

MASTER WINDOW SYSTEMS TEST REPORT

SCOPE OF WORK

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

TESTING ON SERIES/MODEL: 2700 SERIES SINGLE-SLIDER PRODUCT TYPE: PVC HORIZONTAL SLIDING WINDOW (XO)

REPORT NUMBER

H5964.08-501-44-R0

TEST DATES

10/17/17 - 01/15/18

ISSUE DATE

03/17/25

RECORD RETENTION END DATE

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ATI 00438 (07/24/17) RT-R-AMER-Test-2804 © 2017 INTERTEK





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TEST REPORT FOR MASTER WINDOW SYSTEMS

Report No.: h5964.08-501-44-R0

Date: 03/17/25

REPORT ISSUED TO

Master Window Systems 5070 Nifda Drive SE Atlanta, Georgia 30339

SECTION 1

SCOPE

Intertek Building & Construction (B&C) was contracted by Chelsea Building Products, Oakmont, Pennsylvania to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-11, NAFS 2011 - North American Fenestration Standard/Specification for Windows, Doors, and Skylights and AAMA/WDMA/CSA 101/I.S.2/A440-08, NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights, on their 9230/9280 HS-T510, PVC Horizontal sliding window. This test report is a reissue of the original Report No. H5964.01-501-44. This report is issued in the name of Master Window Systems on their 2700 Series Single-Slider, PVC Horizontal Sliding Window through written authorization of Chelsea Building Products. Results obtained are tested values and were secured by using the designated test method(s). Testing was conducted at Intertek test facility in Springdale, Pennsylvania. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory.

For INTERTEK B&C:

COMPLETED BY:	Matthew Hollinger	REVIEWED BY:	Stephen D. Shank, FMPC
			Regional Manager – Field &
	Project Manager – Field &		Laboratory Testing Building
TITLE:	Laboratory Testing	TITLE:	and Construction
SIGNATURE:		SIGNATURE:	
DATE:	03/17/25	DATE:	03/17/25
	_		
COMPLETED BY:	James P. Grippo	REVIEWED BY:	Joseph E. Allison
COMPLETED BY:	• •	REVIEWED BY:	Joseph E. Allison
COMPLETED BY:	James P. Grippo Technician — Building and Construction	REVIEWED BY: TITLE:	·
	Technician – Building and		Joseph E. Allison Laboratory Supervisor
	Technician – Building and		·
	Technician – Building and Construction		Laboratory Supervisor
TITLE:	Technician – Building and Construction	TITLE:	Laboratory Supervisor

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SECTION 2

SUMMARY OF TEST RESULTS

TITLE	TEST SPECIMEN #1 NEW CONSTRUCTION FRAME 9230-HS-T510	TEST SPECIMEN #2 REPLACEMENT FRAME 9280-HS-T510
AAMA/WDMA/CSA 101/I.S.2/A440-08 and -11	Class LC-PG30 1829 x 1524 (72 x 60)-HS	Class LC-PG30 1829 x 1524 (72 x 60)-HS
Design Pressure	±1440 Pa (±30.08 psf)	±1440 Pa (±30.08 psf)
Air Infiltration	0.9 L/s/m ² (0.18 cfm/ft ²)	Reference Specimen #1
Canadian Air Infiltration/Exfiltration Level	A2	Reference Specimen #1
Water Penetration Resistance Test Pressure	220 Pa (4.60 psf)	Reference Specimen #1

SECTION 3

TEST METHOD(S)

The specimens were evaluated in accordance with the following:

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

SECTION 4

MATERIAL SOURCE/INSTALLATION

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

The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 3/16" shim space. The exterior perimeter of the window was sealed with sealant.

Test Specimen #1;

LOCATION	ANCHOR DESCRIPTION	ANCHOR LOCATION
Integral nail fin	#6 x 1-1/4" long drywall screws	Nominally spaced at 8" on centers and starting 2" in from each end.

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Test Specimen #2;

LOCATION ANCHOR DESCRIPTION		ANCHOR LOCATION
Jambs	#8 x 2" long pan head screws	Two screws per jamb, one 5" in from each end (inner track).
Head	#8 x 2" long pan head screws	One screw at the midspan (inner track).

SECTION 5

EQUIPMENT

Calibration of test equipment was performed by Intertek B&C in accordance with AAMA 205-01 "In-Plant Testing Guidelines for Manufacturers and Independent Laboratories"

SECTION 6

LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Joe Powers	Chelsea Building Products
Joseph Allison	Intertek B&C
Samuel Fortuna	Intertek B&C
Shawn Baker	Intertek B&C

SECTION 7

GATEWAY

Reference Intertek B&C Report No. H5964.01-501-44, dated 01/23/18 for complete *Gateway* test specimen description and test results.

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SECTION 8

TEST SPECIMEN DESCRIPTION

Product Type: PVC Horizontal Window Sliding (XO)

Series/Model: 2700 Series Single-Slider

Product Size(s):

Test Specimens #1and #2:

OVERALL AREA:	WIDTH		HEIGHT	
2.8 m ² (30.0 ft ²)	millimeters	inches	millimeters	inches
Overall size	1829	72	1524	60
Sash size	905	35-5/8	1470	57-7/8
Screen size	845	33-1/4	1435	56-1/2

The following descriptions apply to all specimens.

Frame Construction:

FRAME MEMBER	MATERIAL	DESCRIPTION
Head, sill and jambs	PVC	Extruded
Fixed meeting stile	PVC	Extruded
Roller track	PVC	Extruded
	JOINERY TYPE	DETAIL
All corners	Mitered	Thermally welded
Fixed meeting stile	Coped and butted	Secured to the head and sill with a metal diecast pass-thru clip. Each clip was fastened to the stile with two #6 x 1" long screws and to the frame member with two the #6 x 1" long screws.
Roller track	Straight-cut	Sill insert

Sash Construction:

SASH MEMBER	MATERIAL	DESCRIPTION
All rails and stiles	PVC	Extruded
	JOINERY TYPE	DETAIL
All corners	Mitered	Thermally welded

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Reinforcement:

DRAWING NUMBER	LOCATION	MATERIALS
9252	Fixed meeting stile	Extruded aluminum
9253	Lock stile	Extruded aluminum

Weatherstripping:

Treather bhill.		
DESCRIPTION	QUANTITY	LOCATION
0.187" backed with 0.250" high center fin pile	2 Rows	Top rail and bottom rail
0.187" backed with 0.250" high center fin pile	1 Row	Pull stile and all frame members
0.187" backed with 0.220" high center fin pile	1 Row	Lock stile and fixed meeting stile
Adhesive back pad (1/2" wide by 1" high) with 0.230" high pile	1 Each	Lock stile, one at the bottom 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
3/4" IG	"U" shaped aluminum/butyl	1/8" annealed	1/8" annealed	Set against double-sided adhesive tape and secured with rigid vinyl glazing beads. The sash lite was set from the exterior and the fixed lite was set from the interior.

Location	QUANTITY	DAYLIGHT OPENING		GLASS
		millimeters	inches	BITE
Sash	1	835 x 1400	32-7/8 x 55-1/8	1/2"
Fixed lite	1	835 x 1407	32-7/8 x 55-3/8	1/2"



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Drainage:

Drainage:			
DRAINAGE METHOD	SIZE	QUANTITY	LOCATION
Weepslot with flap	1" wide by 1/4" high	3	Exterior sill face, one at each end and one at the midspan
Weepslot	1-3/16" wide by 1/4" high	2	Sill, interior track, one at each end
Weepslot	3/8" wide by 3/16" deep	2	Sill, glazing plane/outer track, through two walls, one at each end
Weepslot	3/8" wide by 3/32" deep	2	Sill, glazing bead channel/outer track, one at each end.
Weepslot	3/4" wide by 3/16" deep	2	Sill, internal horizontal wall, one at each end
Weepslot	3/8" wide by 3/16" deep	2	Bottom rail, glazing plane (through two walls), one at each end
Weep notch	1" wide by 1/4" high	4	Roller track, both legs (center leg with angle cut), two at each end

Hardware:

DESCRIPTION	QUANTITY	LOCATION
Metal cam lock with keeper	2	Lock stile with mating keeper on the fixed meeting stile, one 7" in from each end.
Dual metal roller assembly	2	Bottom rail, one at each end

Screen Construction:

FRAME MATERIAL	CORNER CONSTRUCTION	MESH TYPE	MESH ATTACHMENT METHOD
Roll-form aluminum	Square-cut with plastic corner keys	Fiberglass	Flexible vinyl spline

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SECTION 9

TEST RESULTS

The temperature during testing was 19.4°C (67°F). The results are tabulated as follows:

Test Specimen #1:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
	Initiate Motion:		
	45 N (10 lbf)	Report only	
Operating Force,	Maintain Motion:		
per ASTM E2068	26 N (6 lbf)	90 N (20 lbf) max	
	Locks:		
	18 N (4 lbf)	100 N (22.5 lbf) max	
Air Leakage,			
Infiltration per ASTM E283	0.9 L/s/m ²	1.5 L/s/m ²	
at 75 Pa (1.57 psf)	(0.18 cfm/ft ²)	(0.3 cfm/ft ²) max.	1, 2
Air Leakage,			
Exfiltration per ASTM E283	0.9 L/s/m ²	1.5 L/s/m ²	
at 75 Pa (1.57 psf)	(0.18 cfm/ft ²)	(0.3 cfm/ft ²) max.	1, 2
Canadian Air		1.5 L/s/m ²	
Infiltration/Exfiltration Level	A2	(0.3 cfm/ft ²) max	
Water Penetration,			
per ASTM E547	N/A	N/A	4
Uniform Load Deflection,			
per ASTM E330	N/A	N/A	4
Uniform Load Structural,			
per ASTM E330	N/A	N/A	4
Forced Entry Resistance,			
per ASTM F588 ,			
Type: A - Grade: 20	Pass	No entry	
Thermoplastic Corner Weld	Pass	Meets as stated	
Deglazing,			
per ASTM E987			
Operating direction,			
320 N (72 lbf)	Pass	Meets as stated	
Remaining direction,			
230 N (52 lbf)	Pass	Meets as stated	

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Test Specimen #1:

TITLE OF TEST	RESULTS	ALLOWED	NOTE		
OPTIONAL PERFORMANCE					
Water Penetration,					
per ASTM E547					
at 220 Pa (4.60 psf)	Pass	No leakage	3		
Uniform Load Deflection,					
per ASTM E330					
Deflections taken at the					
fixed meeting stile					
+1440 Pa (+30.08 psf)	28.5 mm (1.12")	Report only			
-1440 Pa (-30.08 psf)	26.9 mm (1.06")		5, 6, 7		
Uniform Load Structural,					
per ASTM E330					
Permanent set taken at the					
fixed meeting stile					
+2160 Pa (+45.11 psf)	1.5 mm (0.06")	5.5 mm (0.22") max.			
-2160 Pa (-45.11 psf)	1.8 mm (0.07")	5.5 mm (0.22") max.	6, 7		

Test Specimen #2:

rest specimen #2:			
TITLE OF TEST	RESULTS	ALLOWED	NOTE
OPTIONAL PERFORMANCE			
Uniform Load Deflection,			
per ASTM E330			
Deflections taken at the			
fixed meeting stile			
+1440 Pa (+30.08 psf)	30.2 mm (1.19")	Report only	
-1440 Pa (-30.08 psf)	27.9mm (1.10")		5, 6, 7
Uniform Load Structural,			
per ASTM E330			
Permanent set taken at the			
fixed meeting stile			
+2160 Pa (+45.11 psf)	2.0 mm (0.08")	5.5 mm (0.22") max.	
-2160 Pa (-45.11 psf)	1.8 mm (0.07")	5.5 mm (0.22") max.	6, 7

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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 01/10/18 / Time: 1:30PM

Note 3: With and without insect screen.

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

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

Note 6: Loads were held for 10 seconds.

Note 7: Tape and film were used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

SECTION 10

ALTERATIONS

No alterations were required.

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TEST REPORT FOR MASTER WINDOW SYSTEMS

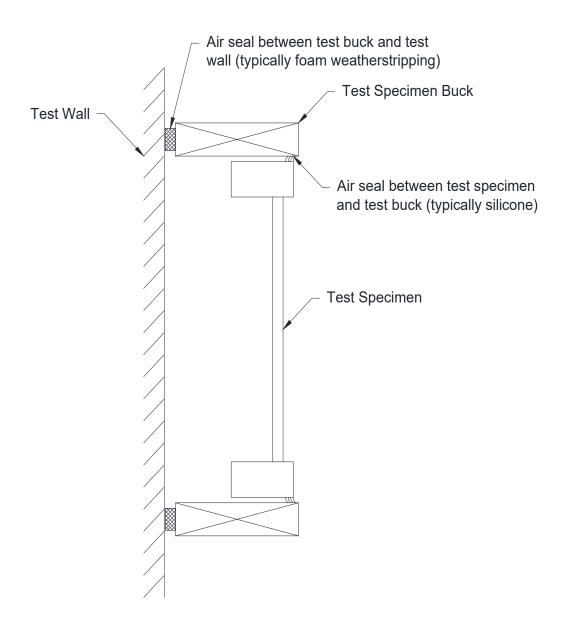
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SECTION 11

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.



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SECTION 12

CONCLUSION

The specimens tested successfully met the performance requirements for the following ratings:

TEST SPECIMEN(S)	TITLE	SUMMARY OF RESULTS
1	101/I.S.2/A440-08 and -11	Class LC-PG30 1829 x 1524 (72 x 60)-HS
2	101/I.S.2/A440-08 and -11	Class LC-PG30 1829 x 1524 (72 x 60)-HS

Reference Intertek-ATI Report No. H5964.01-501-44, dated 01/23/18 for complete *Gateway* test specimen description and test results.

This report is reissued in the name of Master Window Systems through written authorization from Chelsea Building Products to whom the original report was rendered. The original Chelsea Building Products Report No. is H5964.01-501-44.

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

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SECTION 13

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 on file with Intertek-ATI. Any deviations are documented herein or on the drawings.

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BILL OF MATERIALS Model 9230-HS-T510

A596401-501-46

New Construction XO Slider

3/4" Glass (7/8" Glass Optional)

Revised December 8, 2017

ITEM	DESCRIPTION	GBP PART#	QTY	MATERIAL/SOURCE	NOTES
1	Master Frame	9214	4	CBP	2
2	Rail	9208	2	CBP	2
3	Lock Stile	9206	1	CBP	2
4	Meeting Stile	9257	1	CBP	2
5	Pull Stile	9205	1	CBP	2
6				CBP	2
7	3/4" Glazing Bead (Fixed)	9216	4		2
	3/4" Glazing Bead (Vent)	816	4	CBP	· · · · · · · · · · · · · · · · · · ·
8	Sill Track	9247	1	CBP	2
9	Aluminum Stiffener – Lock Stile	9253	1	BRT Extrusions #14605-A	1
10	Aluminum Stiffener – Meeting Stile	9252	1_1_	BRT Extrusions #14606	1
11	Anti Lift	9247	1	СВР	2
12	Pass-thru Clip		2	Four-Jaks #VCP028	1
13	Roller		2	Vision #1173	1
14	Silicone Glazing Sealant		AR	Pecora #895	1
15	Glazing Block (3/4" x 3/4" x 1/8")		AR	Tremco	1
16	Weep Cover		2	Choose from optional section	1,2
17	Keeper		1	Vision #9316-00	2,3
18	Lock		1	Vision #671-00	2,3
	SCREWS (#410 Stainless	Steel or 2	Zinc Plated)	=[=
				#6 x 1" PH Flat HD	
19	Pass-thru Clip		8	Type AB, SMS	
	Keeper Screw		4.5	#6 x 3/4" PH Flat HD	
20	(Alum or Steel Rebar)		AR	TEK (Self-drilling) #6 x 3/4" PH Flat HD	2,3
21	Lock Screw (Alum or Steel Rebar)		AR	TEK (Self-drilling)	2,3
	Stiffener Screw		1.00	#6 x 1/2" PH Flat HD	
22	(Alum or Steel Rebar)		AR	TEK (Self-drilling)	
		WEATHERST	RIPPING		•
	Center Fin Pile				
23	(Lock Rail, Meeting Rail)		AR	.187 x .220	
24	Center Fin Pile (Pull Stile, Rail, Frame)		AR	.187 x .250	
		OPTION	IAL		
25	Drip Cap (J Removed)	9236	AR	CBP	2
26	Drip Cap	9239/ 9239M	AR	СВР	2
27	Transom Clip	727	AR	CBP	2

Intertek Date:

Report #: Verified by:

H5964.01-501-47 01/18/2018 An office

New Construction XO Slider 3/4" Glass (7/8" Glass Optional) 9230hst510.doc Page 2 of 2

	OPTIONAL (cont.)					
28	Jamb Extension Clip	723	AR	CBP	2	
29	1/2" Mullion Clip	749	AR	СВР	2	
30	Drywall Receptor	722	AR	CBP	2	
31	3/4" Wood Return	738	AR	CBP	2	
32	Structural Mullion	803	AR	CBP	2	
33	Screen Clip	9218	AR	CBP	2	
34	Non-removable Meeting Stile Screw	}	4	#6 x 2" PH Pan HD Type AB, SMS		
35	Glazing Block (7/8" x 7/8" x 1/8")		AR	Tremco	1	
36	Glazing Tape (1/16" x 3/8")		AR	Lamatek HGT	1	
37	Lock		1	Lawrence Industries #2802 Requires fab tooling change	2,3	
38	Keeper		1	Lawrence Industries #2600-402 Requires fab tooling change	2,3	
39	Weep Cover		2/15)	Gaer #98-03-00-00	1,2	
40	Weep Cover		2(3)	Vision #1230	2	
41	Screen Frame		AR	3/8"	2	

NOTES:

1 = Or Approved Equivalent 2 = Specify color (White, Beige, Brown) 3 = For windows over 32" double amount used

No.	Revision	Ву	Date	Checked By	Approved By
7	Added Vision lock & keeper as standard WO#17292	BLG	12/08/17		
6	Added Lawrence lock & keeper as standard	BLG	09/27/16		
5	Added 5/8" Glass Glazing Beads	EAS	02-05-15		
4	Added 9236 Drip Cap	BLG	07/31/13		
3	Revised Rebar	DRN	05-09-13		
2	Revised Truth lock part # from A09000425	DW	9-28-12		
1	BOM Created	EAS	12-05-11		

Report #:

H5964.01-501-47 01/18/2018

Verified by:

Cope Both

BILL OF MATERIALS Model 9280-HS-T510

Replacement XO Slider 3/4" Glass (7/8" Glass Optional)

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·	925Unstatu.doc page 1 or 2						
ITEM	DESCRIPTION	CBP PART#	QTY	MATERIAL/SOURCE	NOTES		
1	Master Frame	9214F	4	CBP	2		
2	Rail	9208	2	СВР	2		
3	Lock Stile	9206	1	CBP	2		
4	Meeting Stile	9257	1	CBP	2		
5	Pull Stile	9205	1	CBP	2		
6	3/4" Glazing Bead (Fixed)	9216	4	CBP	2		
7	3/4" Glazing Bead (Vent)	816	4	CBP	2		
8	Sill Track	9247	1	CBP	2		
9	Aluminum Stiffener – Lock Stile	9253	1	BRT Extrusions #14605-A	1		
10	Aluminum Stiffener – Meeting Stile	9252	1	BRT Extrusions #14606	1		
11	Anti Lift	9247	1	CBP	2		
12	Pass-thru Clip		2	Four-Jaks #VCP028	1		
13	Roller		2	Vision #1173	1		
14	Silicone Glazing Sealant		AR	Pecora #895	1		
15	Glazing Block (3/4" x 3/4" x 1/8")		AR	Tremco	1		
16	Weep Cover		2	Choose from optional section	2		
17	Keeper		1	Vision #9316-00	2,3		
18	Lock		1	Vision #671-00	2,3		
		#410 Stainless					
				#8 x 2-1/2" PH Pan HD			
19	Installation		4	Type AB, SMS			
20	Pass-thru Clip		8	#6 x 1" PH Flat HD Type AB, SMS			
21	Keeper Screw (Alum or Steel Rebar)		AR	#6 x 3/4" PH Flat HD TEK (Self-drilling)	2,3		
22	Lock Screw (Alum or Steel Rebar)		AR	#6 x 3/4" PH Flat HD TEK (Self-drilling)	2,3		
23	Stiffener Screw (Alum or Steel Rebar)		AR	#6 x 1/2" PH Flat HD TEK (Self-drilling)			
		WEATHERST	RIPPING				
24	Center Fin Pile (Lock Rail, Meeting Rail)		AR	.187 x .220			
25	Center Fin Pile (Pull Stile, Rail, Frame)		AR	.187 x .250			
		OPTION	AL				
26	Head Expander	750	1	CBP	2		
27	Transom Clip	727	AR	CBP	2		
							



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Replacement XO Slider 3/4" Glass (7/8" Glass Optional)

0,4 0.0	OPTIONAL (cont.)						
28	2-Piece Sill Riser Male	988	1	СВР	2		
29	1/2" Mullion Clip	749	AR	СВР	2		
30	Sill Riser	765/765M	1	CBP	2		
31	2-Piece Sill Riser Female	989	1	СВР	2		
32	Structural Mullion	803	AR	СВР	2		
33	Screen Clip	9218	AR	CBP	2		
34	Flush Flange	9264	AR	СВР	2		
35	Non-removable Meeting Stile Screw		4	#6 x 2" PH Pan HD Type AB, SMS			
36	Glazing Block (7/8" x 7/8" x 1/8")		AR	Tremco	11		
37	Glazing Tape (1/16" x 3/8")		AR	Lamatek HGT	1		
38	Lock		1	Lawrence Industries #2802 Requires fab tooling change	2,3		
39	Keeper		1	Lawrence Industries #2600-402 Requires fab tooling change	2,3		
40	Weep Cover		2(2)	Gaer #98-03-00-00	1,2		
41	Weep Cover		2 (3)	Vision #1230	2		
42	Screen Frame		AR	3/8"	2		

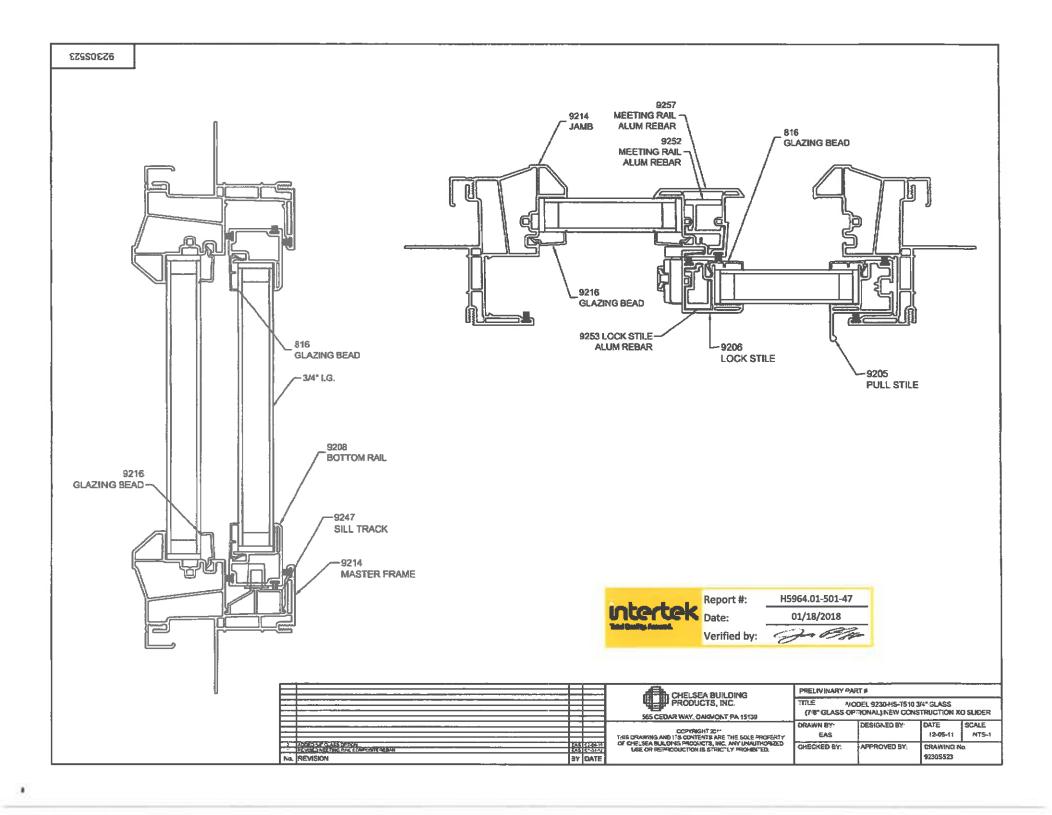
NOTES:

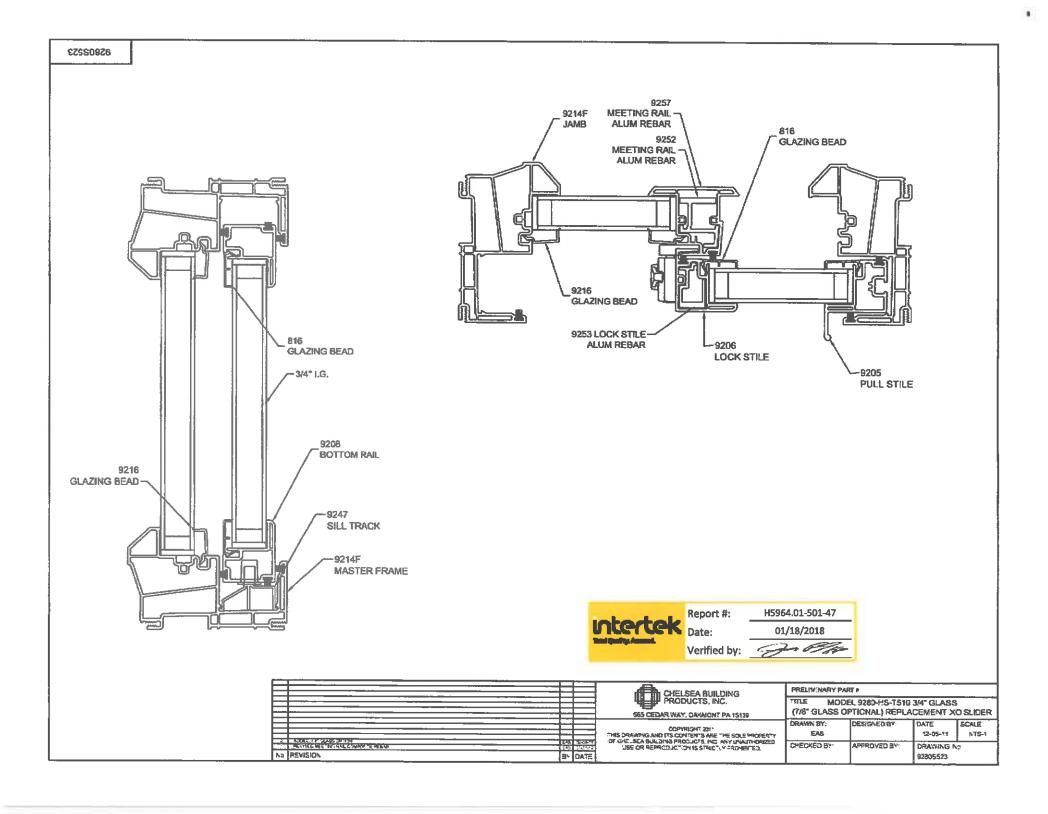
1 = Or Approved Equivalent 2 = Specify color (White, Beige, Brown) 3 = For windows over 32" double amount used

No.	Revision	Ву	Date	Checked By	Approved By
7	Added Vision lock & keeper as standard WO#17292	BLG	12/08/17		
6	Added Lawrence lock & keeper as standard	BLG	09/27/16		
5	Added 5/8" Glass Glazing Beads	EAS	02-05-15		_
4	Revised Rebars	DRN	05-09-13		
3	Added 9264 Flush Flange	EAS	03-04-12		
2	Revised Truth lock part # from A09000425	DW_	9-28-12		
1	BOM Created	EAS	12-05-11		

Report #:

H5964.01-501-47 01/18/2018 Verified by:





QC PRINT NUMBER: DRAWN BY: CHECKED BY: APPROVED BY: DEVELOP INPROCESS PRODUCTION EAS 9214QC SUPPLIER/PLANT: **DESCRIPTION:** PART NAME: **XO SLIDER FRAME** CHELSEA BUILDING PRODUCTS 9214 ILLUSTRATION OF PART AND CONTROL POINTS CHELSEA BUILDING PRODUCTS, INC. PASS-THRU CLIP -565 CEDAR WAY, OAKMONT PA 15139 COPYRIGHT 2017
THIS CRAMING AND ITS COPYTHYS ARE THE SOLE PROPERTY
OF CHELSEA BUILDING PRODUCTS, MC. ARY WARSTHOPSEED
USE OR REPRODUCTION IS STRUCTLY PROHIBITED. (REF) ±.010 .969 -(REF) 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = \$000000000 .100 -.625 3. EXTERIOR COATING = (REF) 4. LANINATE = ZZZZZZZZ .050 5. THINNER INTERIOR WALLS = C 6. WALL THICKNESS = (.062 ±.006 7. RADIUS = .020 R B. LOCATION FOR IMPACT TEST -4.010 .125±010 .2100 9. ANGULARITY = Z 1C. PERPENDICULARITY = I 11. PARALLELISM = // 6 ±.010 .050 ±010 2.25021 12. FLATNESS = 6 EXPOSED SURFACE 13. SPECIFICATION LENGTH TO ±3/8" ±015 14. ANGULARITY TO BE ± 1" +020 1.200 15. PROFILE MUST MEET Q-303 1.625 .020 B .020 B .507 PER AAMA SPECIFICATIONS 11 16. PROFILE MUST MEET Q-304 PER AAMA SPECIFICATIONS 11.500° 17. PROFILE MUST MEET Q-901 .060 .060 PER AAMA SPECIFICATIONS .060 .060 18. PROFILE MUST MEET O-902 IMPACT RESISTANCE PER ~~~ ~~ l ±.016 AAMA SPECIFICATIONS سسا .635 19. MAX BOW .046in PER 3ft LENGTH ±015 19 20, INTERNAL WALL THICKNESS ±.010 .16718 UNLESS OTHERWISE SPECIFIED .060 14 WEATHERSTRIP SPECIFICATION 1.515 WEATHERSTRIP 1.410 15 POSITION (REF) ∠7 .020 .870 - -B-.040 17 24 .188_(REF) **FUNCTIONAL CHECK** .206 (REF) H5964.01-501-47 Report #: VISION PASS-THRU CLIP #VCP028 Date: 01/18/2018 9216 GLAZING BEAD (3/4" GLASS) 3.270 ±.C15 Verified by 9016 GLAZING BEAD (7/8" GLASS) 16 WOOLPILE .187 BACK **CUSTOMER LENGTH** CHELSEA CUT LENGTH TOLERANCE 9247 SILL TRACK 723 JAMB EXTENSION CLIP (INTERIOR POCKET ONLY) REVISED DIMS & TOLS: WO#13153 EAS 07-30-13 REVISED DIMS & TOLS; WO#13136 EAS 07-15-13 DRAWN DATE: 12-09-11 NO. REVISION BY DATE Use the catiper diagram as your guide to measure the following control points. Measure the following control points using #1 on the callper 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 nours. Auditor- I sample oer shift recorded 1 hour after shift start. IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED

QC PRIN	T NUMBER:	9214FQ0	DRAWN BY: EAS	CHECKED BY:	APPR	OVED BY:	DEVELOP	INPROCESS	PRODUCTION
PART NA		DESCRIPTION		i	R/PLANT:		DODUOTO		
92	214F	į XO:	SLIDER FRAME	: CHE	LSEA BU	ILDING P	RODUCTS		1
				ILLUSTRATION OF	PART AND CONTROL P	DINTS			
	CHELSEA BUILDING PRODUCTS, INC.		£			<u>factorer </u>			!
=	R IVAY, OAKMONT PA 151	39	P.A	ASS-THRU CLIP 🥄			1		
*+85 DRAWING AND	COPPRIGHT 2511 DIS CONTENTS ARE THE BOLE!	PROPERTY :	į		3.7	52 (REF)			
USE OR REPR	ONS CONTENTS ARE THE BOLF I ONG PRODUCTS, INC. ANY LAMA: MODICEON IS STREETLY PROME	THORIZED			.969 ±.010	1.322 1.	516 5		}
NOTES:	AL = RIGID P.V.C.				1 ±0101	(REF)	5		
2. FLEXIBLE	EP.V.C. = EXCESSESSESSES	_ I	.625	.025		-			į
4. LAMINAT	E = [///////A		HI (REF)	, (reeri	3300 -2		-444	.050 8	ACE.
	IICKNESS = 1,062 ±.00		KFA				, 11	1	3
8. LOCATIO 9. ANGULAI	IN FOR IMPACT TEST	* 🗖	n	51		J)	.125±.010	2100	SEC
10. PERPEN 11. PARALLI	CICULARITY = II	- 1	2.250 18	<i>\\\</i>		T			EXPOSEO SUNFACE
12. FLATNES		+3/8"	2.25018	[K]	.162			.050	
14. ANGULA	ARITY TO BE ± 1° E MUST MEET Q-303	25/6		_ , //	44		1.200	10	1.625
PER AA	MA SPECIFICATIONS			B			7	19 1.507 19 12	1.023
PER AAI	E MUST MEET Q-304 MA SPECIFICATIONS		21		11.500		2111	13	
PER AA!	E MUST MEET 0-901 MA SPECIFICATIONS			±.010	(REF)			±.010	
MPACT	E WUST MEET 0-902 RESISTANCE PER			17				13	;
19. MAX BO	PECIFICATIONS WW .046in PER 31; LENG		i	Çin.) 1			<u> </u>	•
	AL WALL THICKNESS : OTHERWISE SPECIFI			- 16	*.015 ⁷ 16			±.015	
WEATH	ERSTRIP SPECIFICATIO	N		(060 14	
POSITION	SIZE WEATHER	RSTRIP	/	-	1.516	-			
	TYP	E			(REF)			☑ .020	
	i			1			[-B-]	20	
FLIN	CTIONAL CHECK		[-		3.270 ±015			
			\ / (7			15			FO4 47
VISION PA	ASS-THRU CLIP #VC	P028	/			*****	intectak Re	eport #: H5964.01-	
9216 GLA	ZING BEAD (3/4" GL	ASS)	- J-CHANNEL REMOVA MUST ALIGN WITH TE				Marie Company Company	ate: 01/18/2	
9016 GLA	ZING BEAD (7/8" GL	ASS)	FOR PROPER ADAPT: FIT & FUNCTION!	ER			Ve	erified by:	10/10
wo	OLPILE .187 BACK	\neg							
9.	1247 SILL TRACK	4 AE	DED NAIL FIN CUT-OFF NUB, WO#1318	15		8LG 10/17/13	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
		3 RE	VISED DIMS & TOLS, WOR13153			EAS 07-30-13			:
DRAWN	DATE: 12-09	44 1 AD	VISED DIMS & TOLS; WO#13136 DED J-CHANNEL REMOVAL NOTE			EAS 07-15-13 EAS 01-28-13			
Use the call	ilper diagram as your	guide to measure the	following control points.			BY DATE		l .	1
Measure In	e following control po the following control po	ints using #1 on the c	altper diagram:			2 3			
Measure th	e following control po	ints using #3 on the o	aliper diagram:			/77/r	TORSE A ME		
	e following control po of sampling: Process		auper diagram: s per shift recorded every 4 nours.		1	y L			
Auditor- 1 s	sample per shift recon	ded 1 hour after shift	start.		ļ			, , , , , , , , , , , , , , , , , , ,	-
			E NOT IN SPEC.				J		4
CORRECTIVE ACTION REQUIRED					× 1 b			*	

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QC PRINT NUMBER:	9257QC	DRAWN BY: EAS	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
PART NAME:	DESCRIPTION:		SUPPLIER/PLA	AIT-			
			1		DODUOTO		
9257	FIXED	MEETING RA	IL CHELS	EA BUILDING PI	RODUCIS		
			ILLUSTRATION OF PART A	NO CONTROL POINTS	····		
CHELSEA BUILDING PRODUCTS, INC.		[şm.			
585 CEDAR WAY, DAKMONT PA 151 COPPRIGHT 2011	139	i	ļ -	1.284			
THE DRAWING AND PSICONTENTS AND THE SOLE OF OHESEA BUILDING PRODUCTS INC. ANY SHALL USE OR REPRODUCTIONS STREETLY PROVIDE	PROPERTY ITMORRED ITED		-	1.087			
NOTES: 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = EXECUTION 3. EXTERIOR COATING = EXTERIOR COATING = EXTERIOR COATING = EXTERIOR WALLS = 6. WALL THICKNESS = .062 ± 0. THINNER INTERIOR WALLS = 6. WALL THICKNESS = .062 ± 0. THINNER INTERIOR WALLS = 6. WALL THICKNESS = .062 ± 0. THINNER INTERIOR WALLS = 6. WALL THINNER INTERIOR TO SET = 1. THINNER INTERIOR	±3/8*	16 2.000 15		±010 100 5	2286 2286 2286 2008 7 2008 8 // .020 B 17 443 9	EXPOSEQ SURFACE	
WEATHERSTRIP SPECIFICATIO	N				050 10		
POSITION SIZE WEATHER TYPE					125 11	1	
		9252 REBAR —			±.008	1	
	_			10			
FUNCTIONAL CHECK		İ	.555	14	12		
9216 GLAZING BEAD (3/4" GL	ASS)			17	Do	port #: H5964.	01-501-47
•					intactak	1	
9016 GLAZING BEAD (7/8" GL	H33)	İ	i_	1.512	Tital Quilly, James L.	- 2070	8/2018
716A GLAZING BEAD (7/8" GL	ASS)	L		13	Ve	erified by:	000
* 9252 ALUMINUM REBAR							
					CUSTOMER LENGTH C	HELSEA CUT LENGTH	TOLERANCE
	1 100000	D SCREWBOSS SIZE		EAS 09-29-11 -			
DRAWN DATE: 09-27	-11 NO. REVISION	SCREWBOSS NUBS; ADDED CRI	T DIMS; DIM 1.512 TOL WAS ±.0	18 EAS 09-29-11 BY DATE			
Use the caliper diagram as your	guide to measure the follow	wing control points.		3			
Measure the following control pol Measure the following control pol				2 3			
Measure the following control pol Measure the following control pol	nts using #3 on the calipe	r diagram:			7mil ¹ a 706		
Frequency of sampling: Process Auditor- 1 sample per shift record	Specialist- 3 samples per :	<u> </u>		\ =			
IF ANY CONTROL				11/17			
CORRECTIVE ACT	ION REQUIRE	<u> </u>		VIV			4

QC PRINT NUMBER:	0000		DRAWN BY: FAC	CHE	CKED BY:	Т.	APPROVED	BY:	DEVELOP	INPROCESS	PRODUCTION	
	9206	*	EAS			<u> </u>						
PART NAME:	DESCR						ELSEA BUILDING PRODUCTS					
9206		LOCK	RAIL/LOCK STILE		CHE	LSEA	RAILD	ING PR	KODUCIS			
				ILLU	JSTRATION OF	PART AND CON	TROL POINTS					
CHELSEA BUILDING PRODUCTS, INC. 585 CEDAR WAY, OAMNOT PA 1513 THIS DEWAYD AND PS CONTENTS ARE THE BOLE PA		EX	TERIOR		16	010	1	1.160		INTERIO	<u>OR</u>	
OF CHESSES BUILDING PRODUCTS INC. ANY URALT USE ON REPRODUCTION IS STREETLY PROPERTY. 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = **********************************	MOREED							±010] 2	r	i		
5. EATENCOMINE - 2 4. LAMMATE = 17777723 5. THINNER NTERIOR WALLS = 15. WALL THICKNESS = .062 ± .006 7. RADIUS = .022 8. LOCATION FOR INPACT-TEST 9. ANGULARITY = 11. PARALLELISM = 1/2 12. FLATNESS = 1/2 13. SPECIFICATION LENGTH TO 13.				// 19 🛭	// .020 B		.285 15 .276	.673 .025 .025 –				
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-802 IMPACT RESISTANCE PER AAMA SPECIFICATIONS					.08 .055 (REF)	±010 2 13	2010 .14712			.020 B 17		
19. MAX BOW, 048in PER 31 LENG 20. INTERNAL WALL THICKNESS 2 UNLESS OTHERWISE SPECIFIC WEATHERSTRIP SPECIFICATION POSITION SIZE WEATHER TYPE	ED ED	10 9 507 +±010 -210 7 -						5)	REB	1		
FUNCTIONAL CHECK			SIA		±010	-	±.008			į		
816 GLAZING BEAD (3/4° GLA	_		1		6		5	<u>į –</u> 6	5-1	Report #: H59	64.01-501-47	
6266 GLAZING BEAD (7/8° GL									Interte		01/18/2018	
.187 BACK WOOLPILE									Total Smilty: America.	·Verified by:	2-18/12	
9253 ALUMINUM REBAR								1				
									CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE	
	\dashv			•								
DRAWN DATE: 10-06-	-11 1 NO	ADDED S	CREWBOSS				EAS BY	10-24-11 DATE				
Use the caliper diagram as your g Measure the following control poil Measure the following control poil Measure the following control poil Measure the following control poil Frequency of sampling: Process 8	juide to measi ints using #1 on ints using #2 on ints using #3 on ints using #4 on Specialist- 3 si	ure the follow in the caliper in the caliper in the caliper an the caliper amples per s	diegram: diagram: diegram: diegram:				2	3				
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						W			4			

QC PRINT NUMBER:	9205qc	DRAWN BY: EAS	CHECKED BY:		APPROVED	BY:	DEVELOP	INPROCESS	PRODUCTION
PART NAME:	DESCRIPTION:		SUPPLIE	R/PLANT:					
9205		NDLE RAIL/HANDLE S	TILE CHE	LSEA	BUILD	ING PI	RODUCTS		
			ILLUSTRATION OF	PART AND CO	NTROL POINTS		·· - · ·		
CHELSEA BUILDING PRODUCTS, INC. 565 CEDAR WAY, OAKMONT PA 15139 THIS DEAWING MINT'S COPITIEST ARE THE SOLE PRO OF OILSEA BUILDING PRODUCTS, INC. ANY URLING USE OR REPRODUCTIONS STRIPLY PROTECTIONS STRIPLY PRO-	SPERITY DALKED	XTERIOR	-	1 1.1	±.010 50			INTERIO	<u>OR</u>
NOTES: 1. MATERIAL = RIGID P.V.C. 2. FLEXBLE P.V.C. = \$200000000000000000000000000000000000		// 20		.873 85 17 17 16	.010 2	-	.625 _(REF)	1908:	
16. PROFILE MUST MEET 0-304 PER AAMA SPECIFICATIONS 17. PROFILE MUST MEET 0-903 PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET 0-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS 19. MAX BOW .046in PER 32 LENGT) 20. INTERNAL WALL THICKNESS 2.0 UNLESS OTHERWISE SPECIFIED WEATHERSTRIP SPECIFICATION POSITION SIZE WEATHERS TYPE	1 25 45 45 65 65 65 65 65 65 65 65 65 65 65 65 65	7.055 (REF) 12 11 1284 210 11	15 ±.008 .050 13	714 772 72	12.010		18 L ±,010 1.375 4	WERKE SUR	
	_	.12	010	±.008					
FUNCTIONAL CHECK			9		010 -B-				
816 GLAZING BEAD (3/4" GLAS	SS)		-	6	04	_	taka dala	Report #: H5964	.01-501-47
6266 GLAZING BEAD (7/8" GLA	SS)			3	±.01 .466	10	ntertek	Date: 01/	18/2018
.187 BACK WOOLPILE					5			Verified by:	10 M
AMESBURY #32692 SASH SE	AL .						CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE
BS) PIVOT BAR (USE GAUGE #9205-GA-01)				<u> </u>				S.LUEN GOI BENOIT	
9254 ALUMINUM REBAR									
DRAWN DATE: 10-06-	11 1 REVISE NO. REVISION	ED FUNCTIONAL CHECK AMESBUR	Y SASH SEAL NO.		EAS BY	07-05-12 DATE			
Use the caliper diagram as your gu Measure the following control point Measure the following control point Measure the following control point Measure the following control point Frequency of sampling: Process Sp	ide to measure the folks as using #1 on the calipi as using #2 on the calipi as using #3 on the calipi as using #4 on the calipi	wing control points. er diagram: er diagram: er diagram: er diagram:			2				}
Auditor- 1 sample per shift recorder	d 1 hour after shift start								1
	IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED					VY			4

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PRODUCTION OC PRINT NUMBER: DRAWN BY: CHECKED BY: APPROVED BY: DEVELOP INPROCESS **EAS** 9208qc SUPPLIER/PLANT: DESCRIPTION: PART NAME: CHELSEA BUILDING PRODUCTS 9208 RAIL/STILE ILLUSTRATION OF PART AND CONTROL POINTS **CHELSEA BUILDING** PRODUCTS, INC. INTERIOR **EXTERIOR** 585 CEDAR WAY, QARMONT PA 15139 ±.010 COPPRISE 2011
THE ORAMING WOLLD COMPRISE ARE THE SOLE PROPER
OF CHESEA BUILDING PRODUCTS INC ARTSHAUTYCHEE
USE OR REPRODUCTION IS STRUCKLY PROHIBITED NOTES: 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = TOXXXXXXXXXXXX ±.010 2 3. EXTERIOR COATING = .873 -4. LAMINATE = ZZZZZZZZ // 22 // .020 B 5. THINNER INTERIOR WALLS = C 6. WALL THICKNESS = .062 ±.008 ±.010 ±.005 .285 7. RADIUS = .020 .025 8. LOCATION FOR IMPACT TEST 9. ANGULARITY = Z 3 19 10. PERPENDICULARITY = 11. PARALLEUSM = 2 ±.010 12. FLATNESS = G .276 13. SPECIFICATION LENGTH TO ±3/8" 14. ANGULARITY TO BE ± 11 8 ±.010 .020 B 15. PROFILE MUST MEET 0-303 1 21 ⊥ .020 B .082 -PER AAMA SPECIFICATIONS 20 上 16. PROFILE MUST MEET Q-304 PER AAMA SPECIFICATIONS 17, PROFILE MUST MEET Q-901 (REF PER AAMA SPECIFICATIONS 18. PROFILE MUST NEET Q-902. 1.375 ±.010 IMPACT RESISTANCE PER 4 **AAMA SPECIFICATIONS** CHARLE SUBSACE 19. MAX BOW JOIGH PER 30 LENGTH .062 20, INTERNAL WALL THICKNESS ±010 ±.008 ±.010 ±.010 UNLESS OTHERWISE SPECIFIED 5 .050 .750 .610 WEATHERSTRIP SPECIFICATION 13 ±.008 -±.010 WEATHERSTRIP TYPE **POSITION** .210 ±.010 ±.008 .125 -.050 H5964.01-501-47 FUNCTIONAL CHECK Report #: -8-±.010 .125 10 01/18/2018 816 GLAZING BEAD (3/4" GLASS) Verified by: 210 7 6266 GLAZING BEAD (7/8" GLASS) REBAR .187 BACK WOOLPILE 9259 COMPOSITE REBAR CHELSEA CUT LENGTH **CUSTOMER LENGTH** TOLERANCE DRAWN DATE: 10-06-11 BY DATE 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

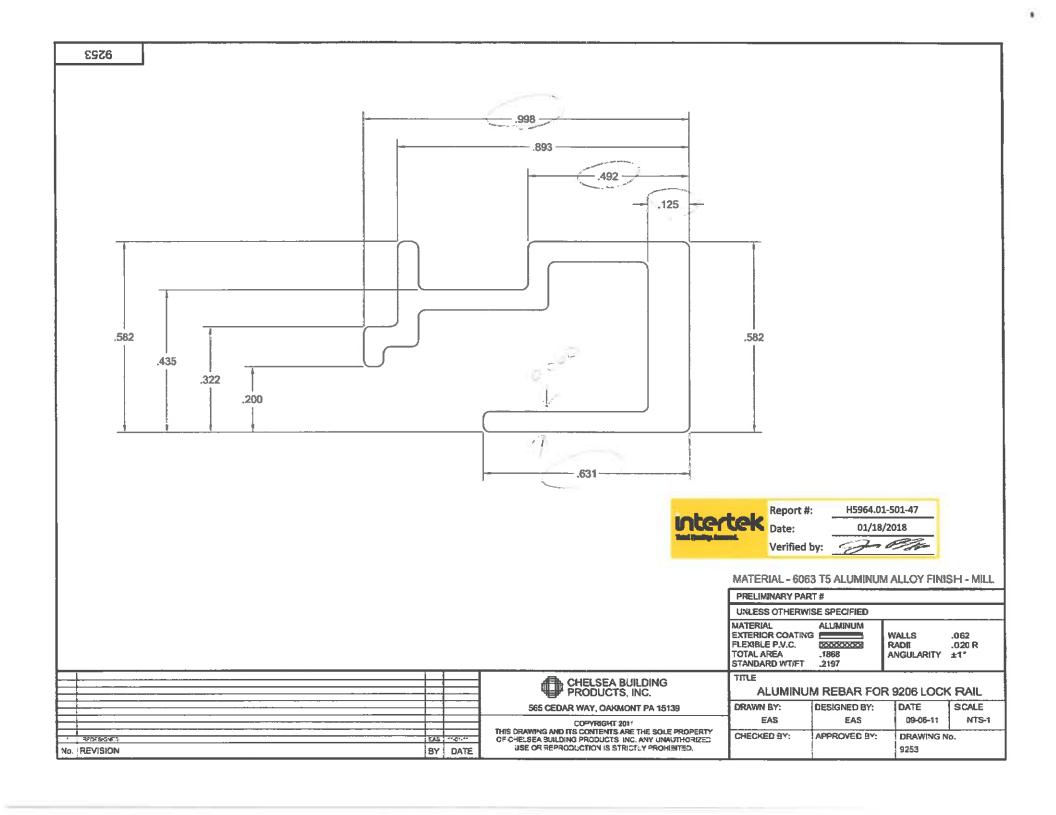
CHECKED BY: APPROVED BY: DEVELOP **INPROCESS** PRODUCTION QC PRINT NUMBER: DRAWN BY: 9247QC SUPPLIER/PLANT: **DESCRIPTION:** PART NAME: CHELSEA BUILDING PRODUCTS SILL TRACK 9247 ILLUSTRATION OF PART AND CONTROL POINTS CHELSEA BUILDING PRODUCTS, INC. 585 CEDAR WAY, DAKMONT PA 15139 COPYMENT 2011

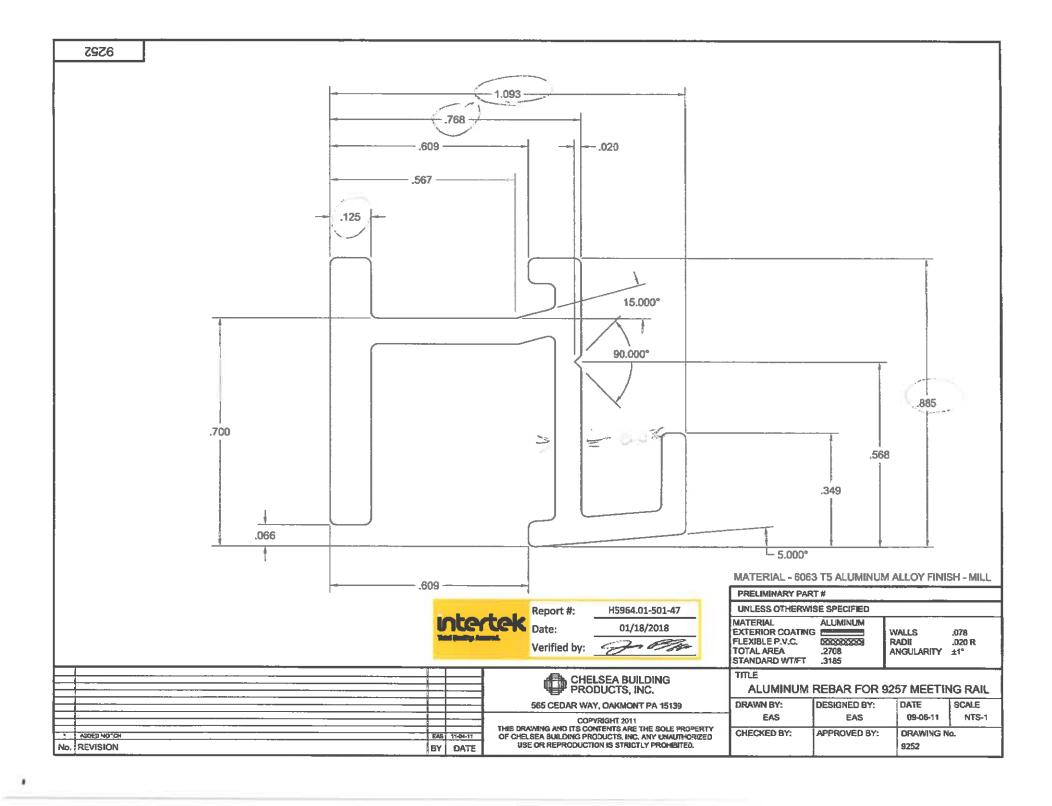
*-BE DRAWING AND ITS CONTENTS ARE THE SOLT PROPERTY
OF CHELSEA BUILDING PRODUCTS INC. ANY UMALTHORIZED
USE OR REPRODUCTION IS STRUCTLY PROHIBITED. NOTES: 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = COMMONOCO ±.015 3. EXTERIOR COATING = 4. LAMINATE = COMMITTEE 5. THINNER INTERIOR WALLS = 6. WALL THICKNESS = 7. RADIUS =
8. LOCATION FOR IMPACFIEST ±.010 ±.010 ±.010 B. ANGULARITON RZ 10. PERPENDICULARITY = [1] - .076 11. PARALLELISM = // 12. FLATNESS = 2 13. SPECIFICATION LENGTH TO 14. ANGULARITY TO BE ± 1° 15. PROFILE MUST MEET Q-303 ±3/6" 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 0-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS ±.010 ±.010 19. MAX BOW .046in PER 3ft LENGTH 20. INTERNAL WALL THICKNESS ±010 .582 UNLESS OTHERWISE SPECIFIED WEATHERSTRIP SPECIFICATION WEATHERSTRIP TYPE POSITION ±.010 ±.010 021 **FUNCTIONAL CHECK** ±.010 .0458 9204 SLIDER FRAME Report #: H5964.01-501-47 9224 SLIDER FRAME 01/18/2018 Verified by: TOLERANCE CUSTOMER LENGTH CHELSEA CUT LENGTH DRAWN DATE: 11-04-04 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: 1,2,3,8,9 Measure the following control points using #2 on the caliper diagram: 4,10 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

PRODUCTION INPROCESS DRAWN BY: CHECKED BY: APPROVED BY: DEVELOP OC PRINT NUMBER: EAS 9216QC SUPPLIER/PLANT: PART NAME: DESCRIPTION: CHELSEA BUILDING PRODUCTS 9216 GLAZING BEAD ILLUSTRATION OF PART AND CONTROL POINTS CHELSEA BUILDING PRODUCTS, INC. 565 CEDAR WAY, OAKMONT PA 15139 THE DRAWAD AND ITS CONTENTS ARE THE BULE PROPERTY OF OWNERS A BURD PRODUCTS, INC. ANY LIMATHORIZES USE ON REPRODUCTION IS STRICTLY PROMINED. +.015-.010NOTES: 1. MATERIAL = RIGID P.V.C. 2. FLEXIBLE P.V.C. = DOCUMENTS 3. EXTERIOR COATING = E 4. LAMINATE = 27777772 5. THINNER INTERIOR WATLS = [6. WALL THICKNESS = .045 ±.005 7. RADIUS = .010
8. LOCATION FOR IMPACT TEST 9. ANGULARITY = 2 10. PERPENDICULARITY = 🛄 11. PARALLELISM = 7/ 12. FLATNESS = 2 ±.010 13. SPECIFICATION LENGTH TO ±3/8" .595 +.010 14. ANGULARITY TO BE ± 1" +.005 -.015 15. PROFILE MUST MEET Q-303 PER AAMA SPECIFICATIONS -.010 .817 16. PROFILE MUST MEET Q-304 081 PER AAMA SPECIFICATIONS .055 17, PROFILE MUST MEET Q-901 .010 R PER AAMA SPECIFICATIONS 18. PROFILE MUST MEET 0-902 IMPACT RESISTANCE PER .084 ±.010 AAMA SPECIFICATIONS 19. MAX BOW .046in PER 3f. LENGTH 20. INTERNAL WALL THICKNESS ±010 .091 UNLESS OTHERWISE SPECIFIED WEATHERSTRIP SPECIFICATION .045WEATHERSTRIP POSITION H5964.01-501-47 Report #: .020 01/18/2018 £.008 Verified by: **FUNCTIONAL CHECK** 6 ±.010 **FLEX DETAIL** 705 LIFT RAIL .193 SCALE = 4X 706 LOCK RAIL 707 KEEPER RAIL 9210 SH HEAD/PW FRAME **CUSTOMER LENGTH** CHELSEA CUT LENGTH TOLERANCE **9213 SH JAMB** DRAWN DATE: 10-07-11 BY DATE 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: 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 caliber diagram: Frequency of sampling: Process Specialist-3 samples per shift recorded every 4 hours. Auditor- I sample per shift recorded 1 hour after shift start. IF ANY CONTROL POINTS ARE NOT IN SPEC. CORRECTIVE ACTION REQUIRED

QC PRINT NUMBER:	816qc	DRAWN BY: JPP	CHECKED BY:	APPROVED BY:	DÉVELCP	INPROCESS	PRODUCTION
PART NAME: 816	DESCRIPTION	GLAZING BEAD	SUPPLIER/PLA CHELS	EA BUILDING	PRODUCTS		
CHELSEA BUILDING PRODUCTS, INC. 585 CEDAR WAY, DAISMONT PA 15 CONNIGHT ZUI- CHESTANA AND TREORITERS ARE THE SOLI OF CHELSEA BUILDING PRODUCTS, INC. AN UNITED THE SOLITOR AND TREORITERS AND THE SOLITOR WAS AND TREORITED AND THE SOLITOR AN	±3/8" ±3/8" ±3/8" KK	VISIBLE SURFACE	±.015 766 	+.005 020 129 145 2 010 .145 2	Intertek Date	ort #: <u>H5964.01-50</u>	
DRAWN DATE: 08-20 Use the caliper diagram as you Measure the following control p Measure the following control p Measure the following control p Frequency of sampling: Process Auditor-1 sample per shift record IF ANY CONTROL CORRECTIVE AC	on 10 NO. IREVISION or guide to measure the followinks using #1 on the callip oints using #2 on the callip oints using #3 on the callip oints using #4 on the callip oints using #4 on the callip is Specialist- 3 samples perded 1 hour after shift start. POINTS ARE I	owing control points. er diagram: er diagram: er diagram: er diagram: er diagram: r shift recorded evary 4 hours.		EAS 01-23-12 BY DATE 2	CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

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> Telephone: 724-275-7100 Facsimile: 717-764-4129 www.intertek.com/building

TEST REPORT FOR MASTER WINDOW SYSTEMS

Report No.: h5964.08-501-44-R0

Date: 03/17/25

SECTION 14

REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	03/17/25	N/A	Original Report Issue – Reissued Report No. H5964.08-501-44 in the name of Master Window Systems

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