

MONTGOMERY COUNTY HISTORIC PRESERVATION COMMISSION
STAFF REPORT

Address: 6807 Westmoreland Ave., Takoma Park **Meeting Date:** 6/13/18

Resource: Non-Contributing Resource
Takoma Park Historic District **Report Date:** 6/6/18

Applicant: Loretta Kelly **Public Notice:** 5/30/18

Review: HAWP **Tax Credit:** n/a

Case Number: 37/03-18DD **Staff:** Dan Bruechert

Proposal: Window Replacement

RECOMMENDATION

Staff recommends that the Historic Preservation Commission approve the HAWP application.

PROPERTY DESCRIPTION

SIGNIFICANCE: Non-Contributing Resource to the Takoma Park Historic District
STYLE: Ranch
DATE: c.1913

The subject property is a heavily modified two-story side gable house. The house is clad in Hardi siding, with vinyl one-over-one sash windows (Staff believes that these windows were replaced c.2000, but has been unable to locate the Staff report for this HAWP). The windows at the basement level are wood awning and sash windows in various states of degradation.



PROPOSAL

The applicant proposes to replace six basement windows with replacement vinyl windows and a square window on the left side of the house.

APPLICABLE GUIDELINES

When reviewing alterations and additions for new construction to Non-Contributing Resources within the Takoma Park Historic District, decisions are guided by the Takoma Park Historic District Design Guidelines (Design Guidelines) and Montgomery County Code Chapter 24A (Chapter 24A).

Takoma Park Historic District Design Guidelines

There are two very general, broad planning and design concepts which apply to all categories. These are:

The design review emphasis will be restricted to changes that are at all visible from the public right-of-way, irrespective of landscaping or vegetation (it is expected that the majority of new additions will be reviewed for their impact on the overall district), and,

The importance of assuring that additions and other changes to existing structures act to reinforce and continue existing streetscape, landscape, and building patterns rather than to impair the character of the district.

Most Alterations and additions to Non-Contributing/Out-of-Period Resources should be approved as a matter of course. The only exceptions would be major additions and alterations to the scale and massing of Non-Contributing/Out-of-Period Resources which affect the

surrounding streetscape and/or landscape and could impair the character of the historic district as a whole.

Montgomery County Code, Chapter 24A Historic Resources Preservation

(b) The commission shall instruct the director to issue a permit, or issue a permit subject to such conditions as are found to be necessary to insure conformity with the purposes and requirements of this chapter, if it finds that:

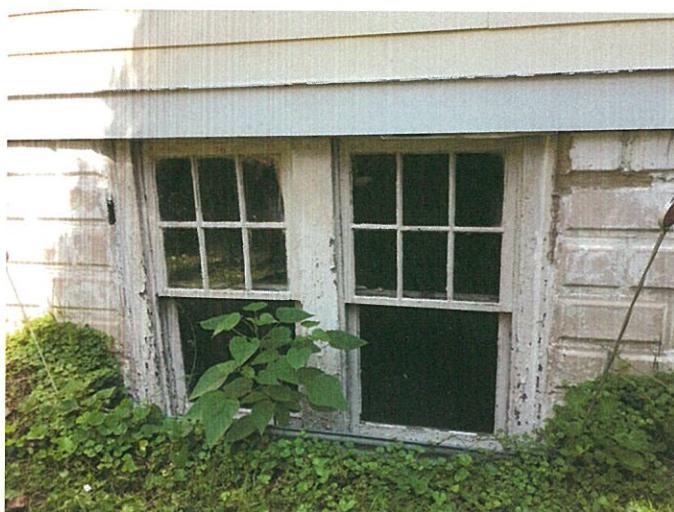
- (1) The proposal will not substantially alter the exterior features of an historic site or historic resource within an historic district; or
- (2) The proposal is compatible in character and nature with the historical, archeological, architectural or cultural features of the historic site or the historic district in which an historic resource is located and would not be detrimental thereto or to the achievement of the purposes of this chapter; or
- (3) The proposal would enhance or aid in the protection, preservation and public or private utilization of the historic site or historic resource located within an historic district in a manner compatible with the historical, archeological, architectural or cultural value of the historic site or historic district in which an historic resource is located; or

STAFF DISCUSSION

The applicant proposes to remove five windows in the basement and one window the left side of the house with Platinum Majestic windows.

Based on Staff's observation at a site visit, the windows in the basement appear to be historic, with the exception of the rear window on the right side, which has been removed and is covered by plywood. Most of the windows show significant signs of degradation and deferred maintenance. Staff observed several rotten members and warping of a number of window frames and jambs. Staff finds that it would be possible through herculean effort to salvage these windows, however, the *Guidelines* for non-contributing resources to the Takoma Park Historic District do not require the retention of these features as they will not affect the scale and massing of the house or affect the surrounding streetscape.





The applicant proposes to remove a single window on the 1st floor of the house. This window is a square casement window on the left side of the house near the street (see below). The existing window is a wood frame with a plexiglass storm. The decorative stained glass is a panel that is installed behind the wood window. Staff supports removal of this window, as it does not appear to be installed in a manner consistent with a historic wood window. The removal of this window will not impact the scale or massing of the non-contributing house and will not have a negative impact on the surrounding streetscape.



Figure 1: The square 1st floor window to be replaced.

The applicant proposes to install Platinum majestic windows to fit the existing window openings. The proposed window is vinyl, which is not typically an appropriate material; however, Staff finds this is an acceptable widow for several reasons. First, this is a non-contributing resource to the Takoma Park Historic District, and changes that don't affect the scale, massing, or surrounding streetscape should be approved as a matter of course. Second, six of the windows are at the basement level, which will have a reduced impact on the visual impact the building has on the streetscape. Third, unlike most vinyl windows, this window will have a finish that is designed to allow it to be painted (Staff has been provided with material samples and will distribute these during the work session prior to the HPC meeting). These windows will not have the shiny appearance of a PVC window that is found to be visually inconsistent in most historic settings. Finally, this window has more depth than many "off the shelf" vinyl windows and though it lacks the profile of a wood window, it is more compatible with this non-contributing resource.

The applicant proposes to replace the double hung windows with double hung windows and will install a hopper window with a dryer vent on the right side (see Circle: _____ for details). The windows on the left side of the house will be fixed picture windows. This configuration is acceptable under the *Guidelines* and Staff recommends approval of this HAWP.

STAFF RECOMMENDATIONS

Staff recommends that the Commission **approve** the HAWP application;

and with the general condition applicable to all Historic Area Work Permits that **the applicant will present 3 permit sets of drawings to HPC staff for review and stamping prior to submission for permits (if applicable)**. After issuance of the Montgomery County Department of Permitting Services (DPS) permit, the applicant will arrange for a field inspection by calling the DPS Field Services Office at 240-777-6370 prior to commencement of work and not more than two weeks following completion of work.



HISTORIC PRESERVATION COMMISSION

301/563-3400

APPLICATION FOR HISTORIC AREA WORK PERMIT

Contact Email: Loretta.Kelley@Fanitull.org Contact Person: Loretta Kelley
 Daytime Phone No.: 301 270 4925

Tax Account No.: 01075944

Name of Property Owner: La Greca Kelley Living Trust Daytime Phone No.: 301-270-4925

Address: 6807 Westmoreland Ave. Takoma Park MD 20912

Street Number _____ City _____ State _____ Zip Code _____

Contractor: American Home Center Inc. Phone No.: 301-220-1144

Contractor Registration No.: MHIC 37401

Agent for Owner: NAT Daytime Phone No.: NA

LOCATION OF BUILDING/PREMISE

House Number: 6807 Street: Westmoreland Ave.

Town/City: Takoma Park Nearest Cross Street: Walnut and Elm

Lot: 11 Block: 18 Subdivision: 025

Lot: 53671 Folio: 191-192 Parcel: 1301075944

PART ONE: TYPE OF PERMIT ACTION AND USE

1A. CHECK ALL APPLICABLE:

- | | | | | | | | | |
|------------------------------------|---|---|--|------------------------------------|--|---|-------------------------------|-------------------------------|
| <input type="checkbox"/> Construct | <input type="checkbox"/> Extend | <input type="checkbox"/> Alter/Renovate | <input type="checkbox"/> A/C | <input type="checkbox"/> Slab | <input type="checkbox"/> Room Addition | <input type="checkbox"/> Porch | <input type="checkbox"/> Deck | <input type="checkbox"/> Shed |
| <input type="checkbox"/> Move | <input checked="" type="checkbox"/> Install | <input type="checkbox"/> Wreck/Replace | <input type="checkbox"/> Solar | <input type="checkbox"/> Fireplace | <input type="checkbox"/> Woodburning Stove | <input checked="" type="checkbox"/> Single Family | | |
| <input type="checkbox"/> Revision | <input type="checkbox"/> Repair | <input type="checkbox"/> Revocable | <input type="checkbox"/> Fence/Wall (complete Section 4) | | | <input checked="" type="checkbox"/> Other: <u>replace windows</u> | | |

1B. Construction cost estimate: \$ 3,000

1C. If this is a revision of a previously approved active permit, see Permit # _____

CHECK ALL APPLICABLE:

2A. Type of sewage disposal: 01 WSSC 02 Septic 03 Other: _____

2B. Type of water supply: 01 WSSC 02 Well 03 Other: _____

PART THREE: COMPLETE ONLY FOR FENCE/RETAINING WALL

3A. Height _____ feet _____ inches

3B. Indicate whether the fence or retaining wall is to be constructed on one of the following locations:

- On property line/property line Entirely on land of owner On public right of way/assessment

I hereby certify that I have the authority to make the foregoing application, that the application is correct, and that the construction will comply with plans approved by all agencies listed and I hereby acknowledge and accept this to be a condition for the issuance of this permit.

Loretta Kelley

Signature of owner or authorized agent

4/8/18

Date

Approved: _____ For Chairperson, Historic Preservation Commission

Disapproved: _____ Signature: _____ Date: _____

Application/Permit No.: _____ Date Filed: _____ Date Issued: _____

Edit 6/21/99

SEE REVERSE SIDE FOR INSTRUCTIONS

(7)

**THE FOLLOWING ITEMS MUST BE COMPLETED AND THE
REQUIRED DOCUMENTS MUST ACCOMPANY THIS APPLICATION.**

1. WRITTEN DESCRIPTION OF PROJECT

- a. Description of existing structure(s) and environmental setting, including their historical features and significance:

NON-CONTRIBUTING. TWO-STORY SINGLE-FAMILY HOUSE BUILT IN 1913, COMPLETELY RENOVATED AND ENLARGED (GUTTED TO STUDS, NEW SIDING, NEW WINDOW OPENINGS, ADDED FRONT BAY, REAR FAMILY ROOM AND ENCLOSED PORCH) UNDER HAWP PERMIT IN 2001-02. AT TIME OF RENOVATION BASEMENT WINDOWS WERE NOT REPLACED. ADDITIONALLY, ONE SMALL PICTURE WINDOW ON FIRST FLOOR IN STAIRWELL TO SECOND FLOOR WAS NOT REPLACED

- b. General description of project and its effect on the historic resource(s), the environmental setting, and, where applicable, the historic district:

REPLACE SEVEN WINDOWS IN BASEMENT (TWO DOUBLE HUNG, FOUR SMALL PICTURE, ONE LARGE PICTURE), REPLACE ONE SMALL PICTURE WINDOW ON FIRST FLOOR. WINDOWS TO BE WHITE VINYL (IDEAL PLATINUM SERIES 3000) WITH WHITE PVC EXTERIOR CAPPING. NO CHANGES TO BE MADE TO WINDOW OPENING SIZES OR LOCATIONS. NO EFFECT ON THE HISTORIC RESOURCE OR ENVIRONMENTAL SETTING.

2. SITE PLAN

Site and environmental setting, drawn to scale. You may use your plat. Your site plan must include:

- the scale, north arrow, and date;
- dimensions of all existing and proposed structures; and
- site features such as walkways, driveways, fences, ponds, streams, trash dumpsters, mechanical equipment, and landscaping.

3. PLANS AND ELEVATIONS

You must submit 2 copies of plans and elevations in a format no larger than 11" x 17". Plans on 8 1/2" x 11" paper are preferred.

- Schematic construction plans, with marked dimensions, indicating location, size and general type of walls, window and door openings, and other fixed fixtures of both the existing resource(s) and the proposed work.
- Elevations (façades), with marked dimensions, clearly indicating proposed work in relation to existing construction and, when appropriate, context. All materials and fixtures proposed for the exterior must be noted on the elevations drawings. An existing and a proposed elevation drawing of each facade affected by the proposed work is required.

4. MATERIALS SPECIFICATIONS

General description of materials and manufactured items proposed for incorporation in the work of the project. This information may be included on your design drawings.

5. PHOTOGRAPHS

- Clearly labeled photographic prints of each facade of existing resource, including details of the affected portions. All labels should be placed on the front of photographs.
- Clearly label photographic prints of the resource as viewed from the public right-of-way and of the adjoining properties. All labels should be placed on the front of photographs.

6. TREE SURVEY

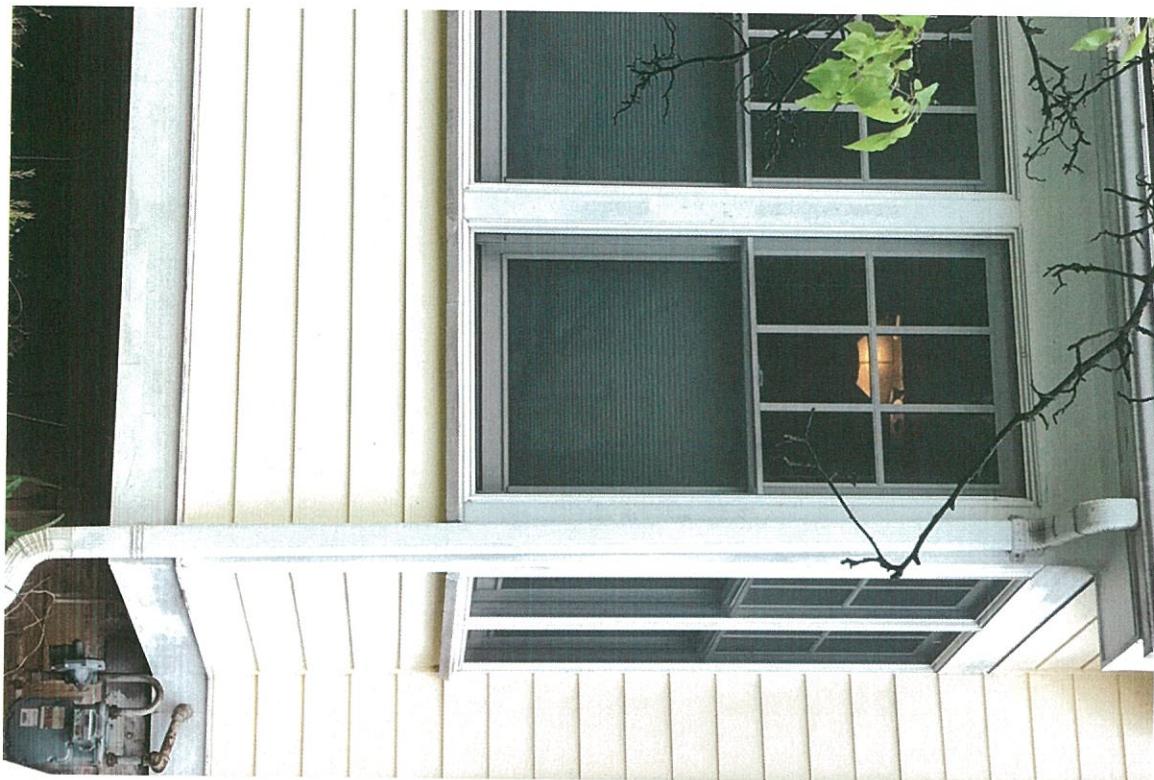
If you are proposing construction adjacent to or within the dripline of any tree 6" or larger in diameter (at approximately 4 feet above the ground), you must file an accurate tree survey identifying the size, location, and species of each tree of at least that dimension.

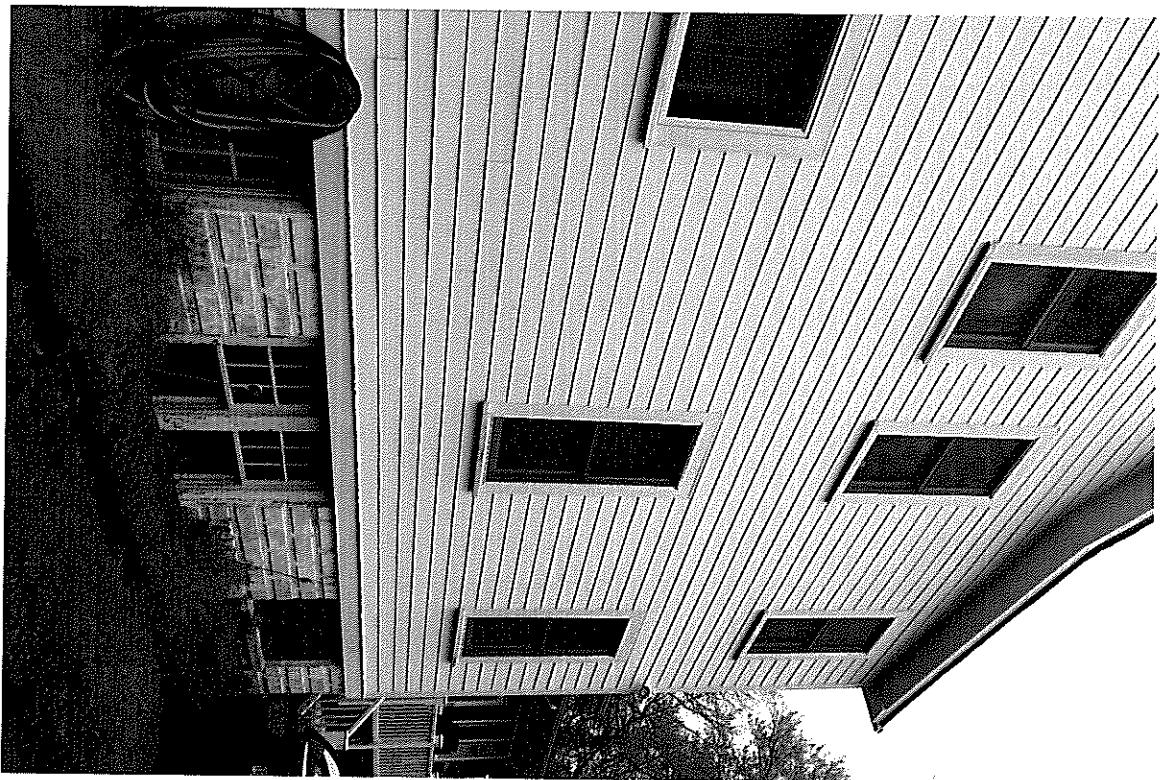
7. ADDRESSES OF ADJACENT AND CONFRONTING PROPERTY OWNERS

For ALL projects, provide an accurate list of adjacent and confronting property owners (not tenants), including names, addresses, and zip codes. This list should include the owners of all lots or parcels which adjoin the parcel in question, as well as the owner(s) of lot(s) or parcel(s) which lie directly across the street/highway from the parcel in question.

PLEASE PRINT (IN BLUE OR BLACK INK) OR TYPE THIS INFORMATION ON THE FOLLOWING PAGE.
PLEASE STAY WITHIN THE GUIDES OF THE TEMPLATE, AS THIS WILL BE PHOTOCOPIED DIRECTLY ONTO MAILING LABELS.

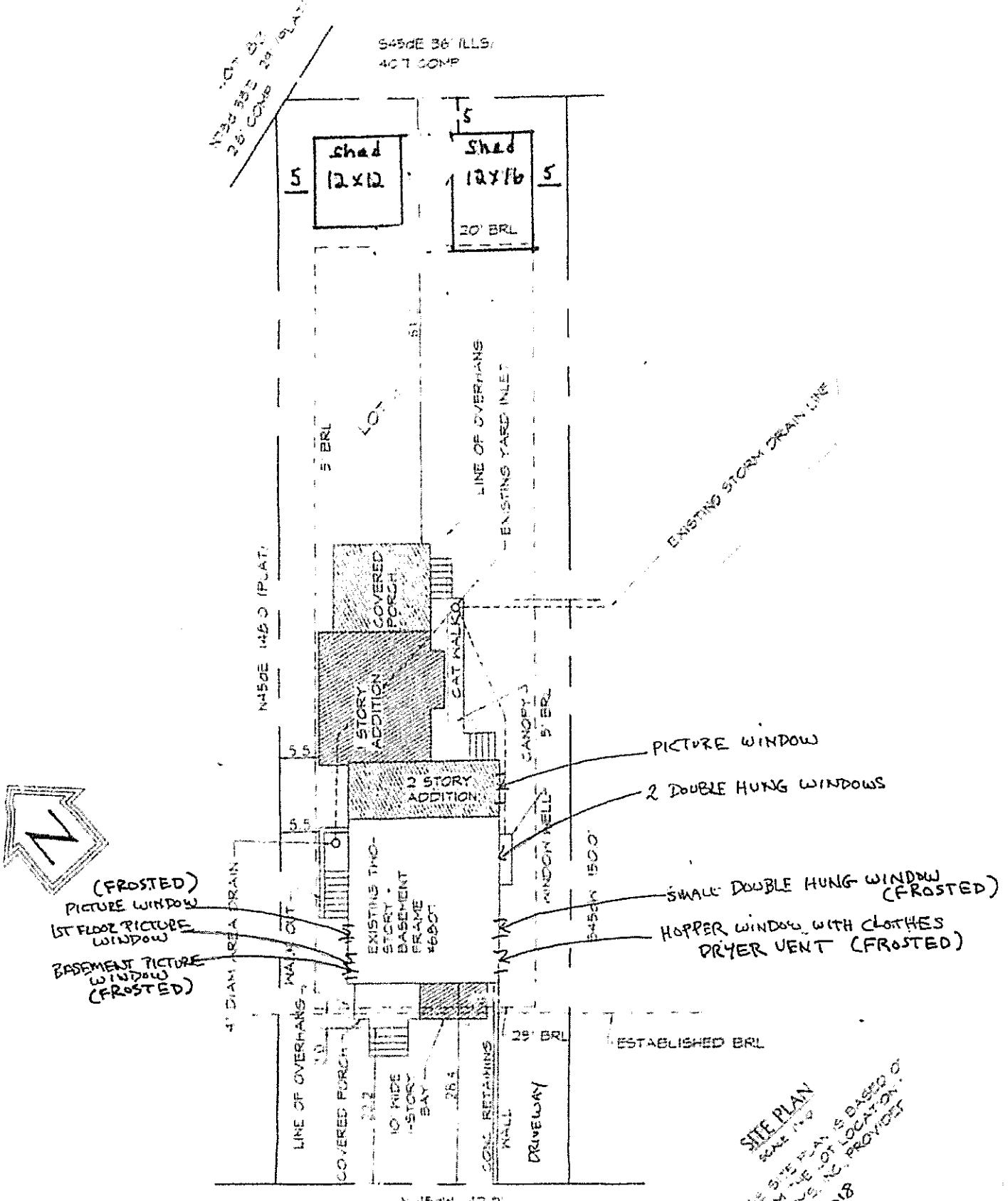










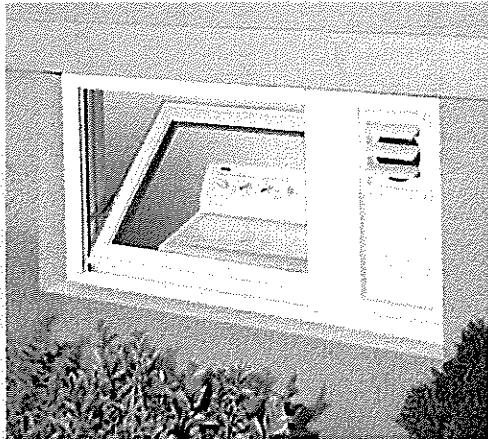


WESTMORELAND AVENUE

SITE PLAN
 THE SITE PLAN IS FOR LOCATIONAL
 PURPOSES ONLY. DO NOT SCALE.
 4/8/2018

Ideal Platinum Hopper Window

Slimline Profile with less vinyl gives you more glass and light



Shown with optional dryer vent.

Tilting inward, our basement hopper provides both light and ventilation in many hard to accommodate areas in your home. The stainless steel hinges provide durability while the sash tilts inward with easy turn and tilt locks. Designed to keep insects, rodents, and cold air outside of the home, the optional dryer vent provides added protection from the weather and minimizes wall damage during installation.

- Weather resistant, fully welded frame and sash is strong, durable and maintenance free.
- Heavy-duty latch and keeper provide enhanced security to your home's basement.
- Slope step sill allows for easier water drainage.
- Foam filled frame and sashes add energy efficiency and comfort
- Slope step sill allows for easier water drainage
- Double strength glass is heavier and far more durable than single strength
- Stainless steel hinge assembly for durability and ease of operation.
- Optional dryer vent includes a 4" diameter aluminum pipe and collar.
- Slimline design provide less vinyl frame, more glass



NATIONAL CERTIFIED TESTING LABORATORIES

FIVE LEIGH DRIVE • YORK, PENNSYLVANIA 17406 • TELEPHONE (717) 846-1200
FAX (717) 767-4100
www.nctlinc.com

AAMA/WDMA/CSA 101/I.S.2/A440-11
AAMA/WDMA/CSA 101/I.S.2/A440-08
AAMA/WDMA/CSA 101/I.S.2/A440-05

TEST REPORT SUMMARY

Rendered to:

Ideal Window Manufacturing, Inc.
100 West 7th Street
Bayonne, NJ 07002

PRODUCT TYPE: Tilt Double Hung

SERIES/ MODEL: "Platinum Series"

Title	Summary of Results
Primary Product Designator AAMA/WDMA/CSA 101/I.S.2/A440-11 AAMA/WDMA/CSA 101/I.S.2/A440-08 AAMA/WDMA/CSA 101/I.S.2/A440-05	Class R-PG35: Size tested 1016 x 1600 mm (~40 x 63 in) - Type H Class R-PG35: Size tested 1016 x 1600 mm (40 x 63 in) - Type H H-R35 1016 x 1600 (40 x 63)
Positive Design Pressure ¹	+1680 Pa (+35.09 psf)
Negative Design Pressure ¹	-1680 Pa (-35.09 psf)
Operating Force (in motion _{max}) ²	106.7 N (24 lbf)
Air Infiltration ²	0.1 L/s/m ² (0.02 cfm/ft ²)
Water Penetration Resistance Test Pressure ²	260 Pa (5.43 psf)
Uniform Load Structural Test Pressure ¹	±2520 Pa (52.63 psf)
Forced Entry Resistance ²	ASTM F588-07 - Grade 10 Pass

NOTE: ¹Test results with 2.5 mm and 3 mm glass

NOTE: ²Test results with 2.5 mm glass only

Test Completed: 06/24/14

Revision Date: 08/20/14

Reference must be made to Report No. NCTL-110-17180-1 dated 08/06/14 for complete test specimen description and data.

For National Certified Testing Laboratories


Jay Leader
DIGITAL SIGNATURE

Jay Leader
Technician



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**AAMA/WDMA/CSA 101/I.S.2/A440-11
AAMA/WDMA/CSA 101/I.S.2/A440-08
AAMA/WDMA/CSA 101/I.S.2/A440-05**

STRUCTURAL TEST REPORT

NCTL-110-17180-1

REPORT TO:
IDEAL WINDOW MANUFACTURING, INC.
100 WEST 7TH STREET
BAYONNE, NJ 07002

REPORT NUMBER: NCTL-110-17180-1
REPORT DATE: 08/06/14
REVISION DATE: 08/20/14

PRODUCT:
“Platinum Series”
Tilt Double Hung



NATIONAL CERTIFIED TESTING LABORATORIES

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FAX (717) 767-4100
www.nctlinc.com

Report Number	NCTL-110-17180-1
Report Date	08/06/14
Revision Date	08/20/14
Report To	IDEAL WINDOW MANUFACTURING, INC. 100 West 7 th Street Bayonne, NJ 07002
Test Date	06/24/14
Specification	AAMA/WDMA/CSA 101/I.S.2/A440-11 NAFS 2011 - North American Fenestration Standard/Specification for windows, doors, and skylights AAMA/WDMA/CSA 101/I.S.2/A440-08 NAFS North American Fenestration Standard/Specification for windows, doors, and skylights AAMA/WDMA/CSA 101/I.S.2/A440-05 Standard/Specification for Windows, Doors, and Unit Skylights
Performance Results	<u>AAMA/WDMA/CSA 101/I.S.2/A440-11 - Specimen 1 & 2</u> Class R-PG35: Size tested 1016 x 1600 mm (~40 x 63 in)-Type H <u>AAMA/WDMA/CSA 101/I.S.2/A440-08 – Specimen 1 & 2</u> Class R-PG35: Size tested 1016 x 1600 mm (40 x 63 in)-Type H <u>AAMA/WDMA/CSA 101/I.S.2/A440-05 – Specimen 1 & 2</u> H-R35 1016 x 1600 (40 x 63)

Description of Specimen Tested

Note: All dimensions are in the order (Width x Height x Thickness) unless otherwise noted.

Model/ Series	Platinum Series
Configuration	Tilt Double Hung
Frame Size	<u>Overall</u> 1016 mm x 1600 mm (40" x 63")
Sash Size	<u>Top Sash</u> 910 mm x 783 mm (35.813" x 30.813") <u>Bottom Sash</u> 935 mm x 783 mm (36.813" x 30.813")
Viewing Area	<u>Top Sash</u> 838 mm x 711 mm (33" x 28") <u>Bottom Sash</u> 864 mm x 711 mm (34" x 28")
Frame & Sash Type	Extruded vinyl
Joint Construction	<u>Frame & Sash</u> Mitered, welded

Glazing Components	
Overall	<u>Specimen 1</u> 22.10 mm (0.870") nominal
Glass Thickness	(2) Lites of 2.5 mm (0.090") nominal annealed glass
Spacer Type/Size	17.53 mm (0.690") Coated U-shaped steel spacer (Type CU-D)
	<u>Specimen 2</u>
Overall	22.10 mm (0.870") nominal
Glass Thickness	(2) Lites of 3 mm (0.122") nominal annealed glass
Spacer Type/Size	15.90 mm (0.626") coated U-shaped steel spacer (Type CU-D)
Glazing System	Exterior glazed with a silicone back-bedding and a snap-in rigid vinyl single leaf dual durometer glazing bead
Weatherstrip	
Type	(1) Strip vinyl wrapped foam
Location	Head
Type	(1) Strip center fin
Size	11.43 mm (0.450") high
Location	Sill
Type	(1) Strip center fin
Size	6.86 mm (0.270") high
Location	Exterior meeting rail
Type	(2) Strips center fin
Size	7.37 mm (0.290") high
Location	Stiles
Type	(1) Strip center fin
Size	8.89 mm (0.350") high
Location	Interior and exterior meeting rails
Type	(1) Strip single leaf foam bulb vinyl
Location	Bottom rail
Type	(2) Strips center fin
Size	5.59 mm (0.220") high
Location	Top rail
Operating Hardware	
Locks	
Type	Metal cam-type sweep lock
Location	178 mm (7") from each end of the interior meeting rail
Keeper	
Type	Metal
Location	Exterior meeting rail at the lock positions
Balance	
Type	Double coil spring balance system
Location	Each jamb track
Pivot Bar	
Type	(1) Die-cast T-shaped
Location	Each end of the exterior meeting rail and bottom rail fastened with (2) screws
Auxiliary	
Type	Rigid vinyl safety latch lock
Location	114.3 mm (4.5") From the exterior meeting rail on the stiles
Type	Rigid vinyl balance cover
Location	Each interior jamb track

Type	Rigid vinyl sash stop
Location	Bottom of each exterior jamb track
Type	Plastic tilt latch with thumb actuator
Location	Each end of the top rail and interior meeting rail
Reinforcement	
Type	Composite contour-shaped
Location	Meeting rails
Weep Description	
Size	(2) 6 mm (0.25") wide by 3 mm (0.125") high
Location	66.68 mm (2.625") from each end of the bottom rail
Size	6 mm (0.25") wide by 3 mm (0.125") high
Location	73.03 mm (2.875") from each end of the exterior meeting rail
Size	82.55 mm (3.25") wide by 1.6 mm (0.063") high
Location	Each end of the sill screen retainer
Interior/ Exterior Surface Finish	White vinyl (PVC)
Insect Screen	
Size	897 mm (35.313") wide by 770 mm (30.313")
Corner Construction	Mitered, staked-in-place aluminum corner keys
Material	Fiberglass mesh with solid spline
	Two (2) jamb retainer springs and spring loaded latches at the bottom rail
Installation Method	The window was installed in a 50.8 mm x 254 mm (2" x 10") spruce-pine-fir lumber test buck and secured to the buck with (1) #8 x 63.5 mm (2.5") pan head screw located at 63.5 mm (2.5") from each end of the interior jamb tracks. 19.05 mm (0.75") x 15.88 mm (0.625") wood blind stops were located at the exterior perimeter of the buck. Each blind stop was fastened with (1) brad nail located at 31.75 mm (1.25") from each end and 305 mm (12") on center thereafter. The exterior perimeter was sealed with a silicone sealant.

Test Results - AAMA/WDMA/CSA 101/I.S.2/A440-2011, 2008 & 2005

<u>Paragraph</u>	<u>Test</u>
5.3.1 / 9.3.1	Operating Force and Force to Latch - Method B (Force Gauge) ASTM E2068-00(08)
Specimen 1	
Initiate Motion	= 102.2 N (23 lbf)
Maintain Motion - Opening	= 93.3 N (21 lbf)
Maintain Motion - Closing	= 106.7 N (24 lbf)
Allowed (Normal Use _{11/08})	= 155 N (35 lbf)
Allowed (R Rating ₀₅)	= 155 N (35 lbf)
Latches	= 31 N (7 lbf)
Allowed	= 100 N (22.5 lbf)

NOTE: The results above represent the maximum force among all sash tested.

Paragraph Test

5.3.2.1/ 9.3.2 Air Leakage Resistance
ASTM E283-04(12)

The tested specimen meets or exceeds the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440-2011, 2008, and 2005 for air infiltration at 75 Pa (1.6 psf).

Maximum Allowable = 1.5 L/s/m² (0.3 cfm/ft²)

Specimen 1

Extraneous Air Leakage = 2.69 L/s (5.7 cfm)

Total Air Leakage = 2.88 L/s (6.1 cfm)

Air Infiltration Rate = 0.1 L/s/m² (0.02 cfm/ft²)

Paragraph Test

5.3.3/ 9.3.3 Water Penetration Resistance
ASTM E547-00(09) and ASTM E331-00(09)

3.4 L/ (min• m²) (5.0 gph/ft²)

Specimen 1

No Leakage after 4 cycles of 5 minutes at 260 Pa (5.43 psf)

NOTE: Tested with and without insect screen

Paragraph Test

5.3.4.2/ 9.3.4.2 Uniform Load Deflection at Design Pressure
ASTM E330-14

No damage after positive = 1680 Pa (35.09 psf) held for 10 seconds
No damage after negative = 1680 Pa (35.09 psf) held for 10 seconds

Specimen 1

Measured Deflection Positive = 7.90 mm (0.311 inches)
Measured Deflection Negative = 8.99 mm (0.354 inches)

Specimen 2

Measured Deflection Positive = 8.15 mm (0.321 inches)
Measured Deflection Negative = 8.13 mm (0.320 inches)

Paragraph Test

5.3.4.3/ 9.3.4.3 Uniform Load Structural Test
ASTM E330-14

No damage after positive = 2520 Pa (52.63 psf) held for 10 seconds
No damage after negative = 2520 Pa (52.63 psf) held for 10 seconds

Specimen 1

Measured Permanent Set Positive = 0.36 mm (0.014 inches)
Measured Permanent Set Negative = 0.48 mm (0.019 inches)
Maximum Allowed (0.4%) = 3.51 mm (0.138 inches)

Specimen 2

Measured Permanent Set Positive = 0.18 mm (0.007 inches)
Measured Permanent Set Negative = 0.41 mm (0.016 inches)
Maximum Allowed (0.4%) = 3.51 mm (0.138 inches)

NOTE: Deflection and Permanent Set measurements taken on the meeting rail over an 876 mm (34.5") span.

Paragraph Test

5.3.5/ 9.3.5 Forced Entry Resistance
ASTM F588-07

Type A Window Assembly/ Grade 10*: = Pass

Specimen 1Test

Disassembly	= No Entry
Lock Manipulation	= No Entry
Sash Manipulation	= No Entry
Test A1	= No Entry
Test A2	= No Entry
Test A3	= No Entry
Test A4	= No Entry
Test A5	= No Entry
Test A6	= No Entry
Test A7	= No Entry
Hardware Manipulation Test	= No Entry
Sash Manipulation Test	= No Entry

NOTE: 1. T1 = 5 minutes, L1 = 667 N (150 lbf), L2 = 333 N (75 lbf), L3 = 111 N (25 lbf)
2. Loads were held for 60 seconds.

Paragraph Test

5.3.6.2/ 9.3.6.2 Specimen 1

Thermoplastic Corner Weld Test (PVC products only) = Pass

Paragraph Test

5.3.6.3/ 9.3.6.3 Deglazing Test
ASTM E987-88(09)

Specimen 1Top Sash

Rails – 320 N (71.84 lbf)	= 90% (100%)
Maximum Allowed	= 90% (100%)
Top Rail	= 6.0%
Meeting Rail	= 4.0%
Stiles – 230 N (51.71 lbf)	= 90% (100%)
Maximum Allowed	= 90% (100%)
Left Stile	= 8.0%
Right Stile	= 8.0%

Bottom Sash

Rails – 320 N (71.94 lbf)	= 90% (100%)
Maximum Allowed	= 90% (100%)
Meeting Rail	= 8.0%
Bottom Rail	= 6.0%
Stiles – 230 N (51.71 lbf)	= 90% (100%)
Maximum Allowed	= 90% (100%)
Left Stile	= 10.0%
Right Stile	= 10.0%

NOTE: The glass bite was approximately 12.7 mm (0.5")

This test report was prepared by National Certified Testing Laboratory (NCTL), for the exclusive use of the above named client and it does not constitute certification of this product. The results are for the particular specimen tested and do not imply the quality of similar or identical products manufactured or installed from specifications identical to the tested product. The test specimen was supplied to NCTL by the above named client. No conclusions of any kind regarding the adequacy or inadequacy of the glass in the test specimen are to be drawn from the ASTM E330 test. Forced entry resistance test equipment used is in compliance with Section 7 of the ASTM F588-07 test method. Foam tape is mounted to the perimeter of the test buck prior to clamping to the test wall. NCTL is a testing lab and assumes that all information provided by the client is accurate and does not guarantee or warranty any product tested or installed. The results in this report are actual tested values and are applicable to the specimen tested only, using the components and construction methods described herein.

Detailed drawings were available for laboratory records and compared to the test specimen at the time of this report. Component drawings were reviewed for product verification. The bill of materials contains details with any deviations noted. Ambient conditions during the referenced testing are available upon request. A copy of this report along with representative sections of the test specimen will be retained by NCTL. This report does not constitute certification or approval of the product, which may only be granted by a certification program validator or recognized approval entity. All tests were conducted in full compliance with the referenced specifications and/or test methods. This report is the joint property of National Certified Testing Laboratories Inc. and the Client to whom it is issued. Permission to reproduce this report by anyone other than National Certified Testing Laboratories Inc and the Client must be granted in writing by both of the above parties. This report may not be reproduced, except its entirety, without the written consent of NCTL.

National Certified Testing Laboratories
DIGITAL SIGNATURE

Jay Leader
Technician


DIGITAL
SIGNATURE

Robert H. Zeiders, P.E.
Vice-President Engineering & Quality

NJL/ drm
Attachments

- Appendix A – Revision Summary
- Appendix B – Drawings

Appendix A

Section 1:

Component Drawings, with Applicable Part Numbers, Manufacturing and Modeling Details, were
Reviewed (as submitted) for Product Verification
(Reference: NCTL-110-17180-1)

See Attached Documentation;
any deviations noted.

Note: The above referenced component drawings (if applicable) along with representative sections of the test specimen will be retained per procedure by NCTL. This testing facility assumes that all information provided by the client is accurate.

Section 2:

<u>Identification</u>	<u>Date</u>	<u>Page & Revision</u>
Original Issue	08/06/14	Not Applicable
Revision 1	08/20/14	Changed from (1) strip to (2) strips of weather strip located at the stiles and top rail and changed meeting rails to interior and exterior meeting rails
Revision 2	08/20/14	Changed (2) strips to (1) strip of weatherstrip located at the bottom rail and (1) strip to (2) strips of weather strip located at the top rail

Appendix B

Drawings

ULTRATITE PLUS WITH DUAL WALL HANDLES

WINDOW WIDTH	40	
WINDOW HEIGHT	63	
TOP GLASS WIDTH		TEST SPECIFICATION OUTLINES WITH THESE DETAILS.
TOP GLASS HEIGHT		28.9375
BOTTOM GLASS WIDTH		33.9375
BOTTOM GLASS HEIGHT		28.9375
TOP INSERT WIDTH		ANY DEVIATION IS NOTED
TOP INSERT HEIGHT		REPORT NO. NCTL-110-11801
BOTTOM INSERT WIDTH	35.75	TEST DATE <u>4/24/14</u>
BOTTOM INSERT HEIGHT	30.84375	
SCREEN WIDTH	36.75	TTT cut sizes w/ weld B/O
SCREEN HEIGHT	30.84375	
SCREEN WIDTH	35.3125	
SCREEN HEIGHT	30.25	
FRAME EXTRUSIONS	35.75	
761 HEAD EXP	40	
701A HEAD REPLIC	40.25	
702W02 SILL W/PILE	40.25	
703 07023 LEFT JAMB-REPLC	63.25	
703 07023 RIGHT JAMB-REPLC	63.25	
763A 07022 left SASH STOP 2.5" long-for limit top sash travel	2.5	
763A 07022 Right SASH STOP 2.5" long for limit top sash travel	2.5	
765 CRM WHT SILL ANGLE (2075) 16'	40	
2408-(569)-101-192 (148) BAL CVR-7 LI LEFT	30.75	
2408-(569)-101-192 (148) BAL CVR-7 LI RIGHT	30.75	
WOOLPILE/SEALS IN FRAME/FOAM EXT. W2323INW-#87-X-23Q W/WHITE W/PLASTIC FIN ***AMES BURY 32343		
082370 CHELSEA SUP. .187 x .290- in extrusion from Chelsea		in Head
096032 33114-001189 .75 x 2" x75' Ether PSA-1		in Sill Leg
096032 33114-001189 .75 x 2" x75' Ether PSA-1		Left Jamb
096032 33114-001189 .75 x 2" x75' Ether PSA-1		Right Jamb
096032 33114-001189 .75 x 2" x75' Ether PSA-1		Head
TOP SASH EXTRUSIONS		

10/12

066250	965 TOP HANDLE-DUAL WALL	36
066137	737A 07023 KEEPER RAIL CREAM WHITE 16'	36
133230	948 06022 REBAR KEEPER RAIL	30
066511	908W01 LEFT TOP STILE	31.09375
066511	908W01 RIGHT TOP STILE	31.09375
066036	716A GLAZING BEAD-Mitred width- 2 pieces	34.125
066036	716A GLAZING BEAD-Mitred-height- 2 pieces	29.25

**TEST SPECIMEN COMPLIES
WITH THESE DETAILS.
ANY DEVIATION IS NOTED
REPORT NO. NOTL-170-1714
TEST DATE 6/24/14**

WOOLPILE/SEALS TOP SASH

CHELSEA SUP. .187 x .220 in extrusion from Chelsea
 CHELSEA SUP. .187 x .220 in extrusion from Chelsea
 W43271NW .187 X .270 WHT W/SOFT FIN*****
 084001 W43351NW WHITE .187 X .350
 CHELSEA SUP. .187 x .250 in extrusion supplied by chelsea 0.187 x .290 ft
 CHELSEA SUP. .187 x .250 in extrusion supplied by chelsea 0.187 x .290 ft

BOTTOM SASH EXTRUSIONS

066508	906 07023 LOCK RAIL	37
133230	948 06022 REBAR LOCKRAIL	30.25
066260	955 BOTTOM HANDLE	37
066511	908W01 LEFT BOTTOM STILE	31.09375
066511	908W01 RIGHT BOTTOM STILE	31.09375
066036	716A GLAZING BEAD BOTTOM WIDTHS-Mitred 2 pieces	35.125
066036	716A GLAZING BEAD BOTTOM HEIGHTS-Mitred 2 pieces	29.25

WOOLPILE/SEALS BOTTOM SASH

W43351NW WHITE .187 X .350
 32689-21 OFF- WHITE BULB SEAL
~~NOT DESCRIBED~~ ~~NOT TO BE DETERMINED~~
 CHELSEA SUP. .187 x .250 in extrusion supplied by chelsea 0.187 x .290
 CHELSEA SUP. .187 x .250 in extrusion supplied by chelsea 0.187 x .290

010405 BA-9710C 3/8" STAPLE, BEA- TY95110NK-(staple to hold in woolpile)
 as required

1/2 SCREEN EXTRUSIONS

179433	E1687 CMP LOCK BTM RAIL OFF WT 16'(E1000)-Bottom Rail	36.5
179432	E1688 CMP PLAIN RAIL OFF WHT 16'(E1001)-Top Plain rail	35.25
179434	E1689 CMP RAIL STOP OFF WHT 16' (E1002)-Side w/ bead	29.625
179432	E1688 CMP PLAIN RAIL OFF WHT 16'(E1001)- Top Plain rail	29.625

TTT cut sizes

Outside Top Handle	37
Inside Top Handle	30.25
Outside Keeper rail	37
Inside Keeper Rail	31.09375
Outside Stile	35.125
Inside Stile	29.25

TTT cut sizes

Lockrail	37
EXT. Seal- Bottom HDL.	30.25
Int. Stile- Bottom HDL Seal	37
Outside Stile	31.09375
Inside Stile	35.125

(27)

1/2 SCREEN PARTS			
SCRN WARNING LBL CKL .206 X .212 CORNER KEY PERFECT FIT (LOC 11)		Qty=1	
9183 X.187 NC SCRIN SPRING 160 BLK SCREEN CORD 1603000-6		Qty=4 Qty=2 as required	
551LH-W08085 SCREEN BOLT EURO-WHITE (LINEN) Left Scrn. Lock 550RH-W08085 SCREEN BOLT EURO-WHITE (LINEN) Right Scrn lock		Qty=1	TEST SPECIMEN COPIES
1066-BW SPRING SCREEN TRIGGERS SCR CLOTH SUMMARY ALL DEPTS		Qty=2 as required	WITH A PRICE DETAILS. ANY DISAGREEMENT IS NOTED
Misc Other Parts LABELS			REPORT NO. NCTL-10- 7180-1 TEST DATE 6/24/14
LABEL-4" X 1 1/8"-BRT PINK ON ROLLS W/RIBBONS 4 X 4 LABELS W/ CLEANTAC II		Qty=2	
COS-09-0947 LABEL * ORDER THRU CARLENE, FROM PASTERS * 8A X 2 1/2" PHIL PAN ZP 4 PCS PER BAG-Installation screw		Qty=2 as req.	
PN#3859 DURA TRUST N/C REP DOUBLE HUNG TP12FS 1/2" REINF FIL TAPE- to hold sli > to head exp.		Qty=1 Qty=1 Qty=20"	
Packaging PULP CORNER 5.5" X 4" X 5.5" ADU20312 10" - 80 GAUGE- 6000/ROLL		Qty=2 as req.	
Balance System Parts- REITTER-F-As Required <i>By Adjustment</i>			as req. by size
BALANCE BRACKET R 101005RH .304P01R- "X"-TOP L BALANCE BRACKET L 101004L .304P01L- "Y"-TOP R		Qty=1 Qty=1	
BALANCE BRACKET R 101005RH .304P01R- "X"-Top L BALANCE BRACKET L 101004L .304P01L- "Y"-Top R		Qty=1 Qty=1	
8A X 5/8" PHIL PAN HEAD SS.410 NO DEFECT Brck-screw 10-24 X 1 1/8" JAMB ADJUSTER SET		Qty=4 Qty=2	
Lock and Keeper Parts			
C30706.42 KEEPER OFF WHITE C30706.42 KEEPER OFF WHIE additional if over 26" wide 6A X 1" #4 PHIL FLAT 410SS VIVL HLD OFF/WHT NEW (4) keeper screws		Qty=1 Qty=1 Qty=4	

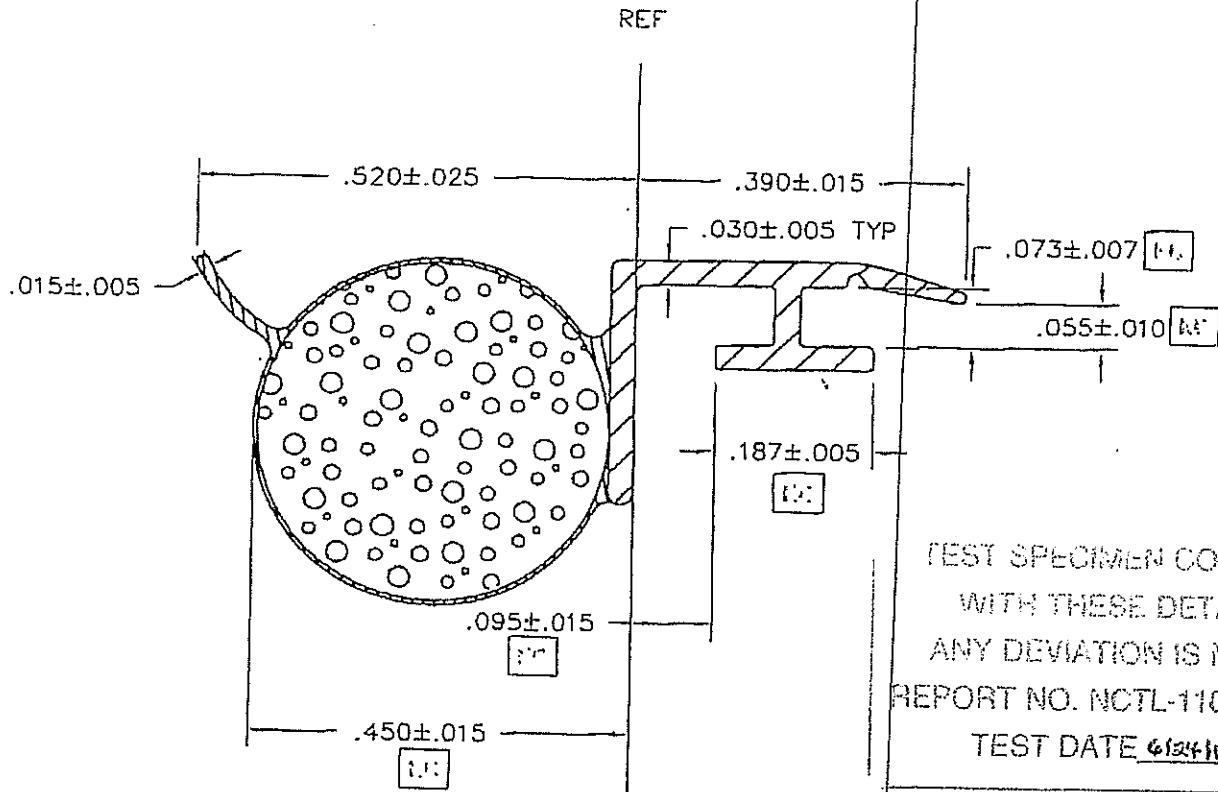
#308

033000	A30700403.42 RIGHT HAND OFF- WHT LOCK A30700403.42 RIGHT HAND OFF- WHT LOCK additional if over 26" wide #6 X 1" PH FL ZINC STL VYN- L- HD IDEAL WHT LOCK SCREW (4) lock screws	Qty=1 Qty=1 Qty=4
SASH PARTS-Misc.		
042004	7390FC--L.005 JW LEFT SIGHTLINE TILT LATCH CRM WHT 76020-001 Top Sash Left	Qty=1
042005	7390FC--L.005 JW RIGHT SIGHTLINE TILT LATCH CREAM WHT 76120-001 Top Sash Right	Qty=1
042021	86099BEE DELUXE VENT LOCK CRM WHT- Night latch	Qty=2
033013	356503000-16Y503 TIE IN PIVOT BAR-Top Sash	Qty=2
010330	6-20 1/4 X 1/2 PHIL TRUSS ZP -Top Sash pivot Bar Screws	Qty=4
040479	2260.003-LH-EURO WHITE END RAIL PLUG-Top Sash LH	Qty=1
040478	2260.003-RH-EURO WHITE END RAIL PLUG-Top Sash RH	Qty=1
042004?????	7390FC--L.005 JW LEFT SIGHTLINE TILT LATCH CRM WHT 76020-001-Bot Sash Left	Qty=1
042005-?????	7390FC--L.005 JW RIGHT SIGHTLINE TILT LATCH CREAM WHT 76120-001 Top Sash Right	Qty=1
033013	356503000-16Y503 TIE IN PIVOT BAR-Bottom Sash	Qty=2
010330	6-20 1/4 X 1/2 PHIL TRUSS ZP-Bottom Sash pivot bar Screws	Qty=4
040479	2260.003-LH-EURO WHITE END RAIL PLUG-Bot Sash LH	Qty=1
040478	2260.003-RH-EURO WHITE END RAIL PLUG-Bot Sash RH	Qty=1
Glass Items		
090105	Wet Glazing Component A Silicone	perm. of glass
090105	Wet Glazing Component B Silicone	perm. of glass
090100	1/8 X 15/16 X 15/16 W HI TCK GLUE (GREEN) ECO BLOCK	as req. by size
Foam-Option- As shown on attached cross section Drawing- injected and strips		
090154	Foam-Resin	per foam drawing
090153	Foam-ISO	per foam drawing
100305	Type "A" EPS Celofaom .562" x .500 x 1.5"	per foam drawing
100308	Type "D" EPS Celofaom 0.49"/0.44" x .875	per foam drawing

8/21

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THE INFORMATION CONTAINED IN THIS DOCUMENT
IS CONFIDENTIAL AND PROPRIETARY TO AMESBURY
GROUP, INC. REPRODUCTION IN WHOLE OR
PART BY ANY MEANS IS EXPRESSLY PROHIBITED.

Dwg No.
32689**CUSTOMER APPROVAL**

DATE _____

FD091 SD22B CD347

REVISIONS

1. Increased hinge gap from .045 to .055 8/JV/12/10/99
2. See ECN # 025-02 8/JV/06/21/02

DRAWN	DATE	CHK'D	SCALE:
RHM	3/16/99		5/1

NOTES:

AMESBURY GROUP INC.
EXTRUDED PRODUCTS DIVISION57 Hunt Rd.
Amesbury, MA 01913

5.

5.

TITLE:

OFFSET T-SLOT WITH PLATFORM

Dwg.

or Part No.
32689

REV.

2ACTUAL
SIZE

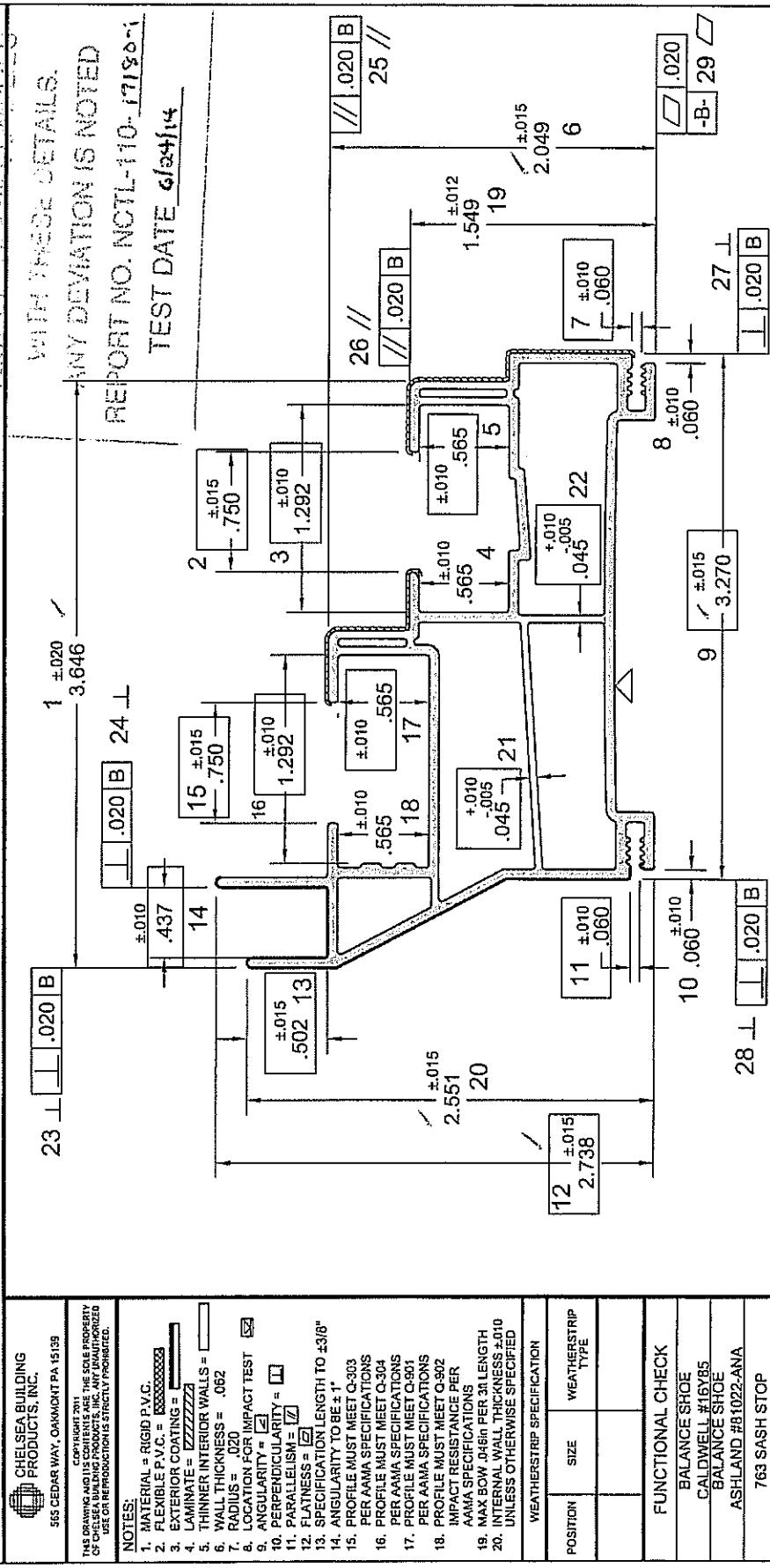
QC PRINT NUMBER:	701Aqc	DRAWN BY:	EAS	CHECKED BY:		APPROVED BY:		DEVELOP	<input type="checkbox"/>	INPROCESS	<input type="checkbox"/>	PRODUCTION																																																																	
PART NAME:	701A	DESCRIPTION:	DOUBLE HUNG HEAD	SUPPLIER/PLANT:	CHELSEA BUILDING PRODUCTS																																																																								
ILLUSTRATION OF PART AND CONTROL POINTS																																																																													
<p>TEST SPECIMEN COUPLES TEST DATE 6/24/14 REPORT NO. NCTL-140-1186-1</p> <p>NOTES: 1. MATERIAL = RIGID PVC. 2. FLEXIBLE PVC = 3. EXTERIOR COATING = 4. LAMINATE = 5. THINNER INTERIOR WALLS = 6. WALL THICKNESS = .062 ± .006 7. RADIUS .00 8. LOCATION FOR IMPACT TEST 9. ANGULARITY = 10. PERPENDICULARITY = 11. PARALLELISM = 12. FLATNESS = 13. SPECIFICATION LENGTH TO ±.18" 14. ANGULARITY TO ±.1° 15. PROFILE MUST MEET Q-303 PER AAMA SPECIFICATIONS 16. PROFILE MUST MEET Q-304 PER AAMA SPECIFICATIONS 17. PROFILE MUST MEET Q-901 PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS 19. MAX BOW .046in PER 31 LENGTH 20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED WEATHERSTRIP SPECIFICATION POSITION SIZE WEATHERSTRIP TYPE 16 .020 -B- 26 .020 -B- FUNCTIONAL CHECK 727 MULLION CLIP WOOLPILE (.187 BACK)</p>																																																																													
<table border="1"> <thead> <tr> <th>NO.</th> <th>REVISION</th> <th>FUNCTION</th> <th>POINT</th> <th>LOCATION</th> <th>SIZE</th> <th>TYPE</th> <th>THICKNESS</th> <th>WIDTH</th> <th>HEIGHT</th> <th>CUSTOMER LENGTH</th> <th>CHELSEA CUT LENGTH</th> <th>TOLERANCE</th> </tr> </thead> <tbody> <tr> <td>1</td> <td></td> <td>ADDED INTERNAL WALL SPEC</td> <td></td> </tr> <tr> <td>2</td> <td></td> <td>ADDED INTERNAL WALL SPEC</td> <td></td> </tr> <tr> <td>3</td> <td></td> <td>ADDED SPECTON NUB</td> <td></td> </tr> <tr> <td>4</td> <td></td> <td>1 ADDED INTERNAL WALL SPEC</td> <td></td> </tr> </tbody> </table> <p>Use the caliper diagram as your guide to measure the following control points. Measure the following control points using #1 on the caliper diagram; Measure the following control points using #2 on the caliper diagram; Measure the following control points using #3 on the caliper diagram; Measure the following control points using #4 on the caliper diagram; Frequency of sampling: Process Specialist- 3 samples per shift recorded every 4 hours. Auditor- 1 sample per shift recorded 1 hour after shift start. IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED</p>													NO.	REVISION	FUNCTION	POINT	LOCATION	SIZE	TYPE	THICKNESS	WIDTH	HEIGHT	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE	1		ADDED INTERNAL WALL SPEC											2		ADDED INTERNAL WALL SPEC											3		ADDED SPECTON NUB											4		1 ADDED INTERNAL WALL SPEC										
NO.	REVISION	FUNCTION	POINT	LOCATION	SIZE	TYPE	THICKNESS	WIDTH	HEIGHT	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE																																																																	
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3		ADDED SPECTON NUB																																																																											
4		1 ADDED INTERNAL WALL SPEC																																																																											

QC PRINT NUMBER:	702w06qc	DRAWN BY:	BLG	CHECKED BY:		APPROVED BY:		DEVELOP	IN PROCESS	PRODUCTION	
PART NAME:	702	DESCRIPTION:	W06 DOUBLE HUNG SILL	SUPPLIER/PLANT:	CHELSEA BUILDING PRODUCTS						
CHELSEA BUILDING PRODUCTS, INC. 565 CEDAR WAY, DARKHORN PA 15139 <small>CONTROLLING DRAWINGS ARE THE SOLE PROPERTY OF CHELSEA BUILDING PRODUCTS, INC. ANY UNAUTHORIZED USE OR REPRODUCTION IS STRICTLY PROHIBITED.</small>		TEST SPECIMEN COMPLIES WITH THESE DETAILS ANY DEVIATION IS NOTED		ILLUSTRATION OF PART AND CONTROL POINTS		NOTE: WHITE WEATHERSTRIP IN ALL COLOR PROFILES					
		REPORT NO. NCFL-110- <u>47186-1</u> TEST DATE <u>6/24/14</u>									
NOTES: 1. MATERIAL = RIGID PVC. 2. FLEXIBLE PVC = <input checked="" type="checkbox"/> 3. EXTERIOR COATING = <input checked="" type="checkbox"/> 4. LAMINATE = <input checked="" type="checkbox"/> 5. THINNER INTERIOR WALLS = <input checked="" type="checkbox"/> 6. WALL THICKNESS = .062 7. RADIUS = .020 8. LOCATION FOR IMPACT TEST 9. ANGULARITY = <input checked="" type="checkbox"/> 10. PERPENDICULARITY = <input checked="" type="checkbox"/> 11. PARALLELISM = <input checked="" type="checkbox"/> 12. FLATNESS = <input checked="" type="checkbox"/> 13. SPECIFICATION LENGTH TO ±3/8" 14. ANGULARITY TO BE ±1° 15. PROFILE MUST MEET Q-303 PER AAMA SPECIFICATIONS 16. PROFILE MUST MEET Q-304 PER AAMA SPECIFICATIONS 17. PROFILE MUST MEET C-901 PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS 19. MAX BOW .06 IN PER 30 LENGTH 20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED											
WEATHERSTRIP SPECIFICATION											
POSITION	SIZE	WEATHERSTRIP TYPE									
A	.187 x .260	ULTRA FAB									
FUNCTIONAL CHECK											
WOOLPILE (.187 x .290)											
765 SILL ANGLE											
Use the caliper diagram as your guide to measure the following control points.											
Measure the following control points using #1 on the caliper diagram:											
Measure the following control points using #2 on the caliper diagram:											
Measure the following control points using #3 on the caliper diagram:											
Measure the following control points using #4 on the caliper diagram:											
Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours.											
Auditor - 1 sample per shift recorded 1 hour after shift start.											
IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED											
4											

QC PRINT NUMBER:	703qc	DRAWN BY:	JPP	CHECKED BY:		APPROVED BY:	
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PART NAME: **703** DESCRIPTION: **DOUBLE HUNG JAMB** SUPPLIER/PLANT: **CHELSEA BUILDING PRODUCTS**

ILLUSTRATION OF PART AND CONTROL POINTS



ITEM	BLG	BLG	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
14 ADDED UPATED PROFILE. WO#J3052	03-08-13	03-08-11			
13 MADE DIMENSION #12 CRITICAL					
12 ADDED INTERNAL WALL SPECS AS CRITICAL DIMS					
11 ADDED INTERNAL WALL SPEC					
10 ADDED .020 R					
9 MADE DIM 15 CRITICAL; WO#886					
NO. [REVISION]					

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram:

Measure the following control points using #2 on the caliper diagram:

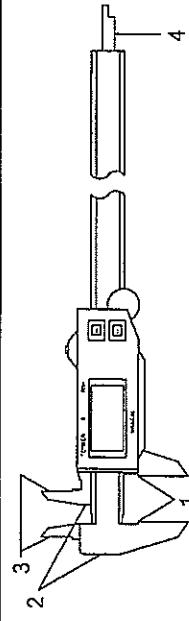
Measure the following control points using #3 on the caliper diagram:

Measure the following control points using #4 on the caliper diagram:

Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours.

Auditor - 1 sample per shift recorded 1 hour after shift start.

IF ANY CONTROL POINTS ARE NOT IN SPEC, CORRECTIVE ACTION REQUIRED



QC PRINT NUMBER: 716AQC DRAWN BY: EAS CHECKED BY: APPROVED BY:

PART NAME: 716A DESCRIPTION: GLAZING BEAD



CHELSEA BUILDING
PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

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NOTES:

1. MATERIAL = RIGID PVC.

2. FLEXIBLE PVC =

3. EXTERIOR COATING =

4. LAMINATE =

5. THINNER INTERIOR WALLS =

6. WALL THICKNESS = .045 ± .005

7. RADIUS = .10

8. LOCATION OR IMPACT TEST =

9. ANGULARITY =

10. PERPENDICULARITY =

11. PARALLELISM =

12. FLATNESS =

13. SPECIFICATION LENGTH TO

14. ANGULARITY TO BE ± 1°

15. PROFILE MUST MEET Q-303 ±.018*

PER KAMA SPECIFICATIONS

16. PROFILE MUST MEET Q-304

PER KAMA SPECIFICATIONS

17. PROFILE MUST MEET Q-901

PER KAMA SPECIFICATIONS

18. PROFILE MUST MEET Q-902

IMPACT RESISTANCE PER

AAMA SPECIFICATIONS

19. MAX BOW JAGS PER 3' LENGTH

20. INTERNAL WALL THICKNESS ±.010

UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION		
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

705 LIFT TRAIL

706 LOCK RAIL

707 KEEPER RAIL

	EAS	06-20-13	CUSTOMER LENGTH	TOLERANCE
6 ADDED BACK NOTE: W#13130	EAS	06-11-13		
5 REVISED DIM & ADDED CRITICALS PER PLANT MANAGER REQUEST	DIN	05-21-13		
4 REVISED BORDER	DIN	05-21-13		
3 ADDED FEELER NOTE	DIN	05-21-13		
2 REVISED DIM. 153 TOL & DIM. 152 TOL	EAS	05-12-08		
1 REVISED SNAP IN LEG; DIM. 193 WAS .198; DIM. 128 WAS .138	EAS	05-04-07		
NO. REVISION	BY	DATE		

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram 2,3,4,6,7

Measure the following control points using #2 on the caliper diagram 5

Measure the following control points using #3 on the caliper diagram 1

Measure the following control points using #4 on the caliper diagram

Auditor: 1 sample per shift recorded 1 hour after shift start.

IF ANY CONTROL POINTS ARE NOT IN SPEC.

CORRECTIVE ACTION REQUIRED

ALL PARTS ARE TO BE PACKED IN SAME DIRECTION

ILLUSTRATION OF PART AND CONTROL POINTS

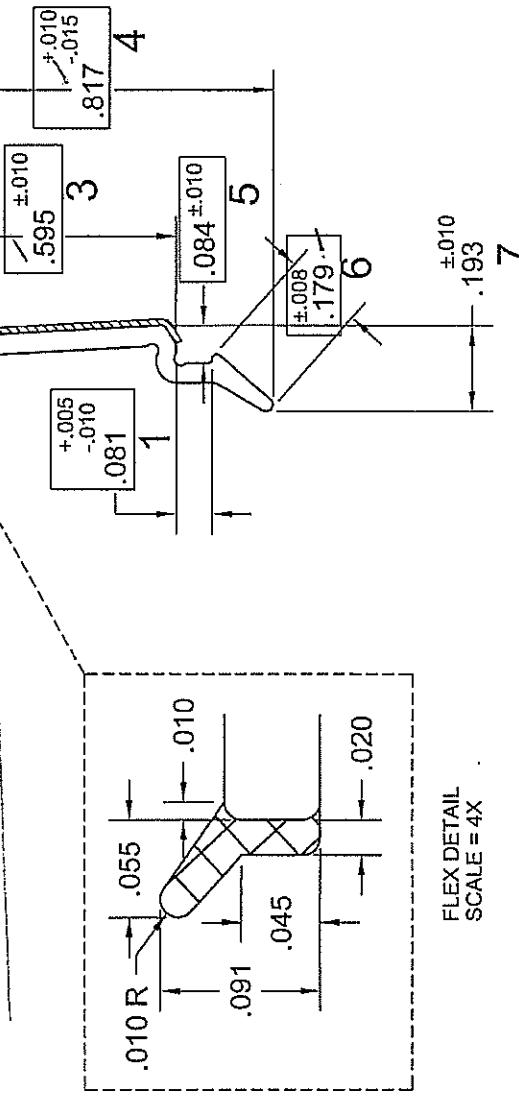
TEST SPECIMEN COMPLIES

FLEX W, OW, CW - USE WHITE FLEX
B, SND - USE BEIGE FLEX

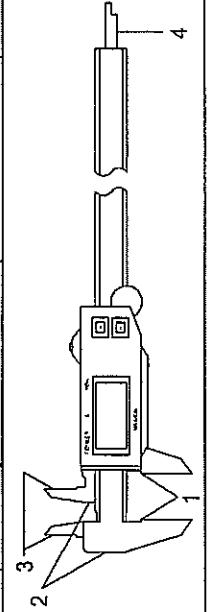
ANY DEVIATION IS NOTED

REPORT NO. NCTL-110- V1186-1

TEST DATE 04-24-07



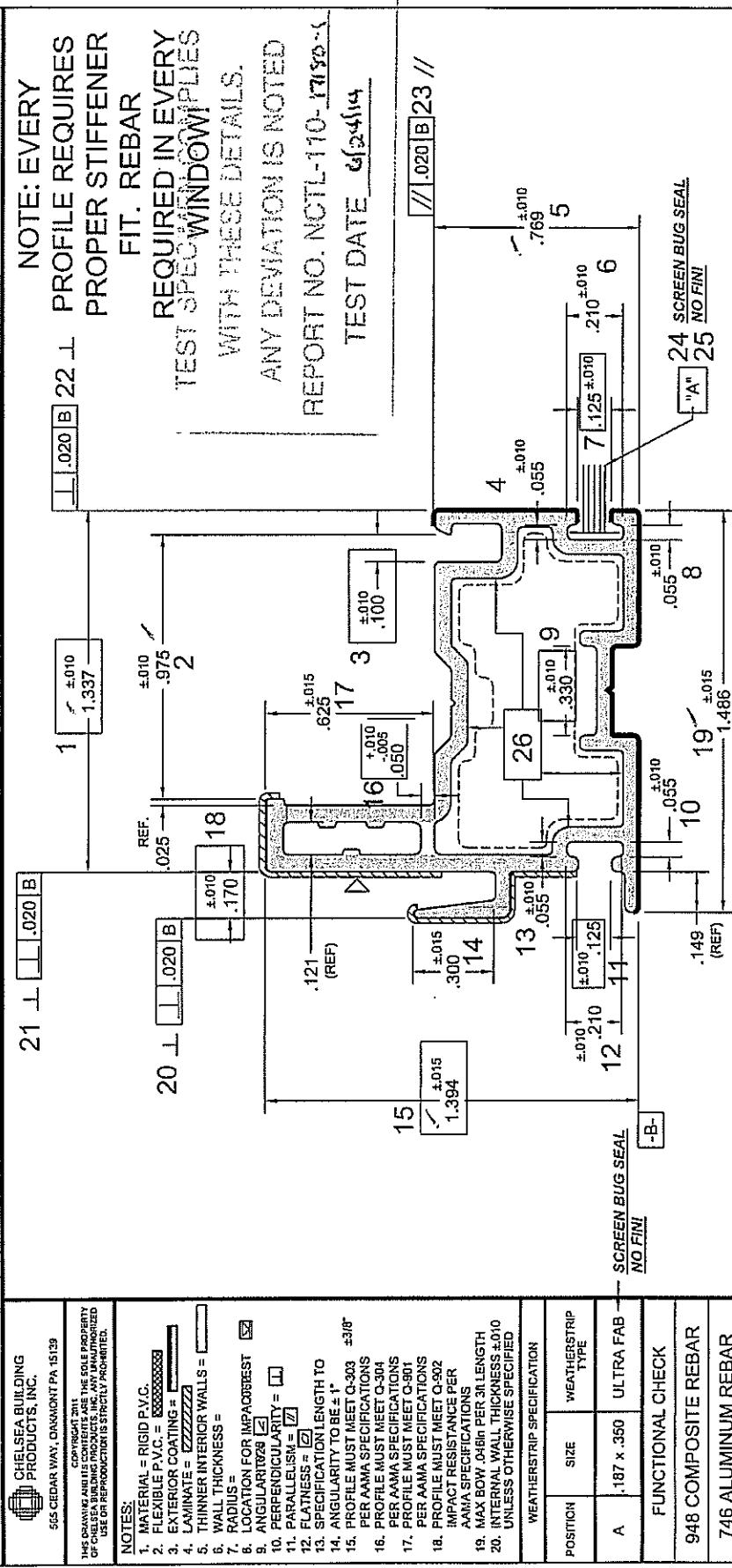
FLEX DETAIL
SCALE = 4X



QC PRINT NUMBER: 737Awsqc DRAWN BY: JPP CHECKED BY: APPROVED BY: PRODUCTION

PART NAME: 737Aws DESCRIPTION: KEEPER RAIL SUPPLIER/PLANT: CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS



NOTE: WHITE WEATHERSTRIP IN ALL COLOR PROFILES!

POSITION	SIZE	WEATHERSTRIP TYPE	FUNCTIONAL CHECK	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
A	.187 x .360	ULTRA FAB	SCREEN BUG SEAL NO FIN			
DRAWN DATE:	01-14-10	NO.1 REVISION				
716A GLAZING BEAD						
948 COMPOSITE REBAR						
746 ALUMINUM REBAR						
743 STEEL REBAR						

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram:

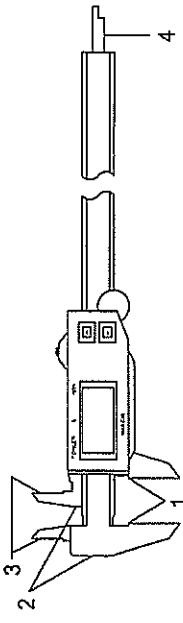
Measure the following control points using #2 on the caliper diagram:

Measure the following control points using #3 on the caliper diagram:

Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours.

IF ANY CONTROL POINTS ARE NOT IN SPEC.

CORRECTIVE ACTION REQUIRED



QC PRINT NUMBER:	763Aqc	DRAWN BY:	EAS	CHECKED BY:		APPROVED BY:		INPROCESS	PRODUCTION									
PART NAME:	763A	DESCRIPTION:	SASH STOP	SUPPLIER/PLANT:	CHELSEA BUILDING PRODUCTS													
ILLUSTRATION OF PART AND CONTROL POINTS																		
<p style="text-align: center;">TEST SPECIMEN COMPIES WITH THESE DETAILS. ANY DEVIATION IS NOTED</p> <p style="text-align: center;">REPORT NO. NCTL-110-11804 TEST DATE 6/3/04</p>																		
<p>NOTES:</p> <p>1. MATERIAL = RIGID PVC. 2. FLEXIBLE PVC = <input checked="" type="checkbox"/> 3. EXTERIOR COATING = <input checked="" type="checkbox"/> 4. LAMINATE = <input checked="" type="checkbox"/> 5. THINNER INTERIOR WALLS = <input checked="" type="checkbox"/> 6. WALL THICKNESS = 7. RADIUS 8. LOCATION FOR IMPACT TEST 9. ANGULARITY = <input checked="" type="checkbox"/> 10. PERPENDICULARITY = <input checked="" type="checkbox"/> 11. PARALLELISM = <input checked="" type="checkbox"/> 12. FLATNESS = <input checked="" type="checkbox"/> 13. SPECIFICATION LENGTH TO 14. ANGULARITY TO BE ±1° 15. PROFILE MUST MEET Q-323 PER AAMA SPECIFICATIONS 16. PROFILE MUST MEET Q-324 PER AAMA SPECIFICATIONS 17. PROFILE MUST MEET Q-501 PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS 19. MAX BOW .010 IN PER 3'L LENGTH 20. INTERNAL WALL THICKNESS ±0.010 UNLESS OTHERWISE SPECIFIED</p>																		
<p>WEATHERSTRIP SPECIFICATION</p> <table border="1"> <thead> <tr> <th>POSITION</th> <th>SIZE</th> <th>WEATHERSTRIP TYPE</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </tbody> </table>										POSITION	SIZE	WEATHERSTRIP TYPE						
POSITION	SIZE	WEATHERSTRIP TYPE																
<p>FUNCTIONAL CHECK</p> <ul style="list-style-type: none"> - 703 JAMB - 733 JAMB - 717 T-MULLION 																		
<p>DRAWN DATE: 06-03-03 NO. REVISION</p>																		
<p>Use the caliper diagram as your guide to measure the following control points.</p> <p>Measure the following control points using #1 on the caliper diagram: Measure the following control points using #2 on the caliper diagram: Measure the following control points using #3 on the caliper diagram: Measure the following control points using #4 on the caliper diagram: Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours. Auditor - 1 sample per shift recorded 1 hour after shift start.</p>																		
<p>IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED</p>																		

QC PRINT NUMBER: 906qc DRAWN BY: JPP CHECKED BY: APPROVED BY: IN PROCESS IN DEVELOP PRODUCTION

PART NAME: 906 DESCRIPTION: LOCK RAIL SUPPLIER/PLANT: CHELSEA BUILDING PRODUCTS



CHELSEA BUILDING
PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

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NOTES:

1. MATERIAL = RIGID PVC.
2. FLEXIBLE PVC =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS S =
7. RADIUS =
8. LOCATION FOR IMPACT TEST
9. ANGULARITY
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO
ANGULARITY TO BE $\pm 1'$.
14. PROFILE MUST MEET Q-303 $\pm .08"$
15. PER RAMA SPECIFICATIONS
16. PROFILE MUST MEET Q-304
17. PER RAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-301
19. PER RAMA SPECIFICATIONS
20. PROFILE MUST MEET Q-302
- IMPACT RESISTANCE PER
AMA SPECIFICATIONS
- MAX BOW .04in PER 3ft LENGTH
- INTERNAL WALL THICKNESS $\pm .10$
UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

- 716A GLAZING BEAD
- 742 REBAR

DRAWN DATE: 09-20-06 NO. I Revision

2 REVISED WOODGRAIN; WOHB28
1 ADDED 1.486 DIN; WOHB24

JPP 03-19-06
JPP 02-26-08
BY DATE

		CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram;

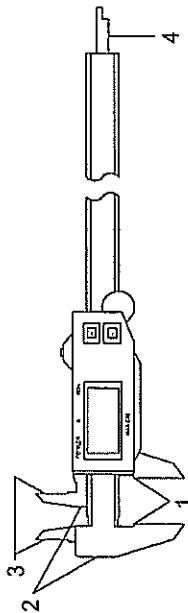
Measure the following control points using #2 on the caliper diagram;

Measure the following control points using #3 on the caliper diagram;

Measure the following control points using #4 on the caliper diagram;

Frequency of sampling: Process Specialist- 3 samples per shift recorded every 4 hours.

If ANY CONTROL POINTS ARE NOT IN SPEC.
CORRECTIVE ACTION REQUIRED



QC PRINT NUMBER: 908w01qc DRAWN BY: JPP CHECKED BY: APPROVED BY:

[] INPROCESS [] PRODUCTION

PART NAME: 908 DESCRIPTION: W01 STILE

SUPPLIER/PLANT:

CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS



CHELSEA BUILDING
PRODUCTS, INC.
55 CEDAR WAY, EASTON, PA 18042

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NOTES:

1. MATERIAL = RIGID P.V.C.

2. FLEXIBLE P.V.C. =

3. EXTERIOR COATINGS =

4. LAMINATE =

5. THINNE INTERIOR WALLS =

6. WALL THICKNESS =

7. RADIUS =

8. LOCATION FOR IMPACTTEST

9. ANGULARITY =

10. PERPENDICULARITY =

11. PARALLELISM =

12. FLATNESS =

13. SPECIFICATION LENGTH TO

14. ANGULARITY TO BE $\pm 4^\circ$

15. PROFILE MUST MEET Q-303 $\pm .018$

PER AAMA SPECIFICATIONS

16. PROFILE MUST MEET Q-304

PER AAMA SPECIFICATIONS

17. PROFILE MUST MEET Q-901

PER AAMA SPECIFICATIONS

18. PROFILE MUST MEET Q-902

PER AAMA SPECIFICATIONS

19. MAX BOW: .016 IN PER 3'L LENGTH

INTERNAL WALL THICKNESS $\pm .010$

UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE
A	.187 x .250	ULTRA FAB
B	.187 x .250	ULTRA FAB

FUNCTIONAL CHECK

716A GLAZING BEAD

NOTE: WHITE WEATHERSTRIP IN ALL COLOR PROFILES

[] .020 B

15. [] .020 B

1 [] $\pm .010$

1.337

2 [] $\pm .010$

.975

REF. [] .025

.625

14 [] $\pm .010$

.625

3 [] $\pm .010$

.100

13 [] $\pm .010$

1.394

-B []

12 [] $\pm .010$

.056

9 [] $\pm .010$

.056

10 [] $\pm .010$

.125

11 [] $\pm .010$

.210

20 [] "B"

21 [] "B"

16. SPECIMEN COMPLIES
WITH THESE DETAILS.
ANY DEVIATION IS NOTED
REPORT NO. NCTL-110-
TEST DATE 6/24/14

DRAWN DATE:	NO. REVISION	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
09-20-06				

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram:

Measure the following control points using #2 on the caliper diagram:

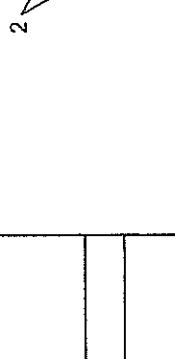
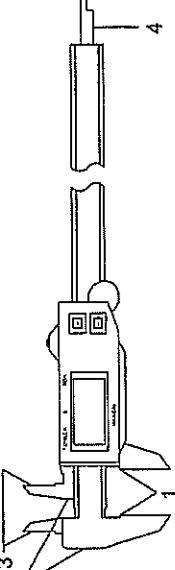
Measure the following control points using #3 on the caliper diagram:

Measure the following control points using #4 on the caliper diagram:

Frequency of sampling: Process Specialist- 3 samples per shift recorded every 4 hours.

Auditor- 1 sample per shift recorded after shift start.

IF ANY CONTROL POINTS ARE NOT IN SPEC.
CORRECTIVE ACTION REQUIRED



QC PRINT NUMBER:	948QC	DRAWN BY:	BLG	CHECKED BY:		APPROVED BY:		DEVELOP	INPROCESS	PRODUCTION
PART NAME:	948	DESCRIPTION:	COMPOSITE STIFFENER		SUPPLIER/PLANT:	CHELSEA BUILDING PRODUCTS SPECIMEN COMPLIES WITH SPECIFICATION DCT-AU.S.				
ILLUSTRATION OF PART AND CONTROL POINTS										
<p>ANY DIMENSION IS NOTED REPORT NO. NCIL-110-11182-1 TEST DATE 6/24/04</p>										
NOTES:	<p>1. MATERIAL = RIGID PVC. 2. FLEXIBLE PVC F 3. EXTERIOR COATING = 4. LAMINATE = 5. THINNER INTERIOR WALLS = 6. WALL THICKNESS = 7. RADIUS = 8. LOCATION FOR IMPACT TEST 9. ANGULARITY ±3° 10. PERPENDICULARITY = ±3° 11. PARALLELISM = 12. FLATNESS = 13. SPECIFICATION LENGTH TO 14. ANGULARITY TO BE ≤ 1° 15. PROFILE MUST MEET Q-303 PER AAMA SPECIFICATIONS 16. PROFILE MUST MEET Q-304 PER AAMA SPECIFICATIONS 17. PROFILE MUST MEET Q-901 PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS 19. MAX BOW 0.65 IN PER 36 IN LENGTH INTERNAL WALL THICKNESS 1.0 IN UNLESS OTHERWISE SPECIFIED WEATHERSTRIP SPECIFICATION</p>									
POSITION	SIZE	WEATHERSTRIP TYPE								
FUNCTIONAL CHECK										
705 LOCK RAIL										
707 KEEPER RAIL										
737 KEEPER RAIL										
Use the caliper diagram as your guide to measure the following control points. Measure the following control points using #1 on the caliper diagram: Measure the following control points using #2 on the caliper diagram: Measure the following control points using #3 on the caliper diagram: Measure the following control points using #4 on the caliper diagram: Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours, Auditor - 1 sample per shift recorded 1 hour after shift start.										
IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED										
3	REVISED DIMS & TOLS									TOLERANCE
2	REVISED DIMS, TOLS & NOTES									
1	REVISED DIMS, TOLS & NOTES									
NO. REVISION										
DRAWN DATE: 05/16/08										
BLG 01/16/09										
BLG 01/13/09										
EAS 12-18-08										
EAS 12-18-08										
BY DATE										
3										
2										
4										

QC PRINT NUMBER:	955qc	DRAWN BY:	DRN	CHECKED BY:		APPROVED BY:	
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PART NAME: **955** DESCRIPTION: **HERITAGE BTM RAIL**

SUPPLIER/PLANT: **CHELSEA BUILDING PRODUCTS**

ILLUSTRATION OF PART AND CONTROL POINTS



CHELSEA BUILDING PRODUCTS, INC.

505 CEDAR WAY, OAKMONT PA 15139

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USE OR REPRODUCTION IS STRICTLY PROHIBITED.

NOTES:

1. MATERIAL = RIGID PVC.
2. FLEXIBLE PVC =
3. EXTERIOR COATING =
4. LAMINATE
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ± .006
7. RADIUS = .100
8. ANGULARITY LOCATION FOR IMPACT TEST =
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO ≤ 30"
14. ANGULARITY TO BE ± 1°
15. PROFILE MUST MEET Q-303
16. PROFILE MUST MEET Q-304
17. PROFILE MUST MEET Q-901
18. PROFILE MUST MEET Q-902
- IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046 IN PER 30 LENGTH
20. INTERNAL WALL THICKNESS = .10 UNLESS OTHERWISE SPECIFIED
- WEATHERSTRIP SPECIFICATION

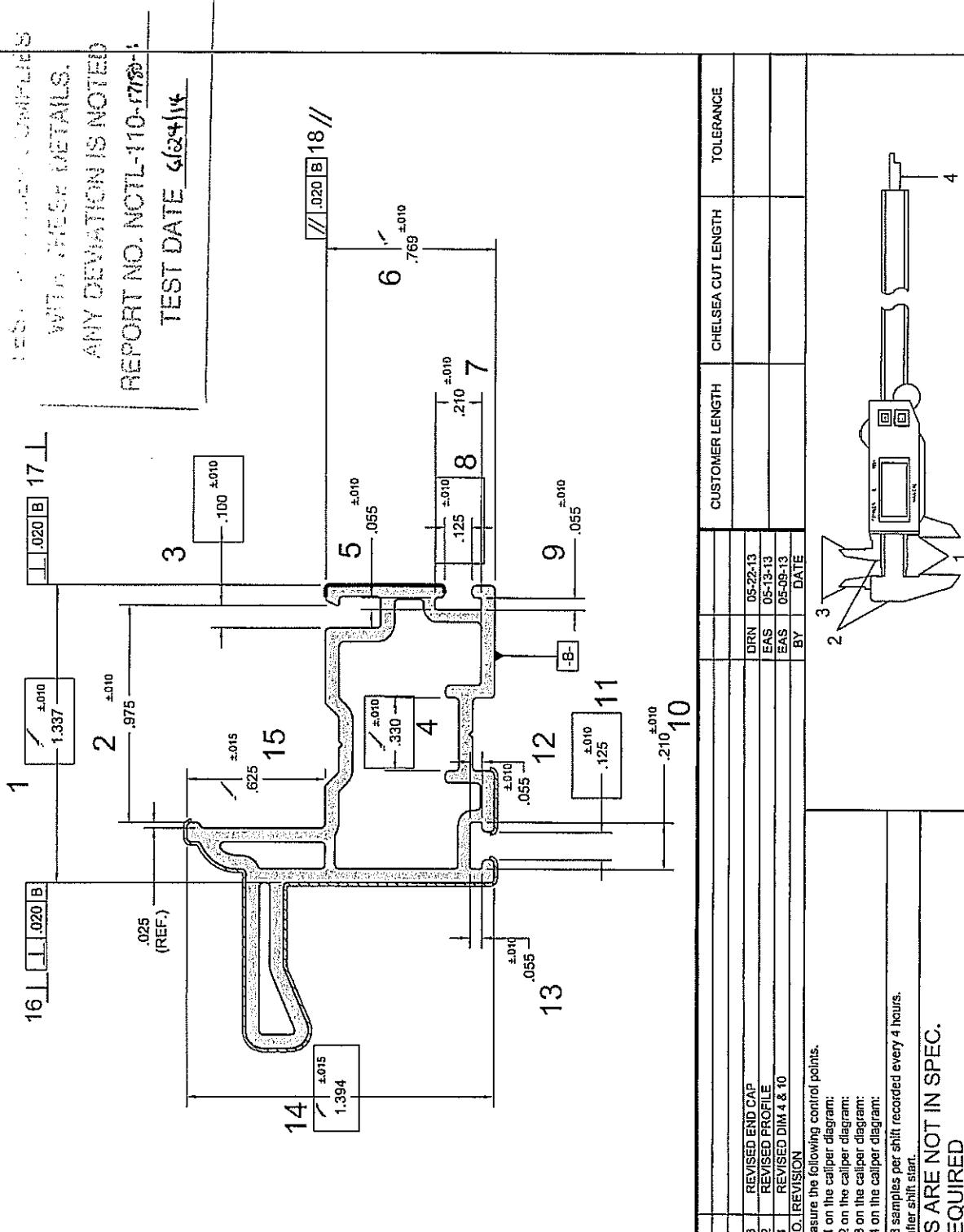
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

716A GLAZING BEAD

#32669 AMESBURY BTM SEAL
END CAP

VISION INDUSTRIES GROUP #2280



NO. / REVISION	REVISED END CAP	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
3	REVISED PROFILE	DRN	05-22-13	
2	REVISED PROFILE	DRN	05-13-13	
1	REVISED DIM 4 & 10	DRN	05-09-13	
		BY DATE		

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram;

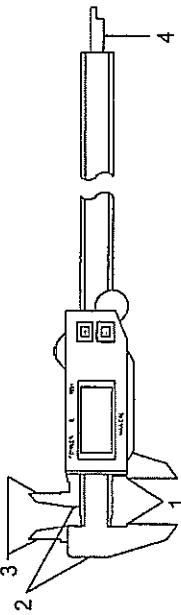
Measure the following control points using #2 on the caliper diagram;

Measure the following control points using #3 on the caliper diagram;

Measure the following control points using #4 on the caliper diagram;

Auditor- 1 sample per shift recorded 1 hour after shift start.

IF ANY CONTROL POINTS ARE NOT IN SPEC.
CORRECTIVE ACTION REQUIRED



QC PRINT NUMBER:	965w03qc	DRAWN BY:	BLG	CHECKED BY:		APPROVED BY:	
PART NAME:	965	DESCRIPTION:	HERITAGE TOP RAIL	SUPPLIER/PLANT:	CHELSEA BUILDING PRODUCTS		



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NOTES:

1. MATERIAL = RIGID PVC
2. FLEXIBLE PVC =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .067 ± .006
7. RADIUS = .020
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO: ±38"
14. ANGULARITY TO: 8E±1°
15. PROFILE MUST MEET Q-303
16. PROFILE MUST MEET Q-304
17. PROFILE MUST MEET Q-301
18. PROFILE MUST MEET Q-302
19. IMPACT RESISTANCE PER AAMA SPECIFICATIONS
20. MAX BOW: .016in PER 3ft LENGTH
21. INTERNAL WALL THICKNESS: ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE
A, B	.187 X .220	ULTRA FAB

FUNCTIONAL CHECK

716A GLAZING BEAD

WOOLPILE (.187 BACK)

END CAP

VISION INDUSTRIES GROUP #2260

DRAWN DATE: 10/09/13 NO. | REVISION

BY DATE

CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

Use the caliper diagram as your guide to measure the following control points.

Measure the following control points using #1 on the caliper diagram:
 Measure the following control points using #2 on the caliper diagram:
 Measure the following control points using #3 on the caliper diagram:
 Measure the following control points using #4 on the caliper diagram:

Frequency of sampling: Process Specialist - 3 samples per shift recorded every 4 hours.
 Auditor - 1 sample per shift recorded 1 hour after shift start.

IF ANY CONTROL POINTS ARE NOT IN SPEC.
 CORRECTIVE ACTION REQUIRED

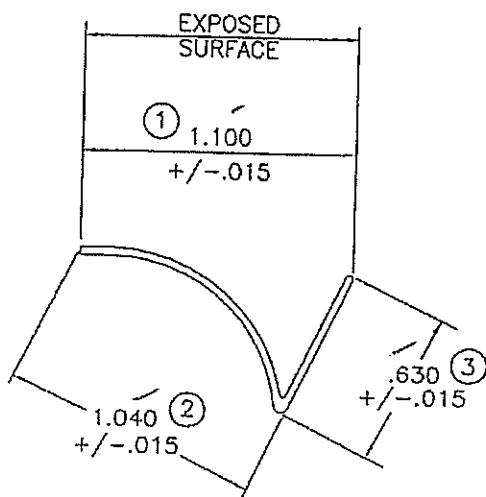
Diagram showing a top rail profile with callout numbers 1 through 21. Control points are indicated by arrows pointing to specific dimensions: 1 (.1337 ± .010), 2 (.975 ± .010), 3 (.100 ± .010), 4 (.055 ± .010), 5 (.769 ± .010), 6 (.125 ± .010), 7 (.125 ± .010), 8 (.055 ± .010), 9 (.055 ± .010), 10 (.055 ± .010), 11 (.125 ± .010), 12 (.210 ± .010), 13 (.1394 ± .015), 14 (.625 ± .015), 15 (.020 ± .020), 16 (.020 ± .020), 17 (.020 ± .020), 18 ("A" ± .010), 19 ("B" ± .010), 20 ("B" ± .010), 21 ("B" ± .010).

2408 BALANCE COVER

QUALITY CONTROL PRINT

TYP. WALL THKNS. = .030 +/- .003
UNLESS NOTED

REVISION DATE: 0



TEST SPECIMEN COMPLIES

WITH THESE DETAILS.

ANY DEVIATION IS NOTED

REPORT NO. NCTL-110-17180-1TEST DATE 4/24/04

	1	2	3	4	5	6	7	8	9	10	11	12
DIM.	1.100	1.040	.630									
LOW	1.085	1.025	.615									
HIGH	1.115	1.055	.645									

NOTES:

- 1.) PART MUST BE SQUARE.
- 2.) ▼ LOCATION FOR IMPACT TEST.
- 3.) ALLOWABLE BOW MAX. 1" PER 14' LENGTH.
- 4.) ◊ LOCATION FOR AAMA SHRINK TEST IF APPLICABLE.

APPROVED BY:

ENG. Kent JohnsonQA Debbie S. Blen

DRWN. BY:

M.P.T.

DATE:

2-11-02

DWG.:

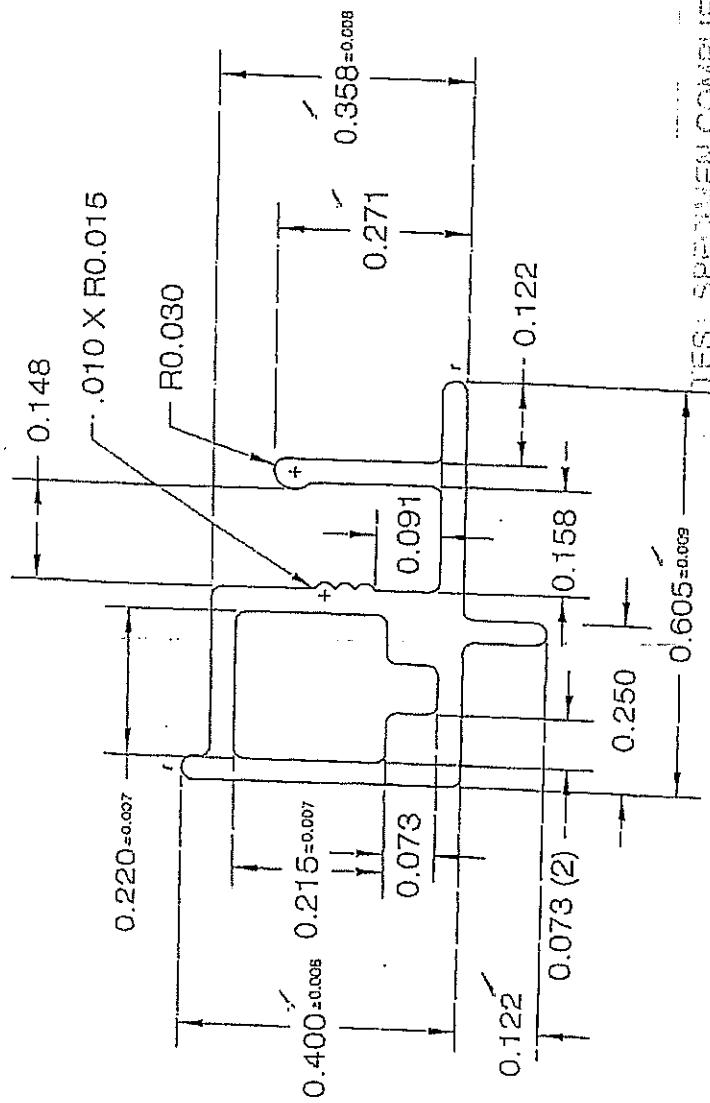
2408QC



Custom Window Extrusions
One Contact Place
Delmont, PA 15628

Shapes Die #

1002-HR4



YES: SPECIMEN COMPIES
WITH THESE DETAILS.
ANY DEVIATION IS NOTED
REPORT NO. NOTL-HR-1786-1
TEST DATE 6/24/94

ALLOY & TEMPER	T5	WT/FT	.100
SCALE	4:1	AREA	.0772
UNMARKED WALLS	.035	DRAWN BY	MTM
BREAK CORNERS	.015		
DESCRIPTION			SCREEN RAIL W/ STOP

SHAPES UNLIMITED, INC.
590 E. Western Reserve Rd.
Youngstown, Ohio 44514

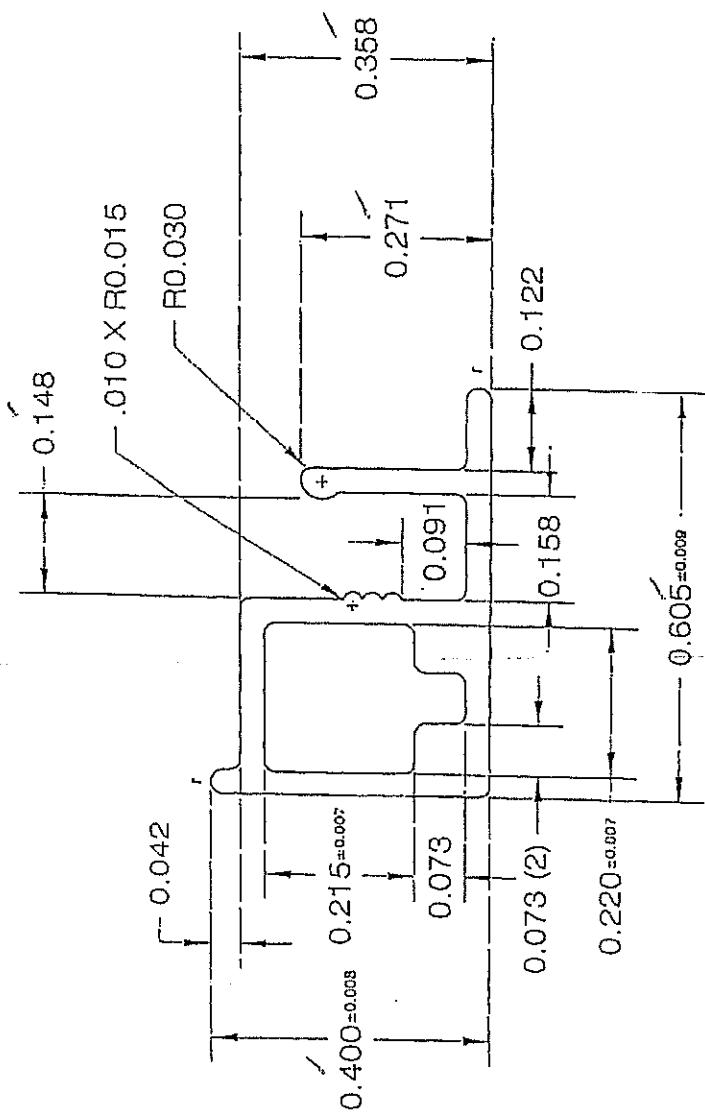
Ph: 330-726-0844
Fax: 330-758-4353

DWG.NO.: 1002-HR4 DATE: 03/09/04

Aluminum Assoc. Std. Tolerances Apply Unless
Specifically Shown Otherwise

Shapes Die #

1001-HR4



TEST SPECIMEN COMPLIES

WITH THESE DETAILS.

ANY DEVIATION IS NOTED

REPORT NO. NCTL-110-1186-A

TEST DATE 4/24/94

ALLOY & TEMPER	WT/FT	AREA	DRAWN BY	DWG.NO.:	DATE:
6063 T5	.088	.0729	MTM	1001-HR4	03/09/04
SCALE	4:1	UNMARKED WALLS	.035		
BREAK CORNERS	.015	DESCRIPTION	SCREEN RAIL		
Aluminum Assoc. Std. Tolerances Apply Unless Specifically Shown Otherwise					

Ph: 330-726-0844
Fax: 330-758-4353

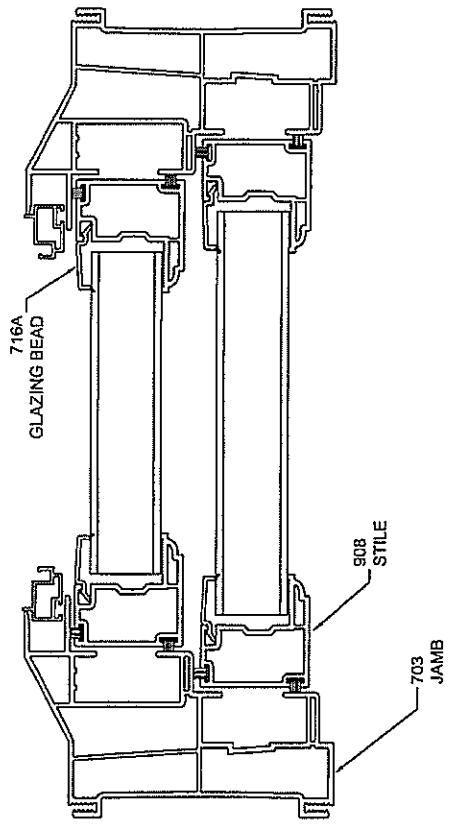
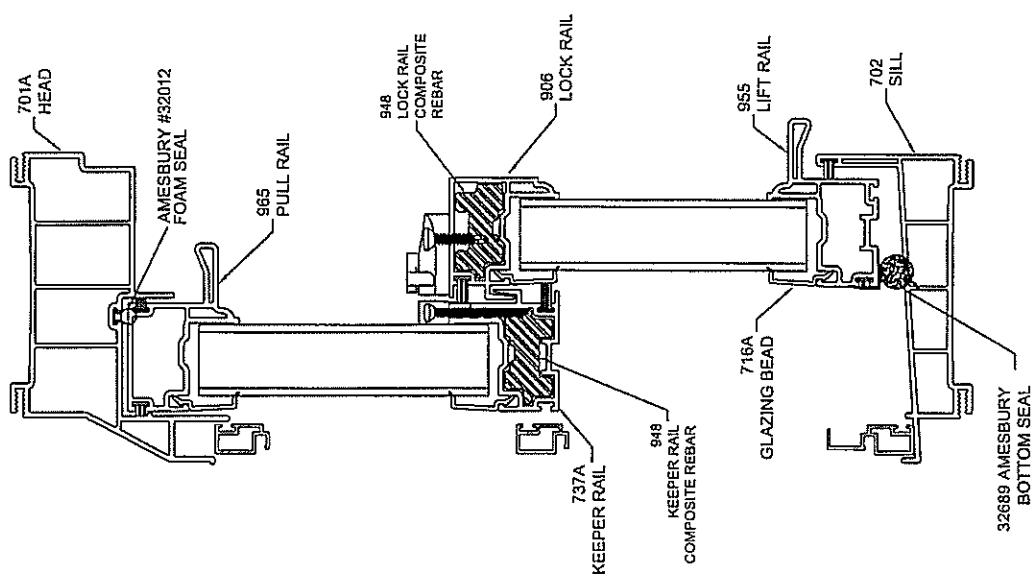
100 E. Western Reserve Rd.

Youngstown, Ohio 44514

100 E. Western Reserve Rd.

Youngstown, Ohio 44514

8065002



TEST SPECIMEN COMPLIES
WITH THESE DETAILS.
ANY DEVIATION IS NOTED
REPORT NO. NCTL-110-17180-1
TEST DATE 6/24/14

PRELIMINARY PART #		TITLE		DRAWN BY:		APPROVED BY:	
		CHELSEA BUILDING PRODUCTS, INC.		565 CEDAR WAY, OAKMONT, PA 15139		DATE 05-22-13	
COPYRIGHT 2011	THIS DRAWING AND ITS CONTENTS ARE THE SOLE PROPERTY	OF CHELSEA BUILDING PRODUCTS, INC. ANY UNAUTHORIZED	USE OR REPRODUCTION IS STRICTLY PROHIBITED.	SCALE	NTS-1	DRAWING No.	700-DH-T300
No. REVISION	BY DATE						