

000.620 PD - 008 - BILL OF MATERIALS 4 LITE

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
1	FXD PNL TOP RAIL	2	10001102	10001102-F-01	A
2	STILE	4	10001102	10001102-F-01	A
3	BOTTOM RAIL	2	10001102	10001102-F-02	A
4	INTERLOCK	2	10001117	10001117-F-04	A
5	SCREW COVER	2	10001118	STRAIGHT CUT	A
6	GLAZING BEAD	8	10001111	10001111-F-01	A
7	STILE REINFORCEMENT - JAMB	2	10300150	STRAIGHT CUT	PPPP
8	STILE REINFORCEMENT - INTERLOCK	2	10300151	STRAIGHT CUT	PPPP
9	WEATHER-STRIPPING - 270 x 250	AS REQD	W21255MW		HHHH
10	OPR PNL	2	10001102	10001102-F-01	A
11	RAIL - TOP	2	10001102	10001102-F-03	A
12	STILE - INTERLOCK	2	10001102	10001102-F-10	A
13	STILE - ACTIVE LOCK	1	10001102	10001102-F-10	A
14	STILE - PASSIVE LOCK	1	10001102	10001102-F-16	A
15	RAIL - BOTTOM	2	10001102	10001102-F-05	A
16	4 LITE ASTRAGAL	1	10001183	STRAIGHT CUT	A
17	INTERLOCK	2	10001117	10001117-F-02	A
18	SCREW COVER	2	10001118	STRAIGHT CUT	A
19	GLAZING BEAD	8	10001111	10001111-F-01	A
20	STILE REINFORCEMENT - INTERLOCK	2	10300151	STRAIGHT CUT	PPPP
21	STILE REINFORCEMENT - ACTIVE LOCK	1	10300150	10300150-F-01	PPPP
22	STILE REINFORCEMENT - PASSIVE LOCK	1	10300151	10300151-F-01	PPPP
23	RAIL REINFORCEMENT - BOTTOM	2	10300152	10300152-F-01	PPPP
24	VERTICAL ASTRAGAL REINFORCEMENT BAR - KEEPER RAIL	1	1/2" X 4" ALUMINUM REINFORCEMENT (EMS 10-61-500)	STRAIGHT CUT	EASTERN
25	SQUARE TUBE REINFORCEMENT - VERTICAL INTERLOCK RAILS	4	1" X 1" X .125" SQUARE ALUMINUM TUBE (EMS 19-61-140)	STRAIGHT CUT	EASTERN
26	WEATHER-STRIPPING - 270 x 250	AS REQD	W21255MW		HHHH
27	MISC				
28	LOCK SET ASSEMBLY - 2817 LOCK W/ PLATE	1	DECU-XXX4		F
29	HANDLE SET ASSEMBLY	2	DECU-XXX1		F
30	HANDLE SET - INTERIOR SWITCH		DECU-XXX2		
31	HANDLE SET - INTERIOR SWITCH / KEY		DECU-XXX3		
32	HANDLE SET - BLANK	4	1988PRS166REVSS		F
33	ROLLER ASSEMBLY - PRECISION 1.66" WHEEL	4	D6096AMWKC 0.810		HHHH
34	DRAFT PLUG - .810 DIA.	4	9946		D
35	3/8" HOLE PLUG	4			F
36	KEEPER - 2778 KEEPER - STAINLESS STEEL	1	DECU-2808-84		MAMMM
37	IMPACT BRACKET	5	01H055-D		
38	1" INSULATED GLASS	4			
39	SETTING BLOCKS (REFER TO SUPPLIER GUIDELINES)	AS REQD			
40	GLAZING COMPOUND	AS REQD			
41	SCOREWS	4	#10 X 1.25" PFH - 410SS		
42	LOCK SET	4	#8 X 3/4" PFH - 410SS		
43	ROLLER ASSEMBLY	8	#8 X 1" PFH - 410SS		
44	REINFORCEMENT	AS REQD	#8 X 5/8" PFH - 410SS		
45	INTERLOCK	AS REQD	#8 X 2" PPH - PAINTED		
46	4 LITE ASTRAGAL	AS REQD	#8 X 3" PPH - 410SS		
47	KEEPER	4	#8 X 2.5" PFH - PAINTED		
48	REPORT:	15			
49					

DATE: 10/11/14
 VERIFIED BY: [Signature]
 REPORT: [Signature]

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 DECEUNINCK NORTH AMERICA

MONROE, OH
 000 620 PD - 008
 JGM
 000620PD-008

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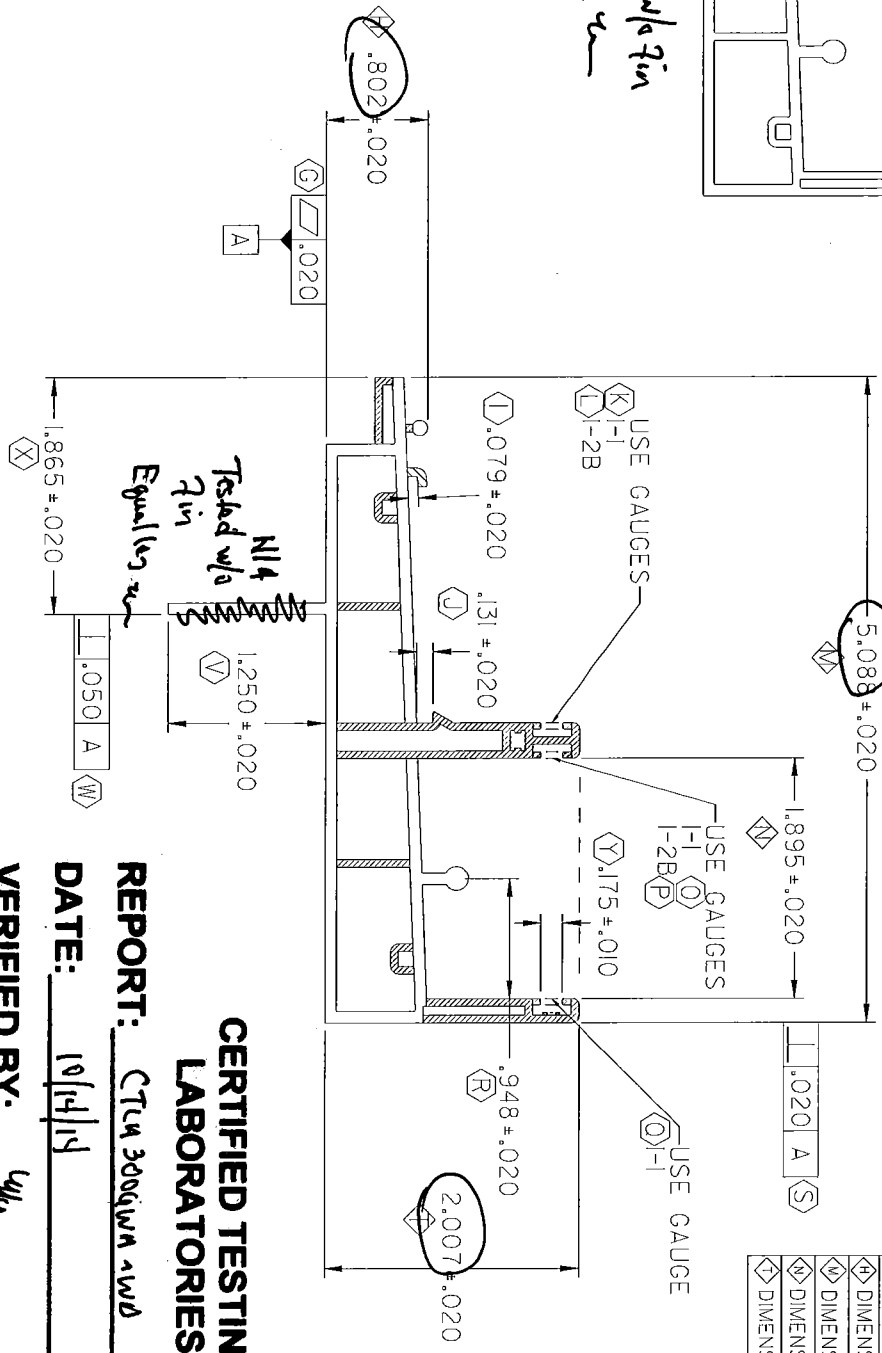
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REV	DESCRIPTION	DATE	APPROVED
F	KPC	09/11/04	BWB

REVISION HISTORY

KEY PRODUCT CHARACTERISTICS
◇ DIMENSION .782 - .822
◇ DIMENSION 5.068 - 5.108
◇ DIMENSION 1.875 - 1.915
◇ DIMENSION 1.987 - 2.207

*N/A - Tested w/o Fin
Equal leg. ✓*



CERTIFIED TESTING LABORATORIES

REPORT: CTU 300qWA 1WD

DATE: 10/14/14

VERIFIED BY: Wp

- WALL THICKNESS
- .090 -
 - .070 -
 - .060 -
 - .050 -
 - .040 -
- NOTES:
1. ST00003' STRAIGHTNESS, CLASS A AND LENGTH TOLERANCES APPLY. (A)
 2. INTERPRET AS A TOLERANCE ON CALCULATIONS PER SECTION 3.1. (A)
 3. UNSPECIFIED EXTERNAL RADI = .XXX +.020 / -.005 (A)
 4. UNSPECIFIED INTERNAL RADI = .XXX +.020 / -.005 (A)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .20% (A)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .20% (A)

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UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES
TOL. ON ANGLES: * 1°
2 PL: +.0010° 3 PL: +.0005°
INTERPRET DIM AND TOL PER
ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:	RJC
DATE:	00/00/20
DRAWN BY:	RJC
DATE:	00/00/20
CHECKED BY:	
DATE:	
APPROVED BY:	
DATE:	
FILE NAME:	4FILE NAME#

NAME: **deceuninck** NORTH AMERICA

30 NORTH UNIVERSITY AVE
MONTICELLO, OHIO 45867

SIZE DWG. NO: 1000101.SH

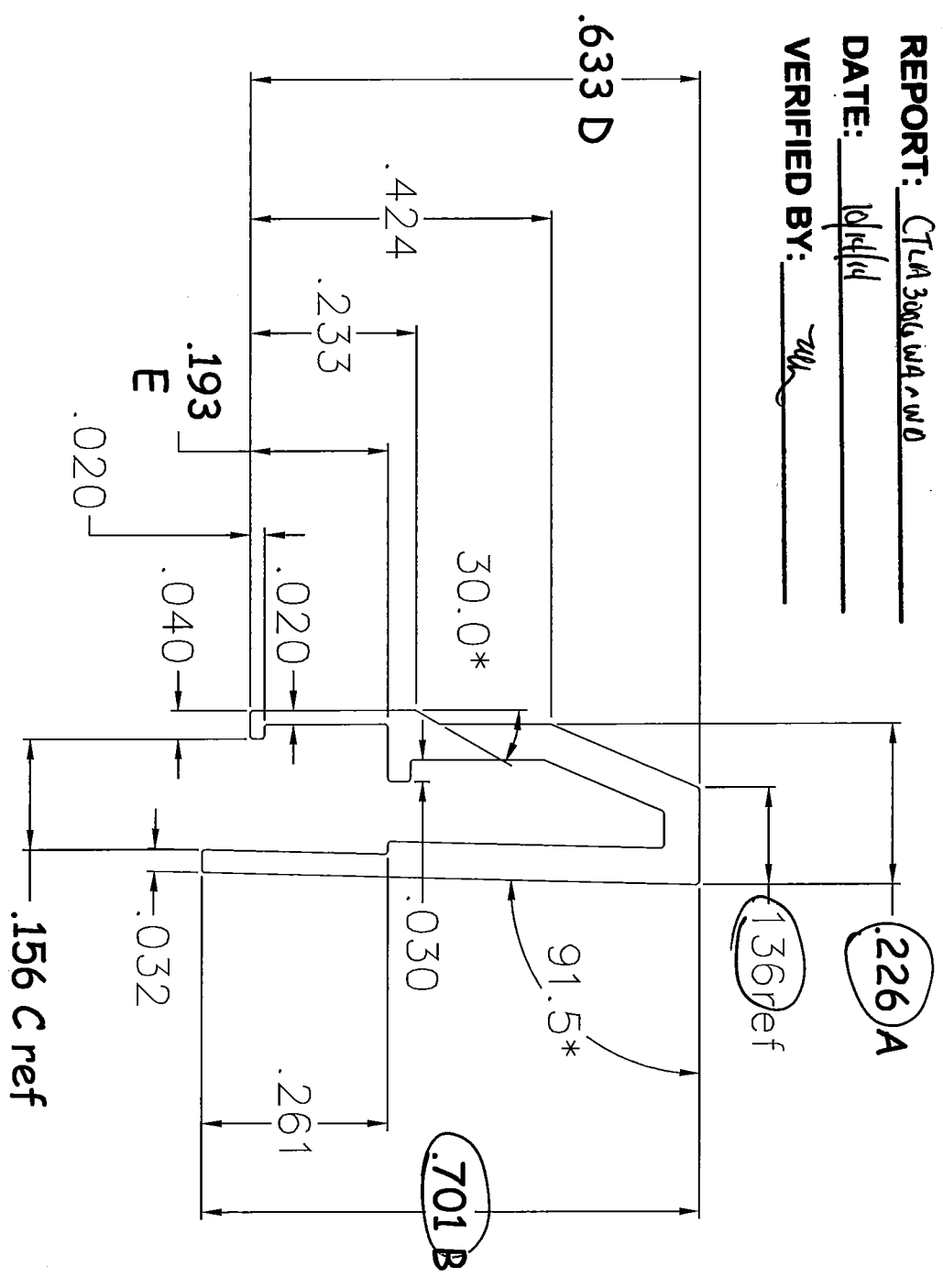
SCALE: 1:1 (ESSY/71) L106 SHEET: 1 OF 1

REV: F

DIE NO.	MATERIAL	WALL THICKNESS	UNSPECIFIED RADII	AREA	WT. / FT.
8052	RIGID VINYL	.050	.005	.062 sq.in.	.039 lbs.

CERTIFIED TESTING LABORATORIES

REPORT: CTLA 300G WA ^ W0
 DATE: 10/14/14
 VERIFIED BY: WU



INSPECTION METHODS	
1	Snap fit to # 8013
2	Cosmetics


ACCEPTABLE LIMITS		
DIM	LOW TOL.	HIGH TOL
A:	.216	.236
B:	.690	.715
C:	.145	.160
D:	.623	.648
E:	.185	.203

PART #: 8052

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ANNUAL USAGE	
1st YEAR	
2nd YEAR	

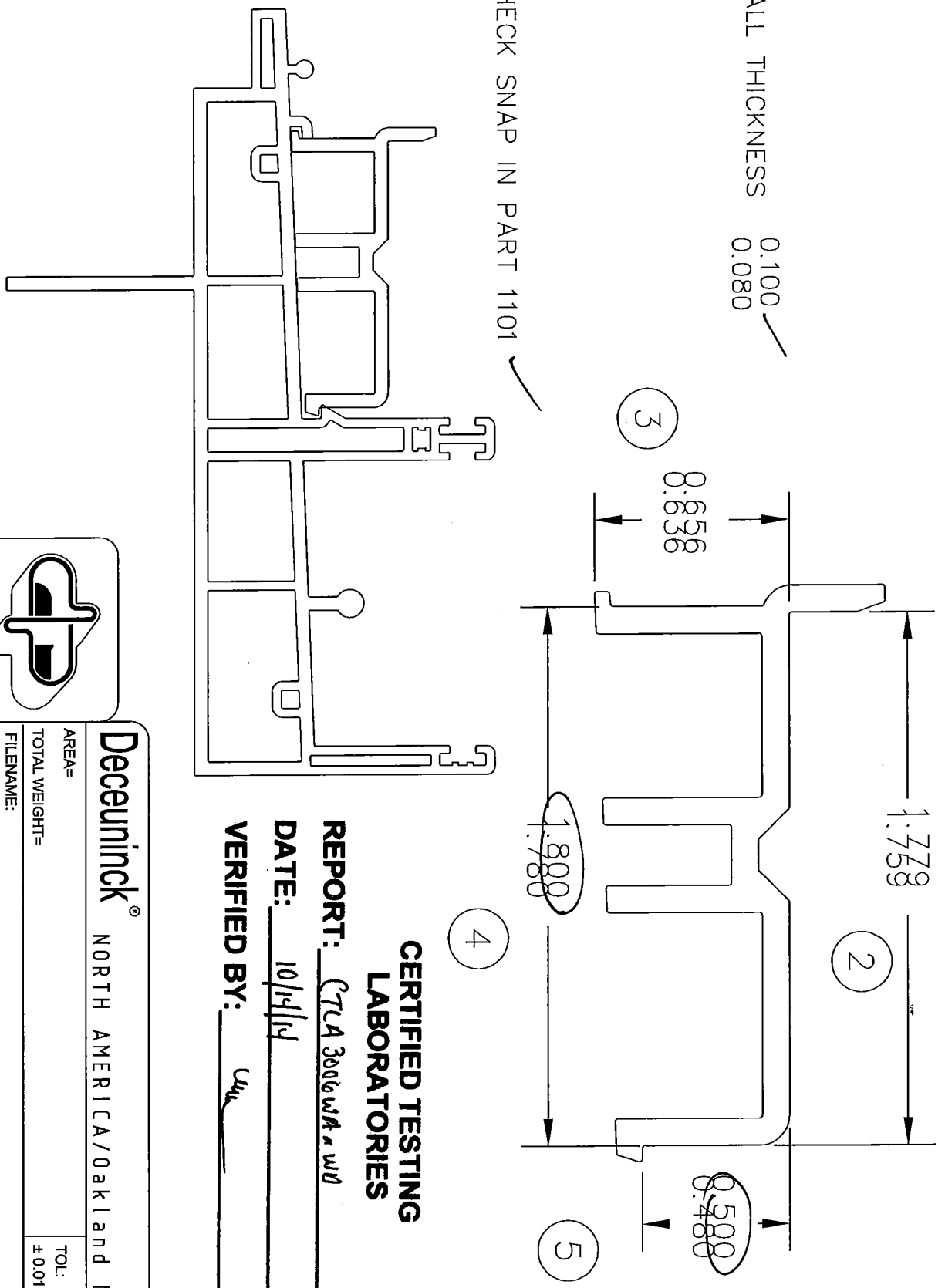
06/04/98	ADDED QC DIM'S	SMD
5/21/98	add dims. for angle TC	
5/14/98	Redrawn for #1013	T.C.
DATE	REVISION RECORD	DRAWN BY


AGROLINE
 AGRO EXTRUSION CORP
 300 EAST 30th STREET
 WILMINGTON, DE 19809
 (800) 441-3859

TITLE:	Sill Extender	
PROJECT:	8000 Series Double Hung	
DATE:	5/4/98	SCALE: 4 : 1
DRAWN BY:	T. Coleman	DWG NO: 20008052
CHECKED BY:		

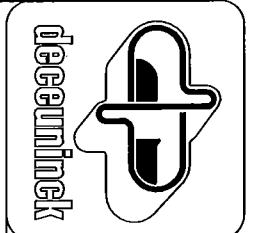
DO NOT SCALE

- ① WALL THICKNESS 0.100 / 0.080
- ②
- ③ 8.636
- ④
- ⑤
- ⑥ CHECK SNAP IN PART 1101



**CERTIFIED TESTING
LABORATORIES**

REPORT: CTCA 3006 WA & WU
 DATE: 10/14/14
 VERIFIED BY: Wu



Deceuninck®
 NORTH AMERICA/Oakland NJ.

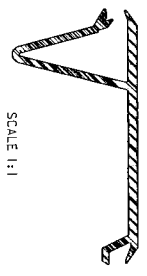
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 TOTAL WEIGHT=
 TOL: ±0.010

FILENAME:
 path

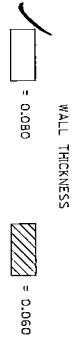
BY	DATE	MATL	SCALE
CTC	11/14/05	PVC	2:1

REV	BY	APPVD	DATE	CHANGE
-----	----	-------	------	--------

SILL INSERT 10001105_SH



SCALE 1:1

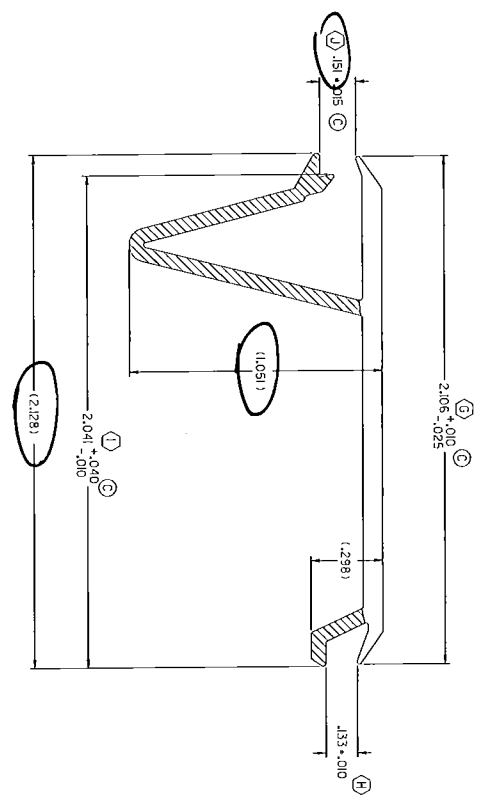


CAD MAINTAINED, CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY
CERTIFIED TESTING LABORATORIES

REPORT: CTUA 30061014 - W10

DATE: 10/14/14

VERIFIED BY: WJL



- NOTES:
1. STATOLOGY STRAIGHTNESS CLASS E AND LENGTH TOLERANCES APPLY (A)
 2. STEERING PLATE CLASS B PER SECTION (B)
 3. UNSPECIFIED EXTERNAL RADIUS = .XXX +.020 / -.005 (D)
 4. UNSPECIFIED INTERNAL RADIUS = .XXX +.020 / -.005 (D)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .20% (E)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .20% (E)

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UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES
 TOL ON ANGLES: .1°
 2 PL: ±.010 3 PL: ±.005
 INTERFERENCE FITS PER ASME Y14.9M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:	
DATE:	05/11/14
DRAWN BY:	CTC
DATE:	05/11/14
AUTH:	DATE:
DATE:	DATE:
DATE:	DATE:

deceunink 25 NORTH CUMBERLAND AVENUE, SUITE 2000, RICHMOND, VA 23260

NAME: **FRAME ADAPTOR**

SIZE/DWG. NO: 1000104-SH

SCALE: 2:1 (LBS/FT) 1/8" SHEET: 1

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
B	QD7 -3	07/12/04	DBF
C	TOLERANCE CHANGE, WAS +/- .010	08/08/06	JGM

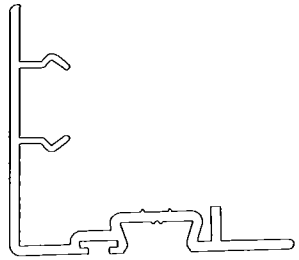
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.
CERTIFIED TESTING LABORATORIES

REPORT: CT1A 3006 WA.WD

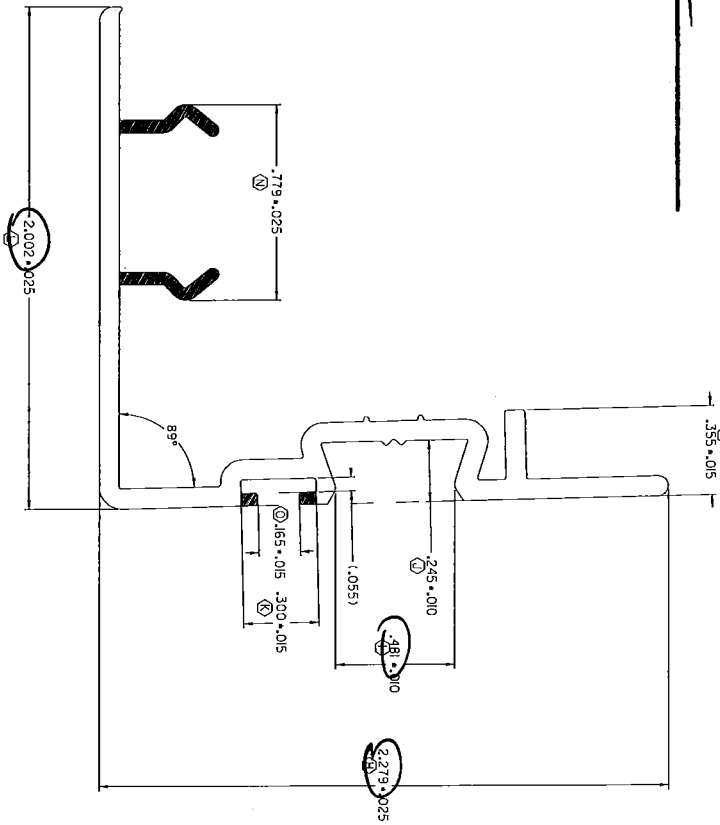
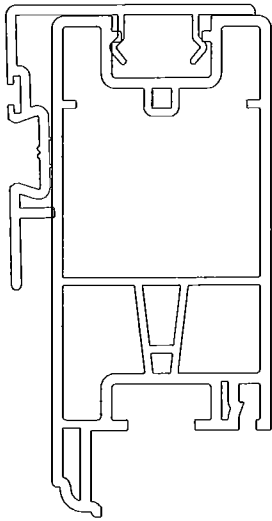
DATE: 10/14/14

VERIFIED BY: WU

SCALE 1:1



CHECK SNAP CONDITION WITH PART 1000002



WALL THICKNESS
 .080 -
 .050 -

- NOTES:
1. ST00003 STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER ST00003
 3. UNSPECIFIED EXTERNAL RADIUS = .XXX +.010 / -.005
 4. UNSPECIFIED EXTERNAL RADIUS = .XXX +.020 / -.005
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .020
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .020

CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES TOL ON ANGLES = °	
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DESIGN BY: PDM	DATE: 06/12/22	DRAWN BY: JDM	DATE: 07/01/02
AUTH: PDM	DATE:	AUTH: JDM	DATE:
FILE NAME: \$FILE NAME\$	SCALE: 2:1	LIBS: 713	290
NAME: deceuninck NORTH AMERICA		SIZE: DIM: NO: 1000017.SH	
SASH ADAPTER		SHEET: 1 OF 1	

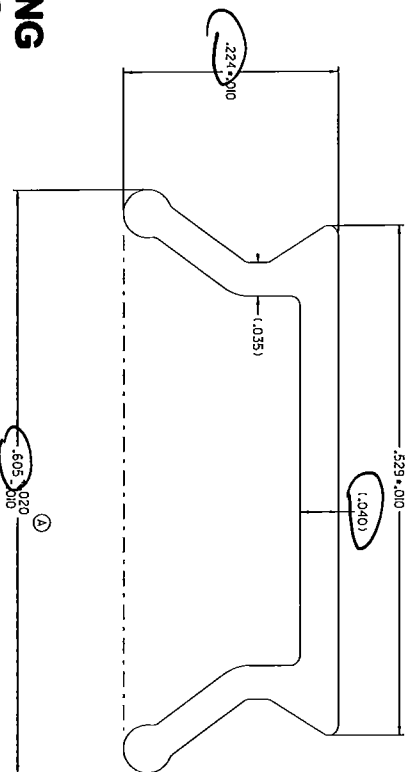
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
D	UPDATE TO CURRENT STANDS	09/06/24	BMB

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY		
REV	DESCRIPTION	DATE
A	CHANGED TOLERANCE	07/01/04



SCALE 1:1



CERTIFIED TESTING LABORATORIES

REPORT: CTCA 3606 UN A WJ

DATE: 10/14/14

VERIFIED BY: [Signature]

- NOTES:
1. STIDDOD3: STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STIDDOD3
 3. UNSPECIFIED EXTERNAL RADI = .XXX +.010 / -.005
 4. UNSPECIFIED EXTERNAL RADI = .XXX +.020 / -.005
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .02
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .02

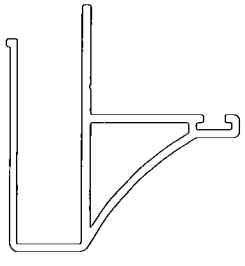
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UNPUBLISHED WORK © 2007 DECEUNINCK NORTH AMERICA		2 PL. ± .000° 3 PL. ± .0005° INTERSECT DIM AND PER ASME Y14.5M - 1994	
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DESIGN BY: PGM		DATE: 06/12/22	
DRAWN BY: JGM		DATE: 07/01/02	
ADJ: [Blank]		DATE: [Blank]	
ADJ: [Blank]		DATE: [Blank]	
FILENAME: 1000118_SH.dgn		SCALE: 8:1 (LBS/FT)	
SIZE: DWG: NO: 1000118.SH		SHEET: 1 OF 1	
NAME: deceuninck 36 NORTH AVENUE, SUITE 200, NEW YORK, NY 10018		DOOR ACCESSORY - SCREW COVER	

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY		
REV	DESCRIPTION	DATE

KEY PRODUCT CHARACTERISTICS

L	DIMENSION 1.995 - 1.9315
M	DIMENSION 1.752 - 1.792



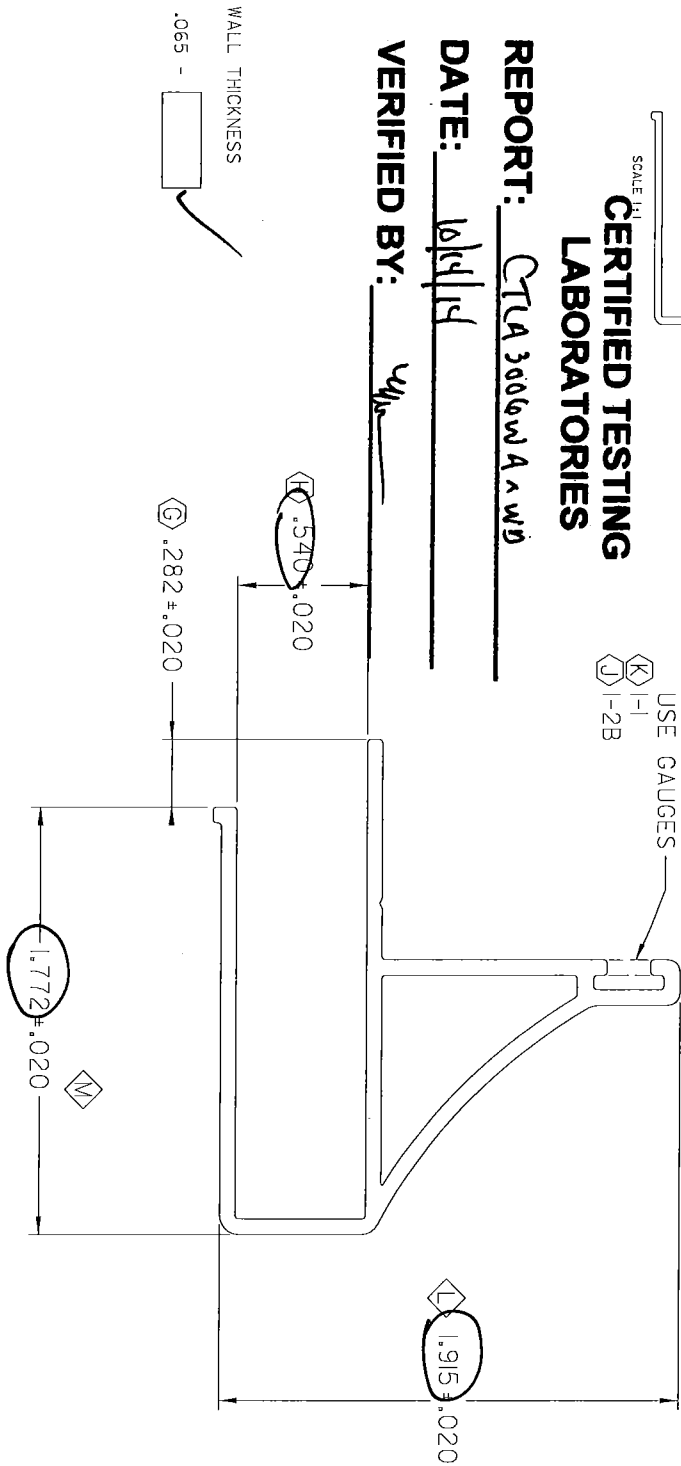
SCALE: 1/1
CERTIFIED TESTING LABORATORIES

REPORT: CTA 3006w A & wD

DATE: 10/11/14

VERIFIED BY: WJ

USE GAUGES
K | 1-1
D | 1-2B



NOTES:

1. 'STDD0013' STRAIGHTNESS CLASS C AND LENGTH TOLERANCES APPLY (A)
2. INTERPRET ALL TOLERANCE APPLICATIONS PER STDD0013 (B)
3. UNSPECIFIED EXTERNAL RADI = .XXX +.010 / -.005 (C)
4. UNSPECIFIED INTERNAL RADI = .XXX +.020 / -.005 (D)
5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .02% (E)
6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .20% (F)

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UNLESS OTHERWISE SPECIFIED
TOL. DIM. AND ANGLES IN DEGREES
2 PL. ± 0.010° 3 PL. ± 0.005°
INTERPRET DIM AND TOL. PER
ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:	FBL
DATE:	05/09/14
DRAWN BY:	FBL
DATE:	05/09/14
AUTH:	
DATE:	
AUTH:	
DATE:	
AUTH:	
DATE:	
FILENAME:	157028

deceunick 25 NORTH AMERICAN
NORTH AMERICA

NAME: 10001183

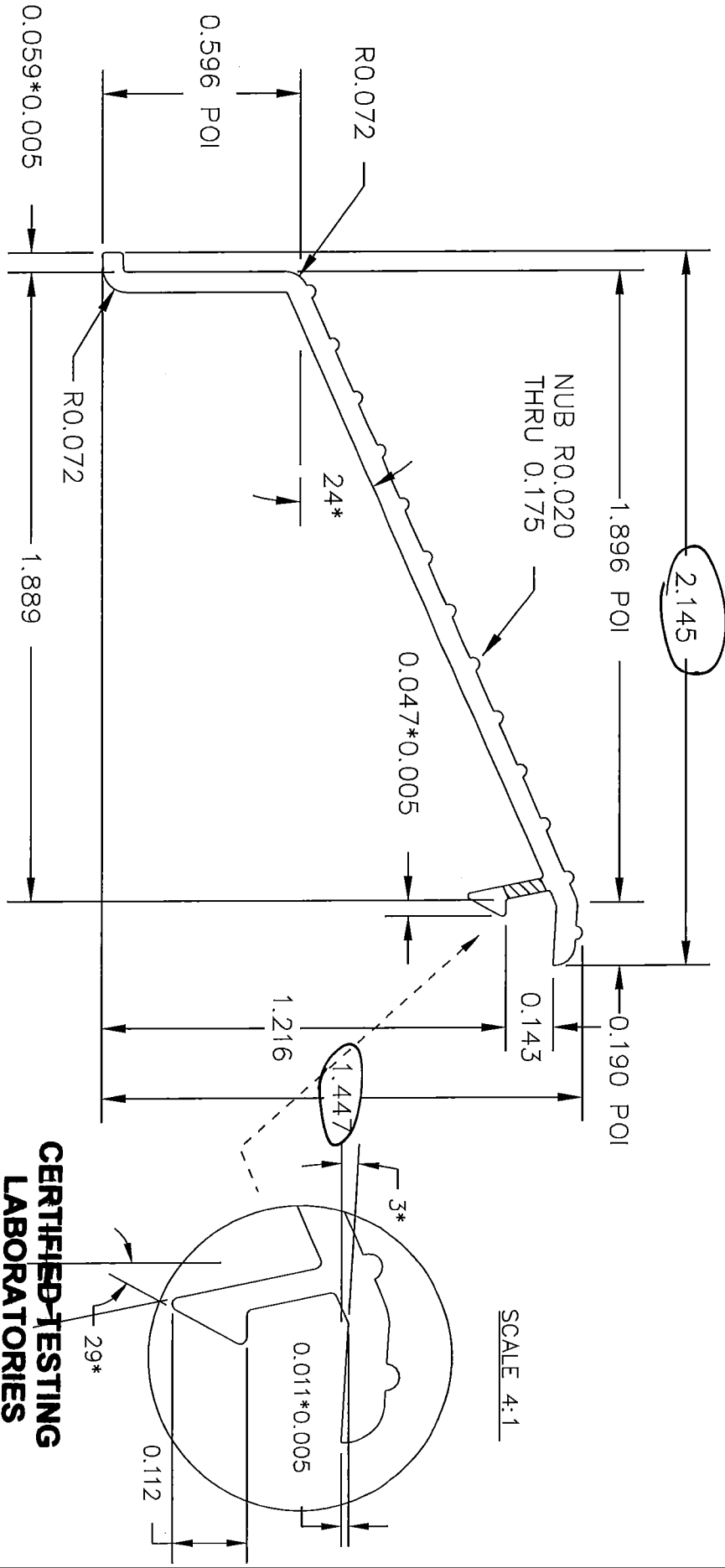
SET PWB, NOS 1000183.SH

SCALE: 2:1 (LBS/FT) 0.296 SHEET: 1 OF 1

REV: NEW

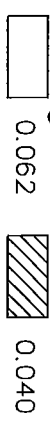
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A 011H006



EXPOSED SURFACE
ACTUAL SIZE

- NOTES:
1. ALL UNSPECIFIED RADII ARE 0.010.
 2. WALL THICKNESS.
 3. PAINT WITH ALCOA, PPG COLOR UC73603, POLYCRON WHITE.



0.062
0.040

CERTIFIED-TESTING LABORATORIES

REPORT: CTA 3006WA & WD
 DATE: 10/14/14
 VERIFIED BY: [Signature]

Vinyltime®
VINYL BUILDING PRODUCTS INC.
 AREA = 0.195
 WEIGHT = 0.229 lb/ft
 TOLERANCES (EXCEPT AS NOTED)
 ? .010 [0.25]

A	MB	2/13/03	ADDED NOTE 3.
REV	BY	APPVD	DATE
			CHANGE
DRAWN	MG	DATE	APPVD
		12/26/00	
SILL COVER. SLIDER		MATL	SCALE
		6061-16 6105-T5	2/1
A			10300171

Sikaflex®-552

High-Strength Structural Assembly Adhesive

Technical Product Data (typical values)

One-part Silane Terminated Polymer	Color	White, Black
	Cure mechanism	Moisture-curing
	Density (uncured)	12.1 lb/gal
	VOC (EPA method 24)	0.16 lb/gal
	Non-sag properties	Good
	Application temperature	40-95°F (5-35°C)
	Tack free time	40 min.
	Curing speed	(see diagram 1)
	Shrinkage	<2%
	Shore A-hardness (ASTM D 2240)	50
	Tensile strength (ASTM D 412)	435 psi
	Tensile shear strength (ASTM D 1002)	300 psi
	Elongation at break (ASTM D 412)	300 %
	Tear propagation resistance (ASTM D 624)	85 pli
	Glass transition temperature	-76°F (-60°C)
	Service temperature	-40°F to +190°F (-40°C to +90°C)
	Short term	Permanent
		4 hours
		1 hour
Shelf life (storage below 80°F (25°C))	Cartridge & Unipac	9 months
	Drum & Hobbock	6 months

73°F (23°C) / 50% r.h.

Description

Sikaflex®-552 is a low VOC, high performance, elastic, gap-filling, one-part, silane-terminated polymer structural adhesive that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-552 contains no isocyanate or solvent. Sikaflex®-552 is manufactured in accordance with the ISO 9001/ISO 14001 quality assurance system and the responsible care program.

Product Benefits

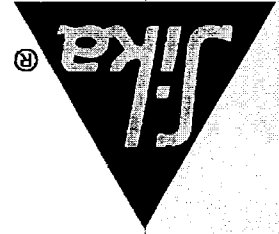
- AAMA 805.2-94 certified
- Bonds well to a wide variety of substrates without the need for special pre-treatment
- Resistant to UV radiation
- Resistant to aging and weathering
- Capable of withstanding high dynamic stresses
- Very low VOC content
- Silicone and PVC-free
- Isocyanate-free
- High recovery
- Elastic
- Low odor
- One-part formulation

Areas of Application

Sikaflex®-552 is suitable for structural joints that will be subjected to dynamic stresses. Sikaflex®-552 bonds well to a wide variety of substrates and is suitable for making permanent high strength elastic adhesive seals. Suitable substrate materials include wood, metals, metal primers and paint coatings (two-part systems), ceramic materials, plastics and glass. Seek manufacturer's advice before using on transparent materials that are prone to stress cracking.

CERTIFIED TESTING LABORATORIES

REPORT: CLA 3006WA-WD
DATE: 10/11/14
VERIFIED BY: [Signature]



Performance Norm	
Thermal Conductance (Klin)	0.32 W/m ² C based on 1/2" (13mm) spacer
Moisture Vapor Transmission Rate	0.09 g H ₂ O/m ² per 24 hrs.
Volatiles Fogging	ASTM E 2189 CGSB 12.8 Passes
Argon Permeance	6-8 c.c./100 in. ² per 24 hrs. ASTM D 1434
Bondline Adhesive UV Resistance	Excellent
Dew Point Development	-20° F (-29° C) in 48 hrs. ASTM E 546
Tensile Strength	50 psi TST 389C

Note: The foregoing information is published as general information only. The listed properties and performance characteristics are approximate value and are not part of the product specification.

Availability/Cost
Availability and cost can be obtained from your local Quanex Representative or by contacting Quanex.

Technical Services
Your Quanex Building Products Representative, in conjunction with your Quanex Building Products Technical Service Group, can provide in-plant training and assistance with special applications.

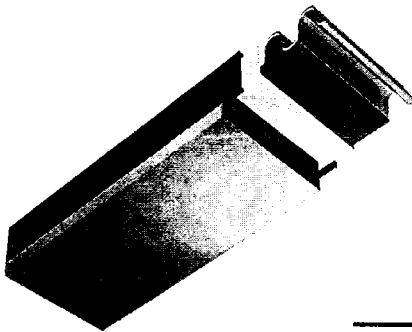
Shelf Life
One year in unopened containers at storage conditions below 77° F (25° C). Surface imprinted with manufacture date.

Packaging
Returnable/recyclable spools available in disposable packaging.

Sizes
Airsapces of 1/4" (6mm) to 13/16" (21 mm). In increments of .021" (0.53 cm).

Colors
Duraseal is available in gray and black.

Basic Use
For use in high-volume production of dual and triple pane insulating glass units in a one-step process where units are sealed using heat and compression. Designed as a single seal system, Duraseal can also be used with a secondary sealant to create a dual seal unit.



Duraseal is an insulating glass edge seal system constructed using a unique Composite Laminating Technology. Duraseal is preassembled with proven components, sealant, spacer and desiccant to create a high performance durable single seal spacer system.

CERTIFIED TESTING LABORATORIES
REPORT: CTA 3006 W4 W2
DATE: 10/14/14
VERIFIED BY: [Signature]

Duraseal®

Quanex
building products

Insulating Glass Systems



building products
Insulating Glass Systems

Duraseal®

Glazing Compatibility and Design Recommendations

In general, materials such as hot-applied sealants, silicones, glazing tapes and solvent acrylics are compatible. Refer to Technical Bulletin SG003 at www.Quanex.com for a list of approved glazing materials or inquire about compatibility testing. Fabricated units shall be glazed in accordance with GANA (Glass Association of North America) and IGMA (Insulating Glass Manufacturers Alliance) recommendations. Please check with your Quanex Representative for specific glazing recommendations.

Storage Conditions

Store in original airtight container. Expose to air only during application. Procedures for opening and resealing Duraseal containers should be followed as outlined in Technical Bulletin IG019 available at www.Quanex.com.

Health & Safety

For all Quanex products, and for other product used in conjunction with Quanex products, users must follow individual product labels and Material Safety Data Sheets for warnings and precautions prior to opening containers and during use and storage.

Environmental Conditions

Non-hazardous under normal use for handling and waste disposal.

Warranty

See Quanex warranty certificate.

Duraseal® is a registered trademark of Quanex Building Products.

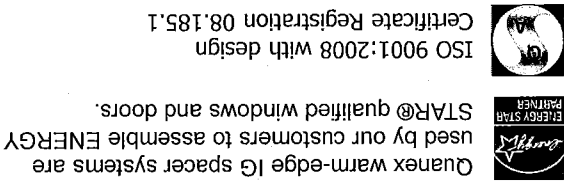
Quanex recommends you visit www.Quanex.com and register to ensure you have the most current updates to this data and all other Quanex sales and technical materials.

CERTIFIED TESTING LABORATORIES

REPORT: CTM3006W4 v W2

DATE: 10/11/14

VERIFIED BY: LM



Quanex warm-edge IG spacer systems are used by our customers to assemble ENERGY STAR® qualified windows and doors. ISO 9001:2008 with design Certificate Registration 08.185.1

- ### Certification Standards
- EN 1279:2002 Part 2, 3, 4, Part 6 B & C
 - CGSB 12.8
 - ASTM E 2190 (HIGS)
 - GOST 24866-99

- ### Key Features Summary
- Composite Laminating Technology
 - A unique patented design
 - Smooth surface appearance
 - Black or gray sightline available
 - Proven adhesive technology
 - Superior argon gas retention
 - Minimal compression required
 - Optimized packaging
 - Low conductivity warm-edge spacer
 - Improved condensation resistance
 - Warmer edge of glass temperature

Quanex IG Systems
800 Cochran Avenue
Cambridge, OH 43759
T 800-233-4383
F 740-439-0121
www.quanex.com

CERTIFIED TESTING LABORATORIES

REPORT: CTA 3006 WA & WD

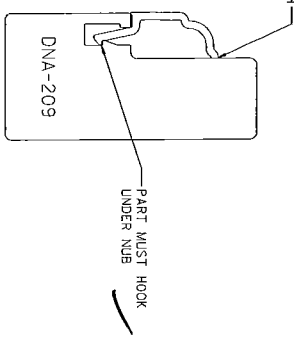
DATE: 10/14/14

VERIFIED BY: WJ

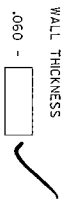
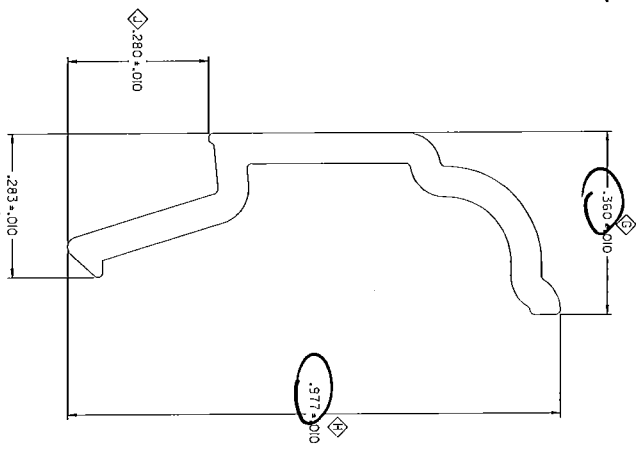
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
D	ADDED GAUGE	09/10/15	3WB
KEY PRODUCT CHARACTERISTICS			
4	GAUGE DWA-209		
1	GAUGE DWA-209		
1	GAUGE DWA-209		

SCALE 1:1



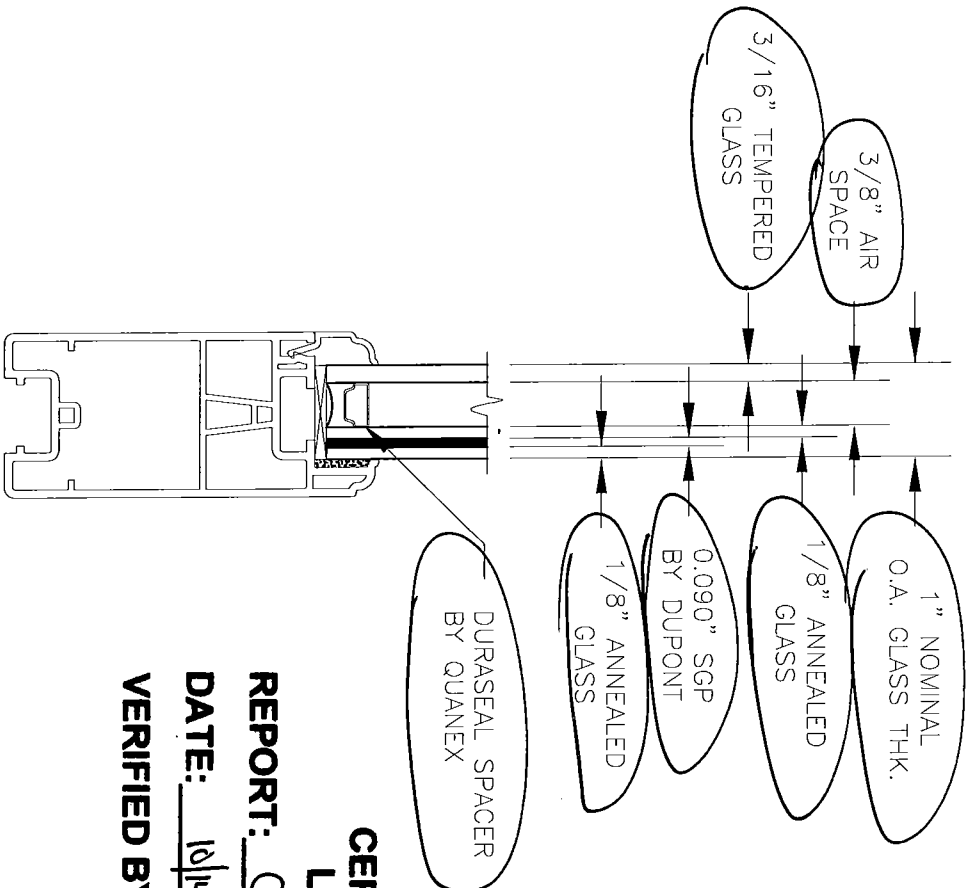
SLIDE PART INTO GAUGE FROM THE END. PART WILL NOT SNAP INTO GAUGE



USE MYLAR 1000III.OP REV C

- NOTES:
1. STD0003 STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD0013 (B)
 3. UNSPECIFIED EXTERNAL RADIUS = .xxx +.020 / -.005 (D)
 4. UNSPECIFIED INTERNAL RADIUS = .xxx +/- .020 (E)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx +/- .200 (E)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx +/- .200 (E)

CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
UNPUBLISHED WORK © 2007 DECEUNINCK NORTH AMERICA		2 PLACES DECIMALS 3 PLACES DECIMALS PER ASME Y14.5M - 1994	
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DESIGN BY: MG		DATE: 00/12/01	
DRAWN BY: MG		DATE: 00/12/01	
AUTH: MG		DATE: 00/12/01	
FILE NAME: 1000III.SH.dgn		DATE: 00/12/01	
SCALE: 4:1		SHEET: 049	
 NORTH AMERICA		NAME: GLAZING BEAD	
30 NORTH WILSON ROAD MONROE, LA 70501		REV: C	



CERTIFIED TESTING LABORATORIES

REPORT: CTA 3006 WA & WD
 DATE: 10/14/14
 VERIFIED BY: WJ

GLAZING DETAIL
 BOTTOM RAIL SHOWN
 TOP RAIL AND STILES SIMILAR

REVISIONS			
BY	DATE	DESCRIPTION	REV

Eastern
 ARCHITECTURAL SYSTEMS
 A DIVISION OF
 EASTERN METAL SUPPLY
 10030 BAVARIA ROAD
 FORT MYERS, FLORIDA 33913
 800-432-2204

TITLE: **SERIES 623 HD SLIDING GLASS DOOR**
 TESTING DETAIL
 GLAZING DETAIL

DATE: 2/7/14 DRAWN BY: TJH
 DRAWING NO: PA-0007 SCALE: N.T.S.
 SHEET: 1 OF 1 REV: -

PREPARED BY: _____

CERTIFIED TESTING LABORATORIES

REPORT: *CTLA 3006 W4 * W4*

DATE: *10/1/14*

SILICONE VERIFIED BY: *[Signature]*

Dense Rubber Extrusions

Product Description

Tremco Silicone Dense Rubber Extrusions are fabricated into gaskets and accessories (such as setting blocks, spacers and shims) for use in sealing and glazing applications in building construction. Custom color matching is available.

Metal Requirements

Tremco Silicone Dense Rubber Extrusions are manufactured to meet existing metal designs or developed with custom metal systems at the design development stage. Many profiles are available depending upon existing metal requirements.

Packaging

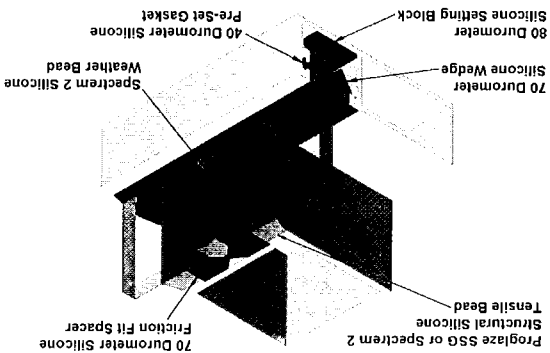
Tremco Silicone Dense Rubber Extrusions are packaged based on customer requirements, profile size, configuration and the need for molded picture frame gaskets.

Availability/Cost

Tremco Silicone Dense Rubber Extrusions are generally custom manufactured but many standard designs are available. Their availability and cost may be obtained from your local Tremco Sales Representative, or by contacting Tremco's Customer Service Department in Ashland, Ohio, at 800-321-6357 or in Canada at 800-363-3213.

Tremco warrants its Products to be free of defects in material. But makes no warranty as to appearance or color. Since method of application and on-site conditions are beyond our control and can affect performance, Tremco makes no other warranty, expressed or implied, including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE, with respect to Tremco Products. Tremco's sole obligation shall be at, its option, to replace, or to refund the purchase price of the quantity of Tremco Products proven to be defective and Tremco shall not be liable for any loss or damage.

Please refer to our website at www.tremcosealants.com for the most up-to-date Product Data Sheets.

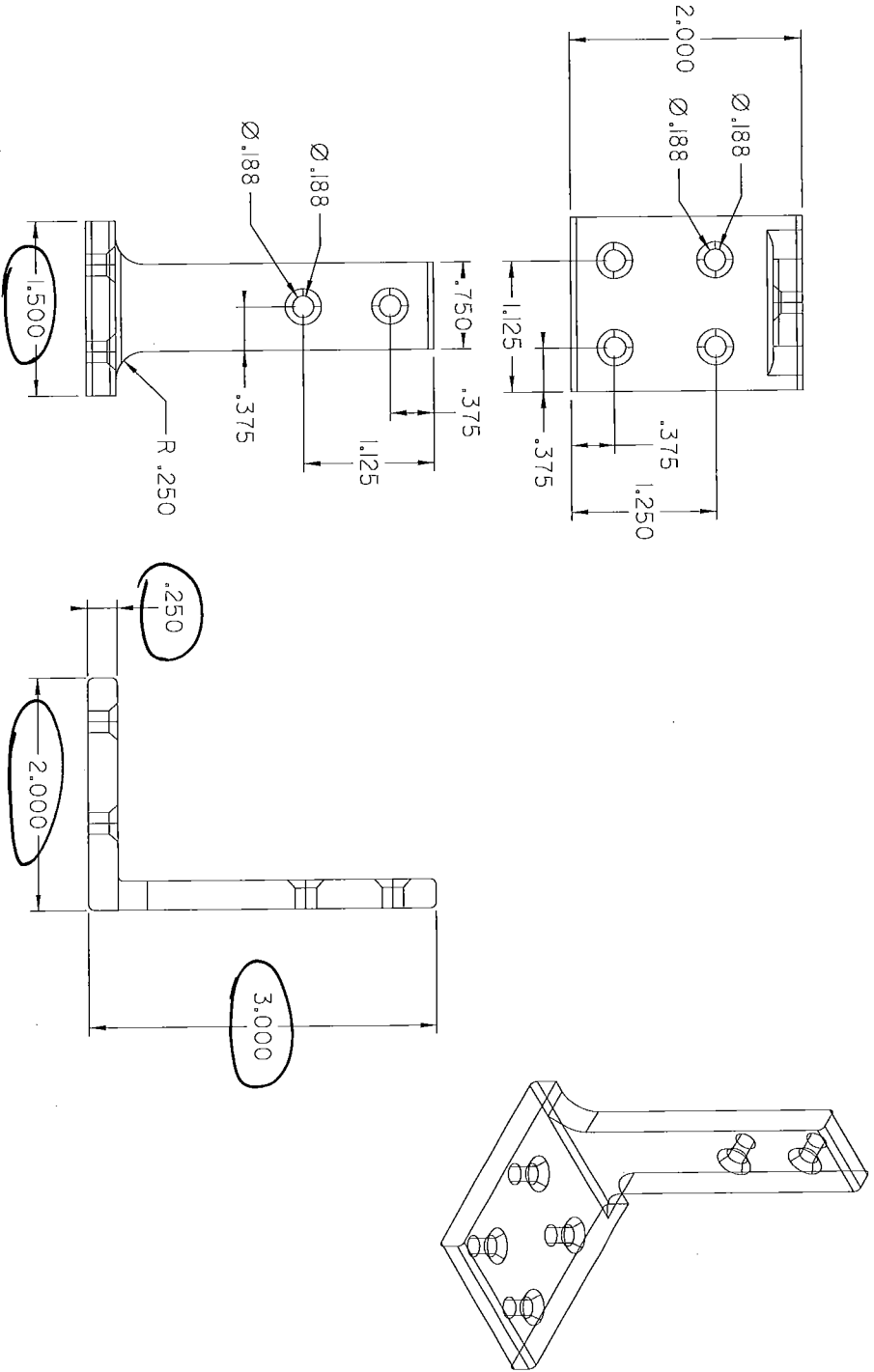


TYPICAL PHYSICAL PROPERTIES

PROPERTY	ASTM	40 Durometer	60 Durometer	70 Durometer	80 Durometer
Shore "A" Hardness	D 2240	43	65	70	80
Compression Set, 22 h @ 212°F (100°C)	D 395	13.8%	12.5%	11.0%	12.9%
Ozone Resistance, 100 mPa, 100 h @ 104°F (40°C) 20% Elongation	D 1149	No Cracks	No Cracks	No Cracks	No Cracks
Tensile Strength	D 412	1060 psi	1139 psi	1075 psi	1095 psi
Elongation @ Rupture	D 412	323%	235%	167%	113%
Tear Strength	D 624	120 lb/in	107 lb/in	121 lb/in	92 lb/in
Brittleness Temperature @ -40K (-40°C)	D 746	Pass	Pass	Pass	Pass



CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.



CERTIFIED TESTING LABORATORIES

REPORT: CT19 3006 WA RWJ

DATE: 10/11/14

VERIFIED BY: WJ

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UNLESS OTHERWISE SPECIFIED
 DIM. ARE IN INCHES
 TOL. ON ANGLES: ± 1°
 2 PLACES DEC. AND 1/16 INCH
 INTERN. ASME Y14.5M - 1994
 THIRD ANGLE PROJECTION

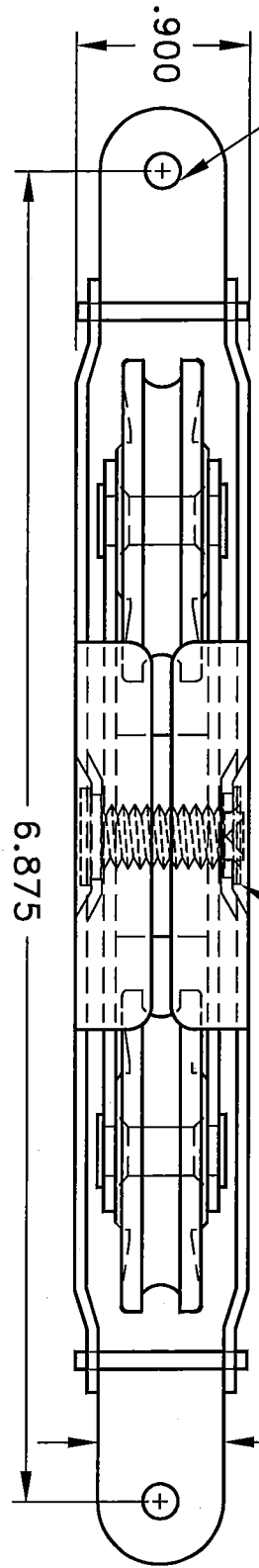
DESIGN BY:	JGM
DATE:	12/05/20
DRAWN BY:	JGM
DATE:	12/05/21
AUTH:	
DATE:	
FILENAME:	126071

deceuninck
 NORTH AMERICA
 28 NORTH GAVEN ROAD
 WILMINGTON, NC 28403
 NAME: HD L BRACKET
 SIZE: Dwg. No: 62362020 B&D
 SCALE: 1:1 (US/FT)
 SHEET: NEW

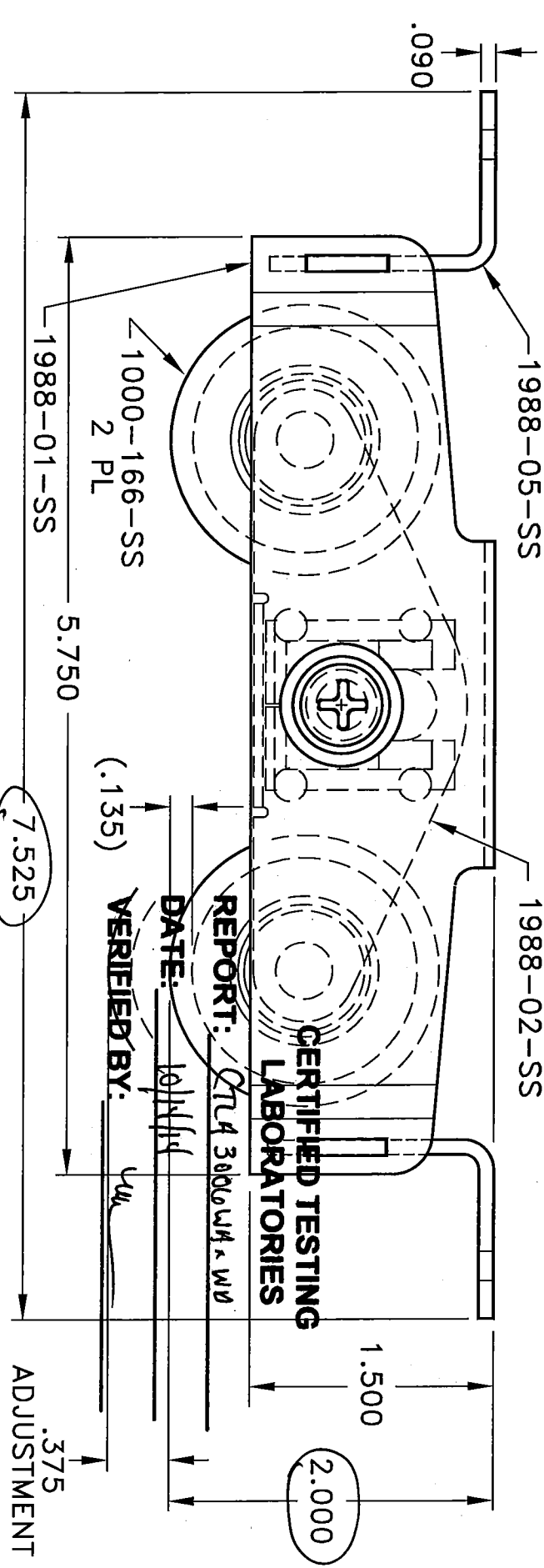
.181 DIA THRU
2 PL

1982-04-SS
1982-05-SS
1982-06-SS
1982-07-L-00
1982-07-R-00

REV	DESCRIPTION	DATE	BY
A	INTERNAL SLIDES ARE STAINLESS STEEL	NOV-13-06	
B	REVISED TAB SLOT LOCATION	APR-11-07	



THIS PRINT IS SUBMITTED FOR APPROVAL AND CORRECTIONS, YOUR PART CANNOT CONTINUE UNTIL AMESBURY DOOR HARDWARE RECEIVES ONE COPY APPROVED FOR PRODUCTION.
CO. NAME: _____
APPR'D BY: _____ DATE: _____
(PRINT NAME): _____



REPORT: CTL4 3000 W4 * W4
DATE: 10/11/07
VERIFIED BY: WJW

CERTIFIED TESTING
LABORATORIES

NOTES:
1. INNER AND OUTER HSG'S ARE STAINLESS STEEL. ROLLERS AND SCREW ARE STAINLESS STEEL. INTERNAL SLIDES ARE STAINLESS STEEL AND CELCON.

THIS DRAWING & SPECIFICATIONS ARE THE PROPERTY OF AMESBURY DOOR HARDWARE AND SHALL NOT BE REPRODUCED WITHOUT WRITTEN PERMISSION.

UNLESS OTHERWISE SPECIFIED
DECIMAL TOL. .XX ± .010
.XXX ± .005
ANGLE ± 1/2°



DOOR HARDWARE
AMESBURY GROUP

FILE NAME: 1988-8000-REV-SS	APPD	SCALE 1/1	DWG. NO. 1988-8000-REV-SS
DRAWN JMS NOV-28-05	CHKD	TITLE TA-88-BSS-166 W/ REVERSED MTC TAB	

Notes:

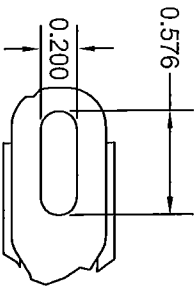
1. Critical dimensions are marked with ϕ , the number is used for reference.
2. All unspecified radii are 0.010 inches
3. All dimensions are in inches
4. Material = 304 Stainless Steel

CERTIFIED TESTING LABORATORIES

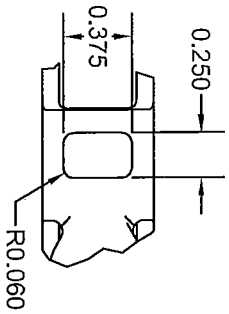
REPORT: CTA 3006WA-WD

DATE: 10/11/14

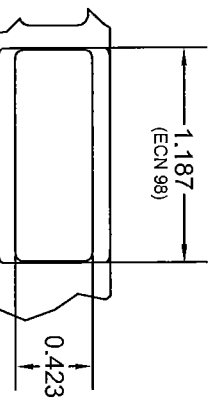
VERIFIED BY: WJ



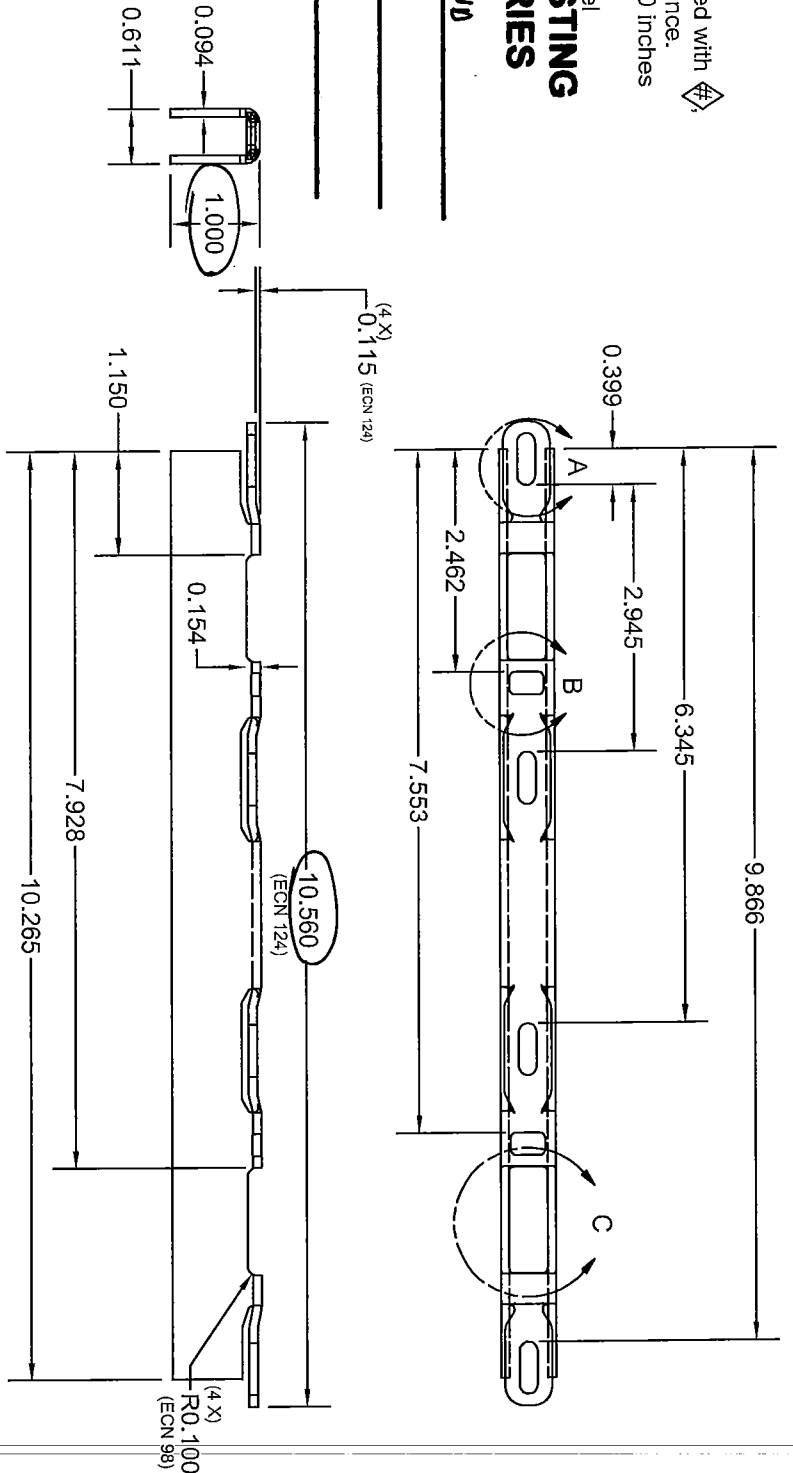
4X DETAIL A
SCALE 1:1




2X DETAIL B
SCALE 1:1

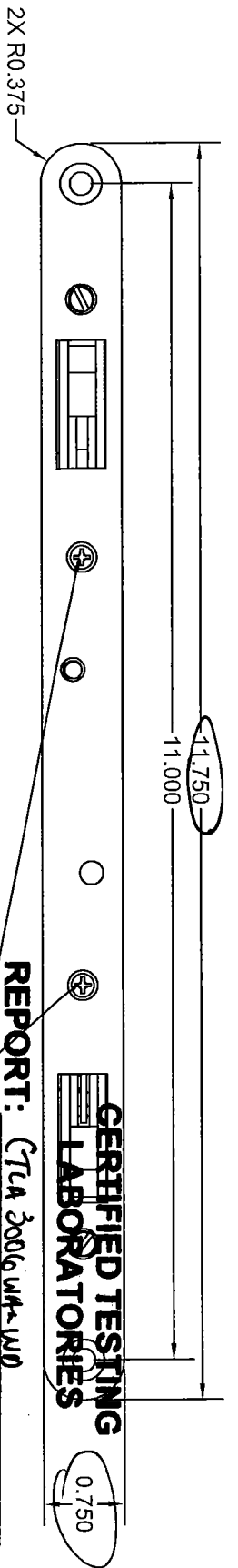


2X DETAIL C
SCALE 1:1



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Date	Revision	#	ECN #	By	Date:	Drawn:	Scale:	Tolerance	Drawing Title:
3/10/06	INITIAL ISSUE	A	90	TAE	1/30/2006	teggebraaen	1:2	Decimal: $\pm .015$ Angular: $\pm 1'$	 <p>DOOR HARDWARE AMESBURY GROUP 1111 West Algonquin Street - Sioux Falls, SD 57104 Phone# (605) 336-1011 FAX# (605) 336-9429</p>
3/22/06	Changed root slot length from 1.176" to 1.187"	B	98	TAE				KEEPER GEMINI 1" TALL	
5/8/06	Added hook slot radius dimension Adjusted screw flat depth from 0.347 to 0.375 and adjusted overall length from 10.875 to 10.560	C	124	TAE					

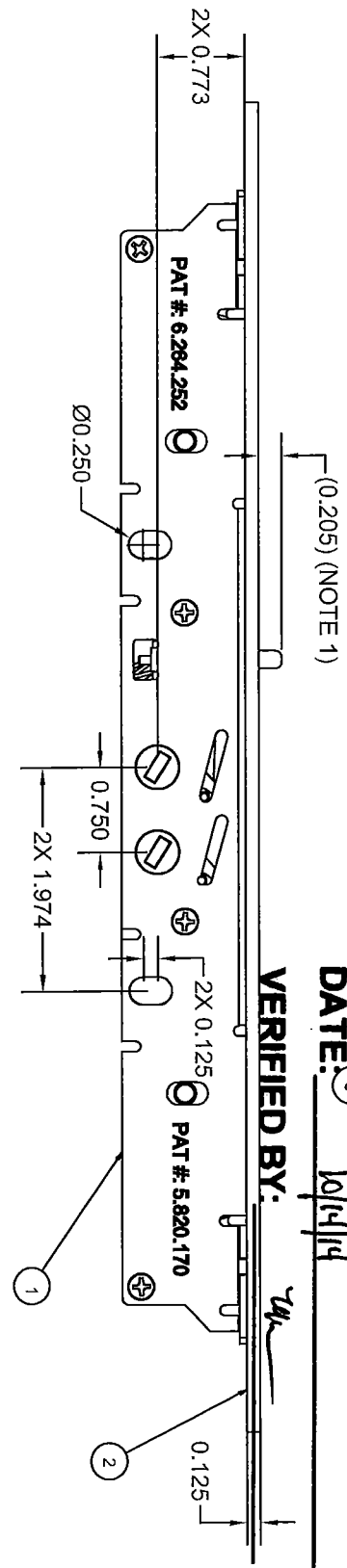


CERTIFIED TESTING LABORATORIES

REPORT: CTA 3006 W/ W0

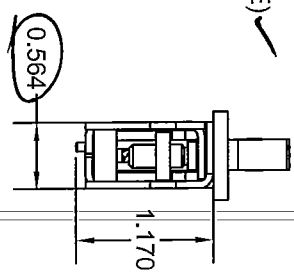
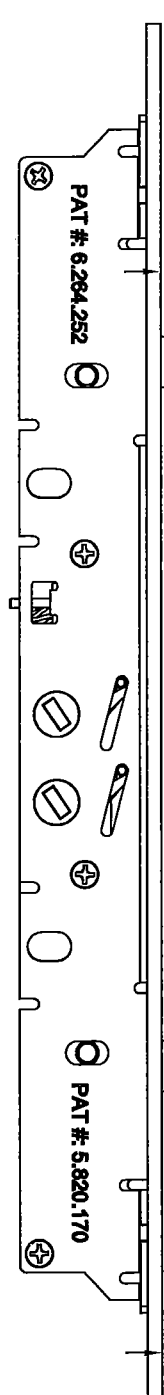
DATE: 10/11/14

VERIFIED BY: TW



2X 0.165±0.083 (ADJUSTABLE)

2X 0.516±0.083 (ADJUSTABLE)



Part Number Matrix			
ASSEMBLY #	LOCK # (ITEM 1)	TRIMPLATE # (ITEM 2)	SCREW # (ITEM 3)
2817-00	2777-00	2450-00	2539-00
2817-01	2777-00	2450-01	2539-01
2817-03	2777-00	2450-03	2539-03
2817-06	2777-00	2450-06	2539-06
2817-12	2777-00	2450-12	2539-12
2817-84	2777-84	2450-84	2539-84

NOTES:
 1. ANTI-SLAM PIN MINIMUM DEPRESS AMOUNT IS 0.060". MAXIMUM DEPRESS AMOUNT IS FLUSH WITH TRIMPLATE.
 2. TRIMPLATE SCREW (ITEM #3) TORQUE IS 10-14 IN-LBS.

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Date	Revision	#	ECN #	By
01/04/07	CREATED PRINT WITH PART NUMBER MATRIX.	A	0342	NG

Date: 1/4/2007
 Drawn: ngraff
 Scale: N/A
 Units: INCH
 Tolerance: Decimal: ± .010
 Angular: ± 1'

Part #: 2817
 Drawing Title: GEMINI II LOCK W/ 2450 TRIMPLATE
 Location: 2817 lock.dwg
 Sheet of Rev: A

DOOR HARDWARE
 AMESBURY GROUP
 1111 West Algonquin Street - Sioux Falls, SD 57104
 Phone# (605) 336-1011 FAX# (605) 336-9429

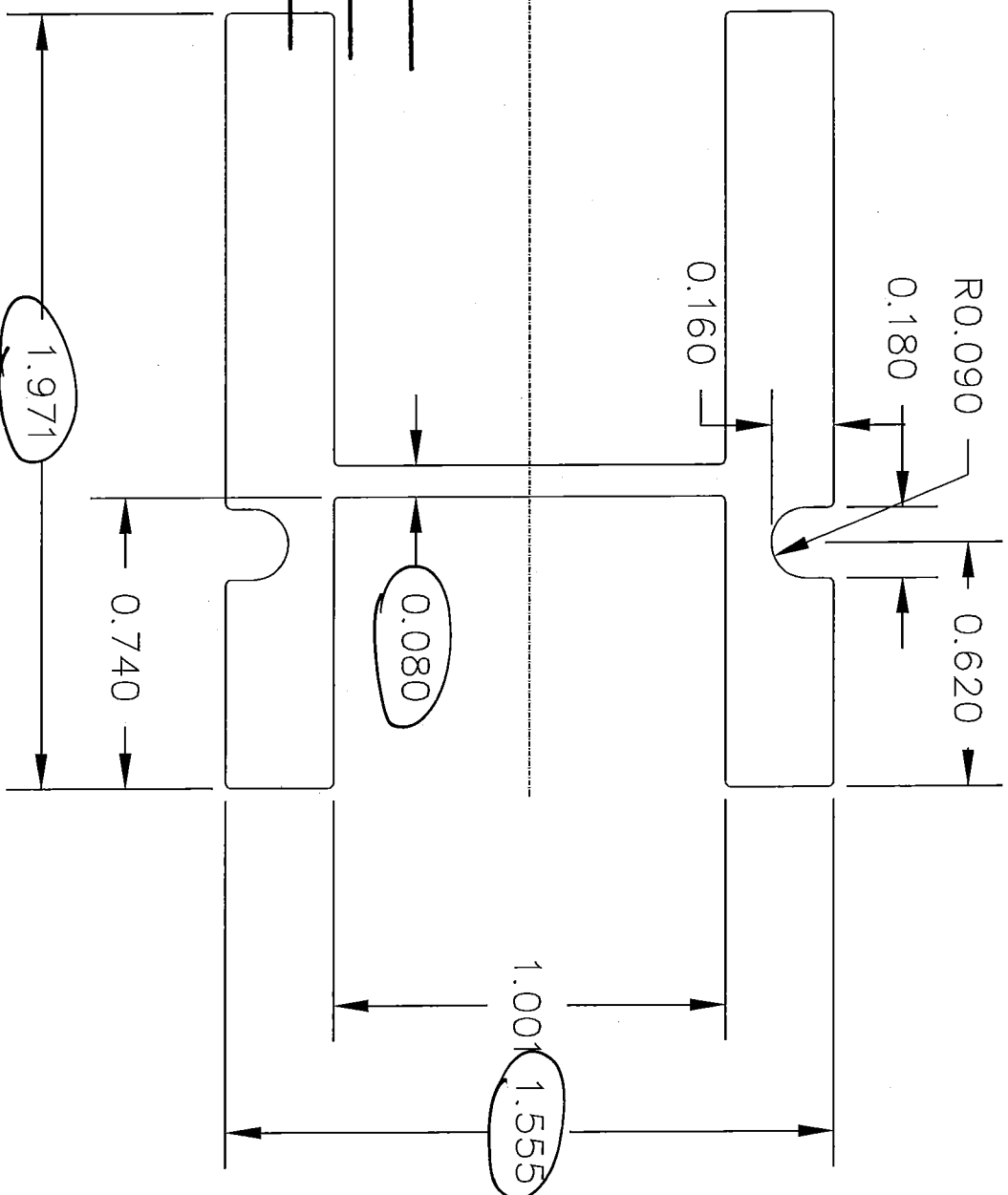
NO EXPOSED SURFACES

**CERTIFIED TESTING
LABORATORIES**

REPORT: CTA 3006WA RWJ

DATE: 10/14/14

VERIFIED BY: W



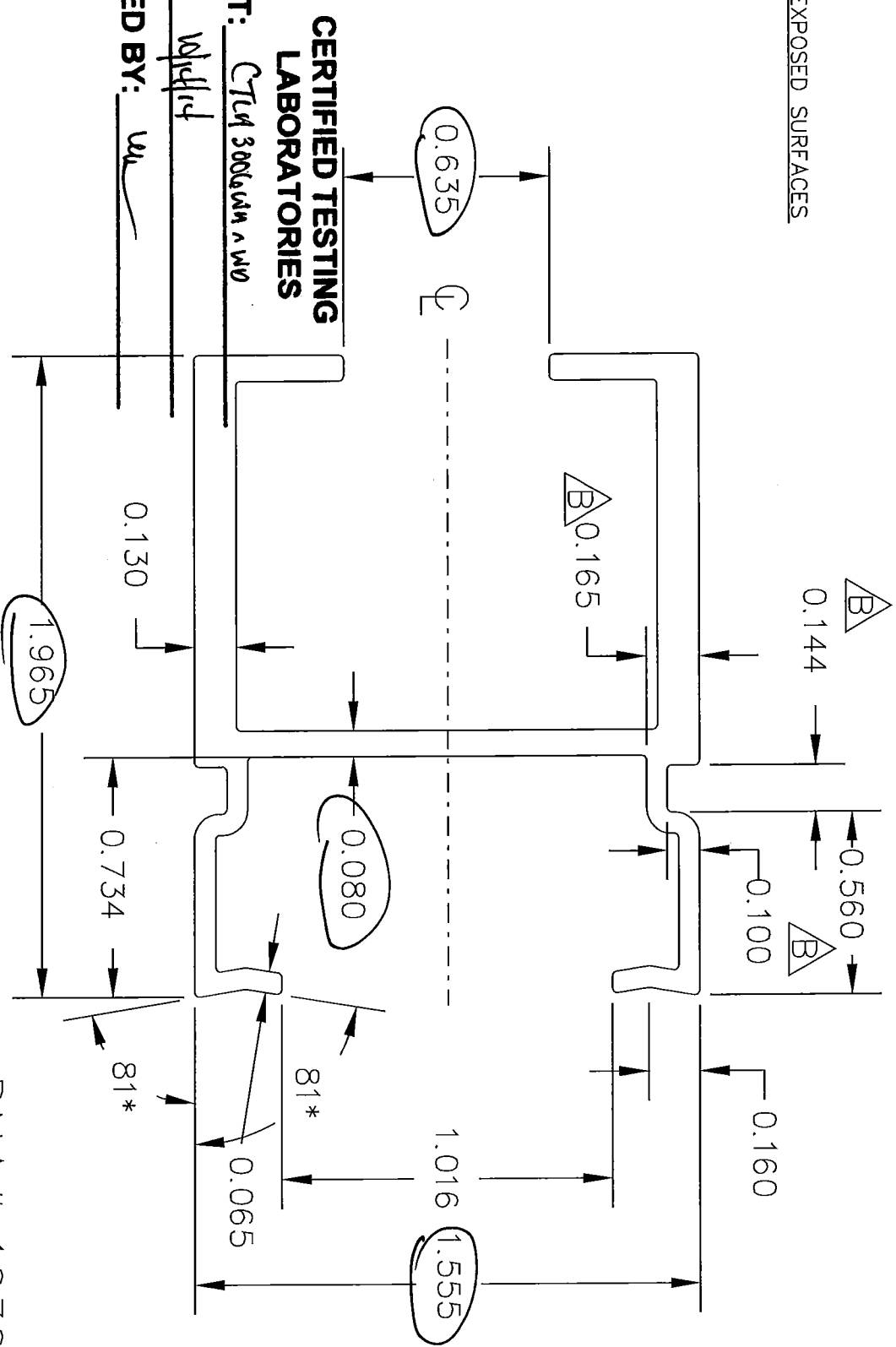
- NOTES:
1. ALL UNSPECIFIED RADII ARE 0.015.

Vinyltime®
VINYL BUILDING PRODUCTS INC.
 AREA = 1.121
 WEIGHT = 1.316 lb/ft
 TOLERANCES (EXCEPT AS NOTED)
 ? .010 [0.25]

DRAWN	DATE	APPV'D	MAT'L	SCALE
MG	02/05/03		6105-15 6061-T6	2/1
SASH REINFORCEMENT XHD				
REV	BY	APPV'D	DATE	CHANGE

REV	BY	APPV'D	DATE	CHANGE

NO EXPOSED SURFACES



CERTIFIED TESTING LABORATORIES

REPORT: CTM 30061A & W0
DATE: 10/11/04
VERIFIED BY: WJ

- NOTES:
 1. ALL UNSPECIFIED RADII ARE 0.015.
 2. MAKE FROM EITHER 6061-T6 or 6105-T6 ALUMINUM.
 3. ALCOA PART NUMBER 23441.

B	CC	10/28/04	Renamed drawing 011H035B Dimension change
A	AL	6/4/04	CHANGED MATERIAL SPECS TO MAKE FROM EITHER 6061-T6 or 6105-T6 ALUMINUM
REV	BY	APPVD	DATE
			CHANGE

Vinylina® VINYL BUILDING PRODUCTS INC.
 AREA = .612 sq in.
 TOTAL WEIGHT = .7175 lb/ft.
 TOLERANCE ±0.010

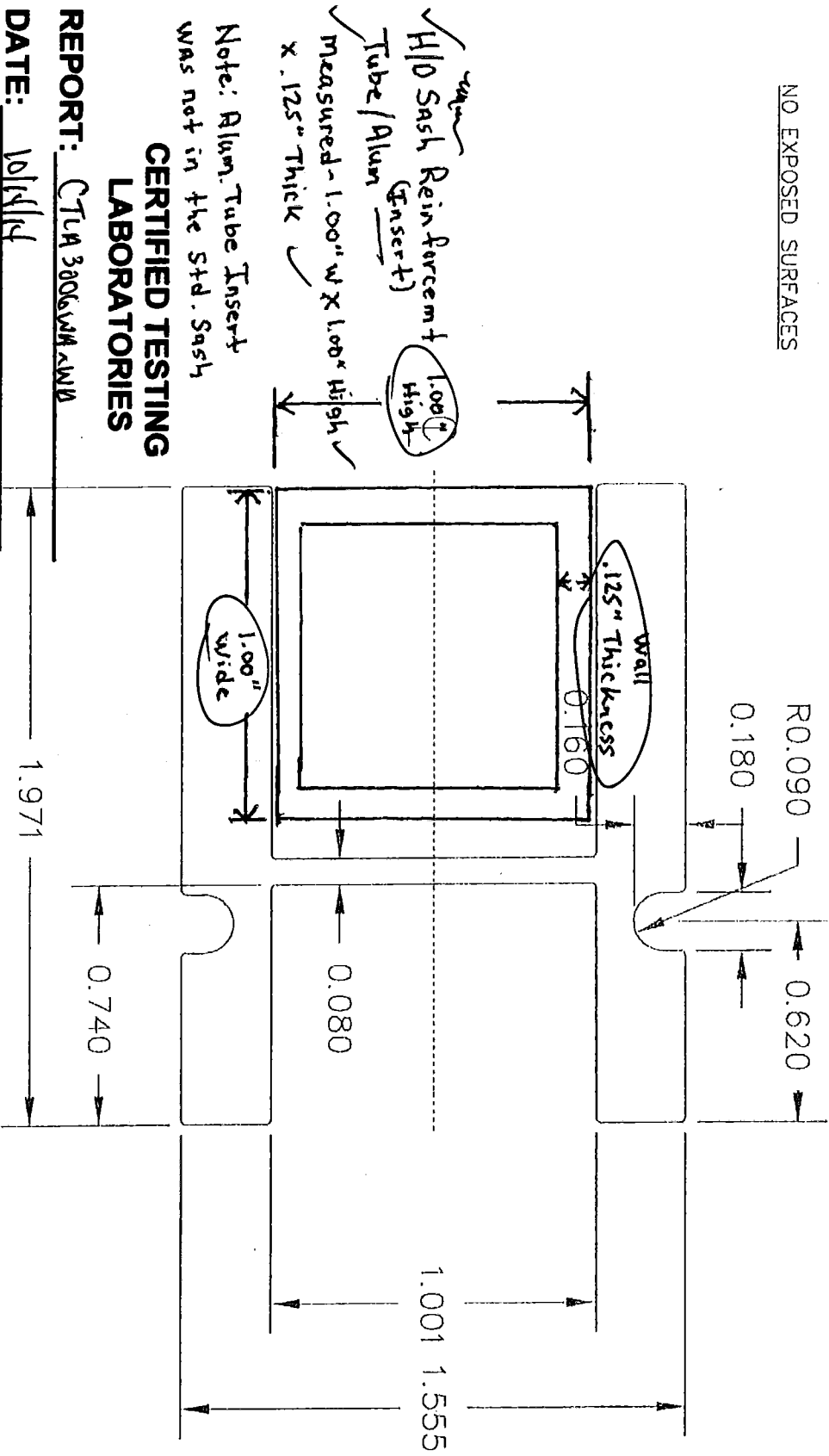
DRAWN	CTC	DATE	10/28/04	APPVD	MATL	Al 6105 T-6	SCALE	2:1
Sash Reinforcement				10300150				

DNA# 10300150

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A 011H049

NO EXPOSED SURFACES



CERTIFIED TESTING LABORATORIES

REPORT: CTM 3006 WA XHD

DATE: 10/11/14

VERIFIED BY: WV

NOTES:

1. ALL UNSPECIFIED RADII ARE 0.015.



VINYL BUILDING PRODUCTS INC.

AREA = 1.121
WEIGHT = 1.316 lb/ft
TOLERANCES (EXCEPT AS NOTED)
?.010 [0.25]

DRAWN	DATE	APPVD	MATL STUS	SCALE
MC	02/05/03		6061-T6	2/1

SASH REINFORCEMENT XHD A 10300151

REV	BY	APPVD	DATE	CHANGE
-----	----	-------	------	--------

CERTIFIED TESTING LABORATORIES

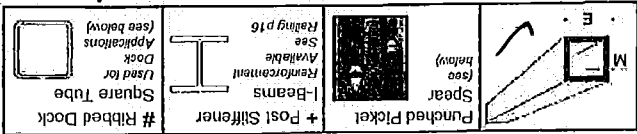
REPORT: C793006444w

DATE: 10/11/14

VERIFIED Square Aluminum Tube

6063-T52 x 24" (Unless noted otherwise)

Items marked as MILL ORDERS are non stock but available. Product codes listed on MILL ORDER items are for the reference only. Customer must specify length, alloy & temper.



Approx. Wt/Ln Ft. Stock Code Size in Inches (E x M x S)

Stock Code	Size in Inches (E x M x S)	Approx. Wt/Ln Ft.
19-63-100	5.00 x .062 x 20"	1.076
19-63-471	.625 x .062 x 20"	1.109
19-63-090	.735 x .045 x 16.6"	1.109
19-63-095	.735 x .045	1.126
19-63-085	.750 x .040 (w/.093 radius)	1.126
19-63-089	.750 x .045 x 16.8" (w/radius)	1.126
19-63-101	.750 x .045 x 18.8" (w/radius)	1.126
19-63-105PS1	.750 x .062 x 58" Punched Pickel Spear	1.1634
19-63-525	.750 x .062 x 16"	1.627
19-63-106	.750 x .062 x 21" (w/radius)	1.530
19-63-108	.750 x .062 x 22" (w/radius)	2.100
19-63-105	.750 x .062	2.052
19-63-107	.750 x .062 (w/.090 radius)	0.982
19-63-110	.750 x .093	2.640
19-63-113	.750 x .093 (w/radius)	0.855
19-63-115	.750 x 1/8	1.074
19-63-116	.750 x 1/8 (.062 radius)	1.425
19-63-821	1 x .047	2.076
19-63-130	1 x .062	1.490
19-63-130PS1	1 x .062 x 58" Punched Pickel Spear	1.298
19-63-130PS2	1 x .062 x 70" Punched Pickel Spear	1.298
19-63-131	1 x .062 (w/radius)	1.380
19-63-136	1 x .075 (w/radius)	1.726
19-63-341	1 x .093	1.670
19-63-345	1 x .093 (w/radius)	1.709
19-63-140	1 x .125	1.546
19-63-140	1 x .125 (6061-T6)	2.502
19-63-141	1 x .125 (w/radius)	2.502
25-BD-310	1 x 1.25 Polished BDA (w/rad) x 20"	2.502
19-63-153	1.250 x .062	3.300
19-63-150	1.250 x .093	3.204
19-63-150	1.250 x .093 (6061-T6)	3.204
19-63-155	1.250 x 1.25	3.204
19-63-157	1.250 x 1.25 x 20" (w/radius)	2.374
19-63-160	1.500 x .060	2.772
19-63-161	1.500 x .062 (w/.093 radius)	4.500
19-63-161	1.500 x .062 (w/.125 radius)	4.500
19-63-174	1.500 x .188	5.173
19-63-173	1.500 x .250 (6061-T6)	4.204
52-61-1045	1.500 x .250 x 18" (w/rad/6061-T6)	5.076
19-63-180	1.750 x .093	5.245
19-63-180	1.750 x .093 (6061-T6)	6.900
19-63-185	1.750 x .125	6.900
19-63-191	2 x .062 x 26"	5.804
19-63-191	2 x .062 x 26"	5.120
19-61-206	2 x .093 (6005-T5)	7.050
19-61-205	2 x .093 x 26" (6005-T5)	17.650
52-63-11425	2 x .093 (with radius)	11.700

Standards 15

EMS FL 1-800-432-2204
EMS NC 1-800-343-8154
EMS TX 1-800-996-6061
EMS MO 1-888-822-6061
 Additional Locations: West Palm Beach & Lakeland, FL; Newark, DE and Birmingham, AL
 Eastern Metal Supply
 Website: www.EasternMetal.com
 Email: info@EasternMetal.com
 Version: 07/24/14

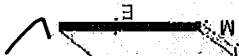
(DWG # EMS 19-61-140)

CERTIFIED TESTING LABORATORIES

REPORT: *CTA 3885W V WY*

DATE: *10/11/14*

Rectangular Aluminum Bar - 6061-T6511 x 12"



Stock Code (E x M) Size In Inches Approx. Wt/Lb In

Stock Code	(E x M)	Size In Inches	Approx. Wt/Lb In
10-61-200 (FL)	1/8 x 1/2	1/8 x 1/2	0.074
MILL ORDER 62-61-4303 (FL)	1/8 x 5/8	1/8 x 5/8	0.092
10-61-201 (FL)	1/8 x 3/4	1/8 x 3/4	0.110
10-61-215	1/8 x 1	1/8 x 1	0.150
10-61-220	1/8 x 1-1/4	1/8 x 1-1/4	0.188
10-61-225	1/8 x 1-1/2	1/8 x 1-1/2	0.225
10-61-230	1/8 x 2	1/8 x 2	0.300
MILL ORDER	3/16 x 3/4	3/16 x 3/4	0.169
10-61-265	3/16 x 1	3/16 x 1	0.226
MILL ORDER 10-61-270 (TX)	3/16 x 1-1/4	3/16 x 1-1/4	0.275
10-61-275	3/16 x 1-1/2	3/16 x 1-1/2	0.338
10-61-285	3/16 x 2	3/16 x 2	0.451
MILL ORDER 10-61-286 (NC)	3/16 x 2-1/2	3/16 x 2-1/2	0.561
10-61-324 (FL)	1/4 x 1/2	1/4 x 1/2	0.147
MILL ORDER 10-61-615 (FL)	3/16 x 4	3/16 x 4	0.884
MILL ORDER 10-61-300 (NC)	1/4 x 3/4	1/4 x 3/4	0.226
10-61-325	1/4 x 1	1/4 x 1	0.300
10-61-330	1/4 x 1-1/4	1/4 x 1-1/4	0.376
10-61-335	1/4 x 1-1/2	1/4 x 1-1/2	0.450
MILL ORDER 10-61-800 (NC)	1/4 x 1-3/4	1/4 x 1-3/4	0.524
10-61-340	1/4 x 2	1/4 x 2	0.600
10-61-345	1/4 x 2-1/2	1/4 x 2-1/2	0.735
10-61-350	1/4 x 3	1/4 x 3	0.900
10-61-353 (FL)	1/4 x 3-1/2	1/4 x 3-1/2	1.050
10-61-355	1/4 x 4	1/4 x 4	1.200
10-61-360	1/4 x 5	1/4 x 5	1.500
10-61-365	1/4 x 6	1/4 x 6	1.800
10-61-366	1/4 x 7	1/4 x 7	2.058
10-61-370	1/4 x 8	1/4 x 8	2.352
10-61-375	1/4 x 10	1/4 x 10	2.940
33-61-100	1/4 x 12	1/4 x 12	3.528
10-61-380 (FL)	5/16 x 3	5/16 x 3	1.101
10-61-414 (FL)	3/8 x 1/2	3/8 x 1/2	0.221
MILL ORDER 10-61-704 (NC)	3/8 x 3/4	3/8 x 3/4	0.330
10-61-415	3/8 x 1	3/8 x 1	0.450
10-61-416	3/8 x 1-1/4	3/8 x 1-1/4	0.563
10-61-420	3/8 x 1-1/2	3/8 x 1-1/2	0.675
10-61-426	3/8 x 2	3/8 x 2	0.900
10-61-417	3/8 x 2-1/2	3/8 x 2-1/2	1.126
10-61-435	3/8 x 3	3/8 x 3	1.350
10-61-440	3/8 x 4	3/8 x 4	1.800
Stock Code	(E x M)	Size In Inches	Approx. Wt/Lb In
10-61-442 (FL)	3/8 x 1/2	3/8 x 1/2	0.074
10-61-443	3/8 x 5	3/8 x 5	2.205
10-61-445	3/8 x 6	3/8 x 6	2.645
10-61-446	3/8 x 7	3/8 x 7	3.087
10-61-448	3/8 x 8	3/8 x 8	3.528
10-61-450	3/8 x 10	3/8 x 10	4.410
10-61-455	3/8 x 12	3/8 x 12	5.292
MILL ORDER 10-61-828 (NC)	1/2 x 3/4	1/2 x 3/4	0.450
10-61-475	1/2 x 1	1/2 x 1	0.600
MILL ORDER 10-61-477 (NC)	1/2 x 1-1/4	1/2 x 1-1/4	0.734
10-61-480	1/2 x 1-1/2	1/2 x 1-1/2	0.900
MILL ORDER 62-61-821 (FL)	1/2 x 1-3/4	1/2 x 1-3/4	1.028
10-61-485	1/2 x 2	1/2 x 2	1.200
10-61-487 (FL)	1/2 x 2-1/4	1/2 x 2-1/4	1.323
10-61-486	1/2 x 2-1/2	1/2 x 2-1/2	1.500
10-61-489	1/2 x 3	1/2 x 3	1.800
10-61-500	1/2 x 4	1/2 x 4	2.400
10-61-501	1/2 x 5	1/2 x 5	2.940
10-61-505	1/2 x 6	1/2 x 6	3.600
52-61-3400 (FL)	1/2 x 7	1/2 x 7	4.116
10-61-511	1/2 x 8	1/2 x 8	4.704
10-61-515	1/2 x 10	1/2 x 10	5.880
33-61-110	1/2 x 12	1/2 x 12	7.056
33-61-112 (FL)	1/2 x 14	1/2 x 14	8.470
10-61-516 (FL)	5/8 x 2	5/8 x 2	1.470
10-61-518 (FL)	5/8 x 3	5/8 x 3	2.205
10-61-517 (FL)	5/8 x 4	5/8 x 4	2.940
52-61-2658 (FL)	5/8 x 6	5/8 x 6	4.500
10-61-545	3/4 x 1	3/4 x 1	0.881
MILL ORDER 10-61-725 (NC)	3/4 x 1-1/4	3/4 x 1-1/4	1.101
10-61-550	3/4 x 1-1/2	3/4 x 1-1/2	1.350
10-61-551 (FL)	3/4 x 1-3/4	3/4 x 1-3/4	1.544
10-61-560	3/4 x 2	3/4 x 2	1.800
10-61-561 (FL)	3/4 x 2-1/4	3/4 x 2-1/4	1.985
10-61-565 (FL/NC)	3/4 x 3	3/4 x 3	2.700
10-61-570	3/4 x 4	3/4 x 4	3.528
10-61-571 (FL)	3/4 x 5	3/4 x 5	4.500
10-61-575	3/4 x 6	3/4 x 6	5.400
10-61-576	3/4 x 8	3/4 x 8	7.056
33-61-120	3/4 x 12	3/4 x 12	10.584
MILL ORDER 10-61-763 (NC)	1 x 1-1/4	1 x 1-1/4	1.469
10-61-620	1 x 1-1/2	1 x 1-1/2	1.800

Items marked as MILL ORDER are non stock but available. Product codes listed on MILL ORDER items are for die reference only. Customer must specify length, alloy & temper.

Standards 01

EMS MO
1-888-822-6061

EMS TX
1-800-996-6061

EMS NC
1-800-343-8154

(704) 391-2267 - fax

EMS FL
1-800-432-2204

(561) 588-4780 - fax

Additional Locations: West Palm Beach & Lakeland, FL; Newark, DE and Birmingham, AL

Website: www.EasternMetal.com e-mail: info@EasternMetal.com Version: 04/02/14

Quality Shapes in Aluminum

(Dwg # 1000183)
(Asfresal)

(Dug # EMS 11-63-275)

Eastern Metal Supply
 Quality Shapes in Aluminum
 Website: www.EasternMetal.com e-mail: info@EasternMetal.com Version: 12/05/13
 Additional Locations: West Palm Beach & Lakeland, FL; Newark, DE and Birmingham, AL
EMS FL 1-800-432-2204 (561) 588-4780 - fax
EMS NC 1-800-343-8154 (704) 391-2267 - fax
EMS TX 1-800-996-6061 (281) 656-2297 - fax
EMS MO 1-888-822-6061 (314) 344-3349 - fax

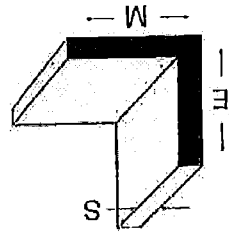


Standards 09

Items marked as MILL ORDER are non stock but available.
 Product codes listed on MILL ORDER items are for die reference only.
 Customer must specify length, alloy & temper.

CERTIFIED TESTING LABORATORIES

REPORT: CTLA 3006 WIA RWD
 DATE: 10/14/14
 VERIFIED BY: mm

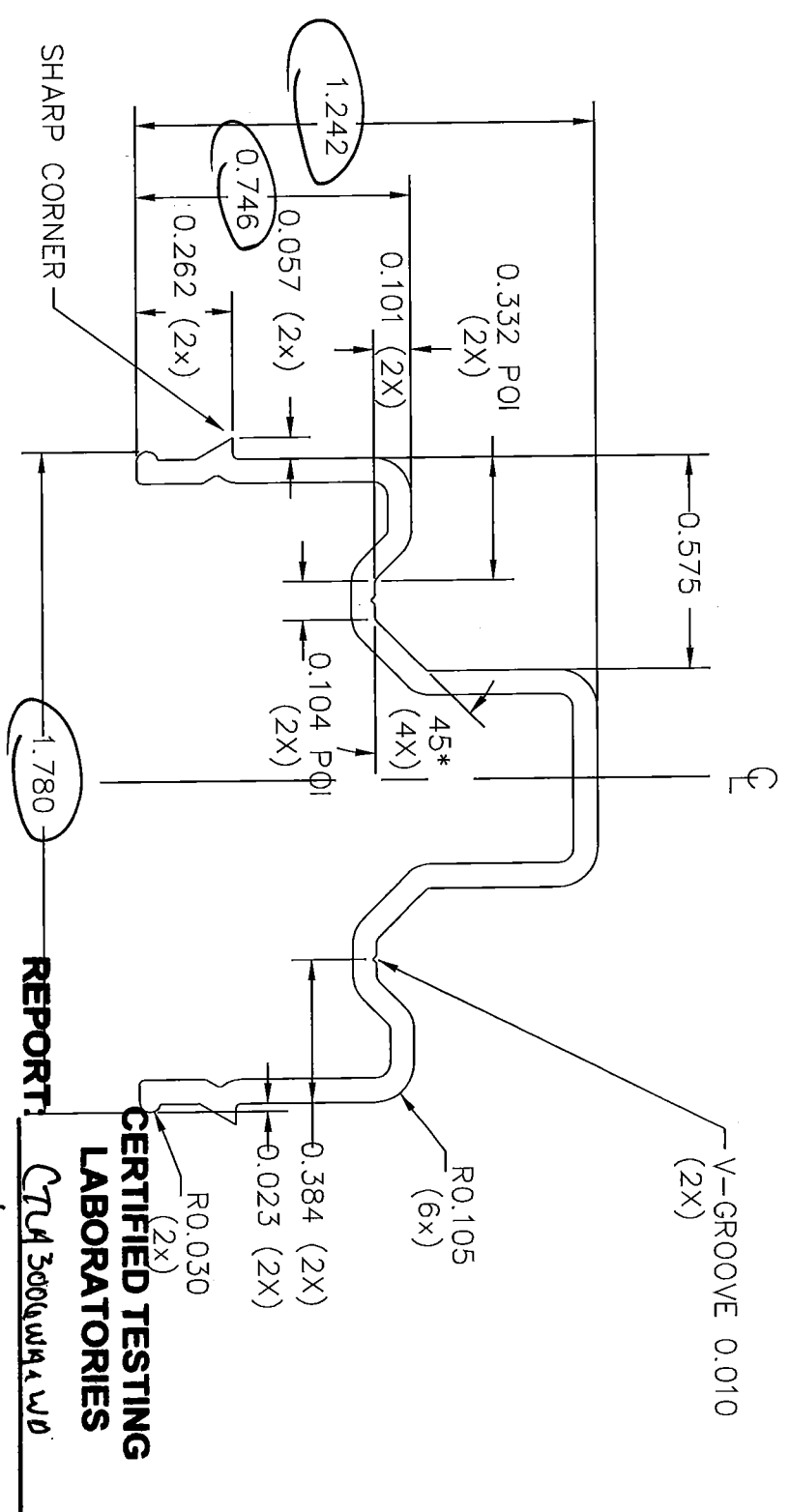


Stock Code	Size in Inches (E x M x S)	Approx. Wt./In. Ft.
11-63-200	1/2 x 1/2 x 1/16	0.069
11-63-205	3/4 x 3/4 x 1/16	0.107
11-63-210	3/4 x 3/4 x 1/8	0.206
11-63-220	1 x 1 x 1/16	0.144
24-63-206	1 x 1 x 1/16 x 24' 6" (6063-T6)	0.144
11-63-225	1 x 1 x 1/8	0.276
11-63-230	1 x 1 x 3/16	0.408
11-63-255	1-1/4 x 1-1/4 x 1/8	0.356
11-63-260	1-1/4 x 1-1/4 x 3/16	0.519
11-63-270	1-1/2 x 1-1/2 x 1/16	0.219
11-63-373 (NC)	1-1/2 x 1-1/2 x 1/16	0.219
24-63-216	1-1/2 x 1-1/2 x 1/16 x 24' 6" (6063-T6)	0.219
11-63-275	1-1/2 x 1-1/2 x 1/8	0.431
24-63-236	1-1/2 x 1-1/2 x 1/8 x 24' 6" (6063-T6)	0.431
11-63-280	1-1/2 x 1-1/2 x 3/16	0.633
11-63-295	1-3/4 x 1-3/4 x 1/8	0.506
11-63-310	2 x 2 x 1/16	0.293
52-63-5805A	2 x 2 x 0.093 x 24' 3"	0.440
11-63-315	2 x 2 x 1/8	0.581
11-63-320	2 x 2 x 3/16	0.859
11-63-325	2 x 2 x 1/4	1.124
11-63-330	3 x 3 x 1/8	0.881
11-63-335	3 x 3 x 1/4	1.725
11-63-350	1/2 x 1-1/2 x 0.093	0.208
11-63-355	3/4 x 1-1/2 x 1/8	0.319
11-63-355	1 x 1-1/2 x 1/8	0.356
11-63-269	1 x 1-1/2 x 1/8	0.218
11-63-365	1 x 2 x 1/16	0.431
11-63-370	1 x 2 x 1/8	0.582
11-63-375	1 x 3 x 1/8	0.506
11-63-410	1-1/2 x 2 x 1/8	0.506
40-63-128	1-1/2 x 2 x 1/8 x 24' 6" (6063-T6)	0.506
11-63-309	1-1/2 x 2 x 3/16	0.731
11-63-390	2 x 3 x 1/8	0.750
11-61-520 (FL)	2 x 3 x 3/16 x 25'	1.085
11-63-395	2 x 4 x 1/8	0.881
11-63-396	2 x 4 x 1/4	1.725
11-63-405	2 x 5 x 1/8	1.031
11-63-415	2 x 7 x 1/4	2.624

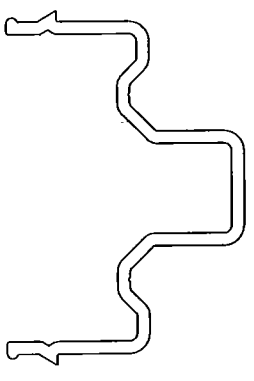
6063-T52 Unequal Leg

6063-T52 x 20' Equal Leg

Architectural Aluminum Angle



ACTUAL SIZE
NO EXPOSED SURFACES



- NOTES:
1. ALL UNSPECIFIED RADII 0.015.
 2. ALCOA P/N 23111 (WHITE P-001, DESERT SAND P-029).

CERTIFIED TESTING LABORATORIES

REPORT: CTU 300644140
DATE: 10/14/14
VERIFIED BY: Wu

Vinyl line® VINYL BUILDING PRODUCTS INC.

AREA= 0.269 sq in
 WEIGHT= 0.316 lb/ft

TOLERANCES (EXCEPT AS NOTED)
 ±0.010

REV	BY	APPV'D	DATE	CHANGE
DRAWN			MG	DATE
10/28/3			APPV'D	
MATERIAL				SCALE
6061-T6.6105-15				2/1
SNUBBER				
10300148				

UNLESS OTHERWISE NOTED THE FOLLOWING TOLERANCES APPLY
 .001 - .003 + .005 1.001 - 1.000 + .020
 .001 - .003 + .010 1.501 - 2.000 + .025
 .501 - 1.000 + .015 2.001 - & UP + .030
 UNSPECIFIED ANGLES * 1° - WOODGRAIN SURFACES ADD .007

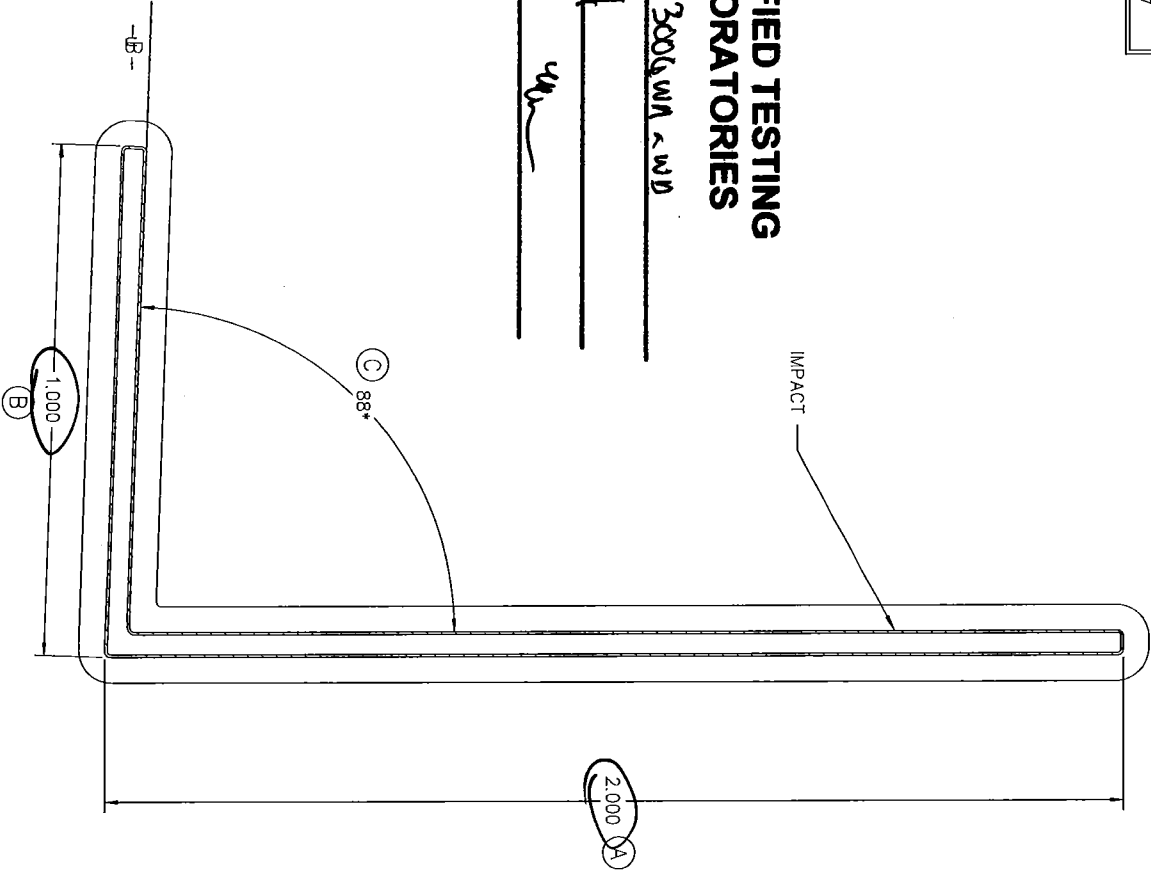
----- = EXPOSED SURFACE ----- WOODGRAIN SURFACE

NOTES:
 1. WALL THICKNESS TO BE .065
 UNLESS OTHERWISE NOTED.

CERTIFIED TESTING LABORATORIES

REPORT: CTA3006 WA & WD
 DATE: 10/14/14
 VERIFIED BY: W

ACTUAL SIZE:



REV.	DATE	DESCRIPTION	BY
A	11/15/95	NEW TITLE BLOCK	CRB

ROW CLASS:	B	IMPACT AREA:	NOTED
CONTROL DIMENSIONS			

DIM	METH	MIN	ENG	MAX	DIM	METH	MIN	ENG	MAX
A	C-0	1.970	2.000	2.030	X				
B	C-0	.970	1.000	1.030	Y				
C	OC	85*	88*	91*	Z				
D					AA				
E					BB				
F					CC				
G					DD				
H					EE				
I					FF				
J					GG				
K					HH				
L					II				
M					JJ				
N					KK				
O					LL				
P					MM				
Q					NN				
R					OO				
S					PP				
T					QQ				
U					RR				
V					SS				
W					TT				

DAYTON TECHNOLOGIES
 AN ALCOA COMPANY
 Copyright 1995
 MONROE, OHIO

NAME: _____
 DRAWN BY: MAB DATE: 8/25/87
 CHECKED BY: _____ DATE: _____
 SCALE: 4 : 1 "B"
 PART NO. 5870A PART DWG NO. P5870-A

Part Wt. (Lbs/Ft)	Rigid:	Cap:	Flex:	Alum:	Total
	.041	.019			.060

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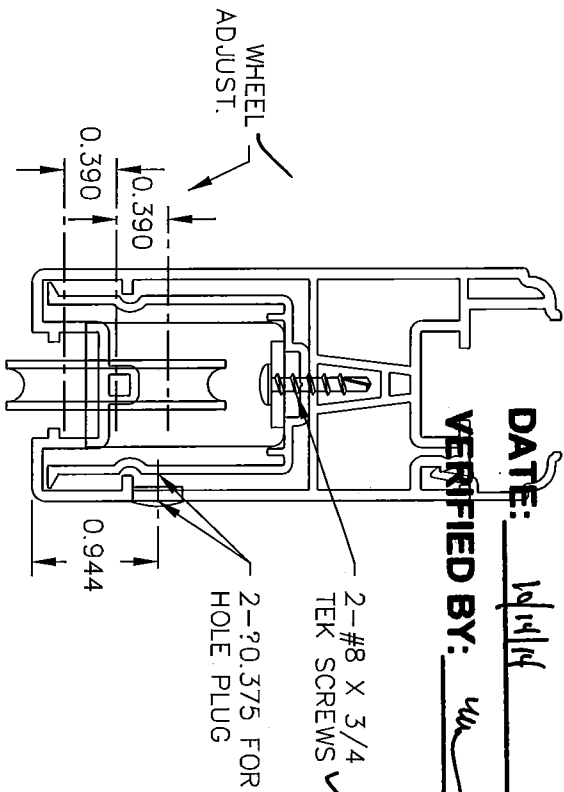
011H074

CERTIFIED TESTING LABORATORIES

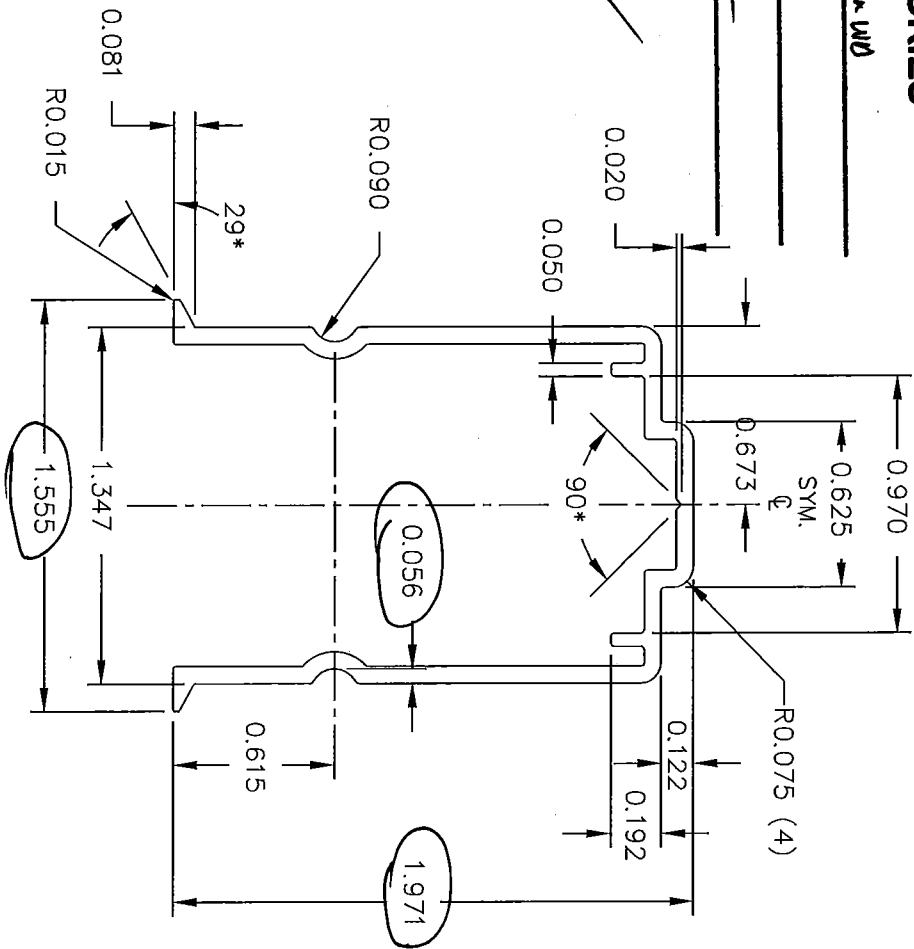
REPORT: CTA 306044 & WU

DATE: 10/14/14

VERIFIED BY: WU



PARTS ASSEMBLY
SCALE: 1/2



NOTES:

1. MATERIAL: ALUM. 6005-T5, 6061-T6 or 6105-T5.
2. UNSPECIFIED WALL THICKNESS = .065".
3. BREAK ALL CORNERS R0.015.
4. NO EXPOSED SURFACES.
5. MOMENTS OF INERTIA: $I_{xx} = .147$; $I_{yy} = .118$.

DEPLIS# 10300152



deuceuninck

VINYL BUILDING PRODUCTS LLC

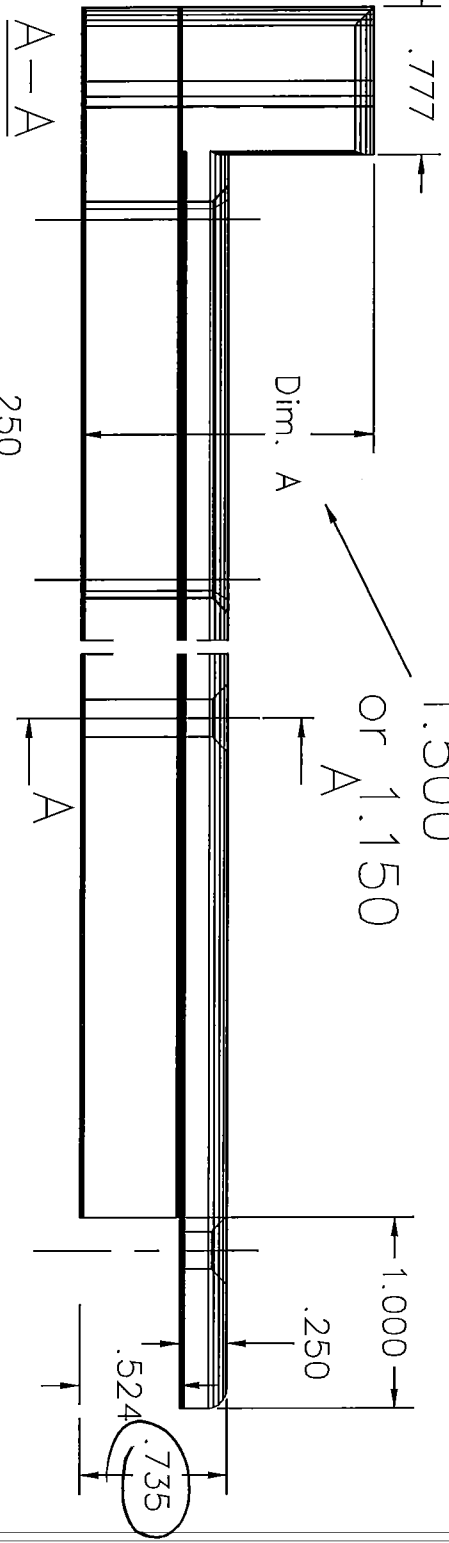
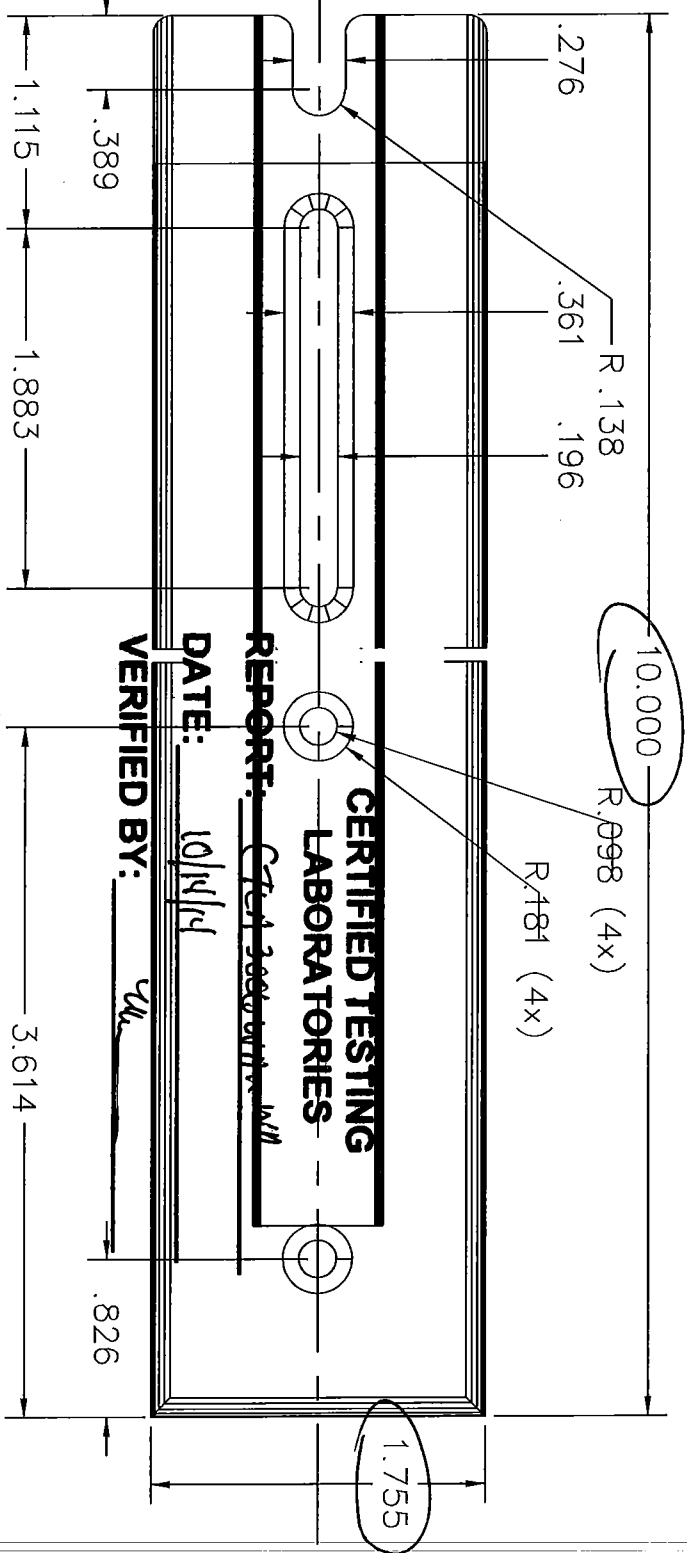
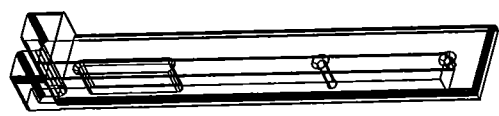
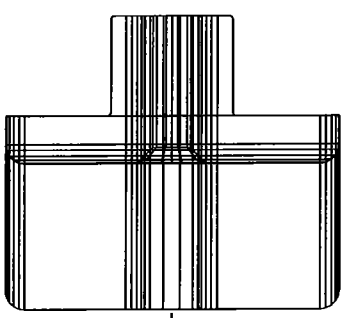
AREA = .359 sq. in.
WT/FT = .431 lb.
PERIM. = 11.200 in.
FACTOR = 26

TOLERANCES (EXCEPT AS NOTED)
AA STANDARDS

REV	BY	DATE	DESCRIPTION												
-	-	-	-												
<table border="1"> <tr> <td>DRAWN</td> <td>DATE</td> <td>APPV'D</td> <td>MAT'L</td> <td>NOTE</td> <td>SCALE</td> </tr> <tr> <td>RJK</td> <td>11-30-05</td> <td></td> <td></td> <td>1</td> <td>FULL</td> </tr> </table>				DRAWN	DATE	APPV'D	MAT'L	NOTE	SCALE	RJK	11-30-05			1	FULL
DRAWN	DATE	APPV'D	MAT'L	NOTE	SCALE										
RJK	11-30-05			1	FULL										
RAIL INSERT-SIDE ADJUST ROLLER															
10300152															

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A 011h055-D



COLOR WHITE

REV	BY	APPVD	DATE	CHANGE

Vinylines®

VINYL BUILDING PRODUCTS INC.

AREA = 8.109 cub in
WEIGHT =

TOLERANCES (EXCEPT AS NOTED)
±0.010

DRAWN	MG	DATE	APPVD	MAT'L	SCALE
		2/25/05		NYLON	1/1
BRACKET					
011h055-D					