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MASTER WINDOW SYSTEMS, INC.
TEST REPORT

SCOPE OF WORK
AAMA/WDMA/CSA 101/I.S.2/A440 TESTING ON 2800 SERIES DOUBLE-SLIDER, HORIZONTAL SLIDING WINDOWS

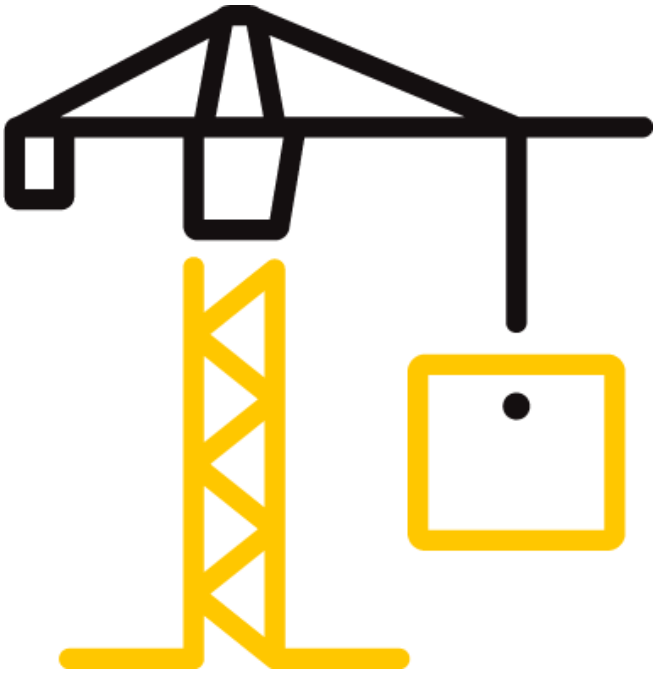
REPORT NUMBER
Q2271.06-109-44

TEST DATES
07/03/23 - 08/01/23

ISSUE DATE
03/19/25

PAGES
29

DOCUMENT CONTROL NUMBER
RT-R-AMER-Test-2804 (03/31/23)



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www.intertek.com/building

TEST REPORT FOR MASTER WINDOW SYSTEMS, INC.
Report No.: Q2271.06-109-44
Date: 03/19/25

REPORT ISSUED TO
MASTER WINDOW SYSTEMS, INC.
5070 Nifda Road SE
Atlanta, Georgia 30339

SECTION 1
SCOPE

Architectural Testing, Inc. (an Intertek company) dba Intertek Building & Construction (B&C) was contracted to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 on their 2800 Series Double-Slider, horizontal sliding windows. This test report is a reissue of the original Report No. Q2271.01-109-44. This report is issued in the name of Master Window Systems, Inc. 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 the Intertek B&C test facility in York, Pennsylvania.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. Intertek B&C will service this report for the entire test record retention period. The test record retention period ends four years after the test date. Test records, such as detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation, will be retained for the entire test record retention period.

Unless differently required, Intertek reports apply the "Simple Acceptance" rule, also called "Shared Risk Approach," of ILAC-G8:09/2019, Guidelines on Decision Rules and Statements of Conformity.

For INTERTEK B&C:

COMPLETED BY:	Richard E Hartman III	**REVIEWED BY:**	Ken R. Stough
TITLE:	Team Lead - Product Testing	**TITLE:**	Project Manager - Product Testing
SIGNATURE:	Digitally Signed by: Richard Hartman III	**SIGNATURE:**	Digitally Signed by: Ken Stough
DATE:	03/19/25	**DATE:**	03/19/25

BSH/REH:mas

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TEST REPORT FOR MASTER WINDOW SYSTEMS, INC.
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SECTION 2
SUMMARY OF TEST RESULTS

TITLE	TEST SPECIMEN #1	TEST SPECIMEN #2
AAMA/WDMA/CSA 101/I.S.2/A440-22	Class R - PG15 - 1829 x 1524 (72 x 60) - HS	Class R - PG20 - 1829 x 1524 (72 x 60) - HS
Design Pressure	±720 Pa (±15.04 psf)	±1200 Pa (±25.06 psf)
Air Infiltration	0.6 L/s/m^2 (0.12 cfm/ft^2)	N/A
Water Penetration Resistance Test Pressure	180 Pa (3.76 psf)	N/A

TITLE	TEST SPECIMEN #3	TEST SPECIMEN #4
AAMA/WDMA/CSA 101/I.S.2/A440-22	Class R - PG25 - 1600 x 1118* (63 x 44*) - HS	Class R - PG25 - 1600 x 1118* (63 x 44*) - HS
Design Pressure	±1200 Pa (±25.06 psf)	±1200 Pa (±25.06 psf)
Air Infiltration	N/A	N/A
Water Penetration Resistance Test Pressure	N/A	N/A

Reference must be made to Intertek B&C Report No. Q2271.06-109-44, dated 03/19/25 for complete test specimen description and detailed test results.

***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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Report No.: Q2271.06-109-44
Date: 03/19/25

SECTION 3
TEST SPECIFICATIONS/METHODS

The specimens were evaluated in accordance with the following:

AAMA/WDMA/CSA 101/I.S.2/A440-22, *North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

The following test methods were used during testing:

ASTM E283/E283M-19, *Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Skylights, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*

ASTM E330/E330M-14(2021), *Standard Test Method for Structural Performance of Exterior Windows, Doors, Skylights and Curtain Walls by Uniform Static Air Pressure Difference*

ASTM E331-00(2016), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference*

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

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

ASTM E2068-00(2022), *Standard Test Method for Determination of Operating Force of Sliding Windows and Doors1*

ASTM F588-17, *Standard Test Methods for Measuring the Forced Entry Resistance of Window Assemblies, Excluding Glazing Impact*

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

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Report No.: Q2271.06-109-44
Date: 03/19/25

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 specimens were installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/8" shim space and the exterior perimeter of the specimen was sealed to the test buck. Installation of the tested product was performed by Intertek B&C.

Specimens #1 and #3

LOCATION	ANCHOR DESCRIPTION	ANCHOR SPACING
Head, sill, and jambs	#6 x 1-1/4" self-drilling flat head screw	Located 2" from each corner, and spaced 11" on center through the nail fin into the wood buck

Specimens #2 and #4

LOCATION	ANCHOR DESCRIPTION	ANCHOR SPACING
Jambs	#8 x 2" pan head screw	Located 4" from each end through the frame into the wood buck

SECTION 5
EQUIPMENT

Tape Measure Verification: 63788
Force Gauge: INT00155, 63156
Weather Station:63316
Spray Rack:003956
Linear Transducers: 64367, 64460, 64461, 62185, INT03251
Control Panel: 003921, 005644,
Dial Indicator: 62216
Load Cell and Reader: 005532
Pressure Gauge: INT01385

The following equipment was utilized to apply Forced Entry Resistance (FER) loading in accordance with ASTM F588.

EQUIPMENT	ASSET NUMBER(S)	CALIBRATION DUE DATE
Spring Scale(s)	INT00009	4/28/24
Force Gauge(s)	INT00155	7/22/23

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EQUIPMENT: (CONTINUED)
A FER tool kit containing the following tools was also utilized:

24-gauge 0.024" thick x 0.78" wide x 3.5" long stainless-steel spatula/putty knife/non-cutting tool, unwrapped
6" Phillips head screwdriver [unpowered, 6 in max]
6" standard slot-type plyers [max 6 to 7 in (150 to 175 mm) overall length]
Black annealed 16-gauge straight wire

SECTION 6
LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Bishop S. Harrell	Intertek B&C
Ken R. Stough	Intertek B&C
Richard E. Hartman III	Intertek B&C

SECTION 7
TEST SPECIMEN DESCRIPTION

Product Type: Horizontal Sliding Window
Series/Model: 2800 Series Double-Slider

Product Sizes:

Test Specimens #1 and #2

OVERALL AREA:	WIDTH		HEIGHT	
2.8 m² (30.0 ft²)	millimeters	inches	millimeters	inches
Overall size	1829	72	1524	60
Sash size (2)	899	35-3/8	1448	57
Screen size	1746	68-3/4	1437	56-9/16

Test Specimens #3 and #4

OVERALL AREA:	WIDTH		HEIGHT	
1.8 m² (19.3 ft²)	millimeters	inches	millimeters	inches
Overall size	1600	63	1118	44
Sash size (2)	783	30-13/16	1045	41-1/8
Screen size	1508	59-3/8	1030	40-9/16

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Date: 03/19/25

Unless otherwise noted the following descriptions apply to all specimens.

Frame Construction:

MEMBER	MATERIAL	DESCRIPTION
Head, sill, jambs, and roller tracks	PVC	Extruded
	JOINERY TYPE	**DETAIL**
All corners	Mitered	Thermally welded
Roller tracks	Square cut	Sill, snapped into each track

Sash Construction:

MEMBER	MATERIAL	DESCRIPTION
Stiles and rails	PVC	Extruded
	JOINERY TYPE	**DETAIL**
All corners	Mitered	Thermally welded

Reinforcement:

DRAWING NUMBER	LOCATION	MATERIALS
9253	Lock stile	Aluminium
9254	Keeper stile	Aluminium

Weatherstripping:

DESCRIPTION	QUANTITY	LOCATION
0.187" backed by 0.250" high with center fin	2 Rows	Sash rails
0.187" backed by 0.250" high with center fin	1 Row	Sash pull stile
0.187 backed by 0.250" high with center fin	1 Row	Lock stile
Dual fin insert with 0.150" diameter hollow vinyl bulb seal	1 Row	Exterior meeting stile (interlocking)
Adhesive backed dust plugs 5/8" x 5/8" with 0.250" high double fin pile	2 Each	Exterior meeting stile (interlocking), one at each end
0.187" backed by 0.250" high with center fin	2 Rows	All frame members

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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
11/16" IG	PVC reinforced butyl spacer	1/8" annealed	1/8" annealed	Exterior glazed onto a bead of sealant. Secured using an extruded PVC snap in glazing stop

Test Specimens #1 and #2

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Sash daylight opening	2	829 x 1372	32-5/8 x 54	1/2"

Test Specimens #3 and #4

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Sash daylight opening	2	708 x 965	27-7/8 x 38	1/2"

Drainage:

METHOD	SIZE	QUANTITY	LOCATION
Weepslot with cover	1" wide by 1/4" high	3	Exterior sill face, located 4" from each end and one at midspan
Weepslot	1" wide by 3/16" deep	4	Sill, both tracks, two at each end
Weepslot	1" wide by 1/4" high	2	Sill, intermediate wall, one at each end
Weepslot	1/4" wide by 1/8" high	2	Sill face at screen track, located 3-3/4" from each end
Weepslot	3/8" wide by 3/16" high	4	Bottom rails, glazing pocket through two walls one at each end

Hardware:

DESCRIPTION	QUANTITY	LOCATION
Sweep lock with adjacent keeper	2	Lock stile, located 7" from each end
Dual nylon rollers with molded housing	2 Per sash	Bottom rail, located 2" from each end

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Screen Construction:

FRAME MATERIAL	CORNER CONSTRUCTION	MESH TYPE	MESH ATTACHMENT METHOD
Extruded aluminum	PVC internal corner keys	Fiber	Flexible vinyl spline

SECTION 8
TEST RESULTS

The temperature range during testing was 26-31°C (78-87°F) The results are tabulated as follows:

Test Specimen #1:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Operating Force, per ASTM E2068	Initiate Motion: 129 N (29 lbf) Maintain Motion: 116 N (26 lbf) Latches: 9 N (2 lbf)	155 N (35 lbf) max 155 N (35 lbf) max 100 N (22.48 lbf) max	
Air Leakage, Infiltration per ASTM E283 at 75 Pa (1.57 psf)	0.6 L/s/m^2 (0.12 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)	0.6 L/s/m^2 (0.11 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Water Penetration, per ASTM E547	N/A	N/A	4
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +720 Pa (+15.04 psf) -720 Pa (-15.04 psf)	 19.3 mm (0.76") 20.1 mm (0.82")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at meeting rail +1080 Pa (+22.56 psf) -1080 Pa (-22.56 psf)	 1.3 mm (0.05") 2.3 mm (0.09")	 5.8 mm (0.23") max. 5.8 mm (0.23") max.	 5, 6, 7
Forced Entry Resistance, per ASTM F588 Type: A - Grade: 10	Pass	No entry	

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Test Specimen #1:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Thermoplastic Corner Weld	Pass	Meets as stated	
Deglazing, per ASTM E987 Operating direction, 320 N (71.94 lbf)	Pass	Meets as stated	
Remaining direction, 230 N (50.71 lbf)	Pass	Meets as stated	
OPTIONAL PERFORMANCE			
Water Penetration, per ASTM E547 at 180 Pa (3.76 psf)	Pass	No leakage	3

Test Specimen #2:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
OPTIONAL PERFORMANCE			
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +960 Pa (+20.05 psf) -960 Pa (-20.05 psf)	 25.9 mm (1.02") 27.9 mm (1.10")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at meeting rail +1440 Pa (+30.08 psf) -11440 Pa (-30.08 psf)	 4.3 mm (0.17") 4.8 mm (0.18")	 5.8 mm (0.23") max. 5.8 mm (0.23") max.	 5, 6, 7

Test Specimen #3:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
OPTIONAL PERFORMANCE			
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +1920 Pa (+40.10 psf) -1920 Pa (-40.10 psf)	 13.5 mm (0.53") 14.5 mm (0.57")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at meeting rail +2880 Pa (+60.15 psf) -2880 Pa (-60.15 psf)	 1.3 mm (0.05") 0.8 mm (0.03")	 4.1 mm (0.16") max. 4.1 mm (0.16") max.	 5, 6, 7

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TEST REPORT FOR MASTER WINDOW SYSTEMS, INC.
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Test Specimen #4:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
OPTIONAL PERFORMANCE			
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +1680 Pa (+35.09 psf) -1680 Pa (-35.09 psf)	 12.4 mm (0.49") 15.2 mm (0.60")	 Report only	 5, 6, 7
Uniform Load Structural, per ASTM E330 Permanent set taken at meeting rail +2520 Pa (+52.63 psf) -2520 Pa (-52.63 psf)	 0.8 mm (0.03") 0.8 mm (0.03")	 4.1 mm (0.16") max. 4.1 mm (0.16") max.	 5, 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 07/03/23 / Time: 2:30PM

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.

Note 8: Reference Intertek B&C Report No. Q2271.06-109-44, dated 03/19/25 *for complete Gateway test specimen description and test results.*

SECTION 9
ALTERATIONS

No alterations were required.

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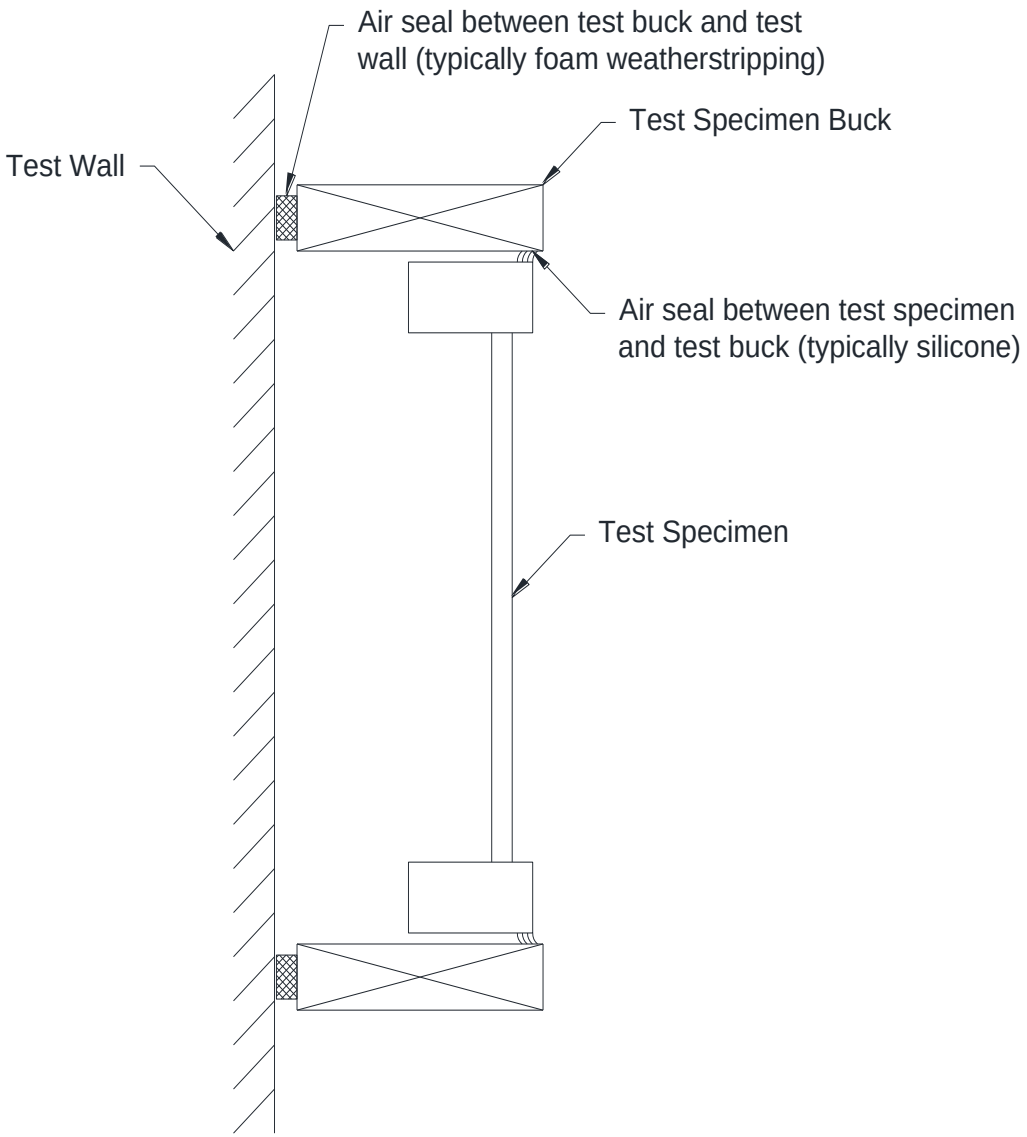
SECTION 10
LOCATION OF AIR SEAL

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 11
CONCLUSION

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

TEST SPECIMENS	TITLE	SUMMARY OF RESULTS
1	AAMA/WDMA/CSA 101/I.S.2/A440-22	Class R - PG15 - 1829 x 1524 (72 x 60) - HS
2	AAMA/WDMA/CSA 101/I.S.2/A44-022	Class R - PG20 - 1829 x 1524 (72 x 60) - HS
3	AAMA/WDMA/CSA 101/I.S.2/A440-22	Class R - PG25 - 1600 x 1118* (63 x 44*) - HS
4	AAMA/WDMA/CSA 101/I.S.2/A440-22	Class R - PG25 - 1600 x 1118* (63 x 44*) - HS

Reference Intertek B&C Report No. Q2271.06-109-44, dated 03/19/25 for complete *Gateway* test specimen description and test results.

***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 12
PHOTOGRAPH

Photo #1
2800 Series Double Slider, Horizontal Sliding Window

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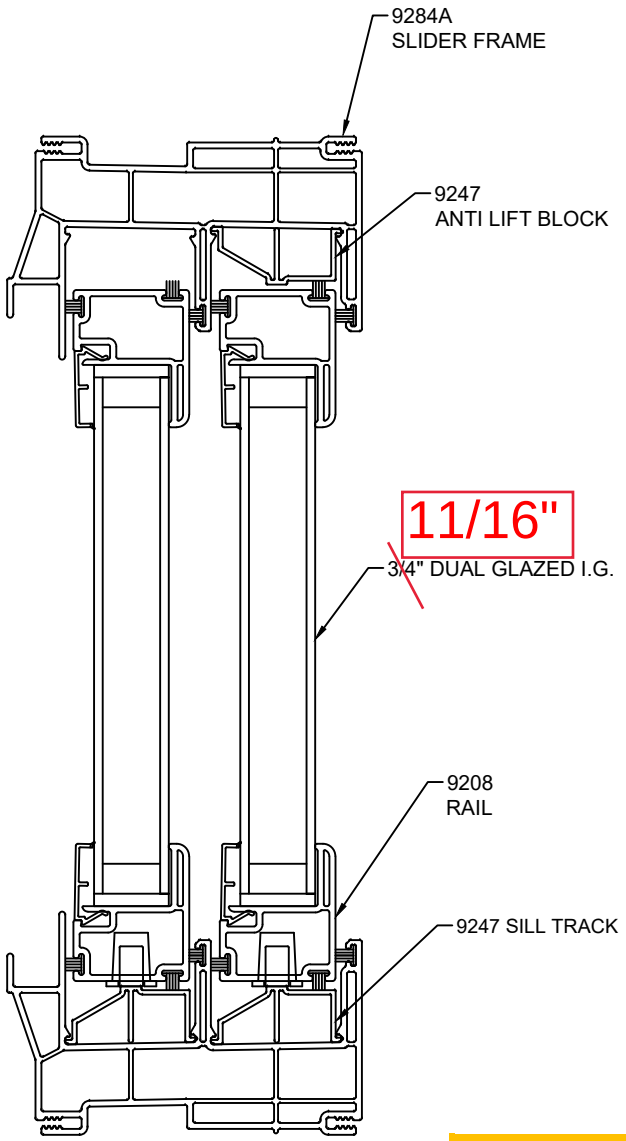
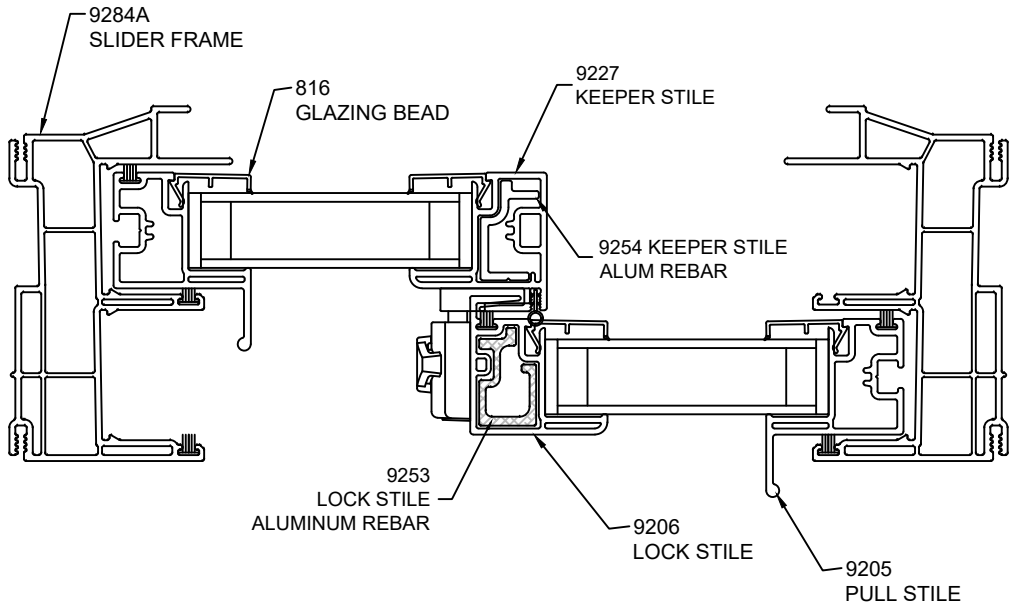
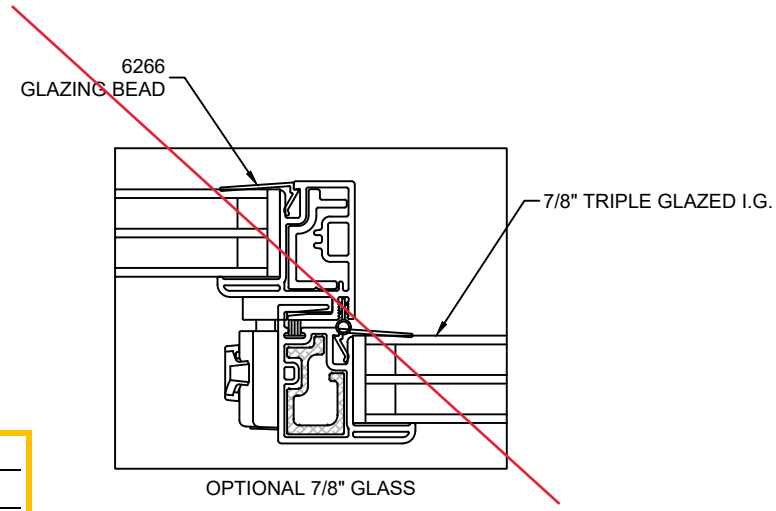
SECTION 13
DRAWINGS

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 included in this report. Any deviations are documented herein or on the drawings.

9280s512







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Report #: Q2271.01
Date: 12/07/23
Verified by: Richard E. Hutchinson III

No.	REVISION	BY	DATE
4	UPDATED 9253; WO#21089	JAF	03/04/21
3	REVISED 9284MA TO 9284A; WO#16171, RBD#16281	JAF	12/12/16
2	UPDATED FRAME; WO#12108	EAS	07-09-12
1	UPDATED LOCK STILE	EAS	10-27-11

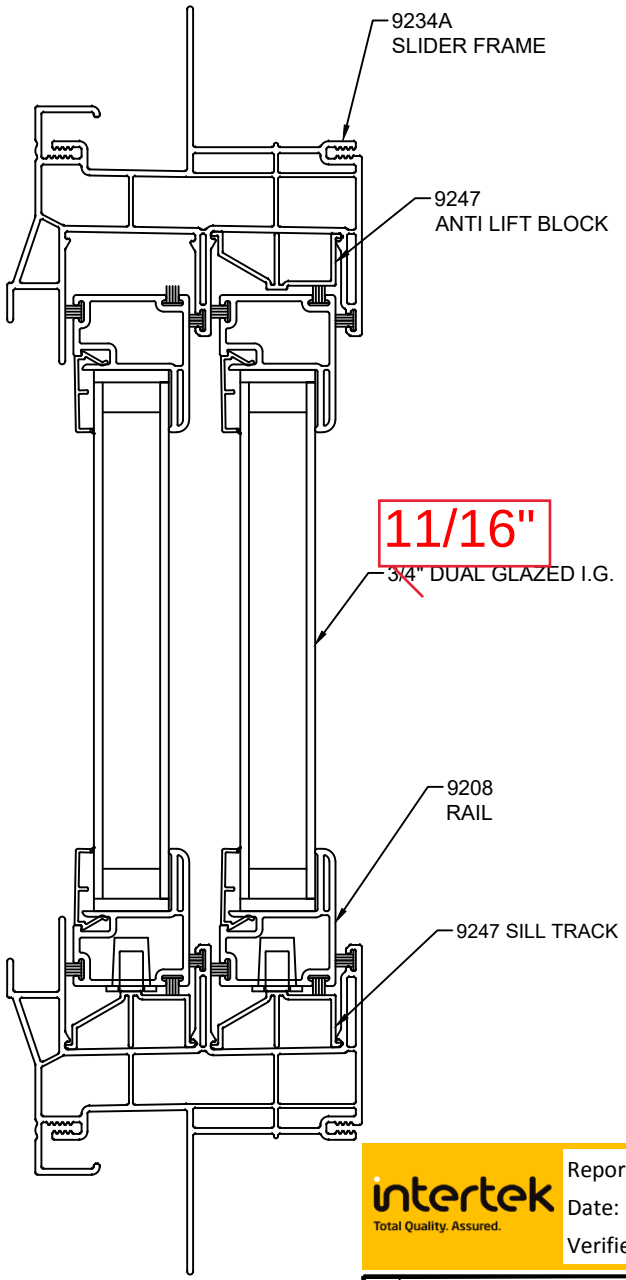
CHELSEA BUILDING PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

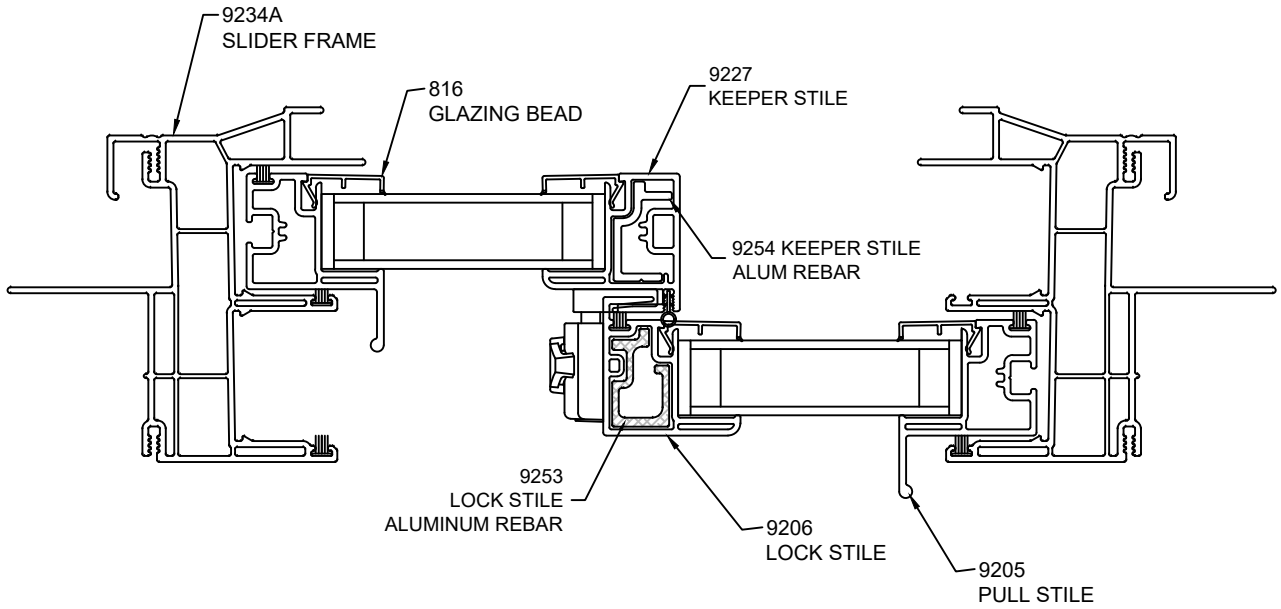
PRELIMINARY PART #

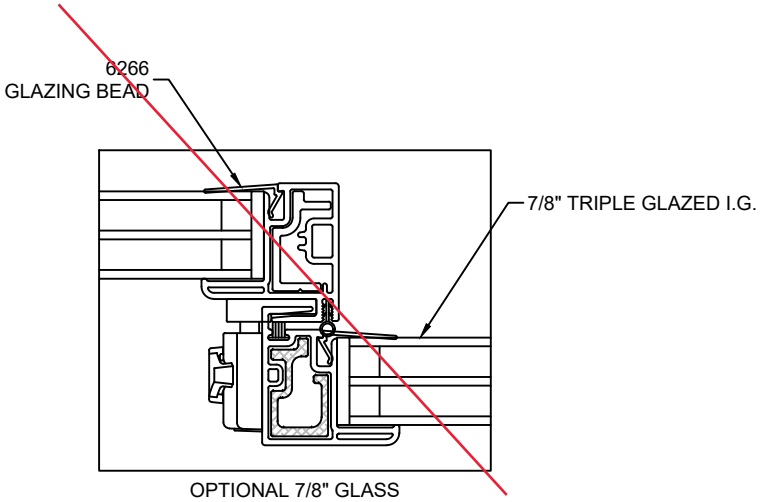
TITLE: 9280-HS-T500 3/4" GLASS (7/8" GLASS OPTIONAL) REPLACEMENT XX SLIDER

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS		10-03-11	NTS-1
CHECKED BY:	APPROVED BY:	DRAWING No.	
		9280s512	

9230s512







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Report #: Q2271.01
Date: 12/07/23
Verified by:

No.	REVISION	BY	DATE
3	UPDATED 9253; WO#21089	JAF	03/03/21
2	REVISED 9234MA TO 9234A; WO#16171, RBD#16281	JAF	12/01/16
1	UPDATED FRAME, WO#12108	EAS	07-09-12

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

PRELIMINARY PART #

TITLE: 9230-HS-T500 3/4" GLASS (7/8" GLASS OPTIONAL) NEW CONSTRUCTION XX SLIDER

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS		10-03-11	NTS-1

CHECKED BY:	APPROVED BY:	DRAWING No.
		9230s512

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

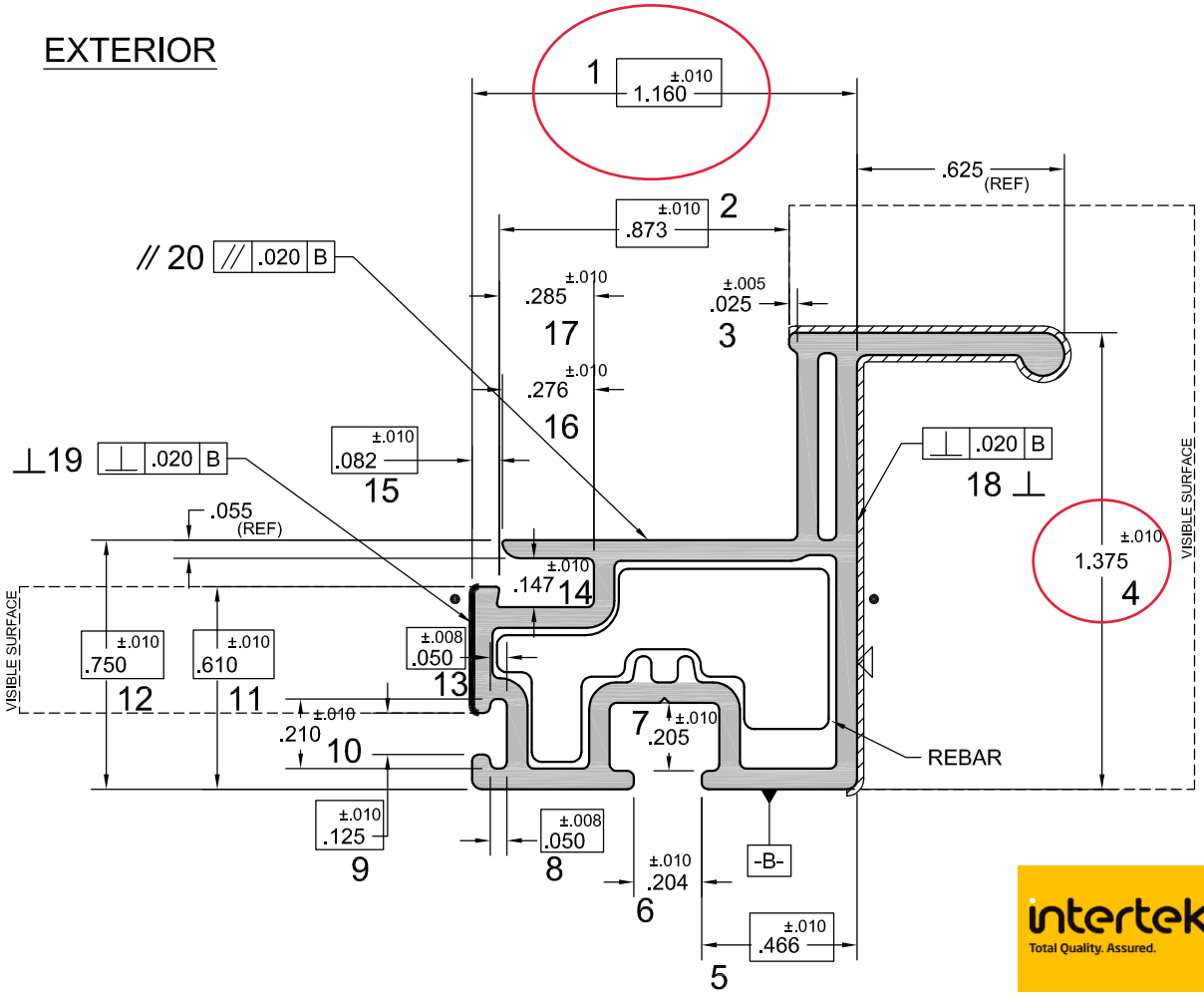
NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO ±3/8"
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 3ft 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 Total Quality. Assured.
Report #: Q2271.01
Date: 12/07/23
Verified by:

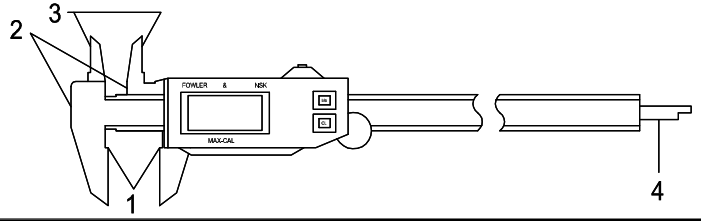
NO.	REVISION	BY	DATE
1	REVISED FUNCTIONAL CHECK AMESBURY SASH SEAL NO.	EAS	07-05-12

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:	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 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

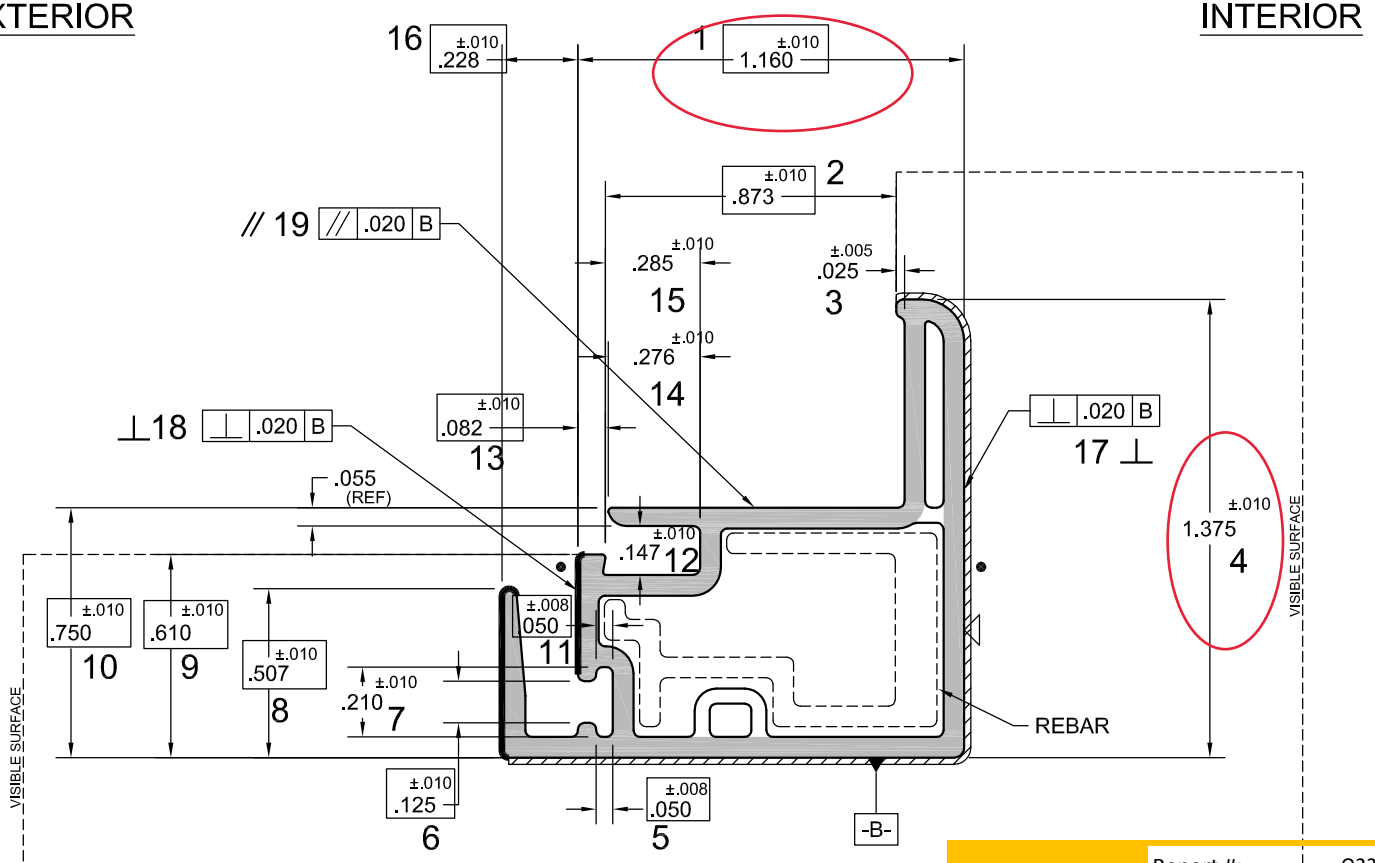
816 GLAZING BEAD (3/4" GLASS)

6266 GLAZING BEAD (7/8" GLASS)

.187 BACK WOOLPILE

9253 ALUMINUM REBAR

DRAWN DATE: 10-06-11



intertek Total Quality. Assured.

Report #: Q2271.01
Date: 12/07/23
Verified by:

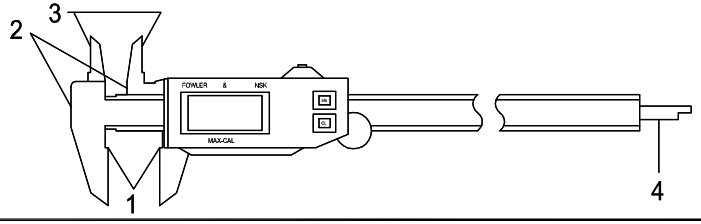
NO.	REVISION	BY	DATE
1	ADDED SCREWBOSS	EAS	10-24-11

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
9208qc	EAS					

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

ILLUSTRATION OF PART AND CONTROL POINTS

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

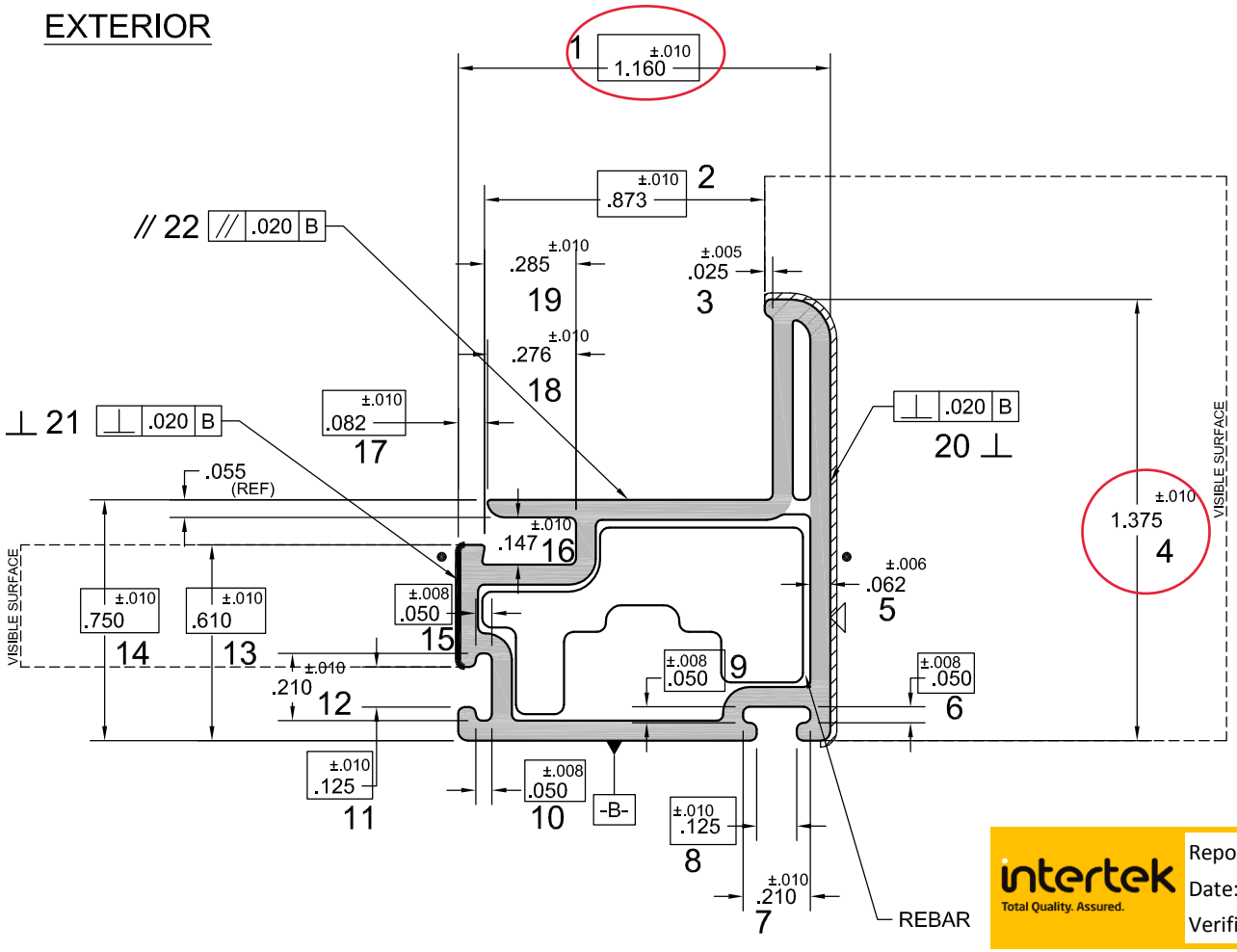
NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .062 ±.006
7. RADIUS = .020
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO ±3/8"
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 3ft 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 #: Q2271.01
Date: 12/07/23
Verified by:

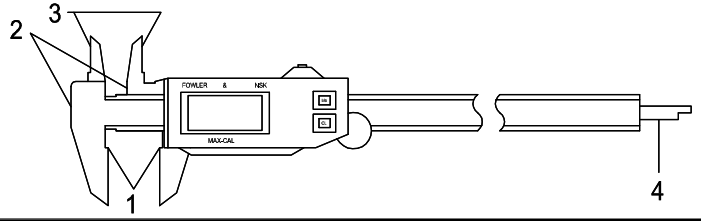
NO.	REVISION	BY	DATE

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:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9227qc	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9227	KEEPER RAIL/KEEPER 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 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

816 GLAZING BEAD (3/4" GLASS)

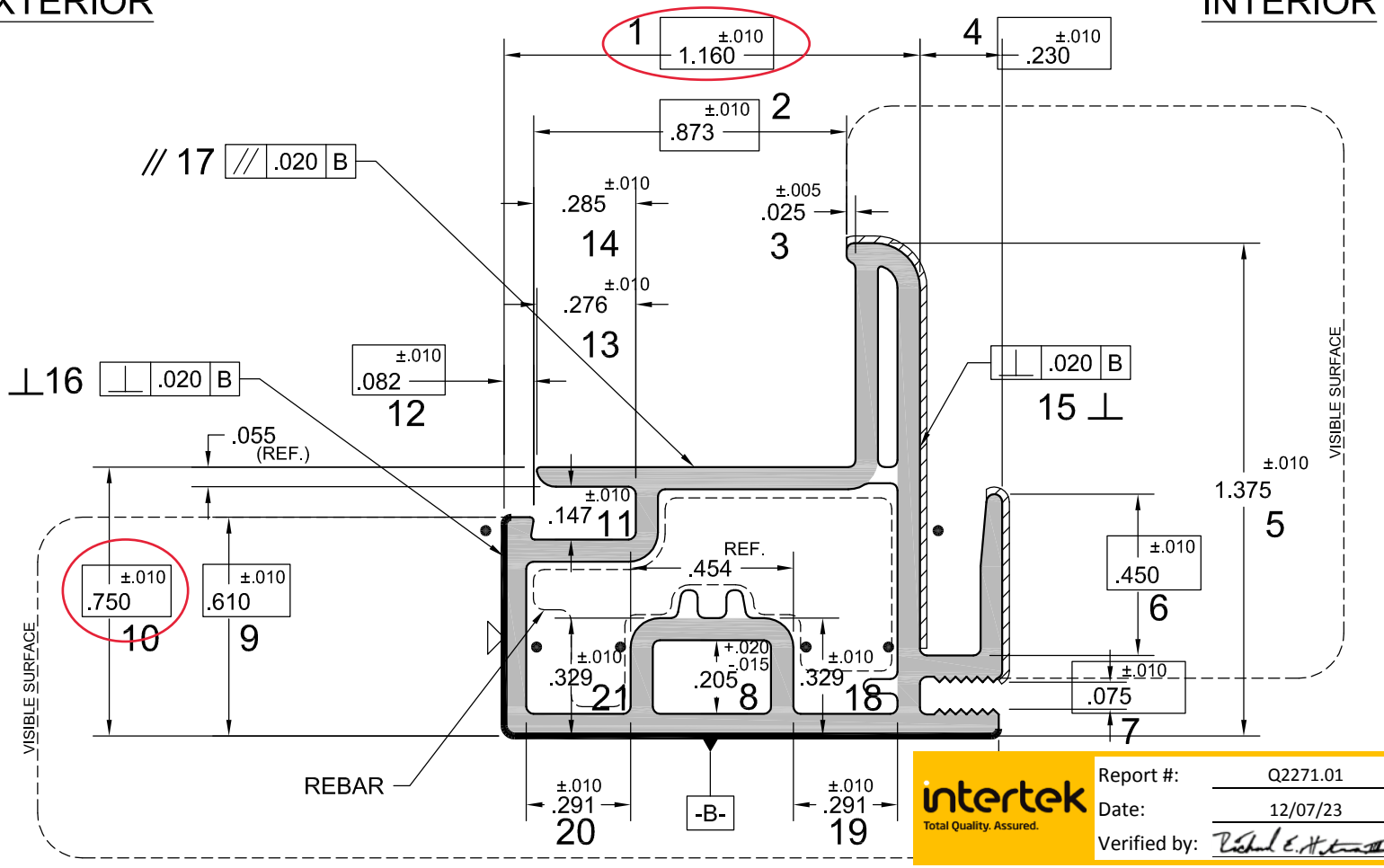
6266 GLAZING BEAD (7/8" GLASS)

ULTRAFAB #E109 SASH SEAL

9259 COMPOSITE REBAR

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

DRAWN DATE: 10-06-11



intertek Total Quality. Assured.

Report #: Q2271.01
Date: 12/07/23
Verified by:

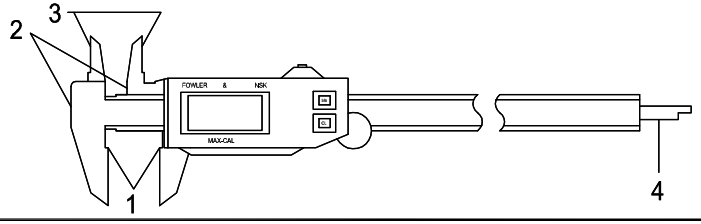
NO.	REVISION	BY	DATE
2	ADDED PIVOT BAR POCKET DIMS, WO#13130	EAS	07-10-13
1	DIM .205 TOL WAS ±.010	EAS	11-21-11

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
9234AQC	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9234A	XX 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 = .060 ±.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 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

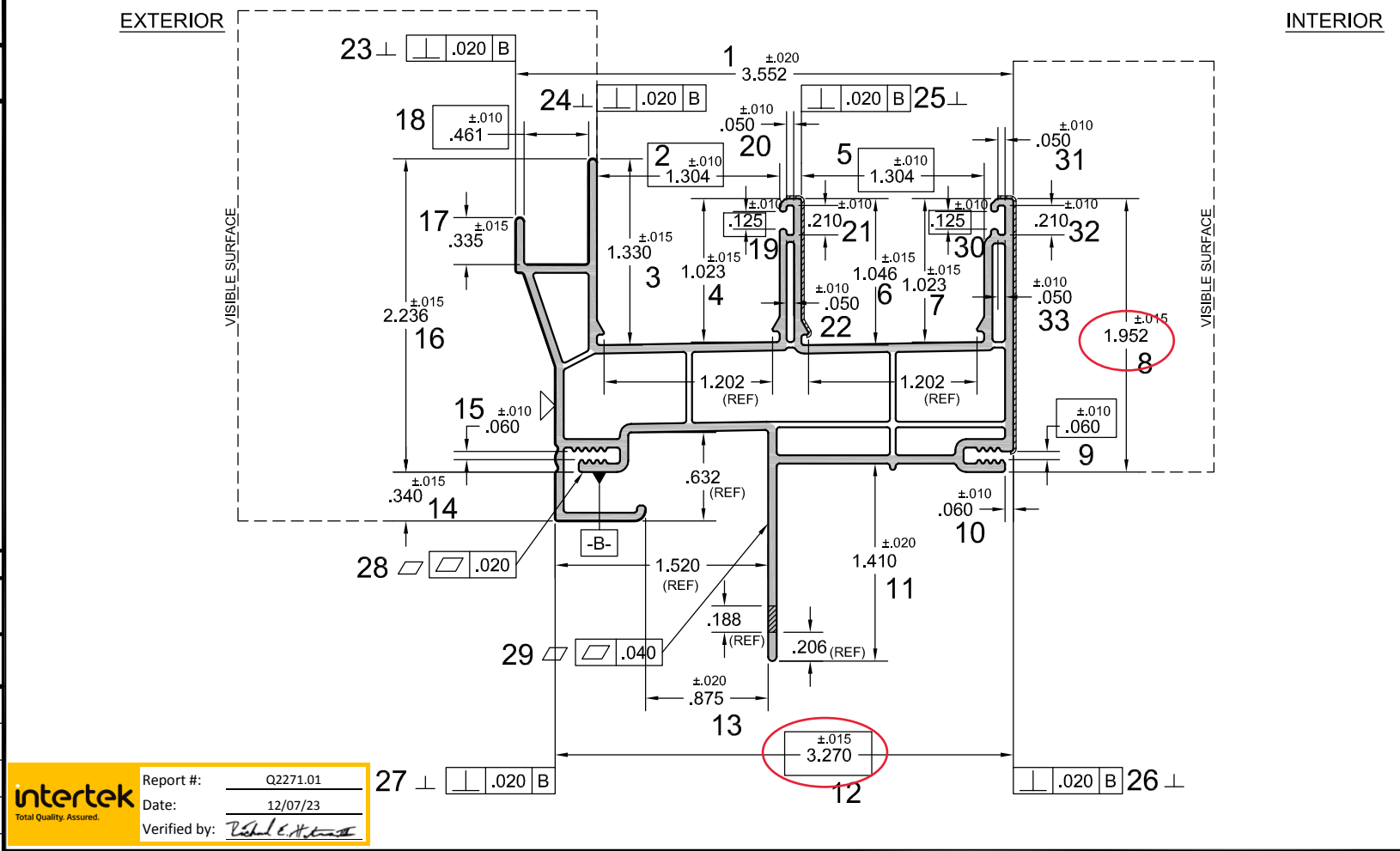
POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK

727 MULLION CLIP

749 1/2" MULLION CLIP

9247 SLIDER TRACK



intertek Total Quality. Assured.
Report #: Q2271.01
Date: 12/07/23
Verified by:

NO.	REVISION	BY	DATE
1	PART NUMBER WAS 9234MA; WO#16171, RBD#16281	JAF	11/08/16

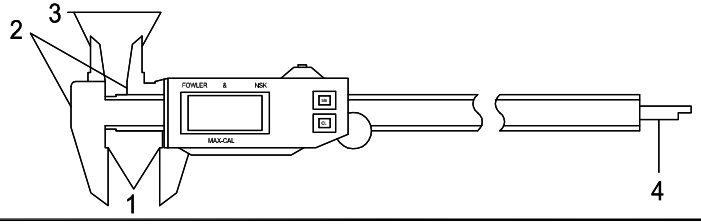
CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

DRAWN DATE: 05-29-12

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
816qc	JPP					

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

ILLUSTRATION OF PART AND CONTROL POINTS

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

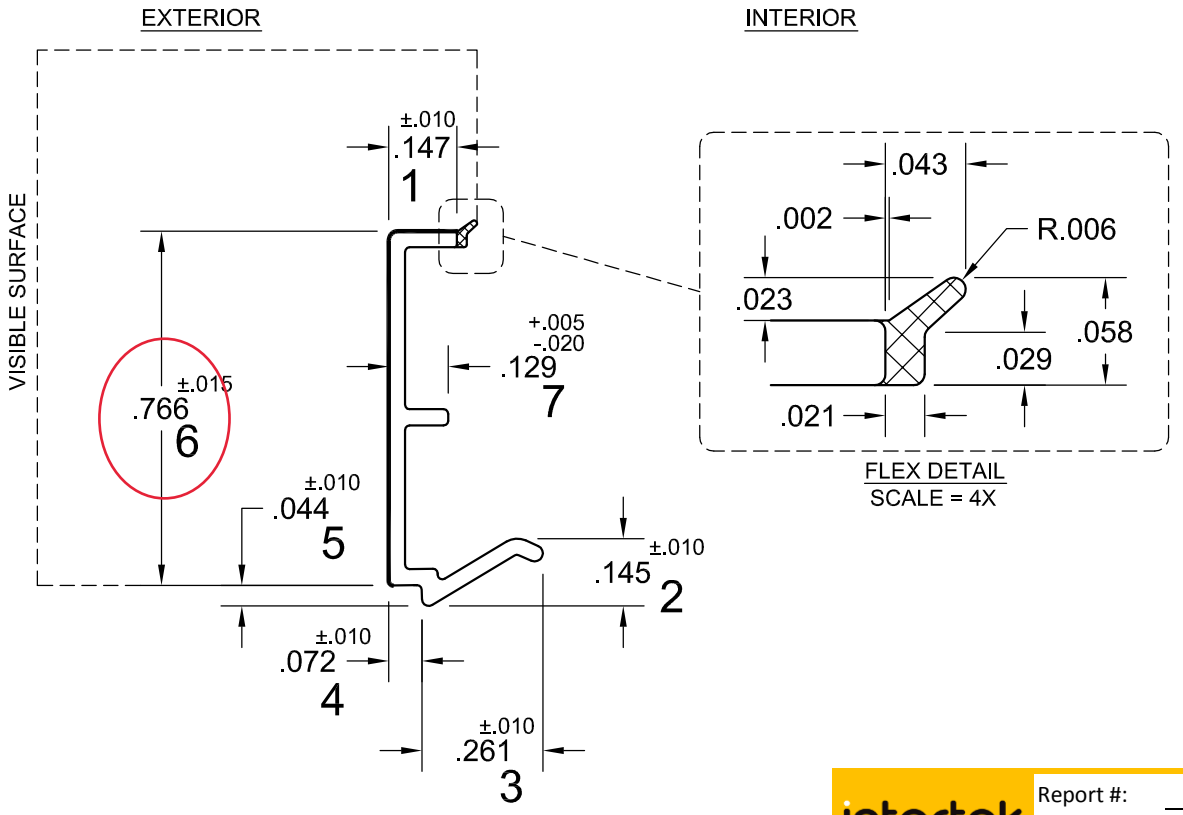
NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .035 ±.004
7. RADIUS = .010 R
8. LOCATION FOR IMPACT TEST
9. ANGULARITY =
10. PERPENDICULARITY =
11. PARALLELISM =
12. FLATNESS =
13. SPECIFICATION LENGTH TO ±3/8"
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 Total Quality. Assured.

Report #: Q2271.01
Date: 12/07/23
Verified by:

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

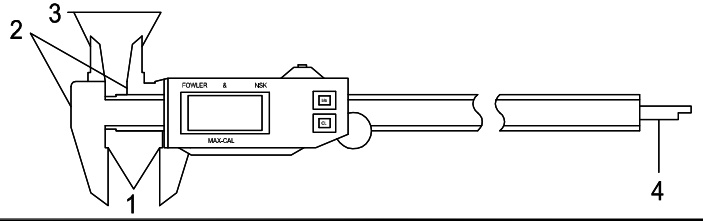
CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

DRAWN DATE: 08-26-10

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



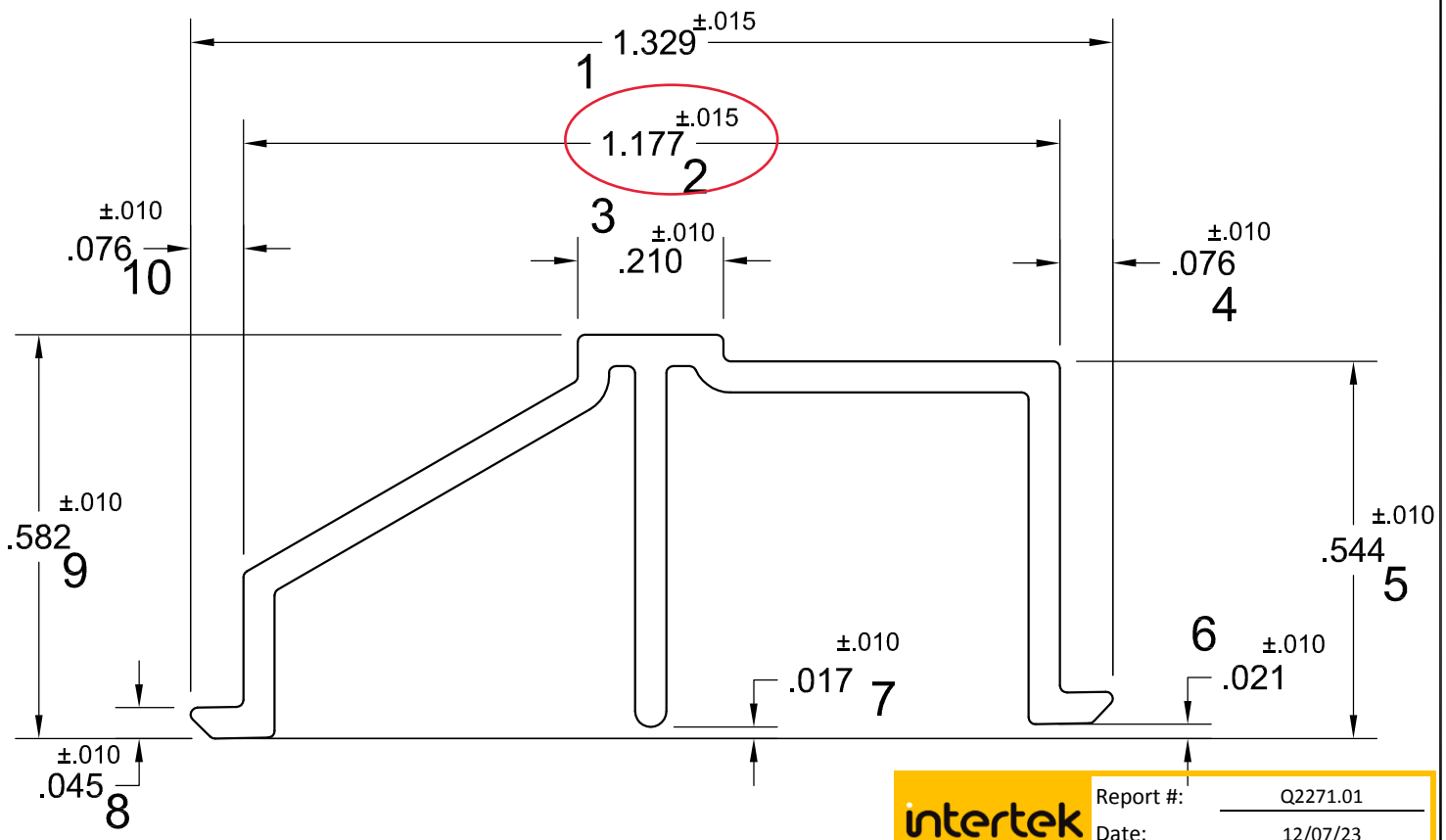
QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:			
9247QC	JPP			DEVELOP	INPROCESS	PRODUCTION

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9247	SILL TRACK	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 =
7. RADIUS =
8. LOCATION FOR IMPACT TEST .046
9. ANGULARITY .010
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



intertek Total Quality. Assured.
Report #: Q2271.01
Date: 12/07/23
Verified by:

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK
9204 SLIDER FRAME
9224 SLIDER FRAME

DRAWN DATE: 11-04-04

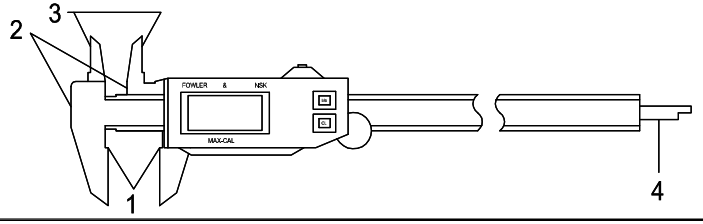
NO.	REVISION	BY	DATE

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



9253

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		

intertek
Total Quality. Assured.

Report #: Q2271.01
Date: 12/07/23
Verified by:

No.	REVISION	BY	DATE
1	REDESIGNED	EAS	11-01-11

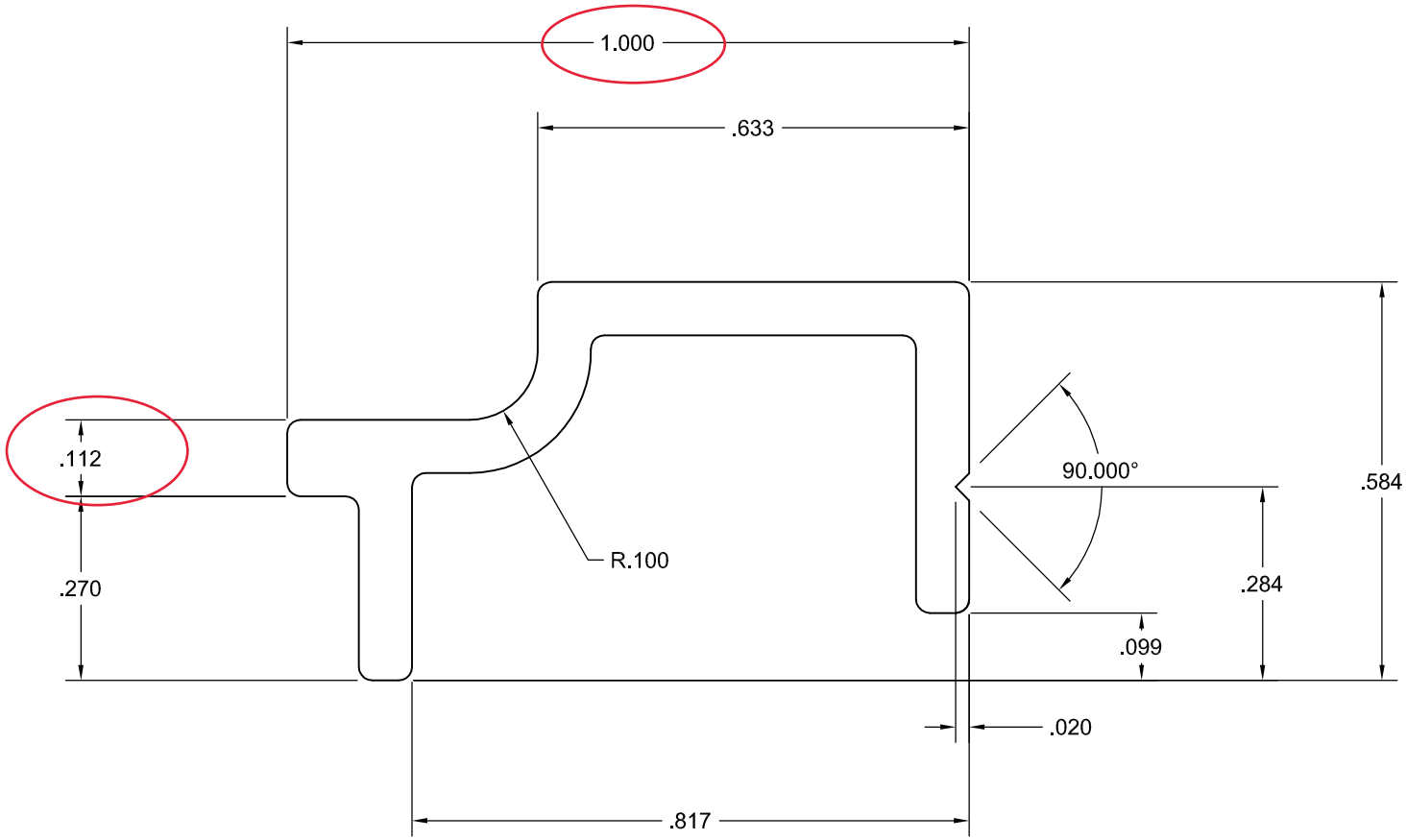
CHELSEA BUILDING PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

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

9254



MATERIAL - 6063 T5 ALUMINUM ALLOY FINISH - MILL

PRELIMINARY PART #

UNLESS OTHERWISE SPECIFIED

MATERIAL	ALUMINUM	WALLS	.078
EXTERIOR COATING		RADII	.020 R
FLEXIBLE P.V.C.		ANGULARITY	±1°
TOTAL AREA	.1474		
STANDARD WT/FT	.1733		

intertek Total Quality. Assured.

Report #: Q2271.01

Date: 12/07/23

Verified by:

No.	REVISION	BY	DATE
1	WALL THICKNESS WAS NOTED AS .062, CHANGED TO .078	EAS	01-19-12

CHELSEA BUILDING PRODUCTS, INC.

565 CEDAR WAY, OAKMONT PA 15139

TITLE

ALUMINUM REBAR FOR 9227 & 9267 KEEPER RAILS

DRAWN BY:	DESIGNED BY:	DATE	SCALE
EAS	EAS	09-06-11	NTS-1

CHECKED BY:	APPROVED BY:	DRAWING No.
		9254

QC PRINT NUMBER:	DRAWN BY:	CHECKED BY:	APPROVED BY:	DEVELOP	INPROCESS	PRODUCTION
9284AQC	EAS					

PART NAME:	DESCRIPTION:	SUPPLIER/PLANT:
9284A	XX SLIDER FRAME	CHELSEA BUILDING PRODUCTS

ILLUSTRATION OF PART AND CONTROL POINTS

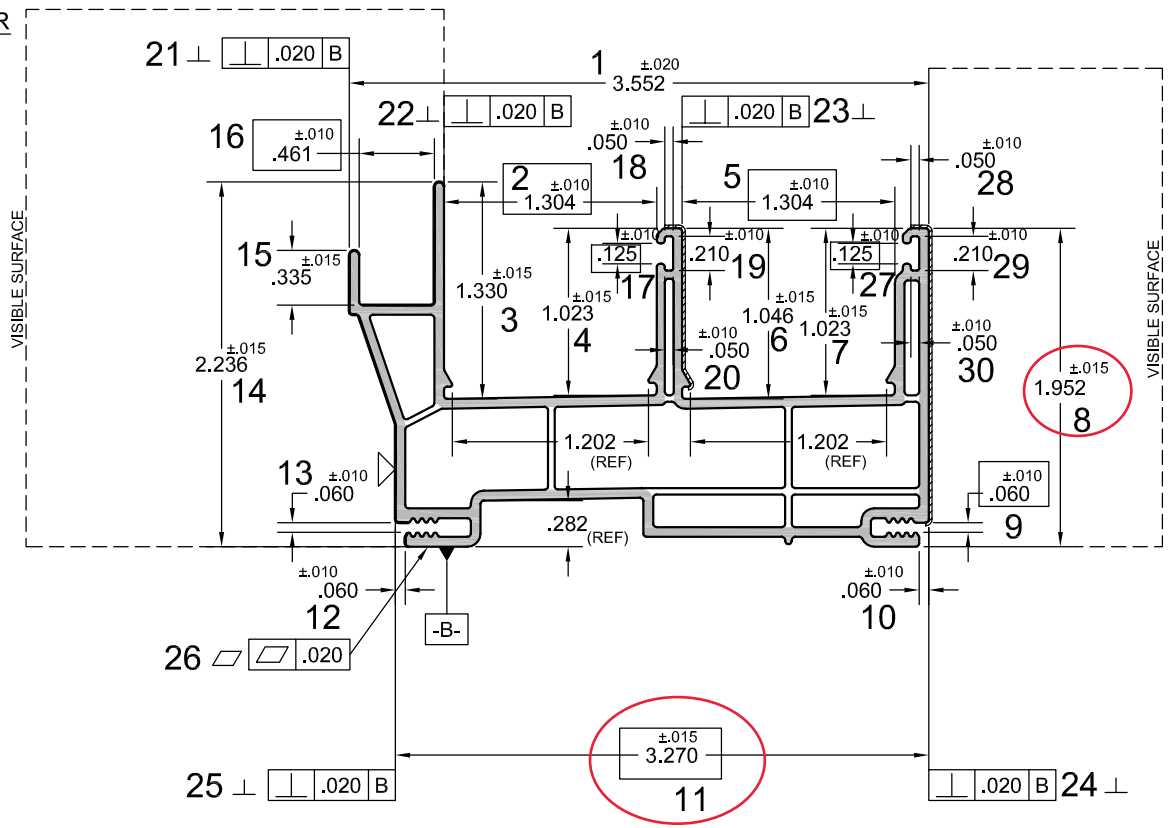
CHELSEA BUILDING PRODUCTS, INC.
565 CEDAR WAY, OAKMONT PA 15139

NOTES:
1. MATERIAL = RIGID P.V.C.
2. FLEXIBLE P.V.C. =
3. EXTERIOR COATING =
4. LAMINATE =
5. THINNER INTERIOR WALLS =
6. WALL THICKNESS = .060 ±.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 3ft LENGTH
20. INTERNAL WALL THICKNESS ±.010 UNLESS OTHERWISE SPECIFIED

WEATHERSTRIP SPECIFICATION

POSITION	SIZE	WEATHERSTRIP TYPE

FUNCTIONAL CHECK
727 MULLION CLIP
749 1/2" MULLION CLIP
9247 SLIDER TRACK



intertek Total Quality. Assured.
Report #: Q2271.01
Date: 12/07/23
Verified by:

NO.	REVISION	BY	DATE
1	PART NUMBER WAS 9284MA; WO#16171, RBD#16281	JAF	11/08/16

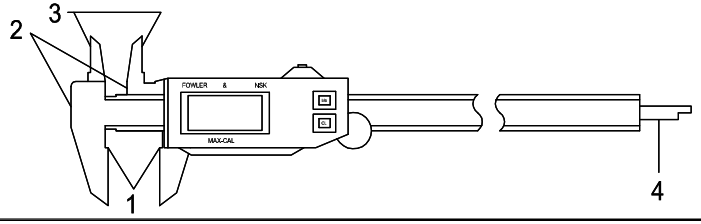
CUSTOMER LENGTH	CHELSEA CUT LENGTH	TOLERANCE

DRAWN DATE: 05-29-12

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



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SECTION 14
REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	03/19/25	N/A	Original Report Issue - Reissued Report No. Q2271.06-109-44 in the name of Master Window Systems, Inc.