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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
01/15/22

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DOCUMENT CONTROL NUMBER
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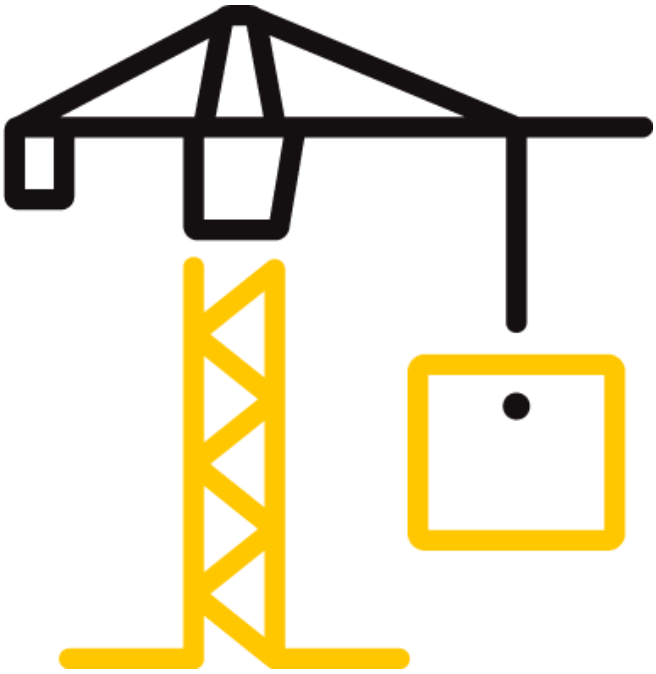

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TEST REPORT FOR MASTER WINDOW SYSTEMS

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
TITLE:	Project Manager – Field & Laboratory Testing	**TITLE:**	Regional Manager – Field & Laboratory Testing Building and Construction
SIGNATURE:	Digitally Signed by:Matthew Hollinger	**SIGNATURE:**	Digitally Signed by: Stephen Shank
DATE:	03/17/25	**DATE:**	03/17/25

COMPLETED BY:	James P. Grippo	**REVIEWED BY:**	Joseph E. Allison
TITLE:	Technician – Building and Construction	**TITLE:**	Laboratory Supervisor
SIGNATURE:	*Original Signatures on File*	**SIGNATURE:**	*Original Signatures on File*
DATE:	03/17/25	**DATE:**	03/17/25

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TEST REPORT FOR MASTER WINDOW SYSTEMS
Report No.: h5964.08-501-44- R0
Date: 03/17/25

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 m² (30.0 ft²)	**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 die-cast 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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Date: 03/17/25

Reinforcement:

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

Weatherstripping:

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 BITE
		millimeters	inches	
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 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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Date: 03/17/25

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
Operating Force, per ASTM E2068	Initiate Motion: 45 N (10 lbf) Maintain Motion: 26 N (6 lbf) Locks: 18 N (4 lbf)	Report only 90 N (20 lbf) max 100 N (22.5 lbf) max	
Air Leakage, Infiltration per ASTM E283 at 75 Pa (1.57 psf)	0.9 L/s/m^2 (0.18 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Air Leakage, Exfiltration per ASTM E283 at 75 Pa (1.57 psf)	0.9 L/s/m^2 (0.18 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Canadian Air Infiltration/Exfiltration Level	A2	1.5 L/s/m^2 (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) Remaining direction, 230 N (52 lbf)	Pass Pass	Meets as stated Meets as stated	

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Report No.: h5964.08-501-44- R0
Date: 03/17/25

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) -1440 Pa (-30.08 psf)	 28.5 mm (1.12") 26.9 mm (1.06")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at the fixed meeting stile +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	 1.5 mm (0.06") 1.8 mm (0.07")	 5.5 mm (0.22") max. 5.5 mm (0.22") max.	 6, 7

Test 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) -1440 Pa (-30.08 psf)	 30.2 mm (1.19") 27.9mm (1.10")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at the fixed meeting stile +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	 2.0 mm (0.08") 1.8 mm (0.07")	 5.5 mm (0.22") max. 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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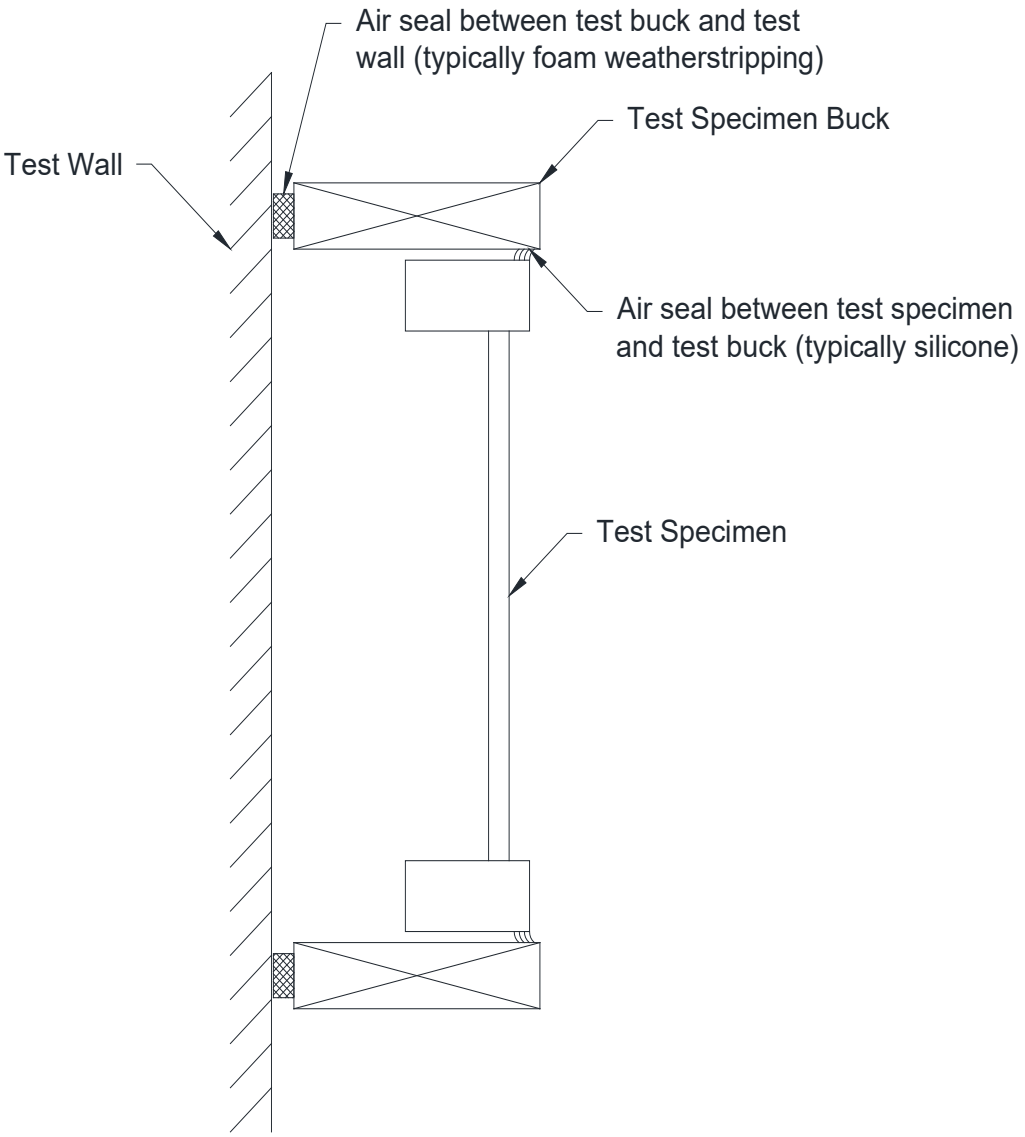
SECTION 11
LOCATION OF AIR SEAL

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.

A5964.01-501-47

BILL OF MATERIALS
Model 9230-HS-T510
New Construction XO Slider
3/4" Glass (7/8" Glass Optional)
Revised December 8, 2017

ITEM	DESCRIPTION	CBP 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	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	1,2
17	Keeper		1	Vision #9316-00	2,3
18	Lock		1	Vision #671-00	2,3
SCREWS (#410 Stainless Steel or Zinc Plated)					
19	Pass-thru Clip		8	#6 x 1" PH Flat HD Type AB, SMS	
20	Keeper Screw (Alum or Steel Rebar)		AR	#6 x 3/4" PH Flat HD TEK (Self-drilling)	2,3
21	Lock Screw (Alum or Steel Rebar)		AR	#6 x 3/4" PH Flat HD TEK (Self-drilling)	2,3
22	Stiffener Screw (Alum or Steel Rebar)		AR	#6 x 1/2" PH Flat HD TEK (Self-drilling)	
WEATHERSTRIPPING					
23	Center Fin Pile (Lock Rail, Meeting Rail)		AR	.187 x .220	
24	Center Fin Pile (Pull Stile, Rail, Frame)		AR	.187 x .250	
OPTIONAL					
25	Drip Cap (J Removed)	9236	AR	CBP	2
26	Drip Cap	9239/ 9239M	AR	CBP	2
27	Transom Clip	727	AR	CBP	2

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Date: 01/18/2018
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OPTIONAL (cont.)					
28	Jamb Extension Clip	723	AR	CBP	2
29	1/2" Mullion Clip	749	AR	CBP	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(3)	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	By	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		

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

BILL OF MATERIALS
Model 9280-HS-T510
Replacement XO Slider
3/4" Glass (7/8" Glass Optional)
Revised December 8, 2017

ITEM	DESCRIPTION	CBP PART#	QTY	MATERIAL/SOURCE	NOTES
1	Master Frame	9214F	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	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
SCREWS (#410 Stainless Steel or Zinc Plated)					
19	Installation		4	#8 x 2-1/2" PH Pan HD 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)	
WEATHERSTRIPPING					
24	Center Fin Pile (Lock Rail, Meeting Rail)		AR	.187 x .220	
25	Center Fin Pile (Pull Stile, Rail, Frame)		AR	.187 x .250	
OPTIONAL					
26	Head Expander	750	1	CBP	2
27	Transom Clip	727	AR	CBP	2

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OPTIONAL (cont.)					
28	2-Piece Sill Riser Male	988	1	CBP	2
29	1/2" Mullion Clip	749	AR	CBP	2
30	Sill Riser	765/765M	1	CBP	2
31	2-Piece Sill Riser Female	989	1	CBP	2
32	Structural Mullion	803	AR	CBP	2
33	Screen Clip	9218	AR	CBP	2
34	Flush Flange	9264	AR	CBP	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	1
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 (1)	Gaer #98-03-00-00	1,2
41	Weep Cover		2 (1)	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	By	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		

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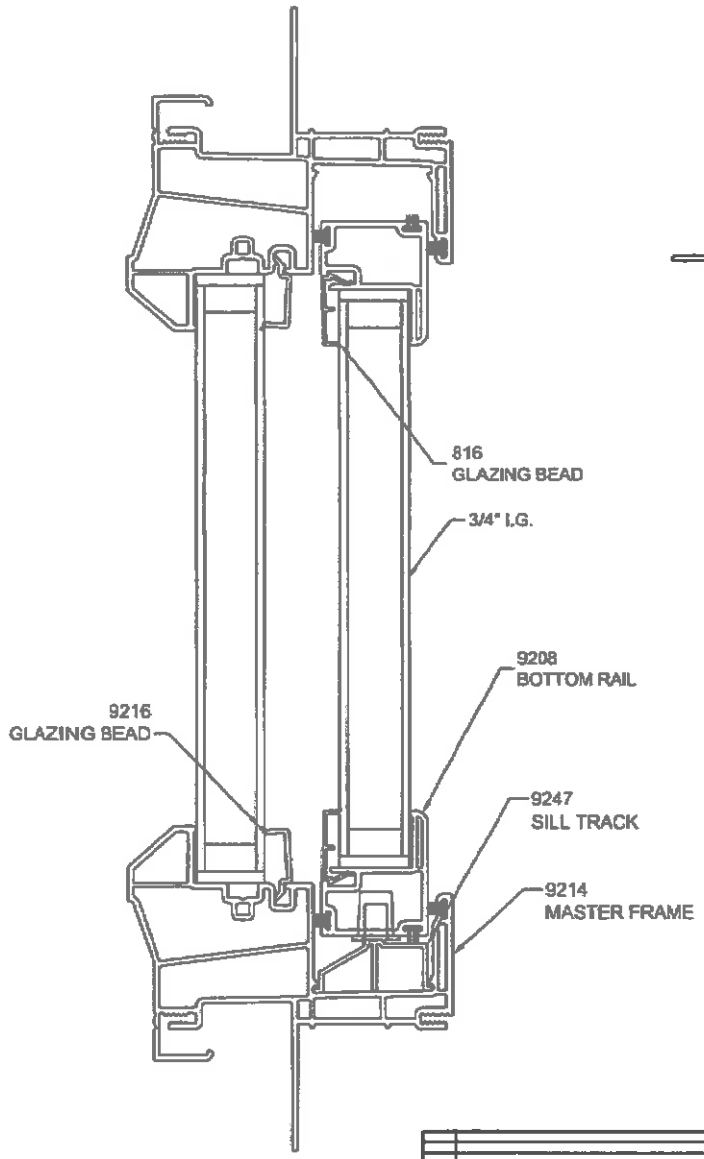
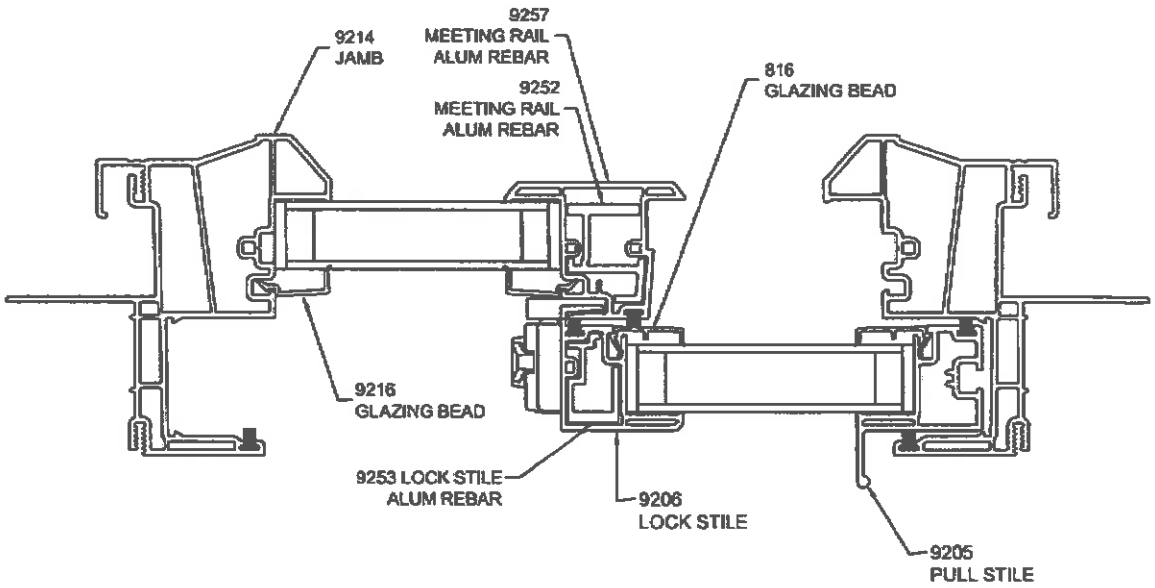
Verified by:

92305523





intertek
Total Quality Assured.

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

No.	REVISION	BY	DATE
2	ADDED 3/4" GLASS OPTION	EAS	12-05-11
1	REVISED MEETING RAIL COMPONENTS	EAS	12-01-11

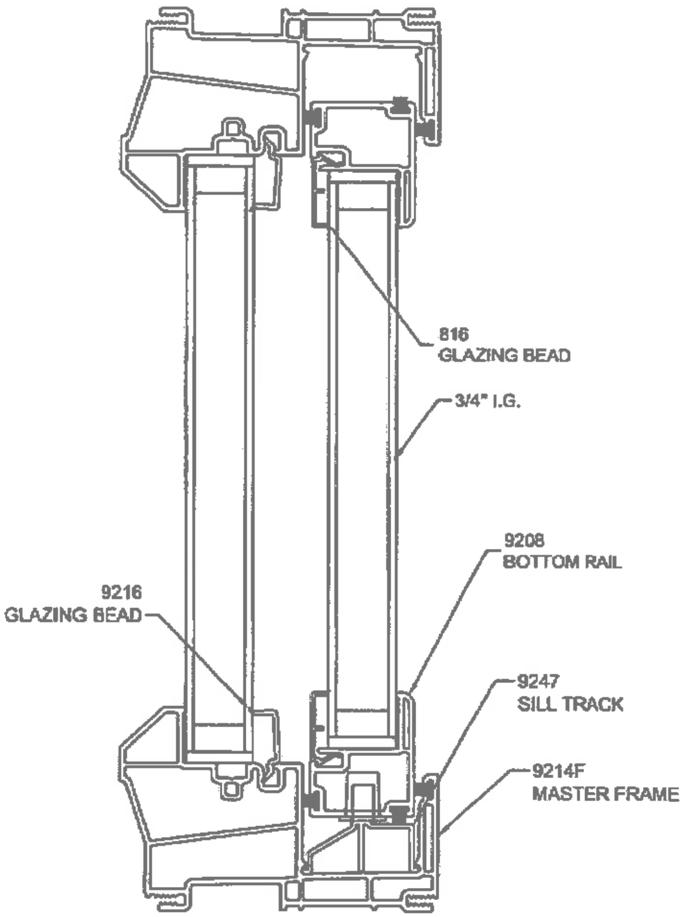
CHELSEA BUILDING PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

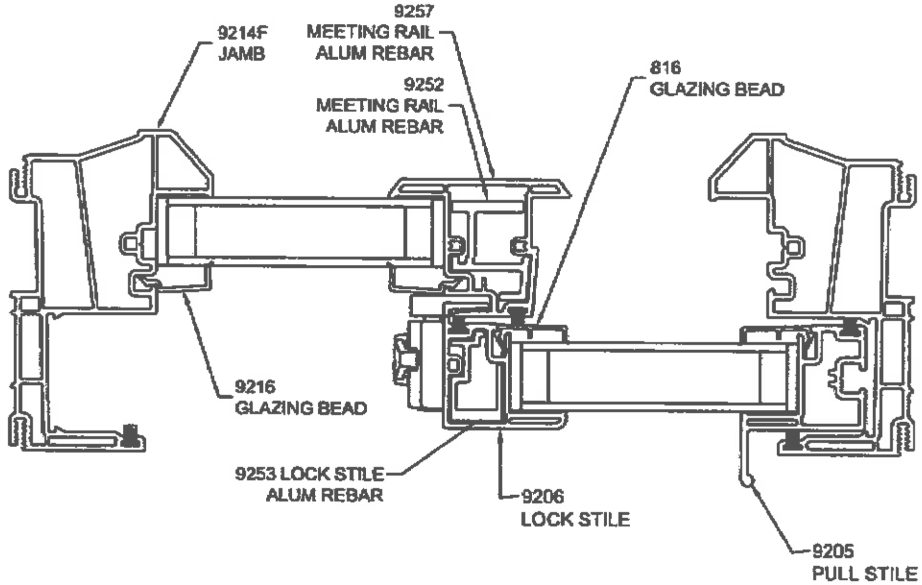
PRELIMINARY PART #

TITLE: MODEL 9230-HS-T510 3/4" GLASS (7/8" GLASS OPTIONAL) NEW CONSTRUCTION XO SLIDER

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS		12-05-11	NTS-1
CHECKED BY:	APPROVED BY:	DRAWING No.	
		92305523	

92805523





intertek
Total Quality. Assured.

Report #:	H5964.01-501-47
Date:	01/18/2018
Verified by:	[signature]

No	REVISION	BY	DATE

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

PRELIMINARY PART #			
TITLE MODEL 9280-HS-T510 3/4" GLASS (7/8" GLASS OPTIONAL) REPLACEMENT XO SLIDER			
DRAWN BY: EAS	DESIGNED BY:	DATE 12-05-11	SCALE NTS-1
CHECKED BY:	APPROVED BY:	DRAWING No 92805523	

QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9214QC	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9214	XO SLIDER FRAME	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.005
7. RADIUS = .020 R
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-501 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-502 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

VISION PASS-THRU CLIP #VCP028

9216 GLAZING BEAD (3/4" GLASS)

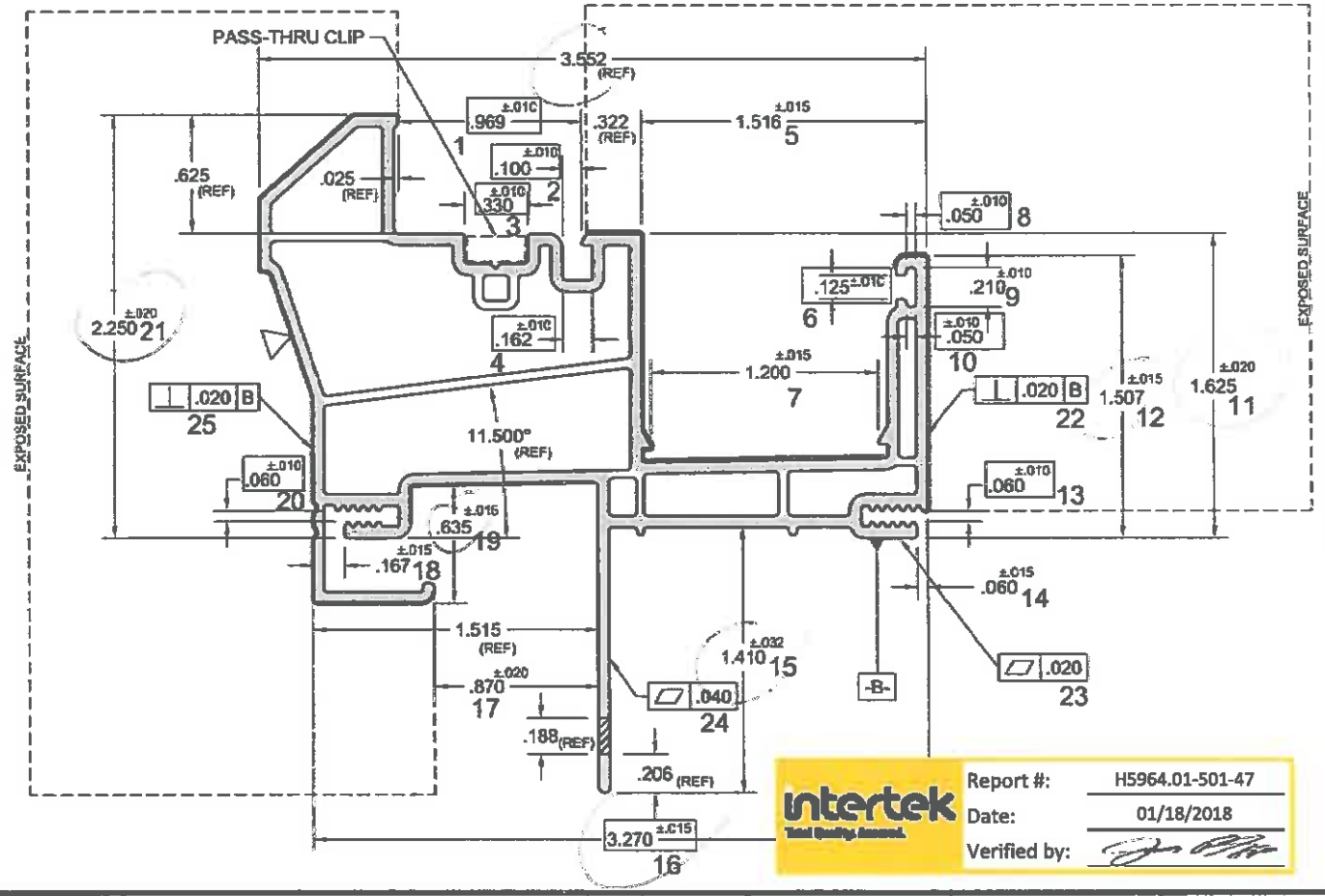
9016 GLAZING BEAD (7/8" GLASS)

WOOLPILE .187 BACK

9247 SILL TRACK

723 JAMB EXTENSION CLIP (INTERIOR POCKET ONLY)

DRAWN DATE: 12-09-11



intertek Total Quality Assured.
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

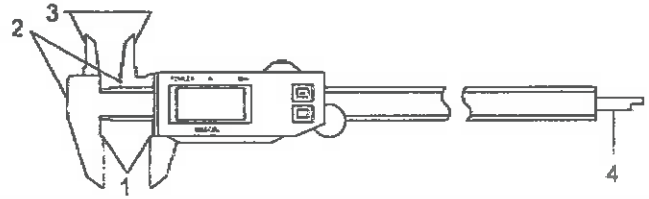
NO.	REVISION	BY	DATE
2	REVISED DIMS & TOLS; WO#13153	EAS	07-30-13
1	REVISED DIMS & TOLS; WO#13136	EAS	07-15-13

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



QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9214FQC	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9214F	XO SLIDER FRAME	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020 R
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

VISION PASS-THRU CLIP #VCP028

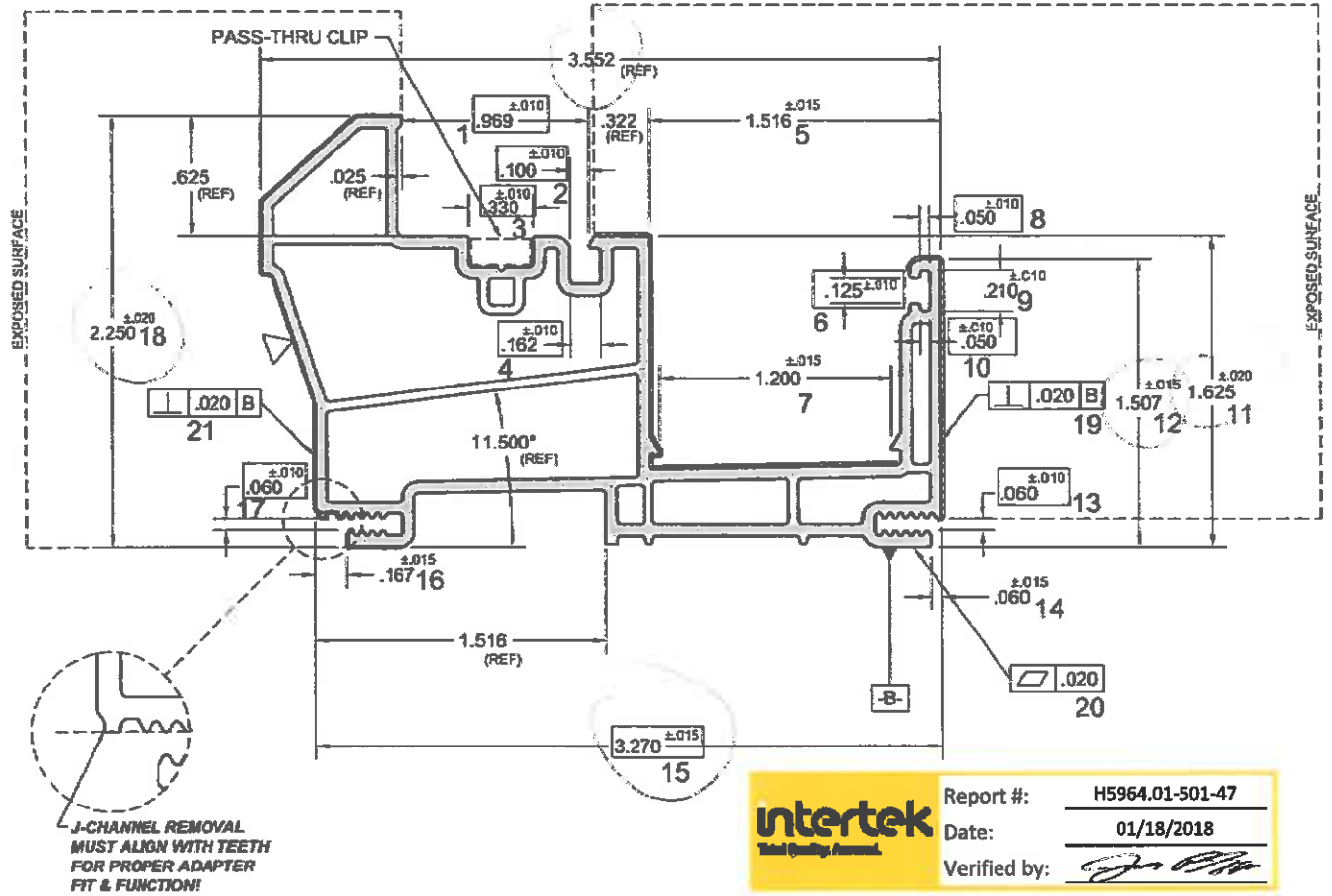
9216 GLAZING BEAD (3/4" GLASS)

9016 GLAZING BEAD (7/8" GLASS)

WOOLPILE .187 BACK

9247 SILL TRACK

DRAWN DATE: 12-09-11



intertek Total Quality Assured.
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

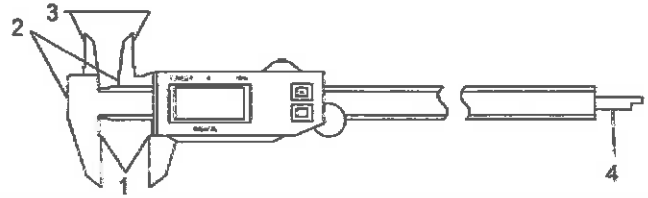
NO.	REVISION	BY	DATE
4	ADDED NAIL FIN CUT-OFF NUB, WO#13185	BLG	10/17/13
3	REVISED DIMS & TOLS; WO#13153	EAS	07-30-13
2	REVISED DIMS & TOLS; WO#13136	EAS	07-15-13
1	ADDED J-CHANNEL REMOVAL NOTE	EAS	01-28-13

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



QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:					
9257QC	EAS				DEVELOP		INPROCESS	PRODUCTION

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9257	FIXED MEETING RAIL	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020 R
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

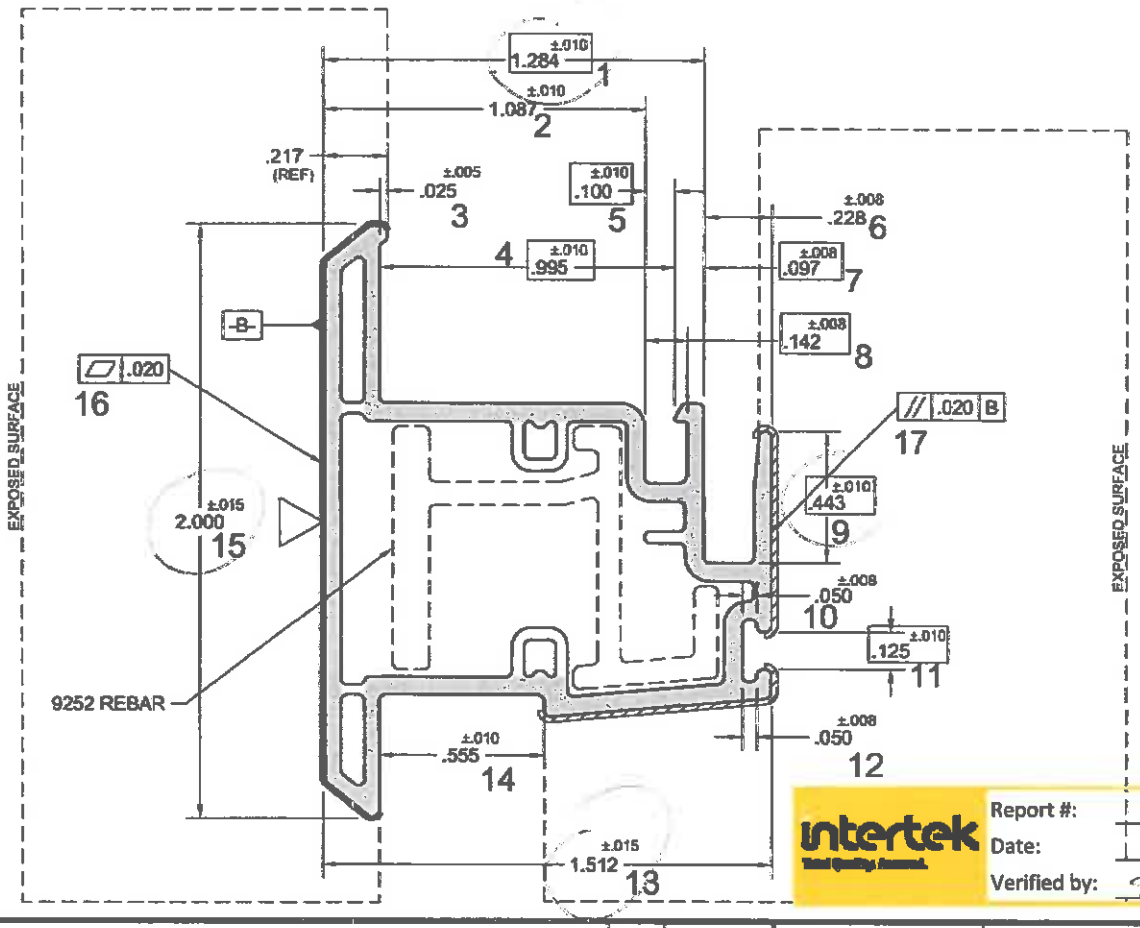
FUNCTIONAL CHECK

9216 GLAZING BEAD (3/4" GLASS)

9016 GLAZING BEAD (7/8" GLASS)

716A GLAZING BEAD (7/8" GLASS)

* 9252 ALUMINUM REBAR



intertek

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

NO.	REVISION	BY	DATE
2	REVISED SCREWBOSS SIZE	EAS	09-29-11
1	ADDED SCREWBOSS NUBS; ADDED CRIT DIMS; DIM 1.512 TOL WAS ±.018	EAS	09-29-11

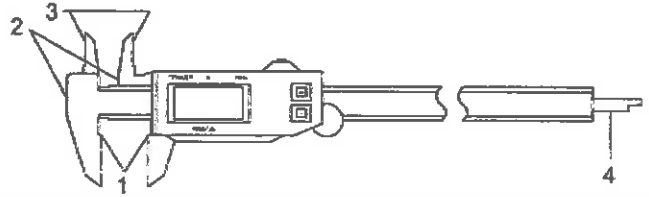
CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

DRAWN DATE: 09-27-11

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:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9206qc	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9206	LOCK RAIL/LOCK STILE	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020
8. LOCATION FOR IMPACT-TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 36 LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

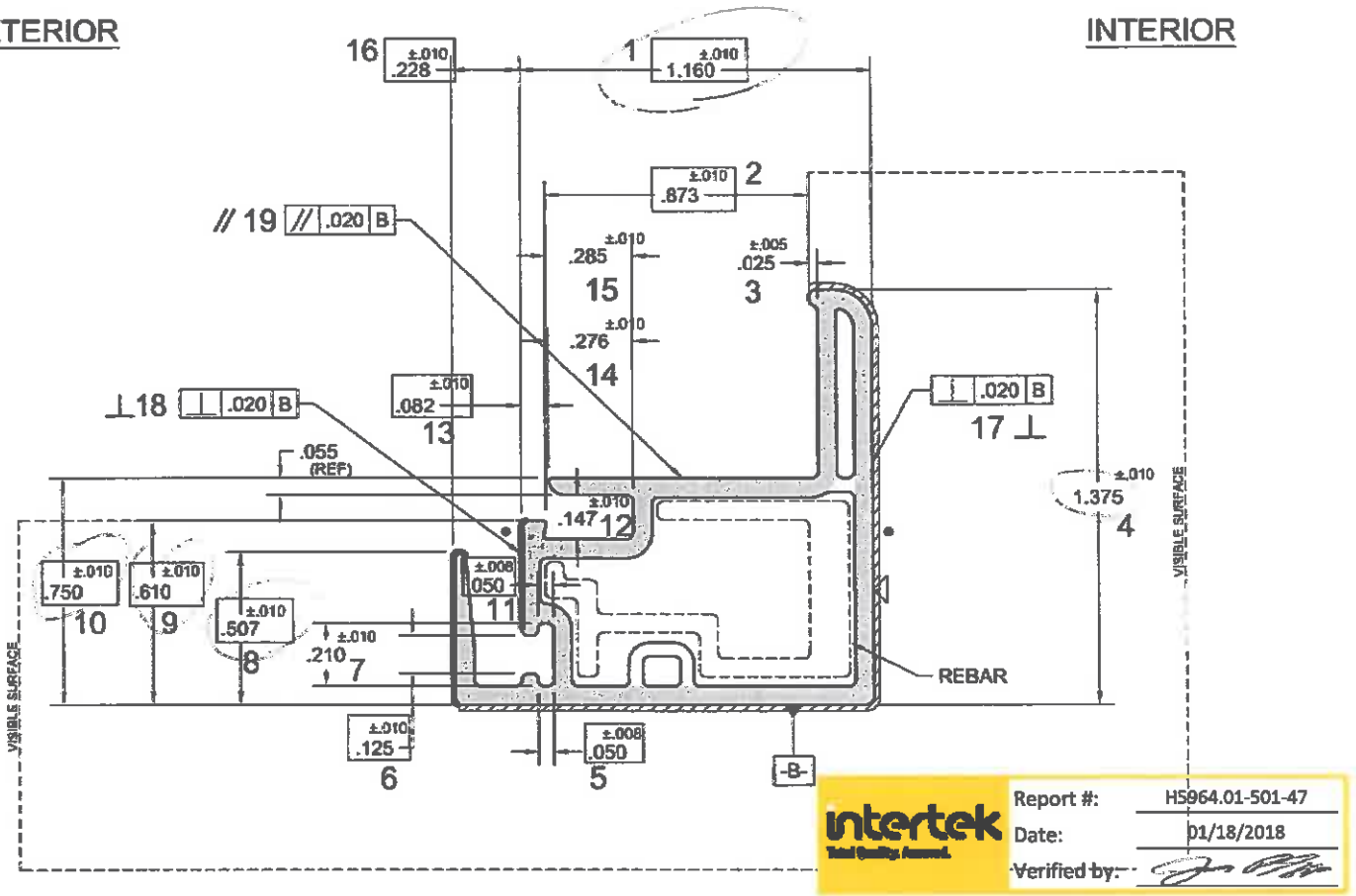
816 GLAZING BEAD (3/4" GLASS)

6266 GLAZING BEAD (7/8" GLASS)

.187 BACK WOOLPILE

9253 ALUMINUM REBAR

DRAWN DATE: 10-06-11



intertek Total Quality Assured.
Report #: HS964.01-501-47
Date: 01/18/2018
Verified by:

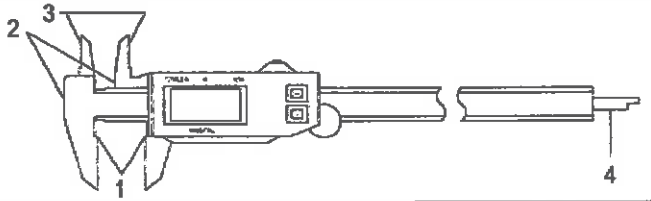
NO.	REVISION	BY	DATE
1	ADDED SCREWBOSS	EAS	10-24-11

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



QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9205qc	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9205	BOTTOM HANDLE RAIL/HANDLE STILE	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 36 LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

816 GLAZING BEAD (3/4" GLASS)

6266 GLAZING BEAD (7/8" GLASS)

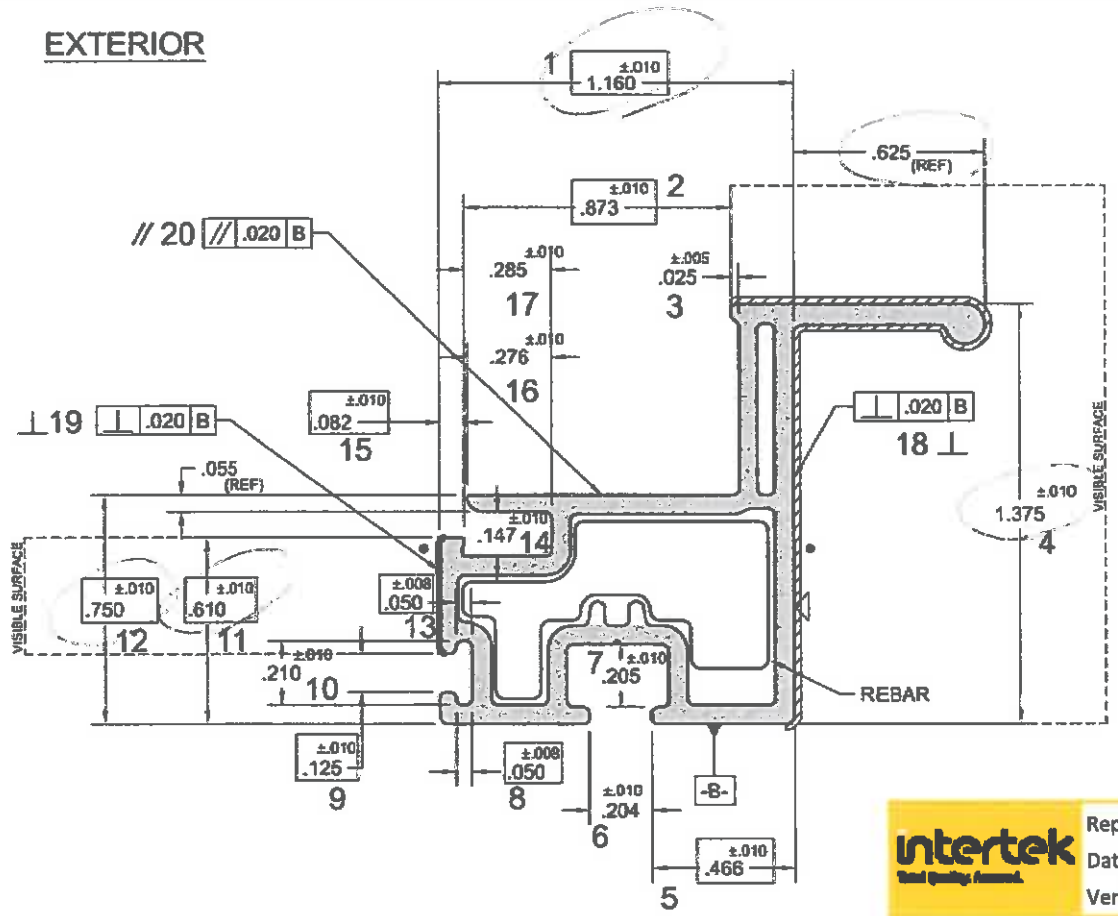
.187 BACK WOOLPILE

AMESBURY #32692 SASH SEAL

BSI PIVOT BAR (USE GAUGE #9205-GA-01)

9254 ALUMINUM REBAR

DRAWN DATE: 10-06-11



intertek
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

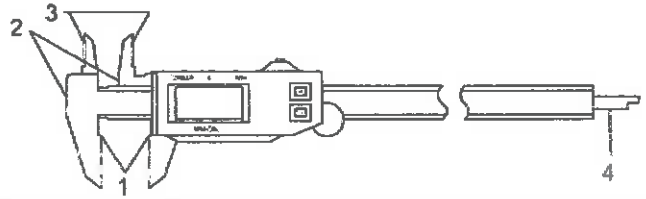
NO.	REVISION	BY	DATE
1	REVISED FUNCTIONAL CHECK AMESBURY SASH SEAL NO.	EAS	07-05-12

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



QC PRINT NUMBER: 9208qc	DRAWN BY: EAS	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9208	RAIL/STILE	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

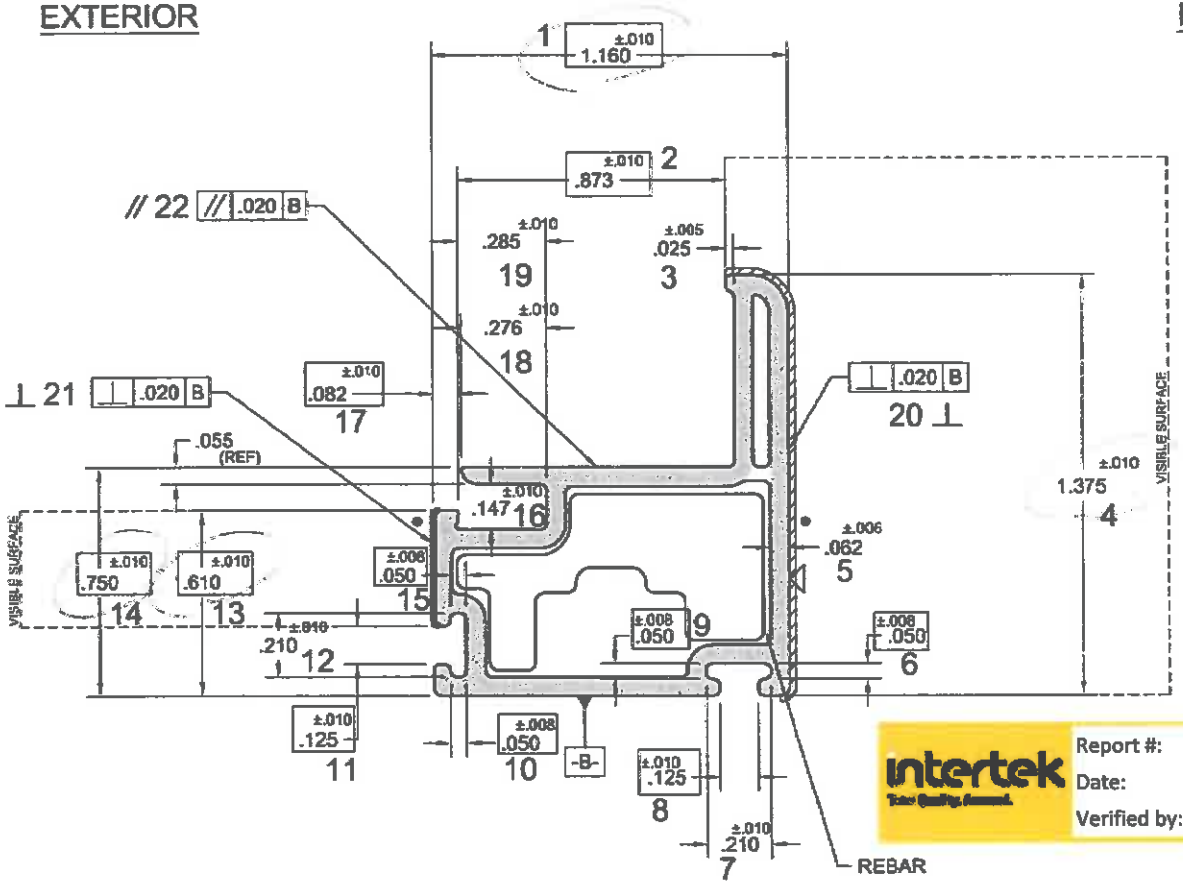
CHELSEA BUILDING PRODUCTS, INC.
585 CEDAR WAY, OAKMONT PA 15139

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .045in PER 36 LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION		
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK
816 GLAZING BEAD (3/4" GLASS)
6266 GLAZING BEAD (7/8" GLASS)
.187 BACK WOOLPILE
9259 COMPOSITE REBAR

DRAWN DATE: 10-06-11



intertek Total Quality Assured.
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

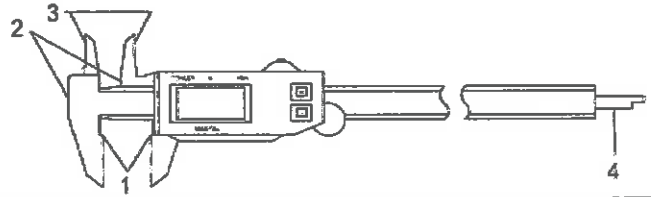
NO.	REVISION	BY	DATE

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



QC PRINT NUMBER: 9247QC	DRAWN BY: JPP	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9247	SILL TRACK	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS =
7. RADIUS =
8. LOCATION FOR IMPACT/REST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO
14. ANGULARITY TO BE ± 1°
15. PROFILE MUST MEET Q-303 PER AAMA SPECIFICATIONS ±3/8"
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 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

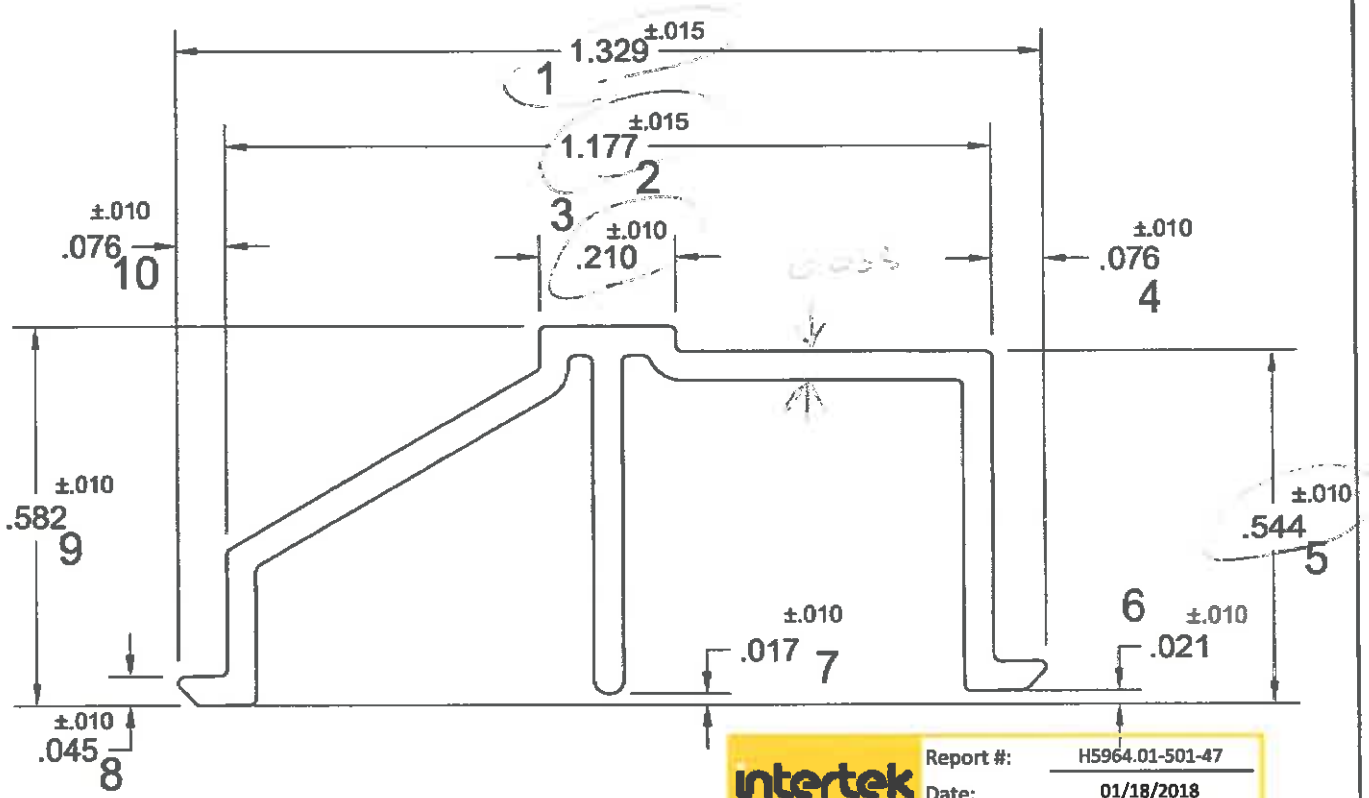
WEATHERSTRIP SPECIFICATION		
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

9204 SLIDER FRAME

9224 SLIDER FRAME

DRAWN DATE: 11-04-04



intertek
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

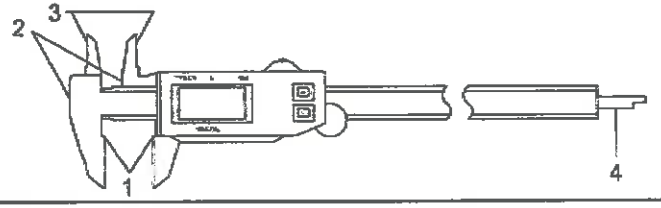
NO.	REVISION	BY	DATE

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: 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



QC PRINT NUMBER: 9216QC	DRAWN BY: EAS	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9216	GLAZING BEAD	CHELSEA BUILDING PRODUCTS

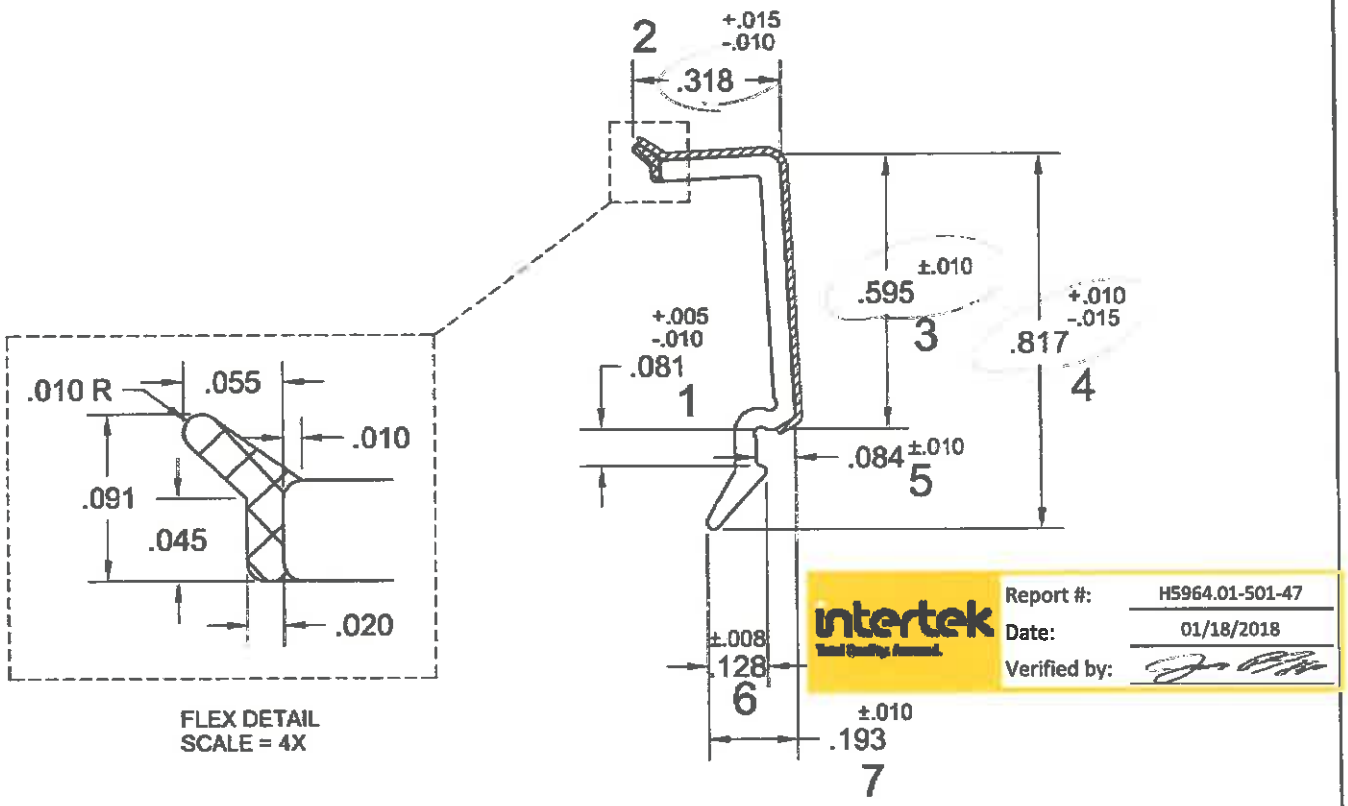
ILLUSTRATION OF PART AND CONTROL POINTS

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

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .045 ±.005
7. RADIUS = .010
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 3ft. LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION		
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK
705 LIFT RAIL
706 LOCK RAIL
707 KEEPER RAIL
9210 SH HEAD/PW FRAME
9213 SH JAMB
DRAWN DATE: 10-07-11



intertek
Total Quality Assured.
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

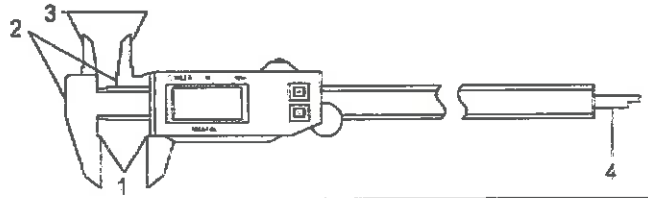
NO.	REVISION	BY	DATE

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: 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:

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:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
816qc	JPP					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
816	GLAZING BEAD	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

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

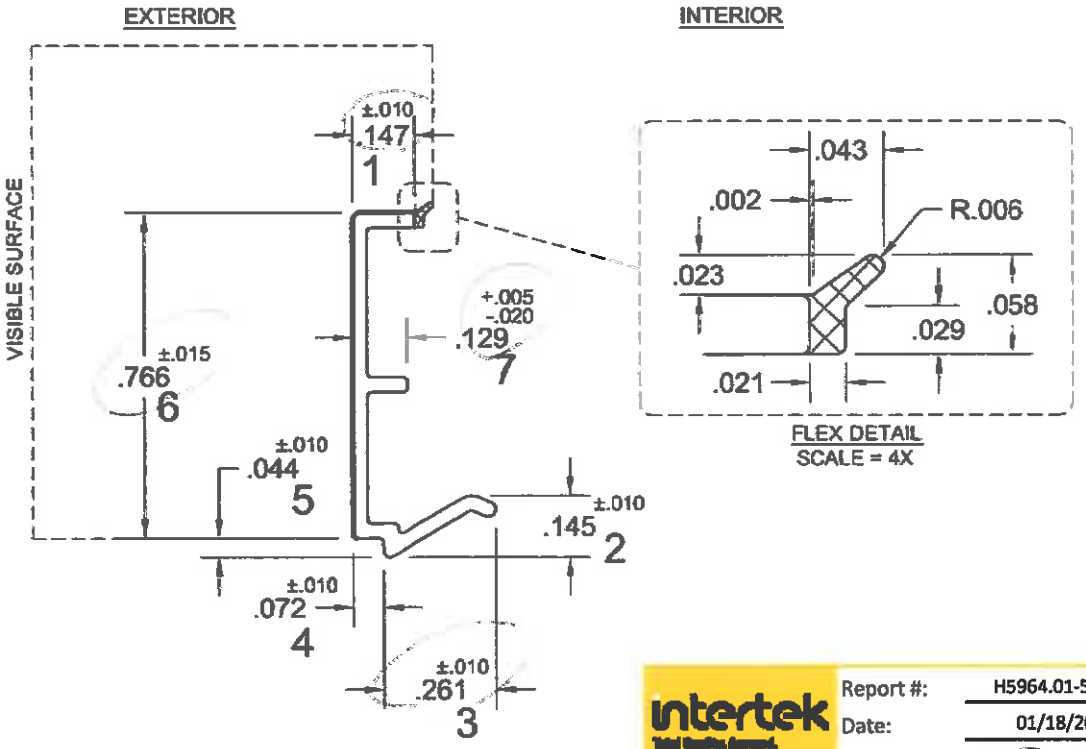
NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .035 ±.004
7. RADIUS = .010 R
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO ±3/8"
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 Q-901 PER AAMA SPECIFICATIONS
18. PROFILE MUST MEET Q-902 IMPACT RESISTANCE PER AAMA SPECIFICATIONS
19. MAX BOW .046in PER 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

800 SASH W/7/8" I.G.



intertek
Report #: H5964.01-501-47
Date: 01/18/2018
Verified by:

NO.	REVISION	BY	DATE
1	REVISED TITLE; WO#12017	EAS	01-23-12

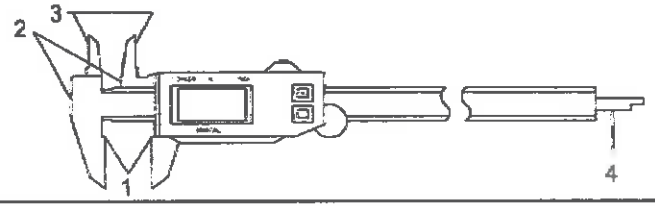
DRAWN DATE: 08-26-10

CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

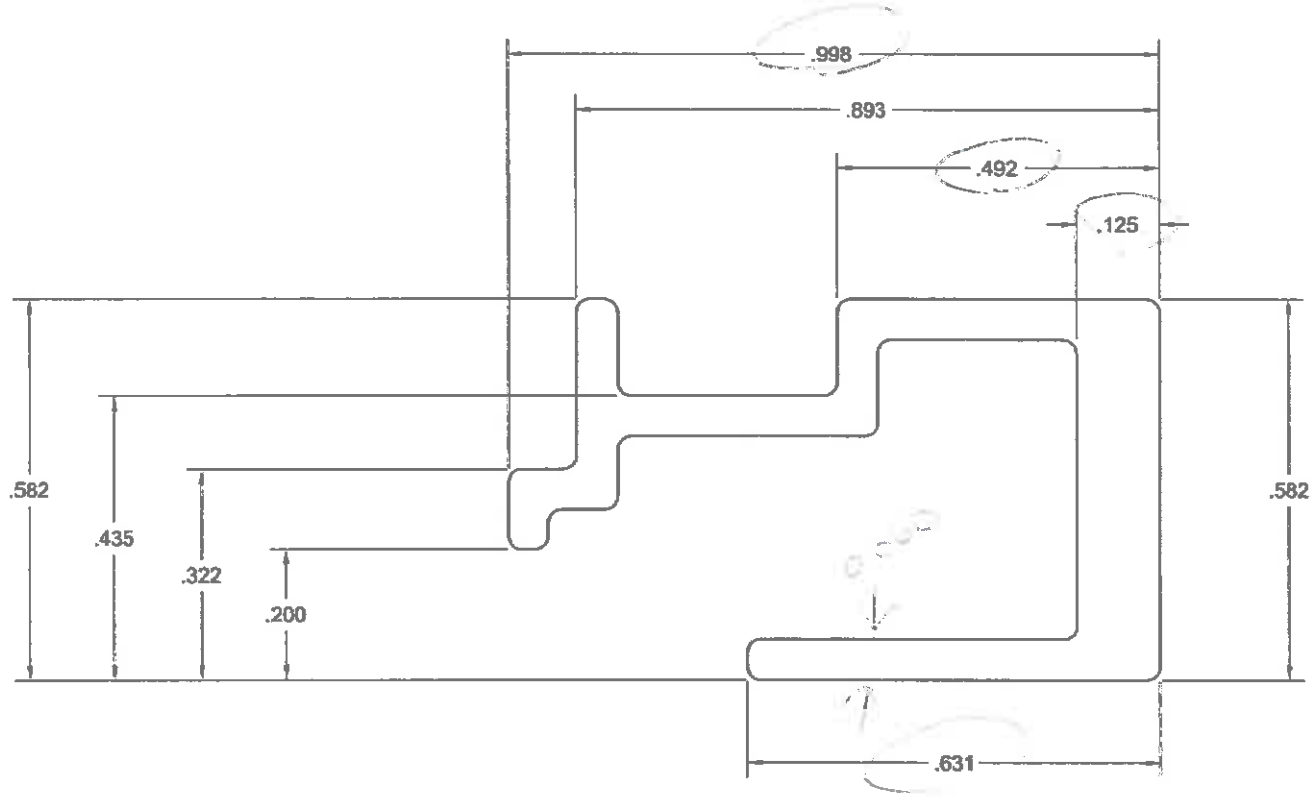
Use the caliper diagram as your guide to measure the following control points.
Measure the following control points using #1 on the caliper diagram:
Measure the following control points using #2 on the caliper diagram:
Measure the following control points using #3 on the caliper diagram:
Measure the 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



9253



intertek

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

MATERIAL - 6063 T5 ALUMINUM ALLOY FINISH - MILL

PRELIMINARY PART #

UNLESS OTHERWISE SPECIFIED

MATERIAL	ALUMINUM	WALLS	.062
EXTERIOR COATING		RADII	.020 R
FLEXIBLE P.V.C.		ANGULARITY	±1°
TOTAL AREA	.1868		
STANDARD WT/FT	.2197		

No.	REVISION	BY	DATE
		EAS	

CHELSEA BUILDING PRODUCTS, INC.

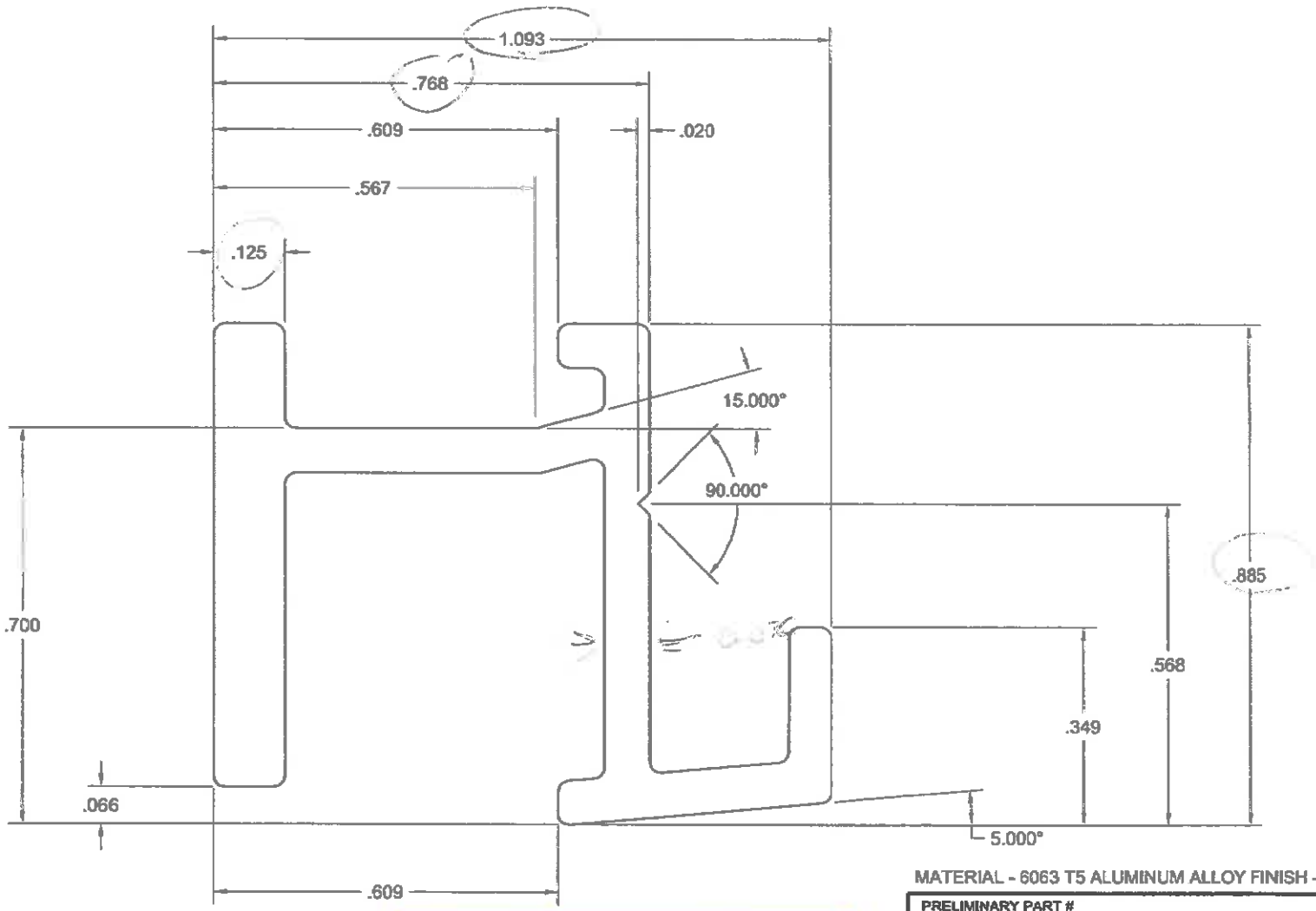
565 CEDAR WAY, OAKMONT PA 15139

TITLE

ALUMINUM REBAR FOR 9206 LOCK RAIL

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS	EAS	09-06-11	NTS-1
CHECKED BY:	APPROVED BY:	DRAWING No.	
		9253	

9252



MATERIAL - 6063 T5 ALUMINUM ALLOY FINISH - MILL

intertek

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

PRELIMINARY PART #

UNLESS OTHERWISE SPECIFIED

MATERIAL	ALUMINUM	WALLS	.078
EXTERIOR COATING		RADII	.020 R
FLEXIBLE P.V.C.		ANGULARITY	±1°
TOTAL AREA	.2708		
STANDARD WT/FT	.3185		

No.	REVISION	BY	DATE
*	ADDED NOTCH	EAS	11-04-11

CHELSEA BUILDING PRODUCTS, INC.

565 CEDAR WAY, OAKMONT PA 15139

TITLE
ALUMINUM REBAR FOR 9257 MEETING RAIL

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS	EAS	09-06-11	NTS-1
CHECKED BY:	APPROVED BY:	DRAWING No.	
		9252	

1140 Lincoln Avenue
Springdale, Pennsylvania 15144

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

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