

ALL WEATHER ARCHITECTURAL ALUMINUM TEST REPORT

SCOPE OF WORK

AAMA/WDMA/CSA 101/I.S.2/A440 TESTING ON 8100 SERIES SLIDING GLASS DOOR

REPORT NUMBER

J0388.01-301-44 R3

TEST DATE

11/06/18 - 01/16/19

ISSUE DATE

02/18/19

REVISION 3 DATE

07/11/19

RECORD RETENTION END DATE

01/16/24

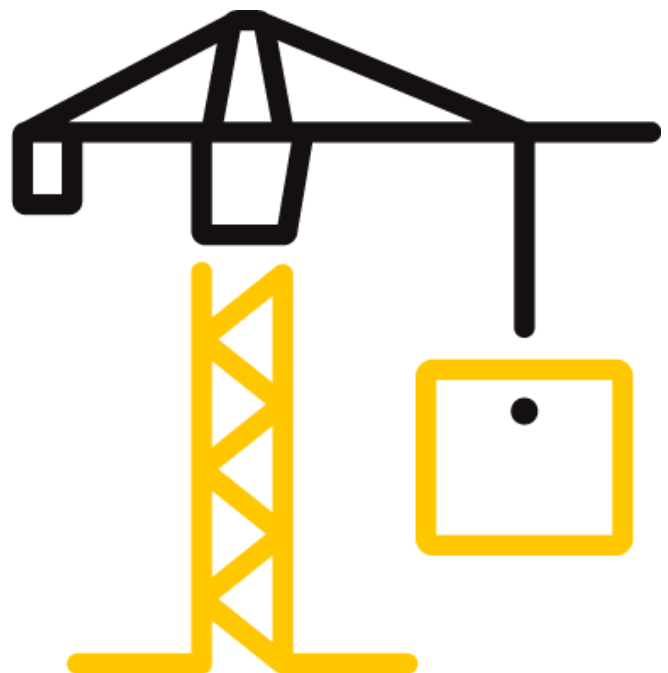
PAGES

27

DOCUMENT CONTROL NUMBER

RT-R-AMER-Test-2804 (04/17/18)

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TEST REPORT FOR ALL WEATHER ARCHITECTURAL ALUMINUM

Report No.: J0388.01-301-44 R3

Date: 02/18/19

REPORT ISSUED TO

ALL WEATHER ARCHITECTURAL ALUMINUM

777 Aldridge Road

Vacaville, California 95688

SECTION 1

SCOPE

Intertek Building & Construction (B&C) was contracted by All Weather Architectural Aluminum to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 on their 8100 Series Sliding Glass Door. Results obtained are tested values and were secured by using the designated test method(s). Testing was conducted at the Intertek B&C test facility in Fresno, California. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory.

SECTION 2

SUMMARY OF TEST RESULTS

TITLE	RESULTS
AAMA/WDMA/CSA 101/I.S.2/A440-11	Class CW – PG30: Size Tested 2400 x 2111 (94-1/2 x 83-1/8) – Type SD
Design Pressure	±1440 Pa (±30.08 psf)
Air Infiltration	1.5 L/s/m ² (0.29 cfm/ft ²)
Water Penetration Resistance Test Pressure	220 Pa (4.59 psf)

Reference must be made to Intertek B&C Report No. J0388.01-301-44 R3, dated 07/11/19 for complete test specimen description and detailed test results.

For INTERTEK B&C:

COMPLETED BY:	Ricardo Cortez	REVIEWED BY:	Tyler Westerling, P.E.
TITLE:	Technician	TITLE:	Senior Project Engineer
SIGNATURE:		SIGNATURE:	
DATE:	07/11/19	DATE:	05/10/19

rc:ec:ms

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SECTION 3

TEST SPECIFICATION(S)/METHOD

The specimens were evaluated in accordance with the following:

AAMA/WDMA/CSA 101/I.S.2/A440-11- *North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

The following test methods were used during testing:

ASTM E283-04(2012), *Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*

ASTM E330/E330M-14, *Standard Test Method for Structural Performance of Exterior Windows, Doors, Skylights and Curtain Walls by Uniform Static Air Pressure Difference*

ASTM E547-00(2016), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Cyclic Static Air Pressure Difference*

ASTM E987-88(2017), *Standard Test Methods for Deglazing Force of Fenestration Products*

ASTM E2068-00(2016), *Standard Test Method for Determination of Operating Force of Sliding Windows and Doors*¹

ASTM F842-17, *Standard Test Methods for Measuring the Forced Entry Resistance of Sliding Door Assemblies, Excluding Glazing Impact*

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SECTION 4

MATERIAL SOURCE/INSTALLATION

Test specimen was provided by the client. Representative samples of the test specimen(s) will be retained by Intertek B&C for a minimum of five years from the test completion date.

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

LOCATION	ANCHOR DESCRIPTION	ANCHOR SPACING
Through frame	Double row of #8 x 2" PPH	Head and jamb 12" on center
Sill	Silicone sealant	Sill seated on 1/4" shims seated on sill pan using only silicone sealant
Sill pan	Silicone sealant	Sill pan seated onto wood buck using only silicone sealant

SECTION 5

LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
David Douglass	Intertek B&C
Gino Vitali	Intertek B&C
Erick Caldera	Intertek B&C

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SECTION 6

TEST SPECIMEN DESCRIPTION

Product Type: Sliding Glass Door

Series/Model: 8100 Series

Product Size:

OVERALL AREA:	WIDTH		HEIGHT	
	Millimeters	Inches	Millimeters	Inches
5.37 m ² (57.8 ft ²)				
Overall size	2400	94-1/2	2111	83-1/8
Active panel	1220	48-1/16	2070	81-1/2
Fixed panel	1220	48-1/16	2070	81-1/2

Frame Construction:

MEMBER	MATERIAL	DESCRIPTION
Head, sill, jambs	Thermally broken aluminum	Broken by glass filled nylon
	JOINERY TYPE	DETAIL
All corners	Butted	Sealed; Four screws in each corner

Panel Construction:

MEMBER	MATERIAL	DESCRIPTION
Interlock	Aluminum	Thermal break between member and glazing bead
Rails and stiles	Thermally broken aluminum	Broken by glass filled nylon
	JOINERY TYPE	DETAIL
All corners	Butted	Sealed; Four screws in each corner

Reinforcement: No reinforcement was utilized.

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Weatherstripping:

DESCRIPTION	QUANTITY	LOCATION
Polypile with center fin	1 row	Interlock stiles
Polypile with center fin	5 rows	Sill
Polypile with center fin	2 rows	Jambs
Polypile with center fin (via attachment piece)	3 rows	Active panel interlock stile at sill corner

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

GLASS TYPE	SPACER TYPE	INTERIOR LITE	EXTERIOR LITE	GLAZING METHOD
1" IG	TPS spacer	3/16" tempered	3/16" tempered	Dry glazed and secured by glazing bead with EPDM gasket

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		Millimeters	Inches	
Fixed and active panel	2	1060 x 1860	41-3/4 x 73-1/4	1/2"

Drainage:

METHOD	SIZE	QUANTITY	LOCATION
Weephole	5/8" wide ovals	2 sets (4 per set)	Sill; 4-3/4" from corners

Hardware:

DESCRIPTION	QUANTITY	LOCATION
Roller track	1 row	Sill track; slip fit
Track clip	1	Head track; snap-fit
Track filler	1	Sill; snap-fit
Roller assembly	2	Bottom rail of active panel
Latch	1	Lock stile
Keeper	1	Lock jamb; opposite lock stile
Handle	1	Lock stile; 3" below latch

Screen Construction: *No screen construction was utilized.*

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Date: 02/18/19

SECTION 7

TEST RESULTS

The temperature during testing was 20°C (68°F). The results are tabulated as follows:

Test Specimen #1:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Operating Force, per ASTM E2068 Initiate Motion: Maintain Motion: Latches:	75 N (17 lbf) 53 N (12 lbf) 36 N (8 lbf)	180 N (40.5 lbf) max 115 N (25.9 lbf) max 100 N (22.5 lbf) max	
Air Leakage, Infiltration per ASTM E283 at 75 Pa (1.57 psf)	1.5 L/s/m ² (0.29 cfm/ft ²)	1.5 L/s/m ² (0.3 cfm/ft ²) max.	1, 2
Water Penetration, per ASTM E547 at 220 Pa (4.59 psf)	Pass	No leakage	3
Uniform Load Deflection, per ASTM E330 Deflections taken at interlock +1440 Pa (+30.08 psf) -1440 Pa (-30.08 psf)	11.9 mm (0.47") 11.9 mm (0.47")	11.9 mm (0.47") 11.9 mm (0.47")	3, 4, 5
Uniform Load Structural, per ASTM E330 Permanent set taken at interlock +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	0.3 mm (0.01") 0.3 mm (0.01")	8.1 mm (0.32") max. 8.1 mm (0.32") max.	3, 4, 5
Forced Entry Resistance, per ASTM F842, Type: A - Grade: 10	Pass	No entry	
Deglazing, per ASTM E987 Operating direction, 320 N (70 lbf) Remaining direction, 230 N (50 lbf)	Pass Pass	Meets as stated Meets as stated	

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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 11/06/18 / Time: 08:15 AM

Note 3: *The client opted to start at a pressure higher than the minimum required.*

Note 4: *Loads were held for 10 seconds.*

Note 5: *Tape and film were not used to seal against air leakage during structural testing.*

SECTION 8 ALTERATIONS

No alterations were required.

TEST REPORT FOR ALL WEATHER ARCHITECTURAL ALUMINUM

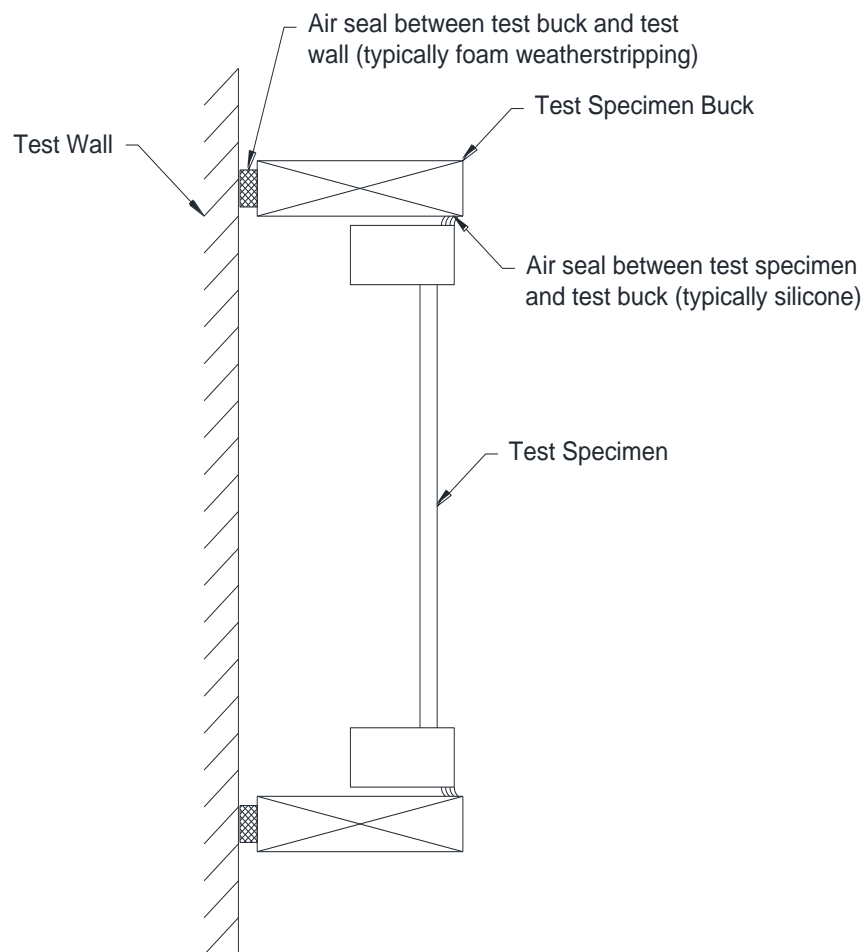
Report No.: J0388.01-301-44 R3

Date: 02/18/19

SECTION 9

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.



SECTION 10

CONCLUSION

The specimen tested successfully met the performance requirements for a **Class CW – PG30:**
Size Tested 2400 x 2111 (94-1/2 x 83-1/8) – Type SD rating.



Total Quality. Assured.

2524 E. Jensen Ave
Fresno, California 93706

Telephone: 559-233-8705
Facsimile: 717-764-4129
www.intertek.com/building

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Date: 02/18/19


SECTION 11

DRAWINGS

The test specimen drawings have been reviewed by Intertek B&C and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek B&C per the drawings included in this report. Any deviations are documented herein or on the drawings.

Company Name:

Series/Model: 8100 Fixed

 Total Quality. Assured.	Report #: J0388.01-301-44
	Date: 02/04/19
	Verified by: <i>Erick Calhoun</i>

Part #	Part Description	Material	Finish
<u>OX Sash and Frame</u>			
81011	Sash – Top Rail	Aluminum	Painted & Anodized
81021	Sash – Bottom Rail	Aluminum	Painted & Anodized
81031	Sash – Lead Stile	Aluminum	Painted & Anodized
81041	Sash - Exterior Interlocker Large Component	Aluminum	Painted & Anodized
81042	Sash – Exterior Interlocker Small Component	Aluminum	Painted & Anodized
81051	Sash – Interior Interlocker Large Component	Aluminum	Painted & Anodized
81052	Sash – Interior Interlocker Small Component	Aluminum	Painted & Anodized
81211	Frame Head Track	Aluminum – Pour and Debridged	Painted & Anodized
81221	Frame Sill Track	Aluminum – Pour and Debridged	Painted & Anodized
81231	Frame Jamb Track	Aluminum – Pour and Debridged	Painted & Anodized
8199	Panel Connector	Aluminum – Pour and Debridged	Painted & Anodized
8196	Track Clip	Aluminum	Painted & Anodized
8113	Sill Filler	Aluminum	Painted & Anodized
8112	Track Filler	Aluminum	Painted & Anodized
Glazing Boot	Gasket	Vinyl	
Thermal Strut	Thermal Strut	Glass Filled Nylon	
Roller Track	Track	Stainless Steel	
Foam Insulation	Foam insert	Extruded Polystyrene (3 lb density)	
Weatherstrip	Weatherstrip	Pile with vinyl fin	

TEST	THICKNESS	CLASS	CORREL. DESCRIPTION	PRINT REFERENCE
1) TWIST: 1/4" / 1.3" MAX.		A	EXPOSED SURFACE FINISH	REF
2) FLATNESS: .004" / 1"		B	EXPOSED SURFACE FINISH	REF
3) STRAIGHTNESS: .002" / 1"		C	EXPOSED SURFACE FINISH	REF
4) CROSS HATCH DEFLECTION LOCATION		D	EXPOSED SURFACE FINISH	REF
5) EXPOSED QUALITY CHECK		E	EXPOSED SURFACE FINISH	REF

NO CERTIFICATION REQUIRED

BEARING STREAKS IN THIS AREA
ARE NOT CAUSE FOR REJECTION

C-63968

sapa:

7933 NE 21st Ave
Portland, OR 97211-0263
(503) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

PART NAME: BOTTOM STYLE

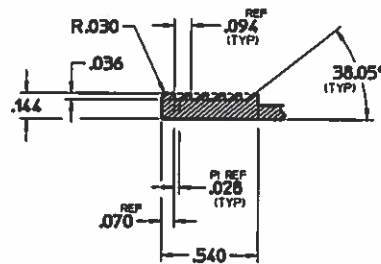
PART NO

DATE 1-17-2018

C-63968

IDENTIFY FUNCTIONAL DIMENSION ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED

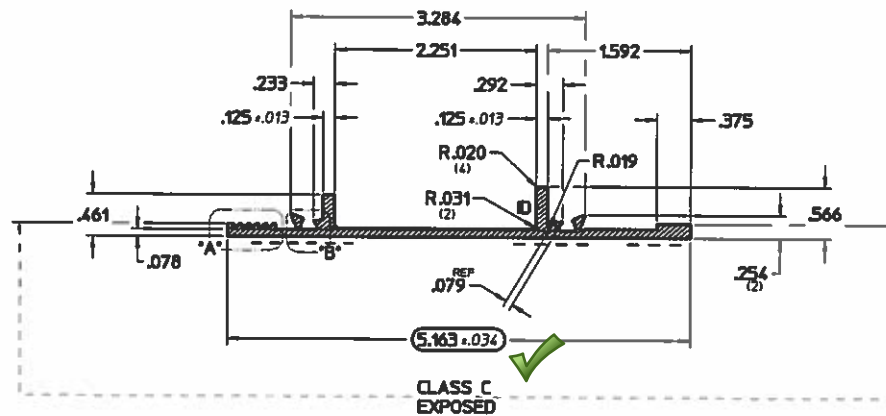
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*** REDUCED DRAWING ***



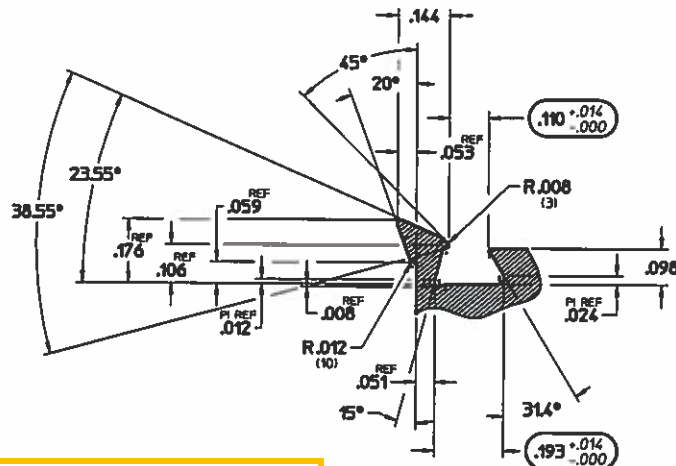
DETAIL 'A' 2 X SIZE

NOT STRUTTED BY HYDRO

----- RUN-OUT -----



ACTUAL SIZE



DETAIL 'B' 4 X SIZE
(SIMILAR 2 PLACES)

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UNITED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION.
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APPROVED BY: DATE

Joe Fort 1/22/18

Part Name: 8100 Bottom Rail
Part #: 81021

intertek
Total Quality. Assured.

Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Calhoun*

(T) TWIST: 1/2° / 1', 5° MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
(F) FLATNESS: .004" / 1'	A	EXPOSED, 2nd PROCESS REVD	Not Applicable
(S) STRAIGHTNESS: .0125" / 1'	B	EXPOSED SURFACE FINISHED	EXPOSED
# CROSS HATCH INSPECTION LOCATION	C	EXPOSED SURFACE MILL	Default, excl. R.O.
X > DENOTES QUALITY DIMENSION CHECK	D	NOT EXPOSED	RA
REFERENCE COSMETIC STANDARDS OAR-034, -035 & -036			
NO CERTIFICATION REQUIRED			

DIE NUMBER
B-63969
DRAWING NUMBER

sapa:

7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME
PART NAME **HEAD STYLE**
PART NO
DATE **1-17-2018**

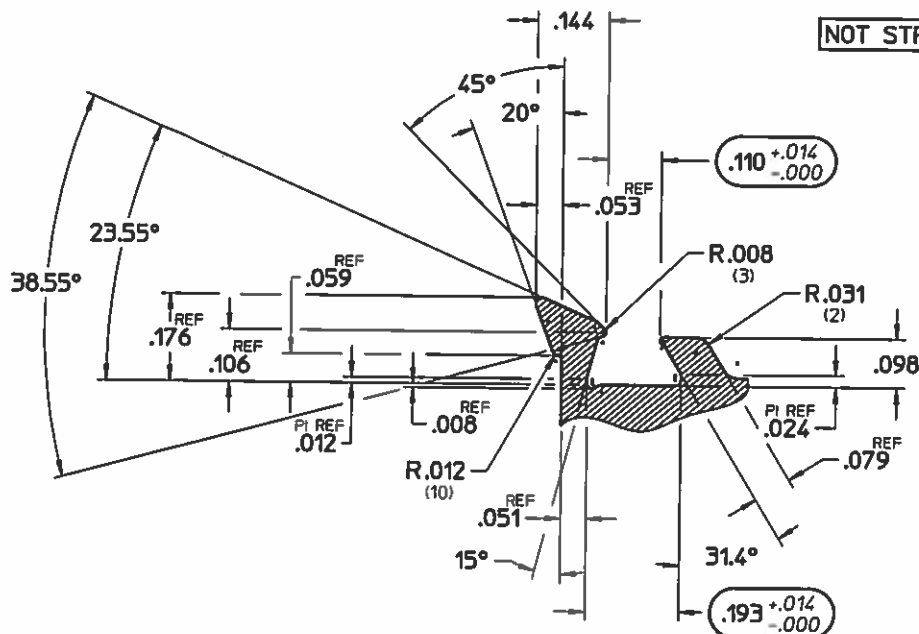
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B-63969

DRAWING NUMBER

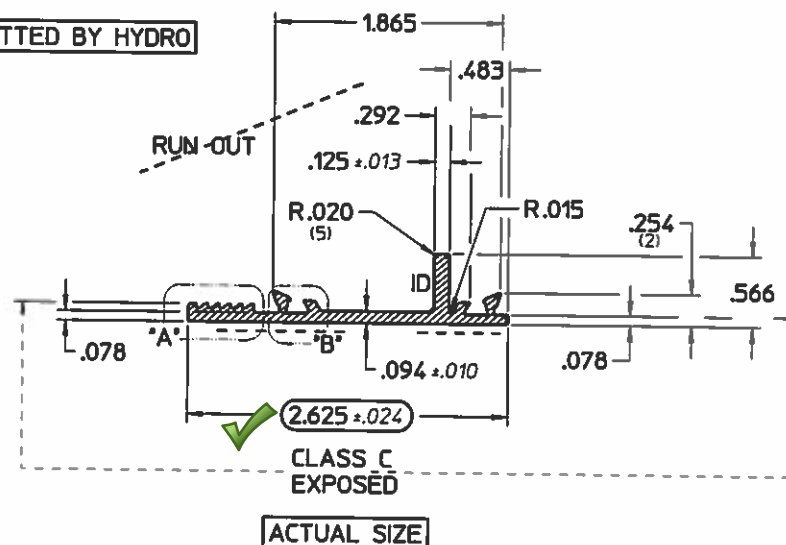
DENOTES FUNCTIONAL DIMENSION ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.O.S. 2008 US CUSTOMARY UNITS EDITION

BEARING STREAKS IN THIS AREA
ARE NOT CAUSE FOR REJECTION

ID = Sapa Extrusions I.D. MARK: .015 R x .015 DEEP U.O.S. TYP WALL U.O.S: .010 TYP RAD U.O.S: .010



DETAIL "B" 4 X SIZE
(SIMILAR 2 PLACES)



DETAIL "A" 2 X SIZE

Part Name: 8100 Top Rail
Part Number: 81011

1/22/18
THE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (ID). ANY CHANGES MADE TO THIS PRINT WILL REQUIRE IT TO BE RE-SUBMITTED FOR YOUR APPROVAL. ELECTRONICALLY CHANGING OR RENDERING ANY DIMENSION UNREADABLE WILL VOID THAT CHANGE TO THE DESIGN. OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION. SAPA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY. HAVING READ THE ABOVE STATEMENT I HEREBY APPROVE THIS DESIGN AS SUBMITTED AND AGREE TO SAPA EXTRUSIONS' LIMITATIONS OF LIABILITIES AND WARRANTIES STATED ELSEWHERE ON THIS PRINT.

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Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Calderin*

(1) TWIST: $1/4^\circ$ / 1' 3" MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
(2) FLATNESS: $.006^\circ$ / 1'	A	EXPOSED SURFACE FINISH	NOT APPLICABLE
(3) STRAIGHTNESS: $.002^\circ$ / 1'	B	EXPOSED SURFACE FINISH	EXPOSED
(4) CROSS HATCH DEFLECTION LOCATION	C	EXPOSED SURFACE FINISH	DESIGN AND N/A
(5) DEFECTS QUALITY CHECK	D	NOT APPLICABLE	NOT APPLICABLE
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		NO CERTIFICATION REQUIRED	

DE NUMBER
C-63976
DRAWING NUMBER

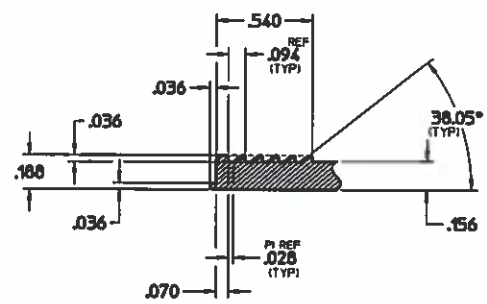
sapa:
7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM
CUSTOMER NAME
PART NAME **INTERLOCK A**
PART NO
DATE **1-17-2018**

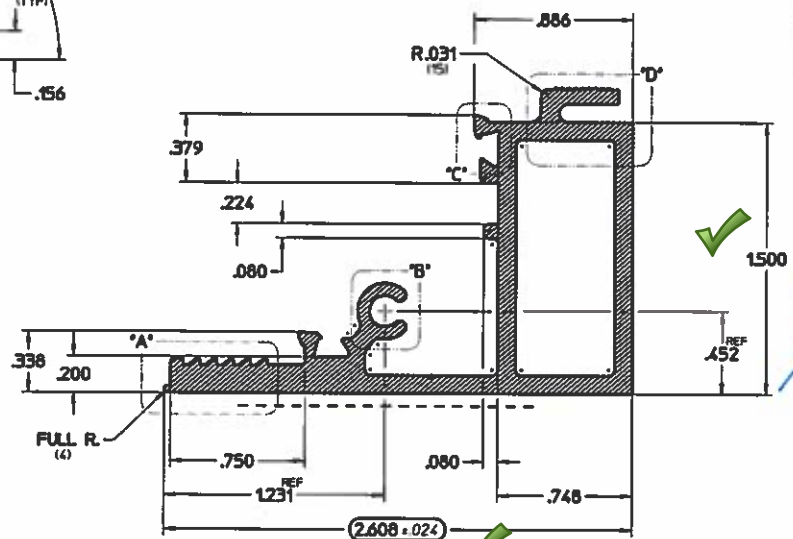
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AS PER	12,961
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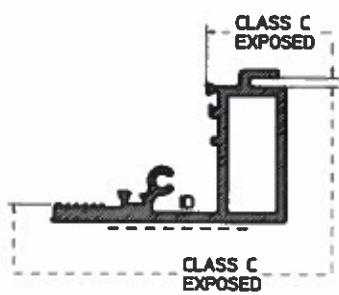
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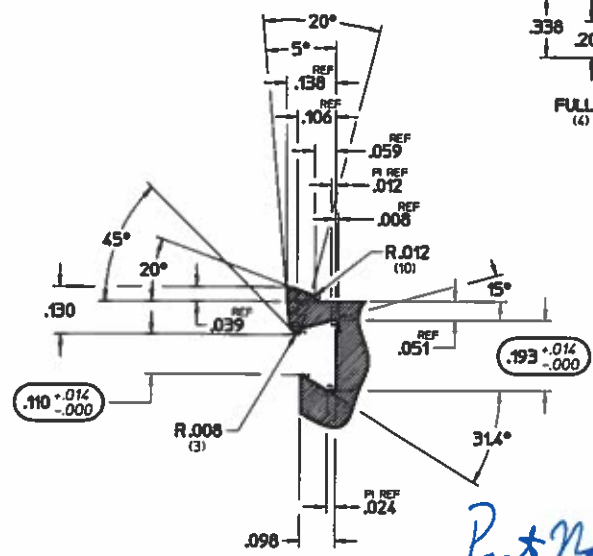
DETAIL 'A' 2 X SIZE



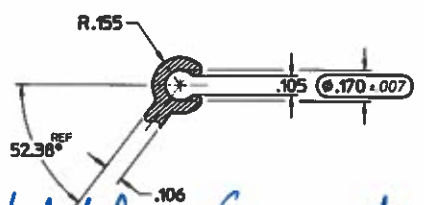
2 X SIZE



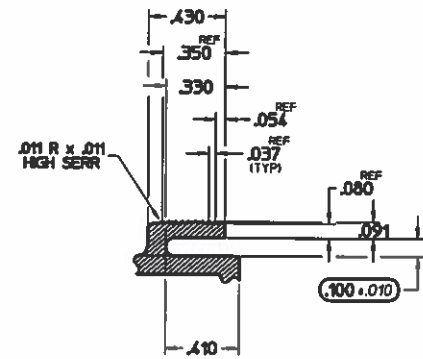
ACTUAL SIZE



DETAIL 'C' 4 X SIZE
(SIMILAR 2 PLACES)



DETAIL 'B' 2 X SIZE



DETAIL 'D' 2 X SIZE

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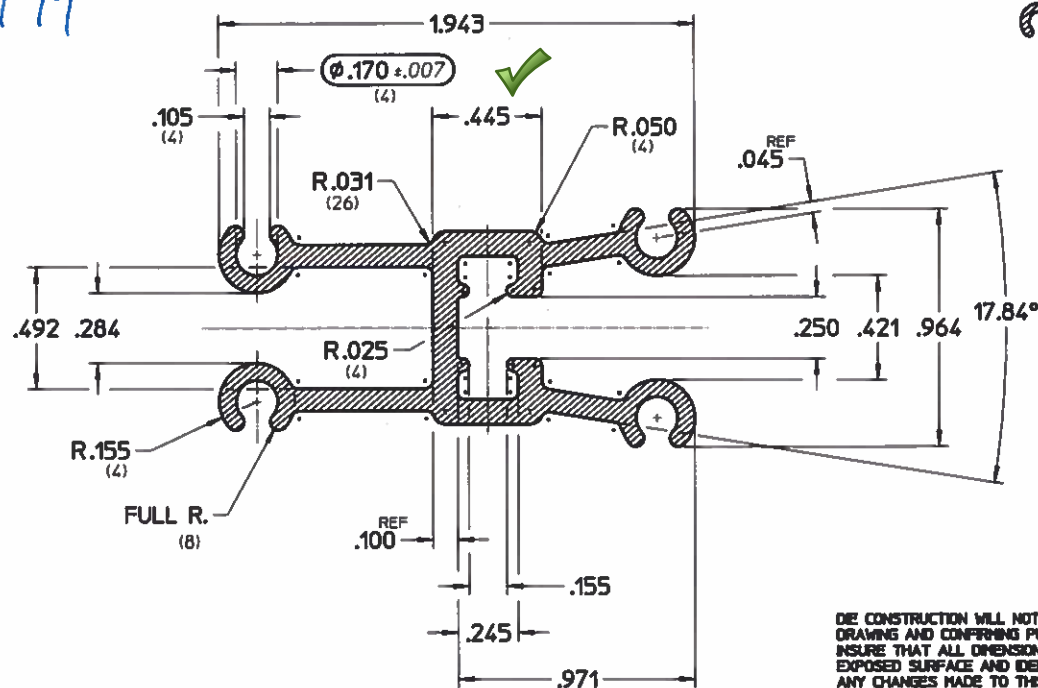
Part Name: Exterior Interlock Large Component
Part Number: 81041

(T) TWIST: 1/2" / 1', 5° MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE	sapa: 7933 NE 21st Ave Portland, OR 97211-0263 (800) 547-0790	ALL WEATHER ARCHITECTURAL ALUMINUM		DIE NUMBER B-63980 DRAWING NUMBER B-63980
(F) FLATNESS: .004" / 1'	A	EXPOSED, 2nd PROCESS RE-010	Not Applicable		CUSTOMER NAME		
(S) STRAIGHTNESS: .0125" / 1'	B	EXPOSED SURFACE FINISHED	EXPOSED		PART NAME TIE SPIGOT		
# CROSS HATCH INSPECTION LOCATION	C	EXPOSED SURFACE MILL	Default, excl. R.O.		PART NO		
[X] > DENOTES QUALITY DIMENSION CHECK	D	NOT EXPOSED	RA		DATE 1-17-2018		
REFERENCE COSMETIC STANDARDS DAR-034, -035 & -036				ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.S. (2013 US CUSTOMARY UNITS EDITION)			
NO CERTIFICATION REQUIRED				ID = Sapa Extrusions I.D. MARK .015 R. x .015 DEEP U.O.S. TYP WALL U.O.S.: .090 ±.010 TYP RAD U.O.S.: ----			

Part Name: 8100 Panel Connector

NO EXPOSED CLASS D

Part Number: 8199



2 X SIZE

intertek
Total Quality. Assured.

Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Calhoun*

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DATE

[Signature] 1/22/18

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(T) TWIST: 1/2" / 1'; 5" MAX. (F) FLATNESS: .006" / 1" (S) STRAIGHTNESS: .0125" / 1" # CROSS HATCH INSPECTION LOCATION X DENOTES QUALITY DIMENSION CHECK	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th>CLASS</th> <th>COSMETIC DESCRIPTION</th> <th>PRINT REFERENCE</th> </tr> <tr> <td>A</td> <td>EXPOSED, 2nd PROCESS REQ'D</td> <td>Not Applicable</td> </tr> <tr> <td>B</td> <td>EXPOSED SURFACE FINISHED</td> <td>EXPOSED</td> </tr> <tr> <td>C</td> <td>EXPOSED SURFACE MILL</td> <td>Default, excl. R.O.</td> </tr> <tr> <td>D</td> <td>NOT EXPOSED</td> <td>R.O.</td> </tr> </table> REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036 NO CERTIFICATION REQUIRED	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE	A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable	B	EXPOSED SURFACE FINISHED	EXPOSED	C	EXPOSED SURFACE MILL	Default, excl. R.O.	D	NOT EXPOSED	R.O.	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th>DIE NUMBER</th> <th>DRAWING NUMBER</th> </tr> <tr> <td>B-63978</td> <td>B-63978</td> </tr> </table>	DIE NUMBER	DRAWING NUMBER	B-63978	B-63978	<h2 style="margin: 0;">sapa:</h2> <p>7933 NE 21st Ave Portland, OR 97211-0263 (800) 547-0790</p>	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2">ALL WEATHER ARCHITECTURAL ALUMINUM</th> </tr> <tr> <td>CUSTOMER NAME</td> <td>B</td> </tr> <tr> <td>PART NAME</td> <td>8100 JAMB TRACK</td> </tr> <tr> <td>PART NO</td> <td>81231</td> </tr> <tr> <td>DATE</td> <td>2-1-2018</td> </tr> </table>	ALL WEATHER ARCHITECTURAL ALUMINUM		CUSTOMER NAME	B	PART NAME	8100 JAMB TRACK	PART NO	81231	DATE	2-1-2018	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th>DIE NUMBER</th> </tr> <tr> <td>B-63978</td> </tr> </table>	DIE NUMBER	B-63978
CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE																																		
A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable																																		
B	EXPOSED SURFACE FINISHED	EXPOSED																																		
C	EXPOSED SURFACE MILL	Default, excl. R.O.																																		
D	NOT EXPOSED	R.O.																																		
DIE NUMBER	DRAWING NUMBER																																			
B-63978	B-63978																																			
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PART NO	81231																																			
DATE	2-1-2018																																			
DIE NUMBER																																				
B-63978																																				
ID = Sapa Extrusions I.D. MARK: .015 R. x .015 DEEP U.D.S. TYP WALL U.D.S.: .070 ±.010 TYP RAD U.D.S.: .010					ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.D.S. (2013 US CUSTOMARY UNITS EDITION)																															

DETAIL "A" 2 X SIZE

DETAIL "C" 2 X SIZE

DETAIL "B" 2 X SIZE

DETAIL "D" 4 X SIZE
(SIMILAR 2 PLACES)

DIE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (ID). ANY CHANGES MADE TO THIS PRINT WILL REQUIRE IT TO BE RE-SUBMITTED FOR YOUR APPROVAL. ELECTRONICALLY CHANGING, OR RENDERING ANY DIMENSION UNREADABLE WILL VOID THAT CHANGE TO THE DESIGN. OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION. SAPA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY. HAVING READ THE ABOVE STATEMENT I HEREBY APPROVE THIS DESIGN AS SUBMITTED AND AGREE TO SAPA EXTRUSIONS' LIMITATIONS OF LIABILITIES AND WARRANTIES STATED ELSEWHERE ON THIS PRINT.

APPROVED BY _____ DATE _____

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CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
B	EXPOSED SURFACE FINISHED	EXPOSED
C	EXPOSED SURFACE MILL	Default, excl. R.O.
D	NOT EXPOSED	R.O.
REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036		
NO CERTIFICATION REQUIRED		

DIE NUMBER	C-63990	TRADING NUMBER
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sapa:

7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME _____ C

PART NAME	8100 SILL TRACK
-----------	-----------------

C	PART NO	81221
---	---------	-------

DATE	2-1-2018
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ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.S. (2013 US CUSTOMARY UNITS EDITION)

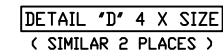
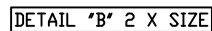
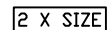
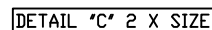
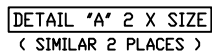
TD = Sapa Extrusions I.D. MARK: .015 R. x .015 DEEP U.D.S.

TYP WALL U.D.S.: ----

TYP RAD U.D.S.: .010

*** REDUCED DRAWING ***

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	DRAWING NUMBER	
	LB/FT	.582
	AREA	.485
	PERI	13.313
	ADJ PERI	----
	CCFAC	2.2 23
	TYPE	SOLID
	TIE VOL	YB.146
	DRN BY	TEG
	ALLDY	6063-T6
	SOLD BY	
	BACKER	
	ROLSTER	
	PRESS	7
	R/HOLES	43 2
	FINISH CODE	P2X
EXP PT	11.266	



DIE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (I.D.). ANY CHANGES MADE TO THIS PRINT WILL REQUIRE IT TO BE RE-SUBMITTED FOR YOUR APPROVAL. DIMENSIONS WILL BE ADDED TO THE DESIGN IF ANY DIMENSION UNREADABLE WILL VOIDLY THAT CHANGE TO THE DESIGN. OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION. SNA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY. HAVING READ THE ABOVE STATEMENT I HEREBY APPROVE THIS DESIGN AS SHOWN AND ACCEPTED. ANY DISCREPANCIES, UNLABLES, UNRELIABILITIES, AND WARRANTIES STATED ELSEWHERE ON THIS PRINT,

APPROVED BY _____ DATE _____

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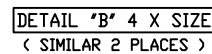
DIE NUMBER	C-63989
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7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

CUSTOMER NAME	C
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ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.S. (2013 US CUSTOMARY UNITS EDITION)

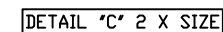
DIE NUMBER	
C-63989	
DRAWING NUMBER	
LB/FT	.325
AREA	.271
PERI	5.303
DJ PERI	----
CCIFAC	1.5 16
TYPE	SOIL ID

[illegible]

Technical drawing of a mechanical part with the following dimensions and labels:

- Overall width: 1.231
- Overall height: .493
- Internal width: .750
- Internal height: .452
- Bottom width: 1.053
- Bottom height: .129
- Overall bottom width: 1.348
- Labels: 'A', 'B', 'C', 'REF', 'RE'

2 X SIZE



DIE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED
 DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO
 INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE
 EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (I.D.).
 ANY CHANGE MADE TO THIS PRINT WILL REQUIRE IT TO BE LIMITED
 TO THE APPROVAL OF THE DESIGN ENGINEERING OR RENDERING OF THE
 DIMENSION UNRECOVERABLE WILL VOID THAT DESIGN TO THE DESIGN.
 OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION.
 SAPA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY.
 HAVING REVIEWED THE ABOVE AND AGREEING TO THE DESIGN AS
 SUBMITTED AND AGREE TO SAPA EXTRUSIONS' LIMITATIONS OF
 LIABILITIES AND WARRANTIES STATED ELSEWHERE ON THIS PRINT.

APPROVED BY _____ DATE _____

Verified by: *Erick Caldera*

(K) TWIST: 1/4" / 1' 3" MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
(F) FLATNESS: .006" / 1'	A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
(S) STRAIGHTNESS: .0125" / 1'	B	EXPOSED SURFACE FINISHED	EXPOSED
# CROSS HATCH INSPECTION LOCATION	C	EXPOSED SURFACE MILL	Default, excl. R.D.
[X] > DENOTES QUALITY DIMENSION CHECK	D	NOT EXPOSED	R.D.
		REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036	
		NO CERTIFICATION REQUIRED	

DIE NUMBER
C-63988

sapa:
7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME
PART NAME 8100 INTERIOR INTERLOCK LARGE COMPONENT
PART NO 81051
DATE 2-1-2018

DIE NUMBER
C-63988
DRAWING NUMBER
LB/FT 1.080
AREA .900
PERI 17.236
ADJ PERI 13.621
COFAC 3.3 16
TYPE HOLLOW

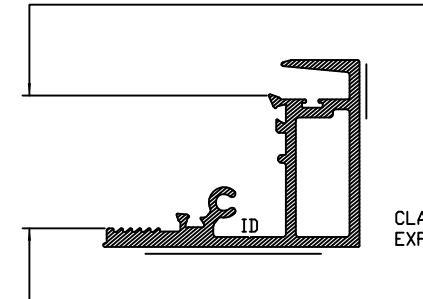
ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.S. (2013 US CUSTOMARY UNITS EDITION)

ID = Sapa Extrusions I.D. MARK: .015 R. x .015 DEEP U.D.S. TYP WALL U.D.S.: .100 ±.010 TYP RAD U.D.S.: .010

*** REDUCED DRAWING ***

BEARING STREAKS IN THIS AREA
ARE NOT CAUSE FOR REJECTION

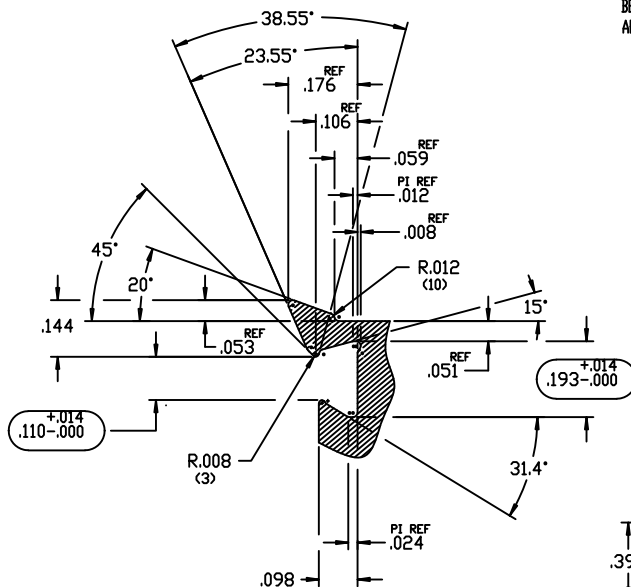
NOT STRUTTED BY HYDRO



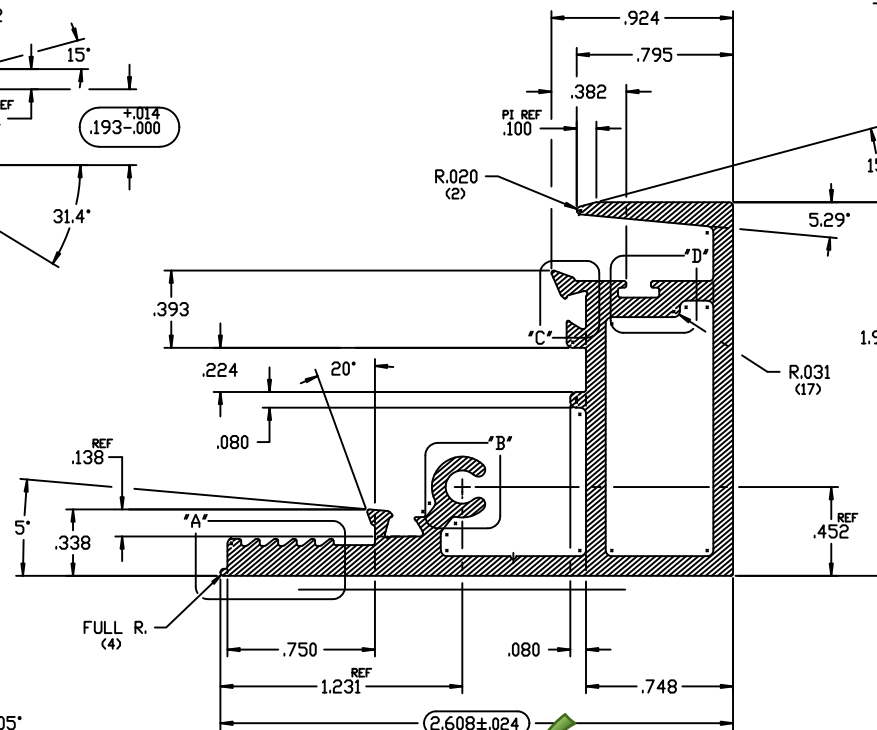
CLASS C
EXPOSED

RUN BUT

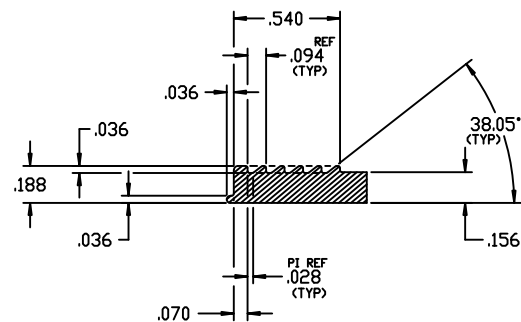
ACTUAL SIZE



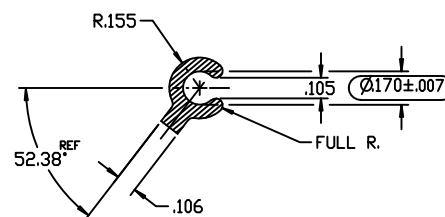
DETAIL "C" 4 X SIZE
(SIMILAR 2 PLACES)



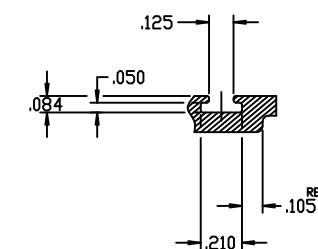
2 X SIZE



DETAIL "A" 2 X SIZE



DETAIL "B" 2 X SIZE



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APPROVED BY _____ DATE _____

intertek
Total Quality. Assured.

Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Calben*

DETAIL "F" 2 X SIZE

(K) TWIST: 1" / 1' 7" MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
(F) FLATNESS: .004" / 1"	A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
(S) STRAIGHTNESS: .050" / 1'	B	EXPOSED SURFACE FINISHED	EXPOSED
# CROSS HATCH INSPECTION LOCATION	C	EXPOSED SURFACE MILL	Default, excl. R.D.
[X] > DENOTES QUALITY DIMENSION CHECK	D	NOT EXPOSED	REF
		REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036	
		NO CERTIFICATION REQUIRED	

DIE NUMBER
C-63977

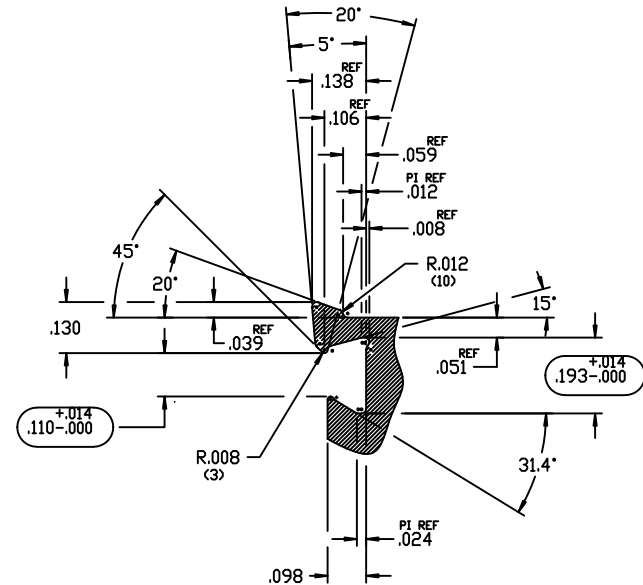
sapa:
7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME
C
PART NAME 8100 EXTERIOR INTERLOCK SMALL COMPONENT
PART NO 81042
DATE 1-31-2018

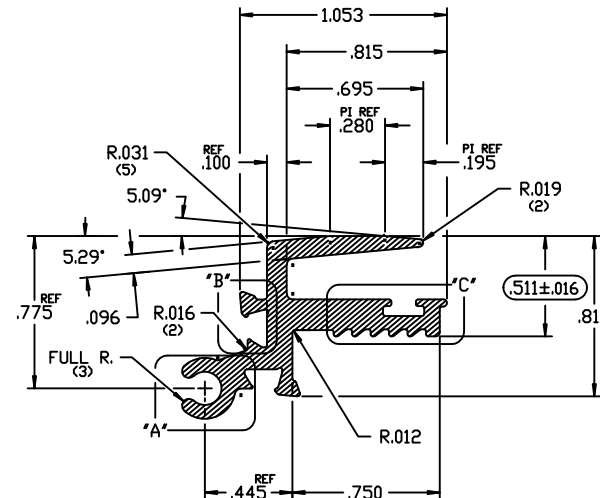
DIE NUMBER
C-63977
DRAWING NUMBER
LB/FT .404
AREA .337
PERI 7.318
ADJ PERI
COFAC 1.5 | 18
TYPE SOLID
TIE VOL
DRN BY TEG
ALLOY 6063-T6
SOLD BY
BACKER
BOLSTER
PRESS 7
RR/HOLES 41 | 3
FINISH CODE P2X
EXP PI 2.352

ID = Sapa Extrusions I.D. MARK: .015 R. x .015 DEEP U.D.S. TYP WALL U.D.S.: ---- TYP RAD U.D.S.: .010
*** REDUCED DRAWING ***

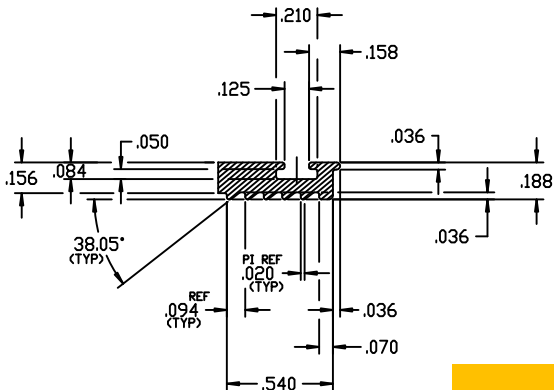


DETAIL 'A' 4 X SIZE
(SIMILAR 2 PLACES)

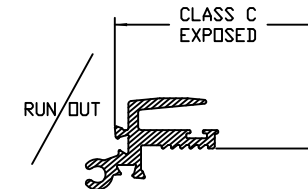
NOT STRUTTED BY HYDRO



2 X SIZE



DETAIL 'B' 2 X SIZE



DETAIL 'C' 2 X SIZE

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APPROVED BY _____ DATE _____

intertek
Total Quality. Assured.

Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Callen*

(T) TWIST: 1/4" / 1' 3" MAX.	CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
(F) FLATNESS: .006" / 1"	A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
(S) STRAIGHTNESS: .0125" / 1'	B	EXPOSED SURFACE FINISHED	EXPOSED
# CROSS HATCH INSPECTION LOCATION	C	EXPOSED SURFACE MILL	Default, excl. R.D.
[X] > DENOTES QUALITY DIMENSION CHECK	D	NOT EXPOSED	R.D.
		REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036	
		NO CERTIFICATION REQUIRED	

DIE NUMBER
C-63979

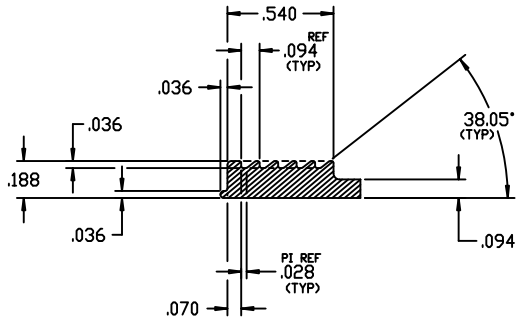
sapa:
7933 NE 21st Ave
Portland, OR 97211-0263
(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME
PART NAME 8100 HEAD STILE
PART NO 81031
DATE 2-1-2018

DIE NUMBER
C-63979
DRAWING NUMBER
LB/FT .677
AREA .564
PERI 14.109
ADJ PERI 10.662
COFAC 3.2 | 21
TYPE HOLLOW

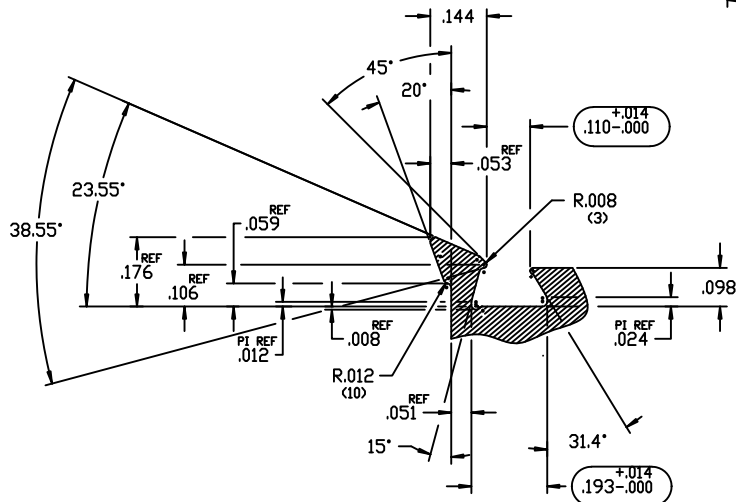
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*** REDUCED DRAWING ***



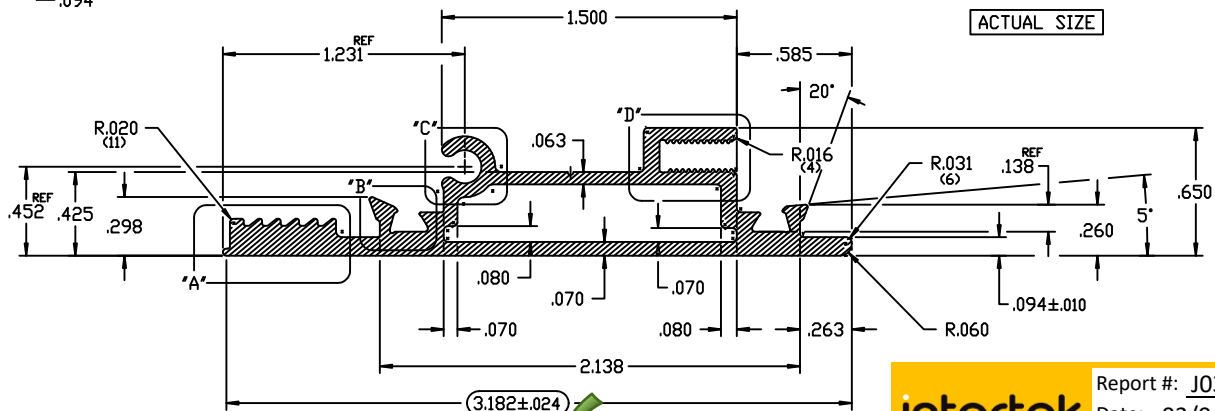
DETAIL "A" 2 X SIZE

DIE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (ID). ANY CHANGES MADE TO THIS PRINT WILL REQUIRE IT TO BE RE-SUBMITTED FOR YOUR APPROVAL. ELECTRONICALLY CHANGING OR RENDERING ANY DIMENSION UNREADABLE WILL VOID THAT CHANGE TO THE DESIGN. OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION. SAPA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY. HAVING READ THE ABOVE STATEMENT I HEREBY APPROVE THIS DESIGN AS SUBMITTED AND AGREE TO SAPA EXTRUSIONS' LIMITATIONS OF LIABILITIES AND WARRANTIES STATED ELSEWHERE ON THIS PRINT.

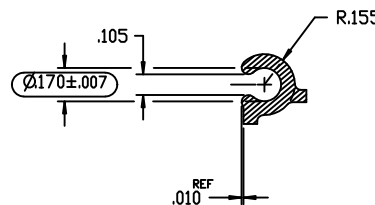
APPROVED BY _____ DATE _____



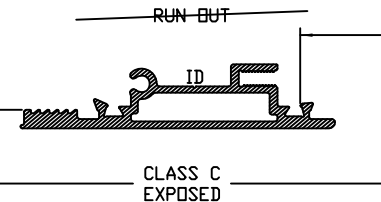
DETAIL "B" 4 X SIZE
(SIMILAR 2 PLACES)



2 X SIZE



DETAIL "C" 2 X SIZE



CLASS C
EXPOSED

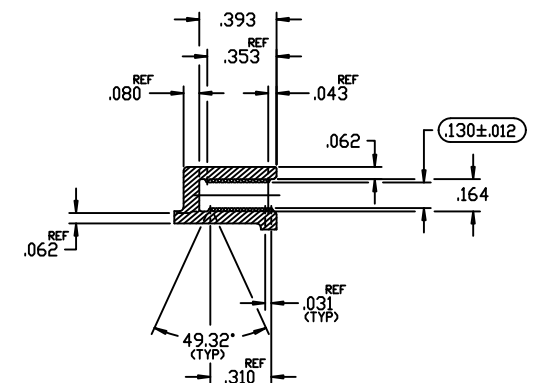
ACTUAL SIZE

intertek
Total Quality. Assured.

Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Callen*



DETAIL "D" 2 X SIZE

REV
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(T) TWIST: 1' / 1'; 7' MAX.

(F) FLATNESS: .004" / 1'

(S) STRAIGHTNESS: .050" / 1'

CROSS HATCH INSPECTION LOCATION

X DENOTES QUALITY DIMENSION CHECK

CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
B	EXPOSED SURFACE FINISHED	EXPOSED
C	EXPOSED SURFACE MILL	Default, excl. R.O.
D	NOT EXPOSED	R.O.
REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036		
NO CERTIFICATION REQUIRED		

DIE NUMBER
DRAWING NUMBER

T-12314

sapa:
Sapa Extrusions TDA
7933 NE 21st Ave Portland, OR 97211
(800) 547-0790

ALL WEATHER ARCHITECTURAL WINDOWS

CUSTOMER NAME

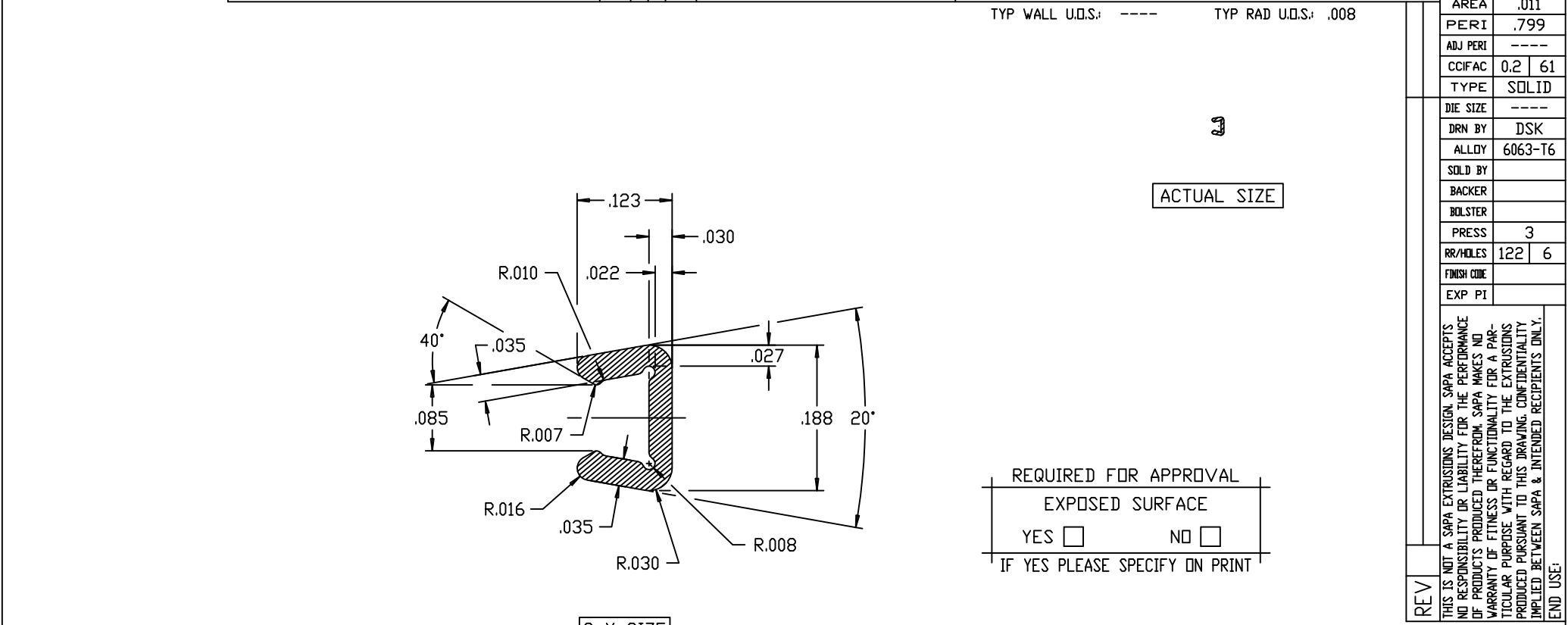
PART NAME SMALL CLIP

PART NO

DATE 3-12-2018

DENOTES FUNCTIONAL DIMENSION

ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.S. (2013 US CUSTOMARY UNITS EDITION)



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Report #: J0388.01-301-44

Date: 02/04/19

Verified by: *Erick Calhoun*

APPROVED BY

DATE

DIE CONSTRUCTION WILL NOT BEGIN PRIOR TO RECEIPT OF AN APPROVED DRAWING AND CONFIRMING PURCHASE ORDER. PLEASE CHECK PRINT TO INSURE THAT ALL DIMENSIONS ARE CORRECT AS SHOWN. NOTE THE EXPOSED SURFACE AND IDENTIFICATION MARK TYPE AND LOCATION (ID). ANY CHANGES MADE TO THIS PRINT WILL REQUIRE IT TO BE RE-SUBMITTED FOR YOUR APPROVAL. ELECTRONICALLY CHANGING, OR RENDERING ANY DIMENSION UNREADABLE WILL VOID THAT CHANGE TO THE DESIGN. OMITTED DIMENSIONS WILL BE ADDED AS A REF. DIMENSION. SAPA EXTRUSIONS WILL EXTRUDE AND CHECK TO THIS PRINT ONLY. HAVING READ THE ABOVE STATEMENT I HEREBY APPROVE THIS DESIGN AS SUBMITTED AND AGREE TO SAPA EXTRUSIONS' LIMITATIONS OF LIABILITIES AND WARRANTIES STATED ELSEWHERE ON THIS PRINT.

(T) TWIST: 1' / 1'; 7' MAX.

(F) FLATNESS: .004" / 1'

(S) STRAIGHTNESS: .0125" / 1'

CROSS HATCH INSPECTION LOCATION

X DENOTES QUALITY DIMENSION CHECK

CLASS	COSMETIC DESCRIPTION	PRINT REFERENCE
A	EXPOSED, 2nd PROCESS REQ'D	Not Applicable
B	EXPOSED SURFACE FINISHED	EXPOSED
C	EXPOSED SURFACE MILL	Default, excl. R.O.
D	NOT EXPOSED	R.O.

REFERENCE COSMETIC STANDARDS QAR-034, -035 & -036

NO CERTIFICATION REQUIRED

DIE NUMBER

DRAWING NUMBER

T-12310

sapa:

Sapa Extrusions TDA

7933 NE 21st Ave Portland, OR 97211

(800) 547-0790

ALL WEATHER ARCHITECTURAL ALUMINUM

CUSTOMER NAME

PART NAME 8100 SILL FILLER

PART NO 8113

DATE 3-7-2018

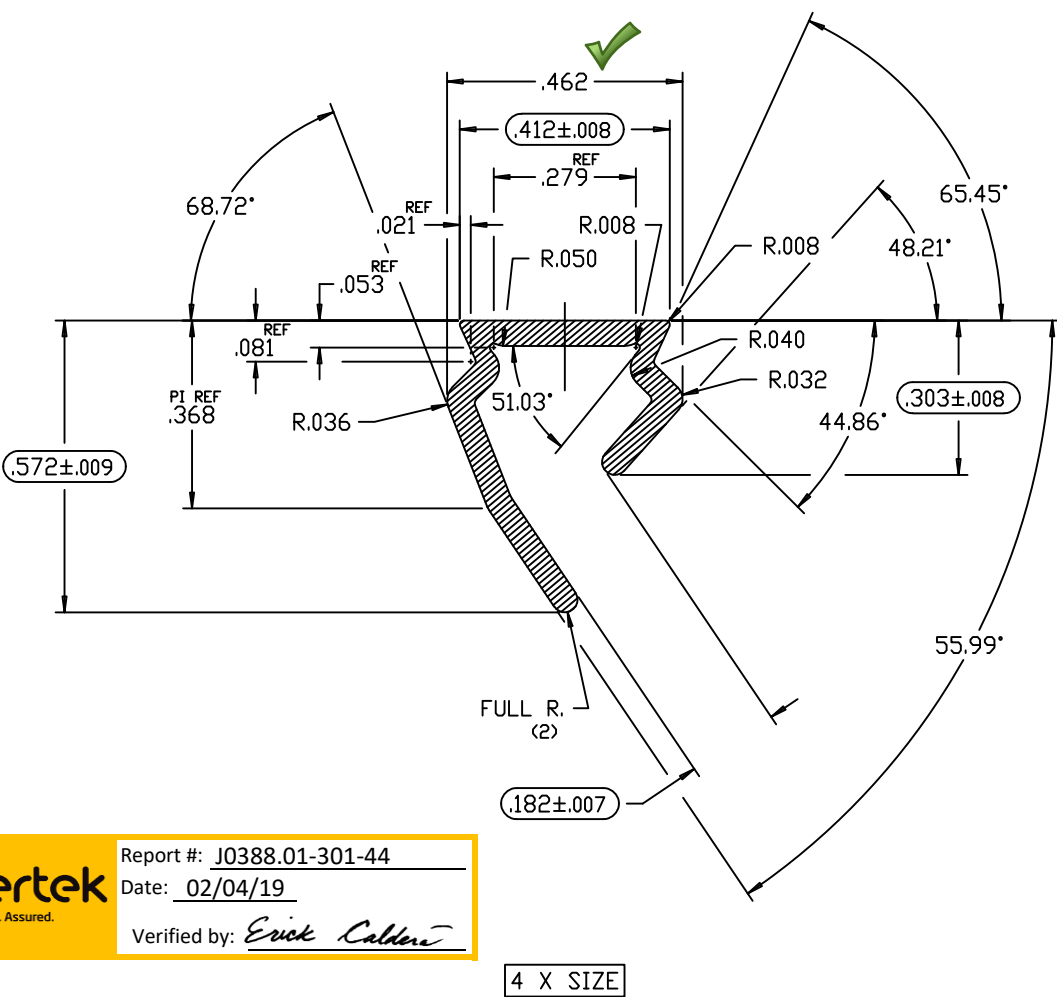
DENOTES FUNCTIONAL DIMENSION

ALUMINUM ASSOCIATION STANDARD TOLERANCES APPLY U.O.S. (2013 US CUSTOMARY UNITS EDITION)

TYP WALL U.O.S.: .050

TYP RAD U.O.S.: .010

LB/FT	.077
AREA	.064
PERI	2.696
ADJ PERI	----
CCIFAC	0.7 35
TYPE	SOLID
DIE SIZE	----
DRN BY	DSK
ALLOY	6063-T6
SOLD BY	
BACKER	
BOLSTER	
PRESS	4,5
RR/HOLES	41 6
FINISH CODE	----
EXP PI	.583



intertek

Total Quality. Assured.

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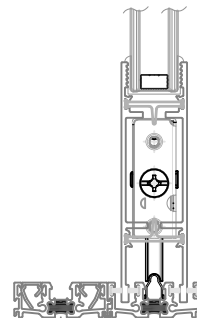
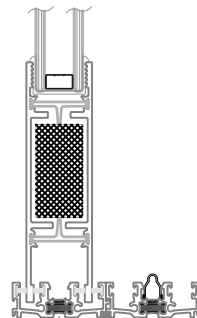
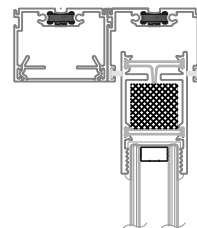
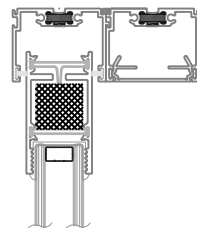
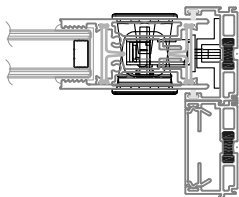
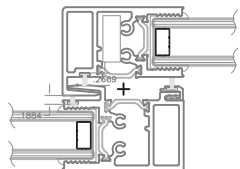
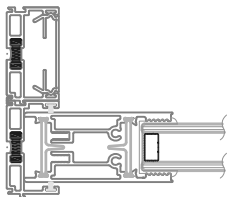
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APPROVED BY _____ DATE _____

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2524 E. Jensen Ave
Fresno, California 93706

Telephone: 559-233-8705
Facsimile: 717-764-4129
www.intertek.com/building

TEST REPORT FOR ALL WEATHER ARCHITECTURAL ALUMINUM

Report No.: J0388.01-301-44 R3

Date: 02/18/19

SECTION 12

REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	02/18/19	N/A	Original Report Issue
1	05/06/19	2,3	Updated report to 2011 AAMA standard
2	05/10/19	2	Updated report to 2011 AAMA standard
3	07/11/19	6	Changed description of spacer from stainless steel to TPS