 Report Date: 00/14/14 Revision 1 Date: 00/14/14 Record Retention End Date: 00/23/18 Page 1 of 7		
	1.0 Report Issued To: All Weather Architectural Aluminum 777 Aldridge Road Vacaville, California 95688		
TEST REPORT	2.0 Test Laboratory: Architectural Testing, Inc. 2524 East Jensen Avenue Fresno, California 93706 559-233-8705		
Report No.: D8931.01-301-44			
Rendered to-	3.0 Project Summary:		
Active of the	3.1 Series/Model: 6000		
ALL WEATHER ARCHITECTURAL ALUMINUM Vacaville, California	3.2 Product Type: Aluminum Casement Window		
SERIES/MODEL: 6000 PRODUCT TYPE: Aluminum Casement Window SPECIEICATION: AAMA/WDMA/CSA 101/US 2/A440.08 NAES - North American	3.3 Compliance Statement: Results obtained are tested values and were secured by using the designated test method(s). The specimen tested successfully met the performance requirements for a rating of Class AW - PG80 - Size Tested 915 x 1524 (36 x 60) - Casement.		
Fenestration Standard/Specification for Windows, Doors, and Skylights	3.4 Test Dates: 06/17/2014-07/23/2014		
	3.5 Test Record Retention End Date: All test records for this report will be retained until July 23, 2018.		
Title Summary of Results	3.6 Test Location: Architectural Testing, Inc. test facility in Fresno, California.		
Primary Product Designator Class AW-PG80-Size Tested 915 x 1524 mm (36 x 60) - Casement	3.7 Test Sample Source: The test specimen was provided by the client.		
Design Pressure         ±3840 Pa (±80.20 psf)           Air Infiltration         0.1 L/s/m² (0.02 cfm/ft²)           Water Penetration Resistance Test Pressure         580Pa (12.11 psf)	3.8 Drawing Reference: The test specimen drawings have been reviewed by Architectural Testing and are representative of the test specimens reported herein. Test specimen construction was verified by Architectural Testing per the drawings located in Appendix A. Any deviations are documented herein or on the drawings.		
Test Completion Date: 07/23/14	3.9 List of Official Observers:		
Reference must be made to Report No. D8931.01-301-44 dated 08/15/14 for complete test	Name Company		
specimen description and detailed test results.	Anthony Dan     All Weather Architectural Aluminum       Jay Ratliff     Architectural Testing, Inc.       David Douglass     Architectural Testing, Inc.		
2524 E. Jensen Avenue Fresno, CA 93706 vww.archtest.com - www.intertek.com/building p. 559.233.8705 f. 717.764.4129	2524 E. Jersen Avenue Fresno, CA 93706 www.archtest.com - www.intertek.com/building f. 559.233.8705 f. 717.764.4129		



Auchitectural Testing			Re Revis Record Retention	port Date: 00/14/ ion 1 Date: 08/15/ a End Date: 07/23/ Page 2 of
4.0 Test Specificatio	ns:			
AAMA/WDMA/CS Standard/Specific AAMA 910-93. Va	A 101/I.S.2/A4 ation for Window Juntary "Life Cyc	40-08, NAFS t. Doors, and Skyl le" Specifications	<ul> <li>North Americ lights</li> <li>and Test Methods</li> </ul>	can Fenestrations for Architectur
5.0 Test Specimen D 5.1 Product Size	escription: \$:	0073		
Overall Area:	Wi	đth	Hei	ght
1.39 m <sup>2</sup> (15.0 ft <sup>2</sup> )	millimeters	inches	millimeters	inches
Overall size	915	36	1524	60
Panel	869	35	1499	59
Member Jambs, Head & Sill	Material Aluminum	Extruded, with	Description crimped thermal l	break.
,				
Joint	Туре		Detail	
All corners	Mitered	Sealed, joined with two #10 self-drilling she square drive p screws.	using corner key x 1-1/2" square set metal screws a an head self-drill	's, and fastened drive pan head nd two #10 x 1" ing sheet metal
5.3 Panel Constr	uction:	-		
Member	Material		Description	
Stiles & Rails	Aluminum	Extruded, with	crimped thermal l	break.
loint	Type		Detail	
All corners	Mitered	Sealed, and fast	tened with staked	corner kevs.



Test Report No.: D0931.01-301-44-R0 Report Date: 08/14/14 Revision 1 Date: 08/15/14 Record Retention End Date: 07/23/18 Page 3 of 7

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

#### 5.4 Weatherstripping:

Description	Quantity	Location
Hollow bulb gasket	1 row	Frame
Hollow bulb gasket	1 row	Panel

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

Type	Spacer	Interior & Exterior	Glazing Method
1" IG	Metal box	3/16" annealed	Double-sided adhesive foam tape against interior stop; secured with snap-fit aluminum bead with rubber gasket; corners sealed with silicone sealant.

Location	Omentity	Daylight	Opening	Class Dita
LOCATION	Quantity	millimeters	inches	GIASS BILE
Panel	1	762 x 1373	30 x 54-1/16	9/16"

#### 5.6 Drainage:

Drainage Method	Size	Quantity	Location
Weep notch	1"long	Z	Bottom rail weatherstripping, 1" from each corner.
Pressure equalization notch	1" long	2	Stiles weatherstripping, 1" from each top corner.

#### 5.7 Hardware:

Description	Quantity	Location	
Multi-arm steel hinge with snubber	2	Fastened with #10 x 3/4" square drive pan head self-drilling sheet metal screws: 4 each in the top and bottom rails, and 5 each in the head and sill.	
Sweep lock	2	Fastened to lock stile using two #10 x 1-1/2" Phillips flat head sheet metal screws.	
Strike plate	2	Fastened to lock jamb using two #10-24 x 5/16" Phillips flat head machine screws.	

#### 5.8 Reinforcement: No reinforcement was utilized.

2524 E. Jensen Avenue Fresno, CA 93706

www.archtest.com - www.intertek.com/building

p. 559.233.8705 f. 717.764.4129



Architectural Testing		Report No.: DBWS101 Report Date Revision 1 Date Record Retention End Date	n: 00/1 e: 08/1 e: 07/2 Page 4
tallation:			
maciman tase inet	Ilad into a Douglas fir woo	od test buck. The rough	h one
wed for a 1/4" shim : cone sealant.	space. The exterior perimet	ter of the window was s	caled v
Location	Anchor Description	Anchor Space	nσ
Docación	1/4" x 1-1/2" souare	1" from each cor	ner:
Nail fin	drive pan head screws	spaced 12" - 15" on	center
Title of Test	Results Life Cycle per AAMA 91	Allowed	Note
	Initiate motion:		
On continue Former	25 N (6 lbf)	Report Only	
Operating Force,	Maintain motion:	125 N (20 2 lb0 max	
per ASIME 2000	I atchesi	100 N (00.0 101) mila.	
	40 N (9 lbf)	100 N (22.5 lbf) max.	
Air Leakage,			
tration per ASTM E 2	83 0.1 L/s/m <sup>2</sup>	0.5 L/s/m <sup>2</sup>	
at 300 Pa (6.27 psf)	(0.02 cfm/ft <sup>2</sup> )	(0.10 cfm/ft <sup>2</sup> ) max.	1
Water Penetration.	224		
51ME 547 & A51ME	Date	No leakam	2.7
a seo ra [12.11 psi]	voling (First Half) per AAM	IA 910	6,1
Vent Panel:	But	Nedaman	
2000 cycles	P/853	No damage	3
2000 cycles	Pass	No damage	4
	Misuse Testing per AAMA	910	
ntilator Torsion Tes	at Deserve	Nodewood	
at 330 N (74.2 lbf)	Pass	No damage	-
at 670 N (150 6 lbf)	Paer	No damage	
at 670 H [150.5101]	cling (Second Half) per AA	MA 910	
	Base	No damage	
Vent Panel:	P 855	No damage	2
Vent Panel: 2000 cycles			
Vent Panel: 2000 cycles Locking Hardware:	Pass	No damage	6

Intertek	Architectural Testing

Test Report No.: D8931.01-301-44-R0 Report Date: 00/14/14 Revision 1 Date: 08/15/14 Record Retention End Date: 07/23/18 Page 5 of 7

#### 7.0 Test Results: (Continued)

The of Fest	Results	Allowed	Notes
Life Cy	cle per AAMA 910 (Con	tinued)	
	Initiate motion:		
	31 N (7 lbf)	Report Only	1
Operating Force,	Maintain motion:		1
per ASTM E 2068	13 N (3 lbf)	135 N (30.3 lbf) max.	
	Latches:		
	13 N (3 lbf)	100 N (22.5 lbf) max.	
Air Leakage,			
Infiltration per ASTM E 283	<0.05 L/s/m <sup>2</sup>	0.5 L/s/m <sup>2</sup>	1
at 300 Pa (6.27 psf)	(<0.01 cfm/ft <sup>2</sup> )	(0.10 cfm/ft?) max.	1
Water Penetration.			
per ASTM E 547 & ASTM E 331			1
at 580 Pa (12.11 psf)	Pass	No leakage	2,7
Uniform Load Deflection,			
per ASTM E 330	N/A	N/A	7
Uniform Load Structural.			
per ASTM E 330	N/A	N/A	7
Forced Entry Resistance,			
per ASTM F 588			1
Type: B - Grade: 10	Pass	No entry	
Sash/Leaf Torsion			
90 N (20.2 lbf)	62.2 mm (2.45")	68.2 mm (2.69") max	
Sash Vertical Deflection			
270 N (60 lbf)	2.0 mm (0.08")	17.8 mm (0.70") max	
Distributed Load			
300 Pa (6.27 psf)	Pass	No damage	
	Optional Performance		
Uniform Load Deflection.			
per ASTM E 330	hinge stile		1
+3840 Pa (+80.20 psf)	1.1 mm (0.05")	8.6 mm (0.34") max.	
-3840 Pa (-80.20 psf)	4.6 mm (0.18")	8.6 mm (0.34") max.	7,8,9
Uniform Load Structural,			
per ASTM E 330	hinge stile		1
+5760 Pa (+120.3 psf)	1.0 mm (0.04")	3.0 mm (0.12") max.	
-5760 Pa (-120 3 pef)	0.4 mm (0.02")	3.0 mm (0.12") max.	7.8.9



ntertek	Acrel family	Test Report No. 1 Re Revisi Record Retention	08931.01-301-44-R0 port Date: 08/14/14 on 1 Date: 08/15/14 End Date: 07/23/18 Page 6 of 7
7.0 Test Results: (	(Continued)		200 <b>5</b> 2502200
Note 1: The t AAMA/WDMA/	ested specimen meets (o CSA 101/I.S.2/A440 for ab	r exceeds) the performance i r leakage resistance.	levels specified in
Note 2: Withou	it insect screen.		
Note 3: Observ began squeakin	ations: At approximately . g.	500 cycles, the vent panel hing	e kardware
Note 4: Observ	ations: Paint wore off the	strike plates during the first 2	000 lock cycles.
Note 5: Observe cycles.	ations: There was no chan	ige observed during the second	i 2000 vent panel
Note 6: Observ plates.	ations: The second 2000 l	ock cycles wore metal of the lo	cks and strike
Note 7: The clie	ent opted to start at a pres	ssure higher than the minimum	n required.
Note 8: Londs	vere held for 10 seconds.		
the opinion of ti	na jum ware used to seat a he test lab, the tape and fil	igenat ar severge array for m did not influence the results	action towards, in

ntertek	Loss Summy	Test Report No., D0 Repo Revision Revision Record Rotentism E	931.01-301-44-R0 et Date: 08/14/14 1 Date: 08/15/14 ed Date: 07/23/18 Page 7 of 7
Architectural Testir Test records that samples of test spe Architectural Testin	ng will service this repo are retained such as cimens, or other pertin g. Inc. for the entire test	ort for the entire test record re detailed drawings, datasheets, ent project documentation will record retention period.	tention period. representative be retained by
This report does no by this laboratory. only to the specime the written approva	t constitute certification It is the exclusive prop n(s) tested. This report d of Architectural Testin	of this product nor an opinion of erry of the client so named her may not be reproduced, except g, Inc.	or endorsement ein and relates in full, without
For ARCHITECTUR	AL TESTING. Inc.	lation	ie.
Digitally Digned by: Devid Dougles	<u> </u>	Dynaty Separat by Louton Hirk	
David Douglass Project Manager		Leaton Kirk Director - Regional Operat	lone
DD: ms			
Attachmenta (pages): T Appendix-A: Alter Appendix-B: Draw	hia report is complete only w ation Addendum [1] rings (8)	ben all attachmenta listed are included	
_			
TABL Papert produced In	om controlled document linin	UME ATL/08434, United 01/17/12.	
524 E. Jersen Avenue	www.architect.com	www.intertale.com/huilding	p. 559.233.8705