


000.620 PD - 009 - BILL OF MATERIALS 2 LITE DP65

| ITEM NO. | DESCRIPTION | QUANTITY | PART NO. | FAB DWG. NO | SOURCE |
|----------|--|----------|---|---------------|---------|
| 1 | EXD PNL TOP RAIL | 1 | 10001102 | 10001102-F-01 | A |
| 2 | STILE | 1 | 10001102 | 10001102-F-01 | A |
| 3 | BOTTOM RAIL | 1 | 10001102 | 10001102-F-02 | A |
| 4 | INTERLOCK | 1 | 10001117 | 10001117-F-04 | A |
| 5 | SCREW COVER | 1 | 10001118 | 10001111-F-01 | A |
| 6 | GLAZING BEAD | 4 | 10001111 | 10001111-F-01 | A |
| 7 | STILE REINFORCEMENT - JAMB | 1 | 10300150 | STRAIGHT CUT | PPP |
| 8 | STILE REINFORCEMENT - INTERLOCK | 1 | 10300151 | STRAIGHT CUT | PPP |
| 9 | WEATHER-STRIPPING - 270 x 250 | AS REQD | W21255MW | STRAIGHT CUT | HHHH |
| 10 | OPR PNL RAIL - TOP | 1 | 10001102 | 10001102-F-01 | A |
| 11 | STILE - INTERLOCK | 1 | 10001102 | 10001102-F-03 | A |
| 12 | STILE - ACTIVE LOCK | 1 | 10001102 | 10001102-F-10 | A |
| 13 | STILE - PASSIVE LOCK | 1 | 10001102 | 10001102-F-16 | A |
| 14 | RAIL - BOTTOM | 1 | 10001102 | 10001102-F-05 | A |
| 15 | INTERLOCK | 2 | 10001117 | 10001117-F-02 | A |
| 16 | SCREW COVER | 2 | 10001118 | STRAIGHT CUT | A |
| 17 | GLAZING BEAD | 4 | 10001111 | 10001111-F-01 | A |
| 18 | STILE REINFORCEMENT - INTERLOCK | 1 | 10300151 | STRAIGHT CUT | PPP |
| 19 | STILE REINFORCEMENT - ACTIVE LOCK | 1 | 10300150 | 10300150-F-01 | PPP |
| 20 | STILE REINFORCEMENT - PASSIVE LOCK | 1 | 10300151 | 10300151-F-01 | PPP |
| 21 | RAIL REINFORCEMENT - BOTTOM | 1 | 10300152 | 10300152-F-01 | PPP |
| 22 | SQUARE TUBE REINFORCEMENT - VERTICAL INTERLOCK RAILS | 1 | 1" X 1" X .125" SQUARE ALUMINIUM TUBE (EMS 19-61-140) | STRAIGHT CUT | EASTERN |
| 23 | WEATHER-STRIPPING - 270 x 250 | AS REQD | W21255MW | | HHHH |
| 24 | MISC LOCK SET ASSEMBLY - 2817 LOCK W/ TRIMPLATE | 1 | DECU-XXXX4 | | F |
| 25 | HANDLE SET ASSEMBLY | 1 | DECU-XXXX1 | | F |
| 26 | HANDLE SET - INTERIOR SWITCH | | DECU-XXXX2 | | |
| 27 | HANDLE SET - INTERIOR SWITCH / KEY | | DECU-XXXX3 | | |
| 28 | HANDLE SET - BLANK | 2 | 1988FRS166REV/SS | | F |
| 29 | ROLLER ASSEMBLY - PRECISION 1.66" WHEEL | 2 | D8096AMW/KC 0.810 | | HHHH |
| 30 | DRAFT PLUG - .810 DIA. | 2 | 9946 | | D |
| 31 | 3/8" HOLE PLUG | 1 | DECU-2808-84 | | F |
| 32 | KEEPER - 2778 KEEPER - STAINLESS STEEL | 2 | 011H055-D | | MNMM |
| 33 | IMPACT BRACKET | 2 | | | |
| 34 | 1" INSULATED GLASS | AS REQD | REFER TO APPLICABLE TEST REPORT | | |
| 35 | SETTING BLOCKS (REFER TO IG SUPPLIER GUIDELINES) | AS REQD | REFER TO APPLICABLE TEST REPORT | | |
| 36 | GLAZING COMPOUND | AS REQD | REFER TO APPLICABLE TEST REPORT | | |
| 37 | LOCK SET | 2 | #10 x 1.25" PFH - 410SS | | |
| 38 | ROLLER ASSEMBLY | 4 | #8 x 3/4" PFH - 410SS | | |
| 39 | REINFORCEMENT TO PANEL | AS REQD | #8 x 1" PFH - 410SS | | |
| 40 | INTERLOCK | AS REQD | #8 x 5/8" PFH - 410SS | | |
| 41 | 4 LITE ASTRAGAL | AS REQD | #8 x 2" PPH - PAINTED | | |
| 42 | KEEPER | 2 | #8 x 3" PPH - 410SS | | |
| 43 | IMPACT BRACKET | 4 | #8 x 2.5" PFH - PAINTED | | |
| 44 | REV | DATE | DESCRIPTION | BY | |

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NGTL - 210 TEST DATE: 09/23/16

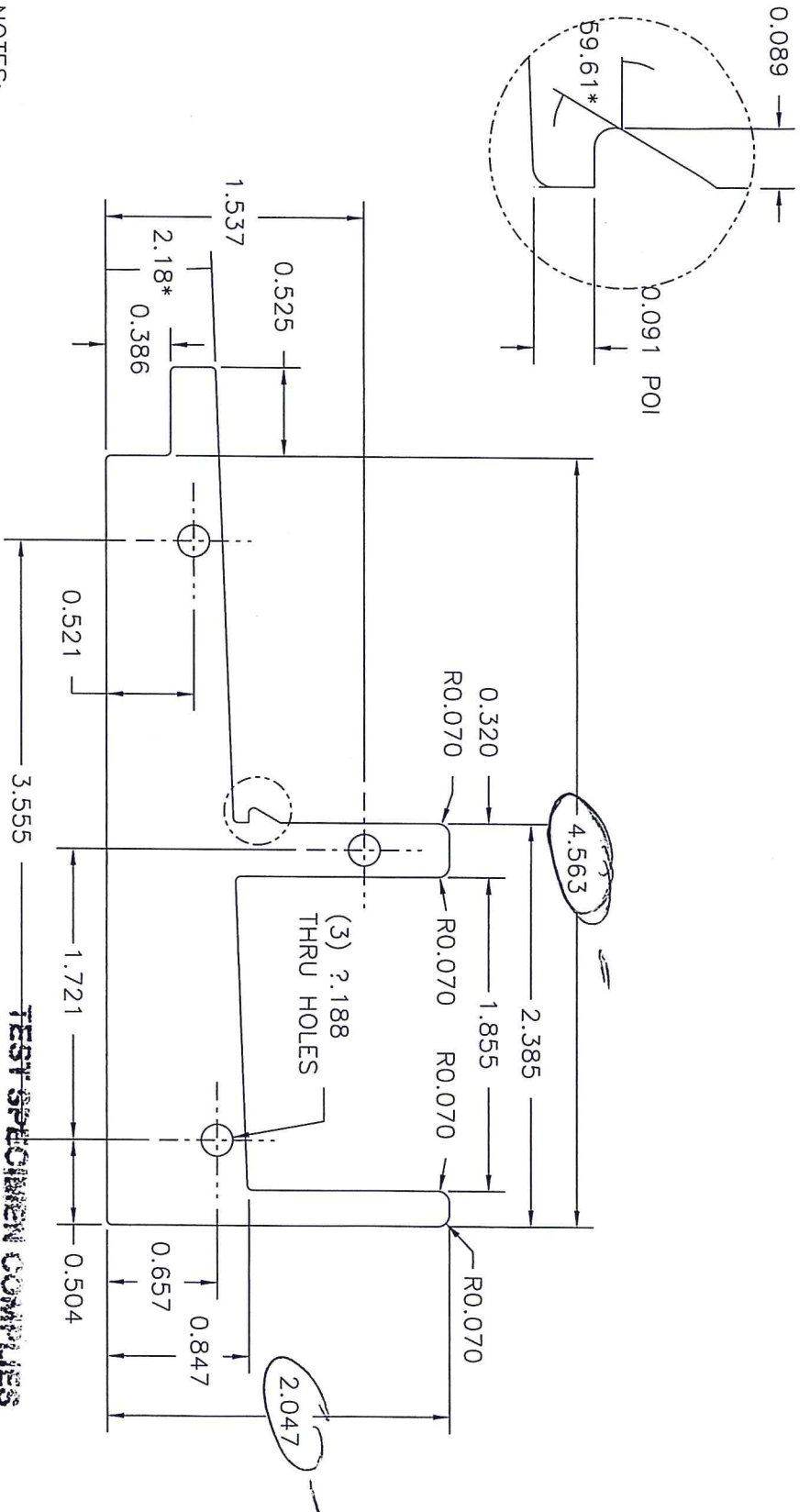
4044-02



 NORTH AMERICA

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 000 620 PD - 009
 CRB 17/01/03
 000620PD-009

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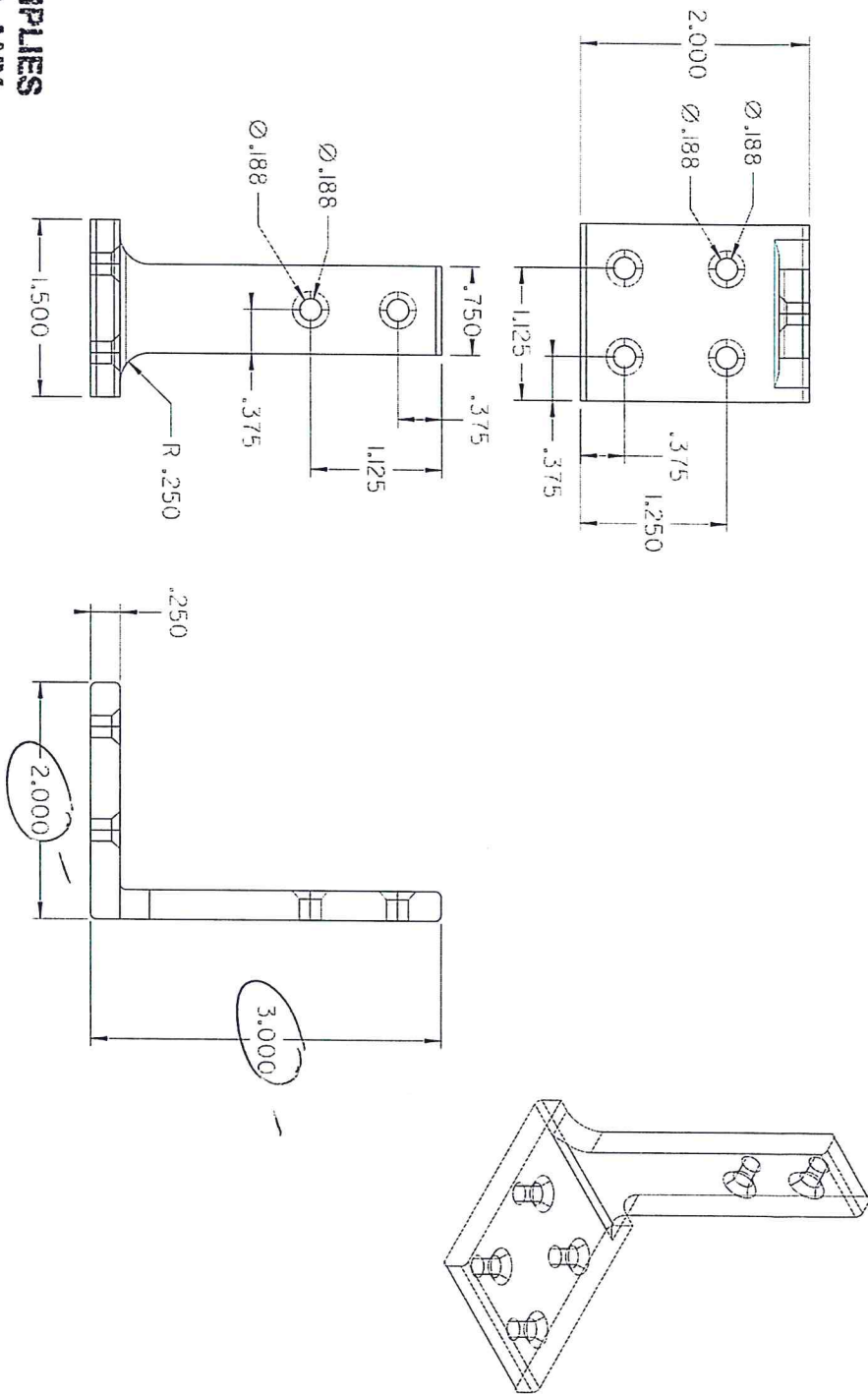
- NOTES:
- 1) MATERIAL: CLOSED CELL, CROSSLINKED POLYETHYLENE FOAM, 4-6 LB/CU. FT. DENSITY, COLORWHITE, UV STABILIZED.
 - 2) PERMANENT, PRESSURE SENSITIVE ADHESIVE, RUBBER OR ACRYLIC BASE, ONE SIDE WITH RELEASE PAPER BACKING. (BOTH SIDES REQUIRED).
 - 3) ALL RADII 0.030 UNLESS OTHERWISE SPECIFIED.
 - 4) H-O Products part no. G-A302-Z1-G600

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTI - 210 - 4044-02
TEST DATE: 09/23/16

Vinylina®
VINYL BUILDING PRODUCTS INC.
 AREA = 4.254 sq. in.
 WEIGHT =
 TOLERANCES (EXCEPT AS NOTED)

| | | | | |
|---|----|--------|------|--------|
| REV | BY | APPV'D | DATE | CHANGE |
| | | | | |
| DRAWN <i>SA</i> DATE 12-14-00 APPV'D WEIGHT = MAT'L PE foam SCALE 1-1 | | | | |
| 1101 SILL GASKET 011H002 | | | | |

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



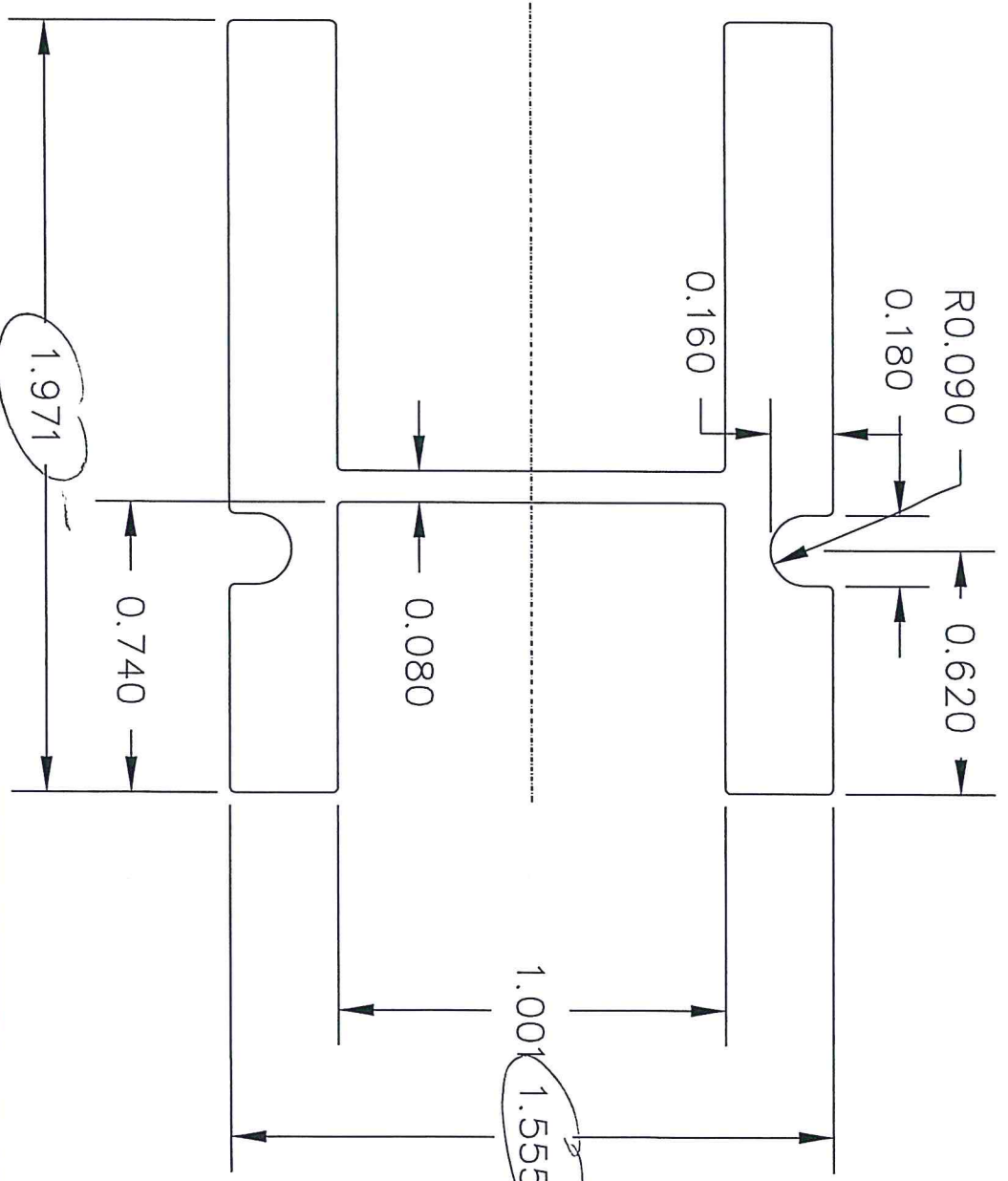
TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4044-02 TEST DATE: 07/23/16

| | | | |
|--|-------|--|----------|
| CONFIDENTIAL | | UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES. TOL ON ANGLES: 1° INTERPRET DIM AND TOL PER ASME Y14.5M - 1994 | |
| UNPUBLISHED WORK © 2012 DECEUNINCK NORTH AMERICA | | THIRD ANGLE PROJECTION | |
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| DESIGN BY: | JCH | DATE: | 12/05/20 |
| DRAWN BY: | JCH | DATE: | 12/05/20 |
| FILENAME: | 26071 | SCALE: | 1:1 |
| SHEET: 1 | | SHEET: 1 | |

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A 011H049

NO EXPOSED SURFACES



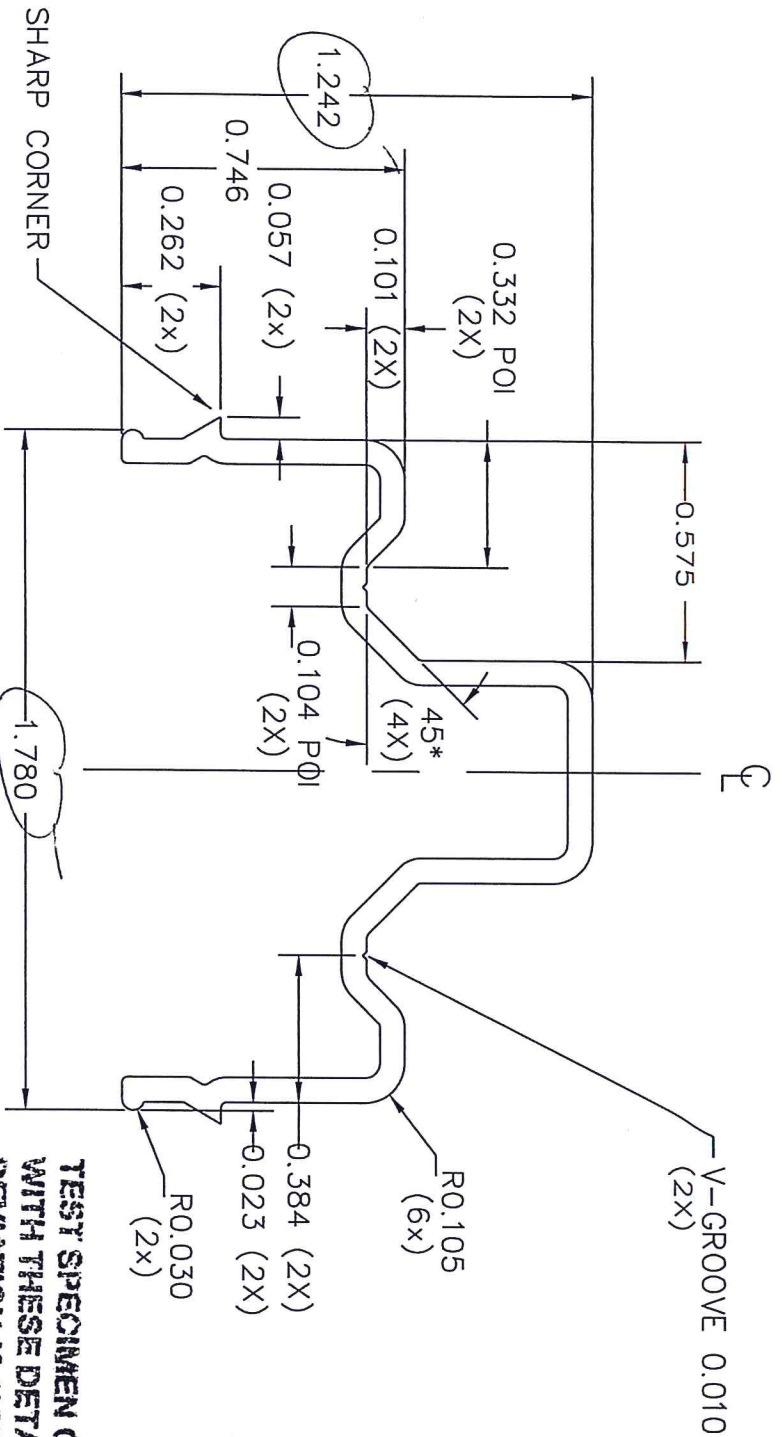
TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. MCTL-210-4044-02
 TEST DATE: 09/23/16

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]

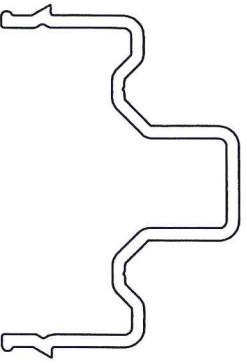
| | | | | |
|------------------------|----|--------|----------|----------|
| REV | BY | APP'VD | DATE | CHANGE |
| | | | | |
| DRAWN | MG | DATE | 02/05/03 | APP'VD |
| SASH REINFORCEMENT XHD | | MAT'L | 6T05-15 | SCALE |
| | | | 6061-T6 | 2/1 |
| | | | | 10300151 |



ACTUAL SIZE
NO EXPOSED SURFACES

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4644-02
 TEST DATE: 09/23/18

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



VINYL BUILDING PRODUCTS INC.

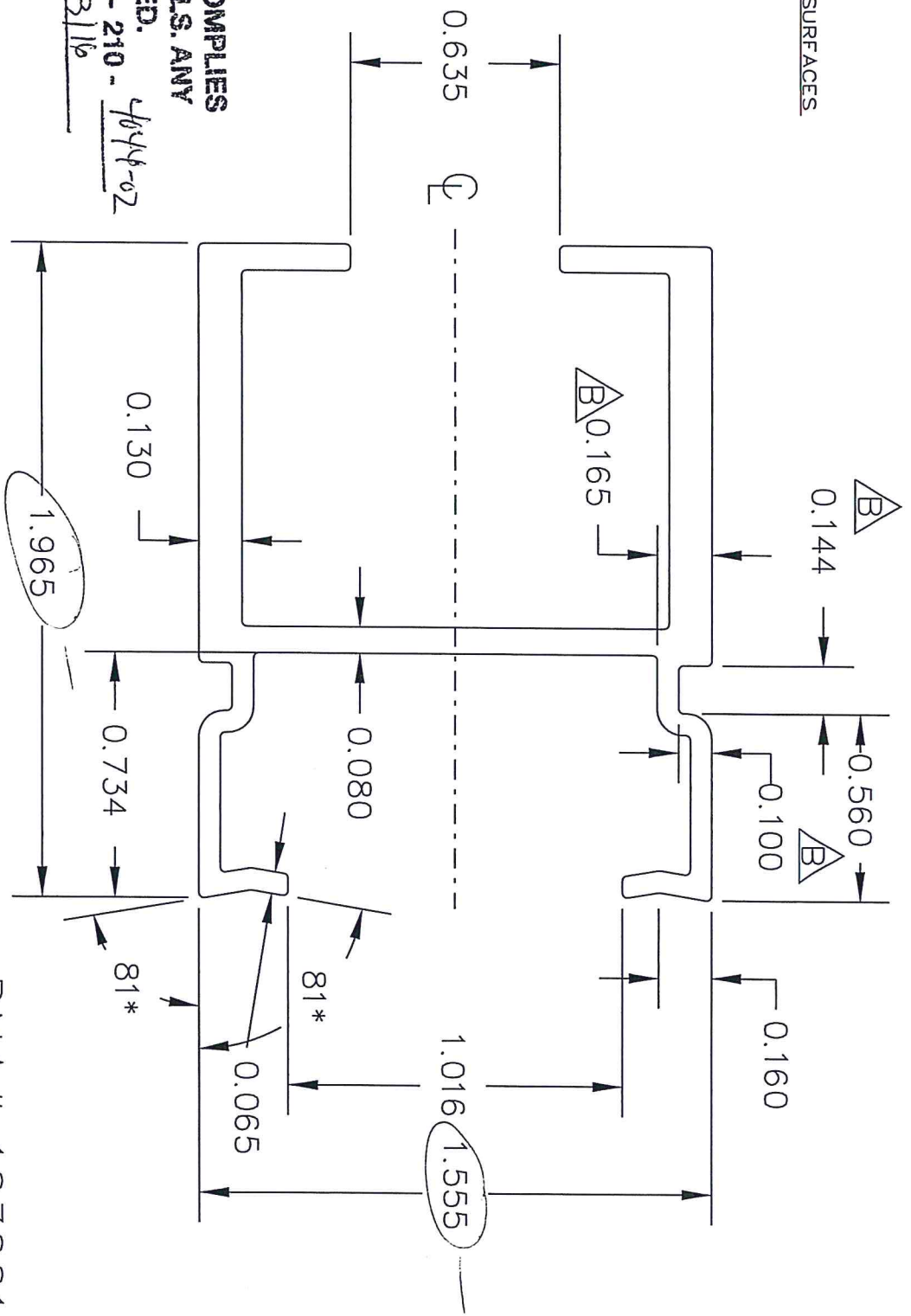
AREA = 0.269 sq in
 WEIGHT = 0.316 lb/ft

TOLERANCES (EXCEPT AS NOTED)
 ±0.010

| | | | | |
|-----|----|--------|------|--------|
| REV | BY | APPV'D | DATE | CHANGE |
| | | | | |

| | | | | | |
|---------|----|-------|------------------|--------|----------|
| DRAWN | MG | DATE | 10/28/3 | APPV'D | |
| SNUBBER | | MAT'L | 6061-T6, 6105-15 | SCALE | 2/1 |
| | | | | | 10300148 |

NO EXPOSED SURFACES



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4844-02 TEST DATE: 09/23/16

- 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 | Renomed 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®

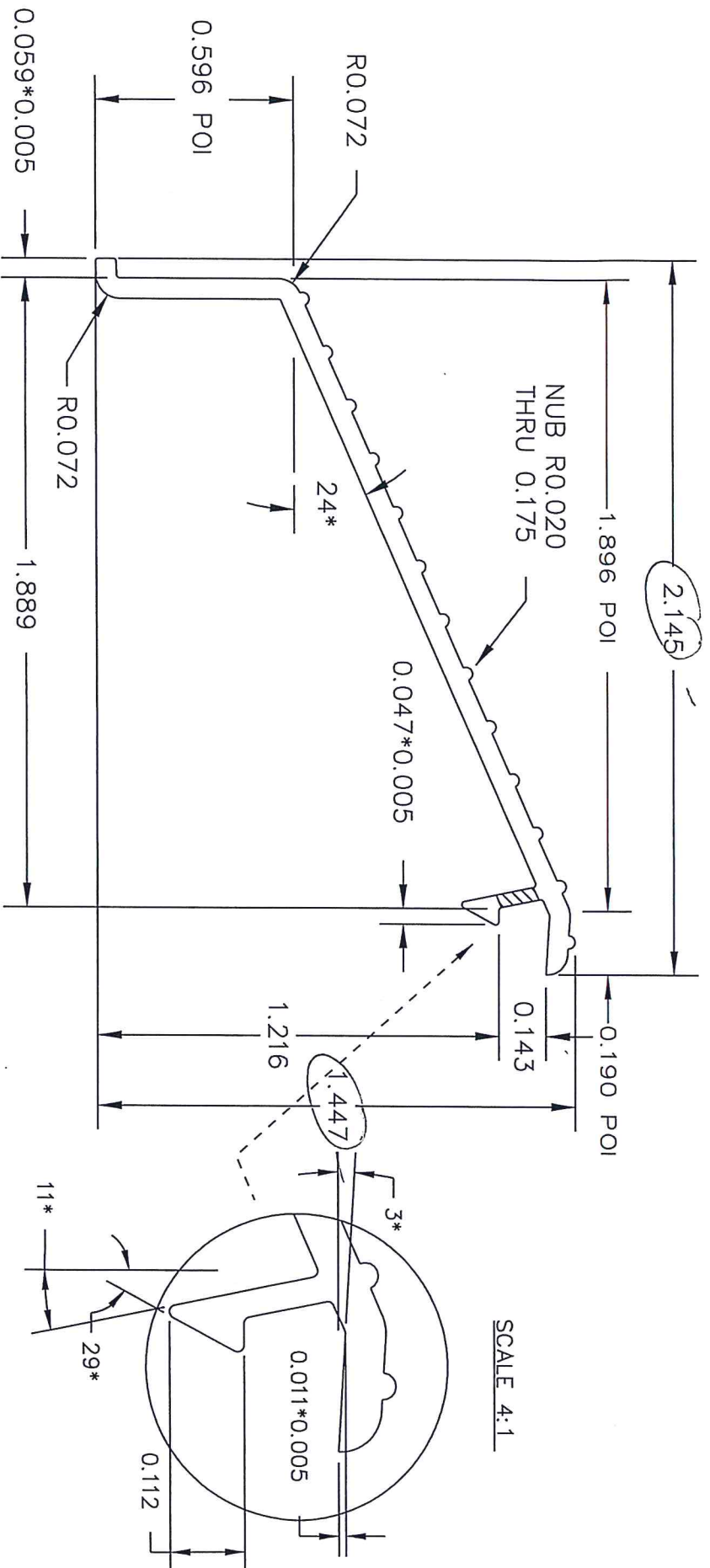
VINYL BUILDING PRODUCTS INC.

AREA = .612 sq in.
TOTAL WEIGHT = .7175 lb/ft.

TOLERANCE ±0.010

| | | | | | | | | |
|--------------------|-----|------|----------|----------|-------|-------------|-------|-----|
| DRAWN | CTC | DATE | 10/28/04 | APPVD | MAT'L | Al 6105 T-6 | SCALE | 2:1 |
| Sash Reinforcement | | | | 10300150 | | | | |

DNA# 10300150



EXPOSED SURFACE
ACTUAL SIZE

NOTES:

1. ALL UNSPECIFIED RADII ARE 0.010.
2. WALL THICKNESS.

- 0.062
 0.040
3. PAINT WITH ALCOA, PPG COLOR UC73603, POLYCRON WHITE.

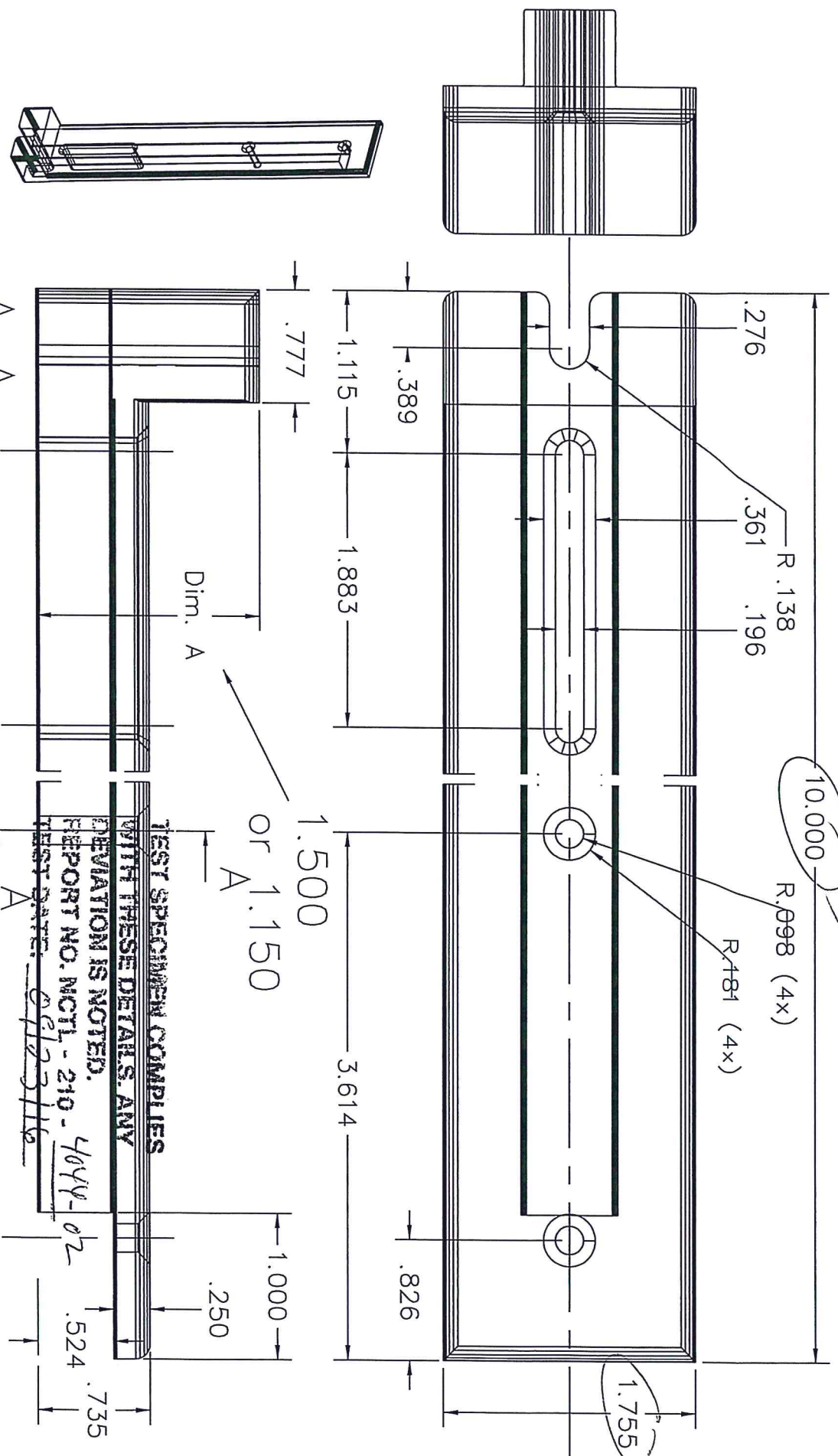
TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4644-02
 TEST DATE: 09/23/16

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

| | | | | | | | | |
|--------------------|----|---------------|----------|--------|-------|--------------------|-------|-----|
| DRAWN | MG | DATE | 12/26/00 | APP'VD | MAT'L | 6061-T6 6105-T5 | SCALE | 2/1 |
| SILL COVER. SLIDER | | ADDED NOTE 3. | | CHANGE | | A 10300171 | | |

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A 011h055-D



COLOR WHITE

| | | | | |
|-----|----|--------|------|--------|
| REV | BY | APPV'D | DATE | CHANGE |
| | | | | |

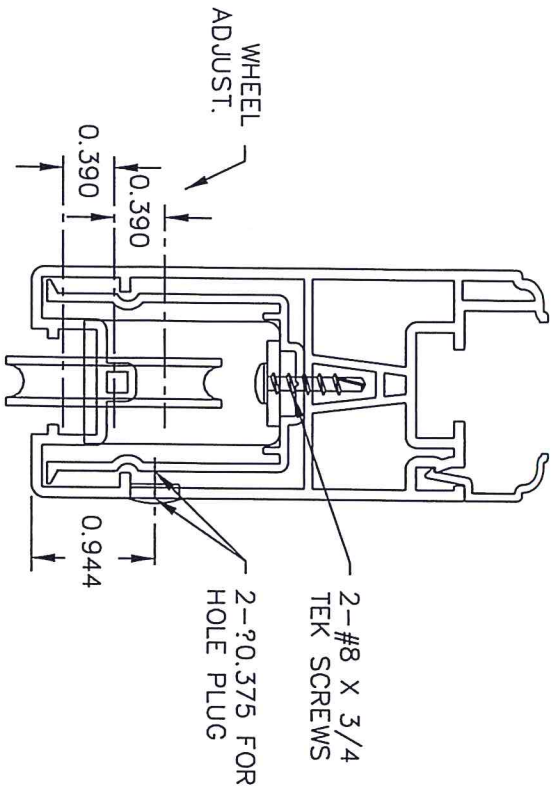


VINYL BUILDING PRODUCTS INC.
 AREA = 8.109 cub in
 WEIGHT =
 TOLERANCES (EXCEPT AS NOTED)
 ±0.010

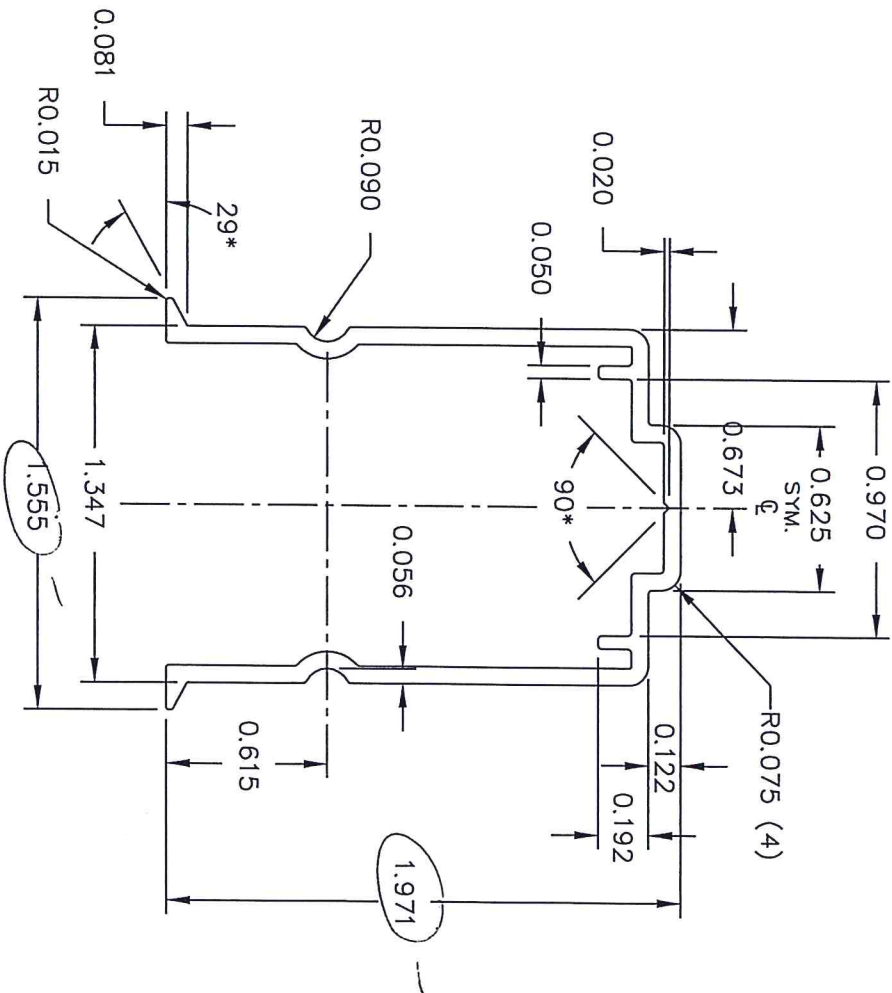
| | | | | | |
|---------|-----|---------|--------|-------|-----------|
| DRAWN | M/G | DATE | APPV'D | MAT'L | SCALE |
| | | 2/25/05 | | NYLON | 1/1 |
| BRACKET | | | | | 011h055-D |

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011H074



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

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.

REPORT NO. VESTRIP 210 - 4044-02
TEST DATE: 6/12/02

| | | |
|-----|----|------|
| REV | BY | DATE |
| - | - | - |



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VINYL BUILDING PRODUCTS LLC

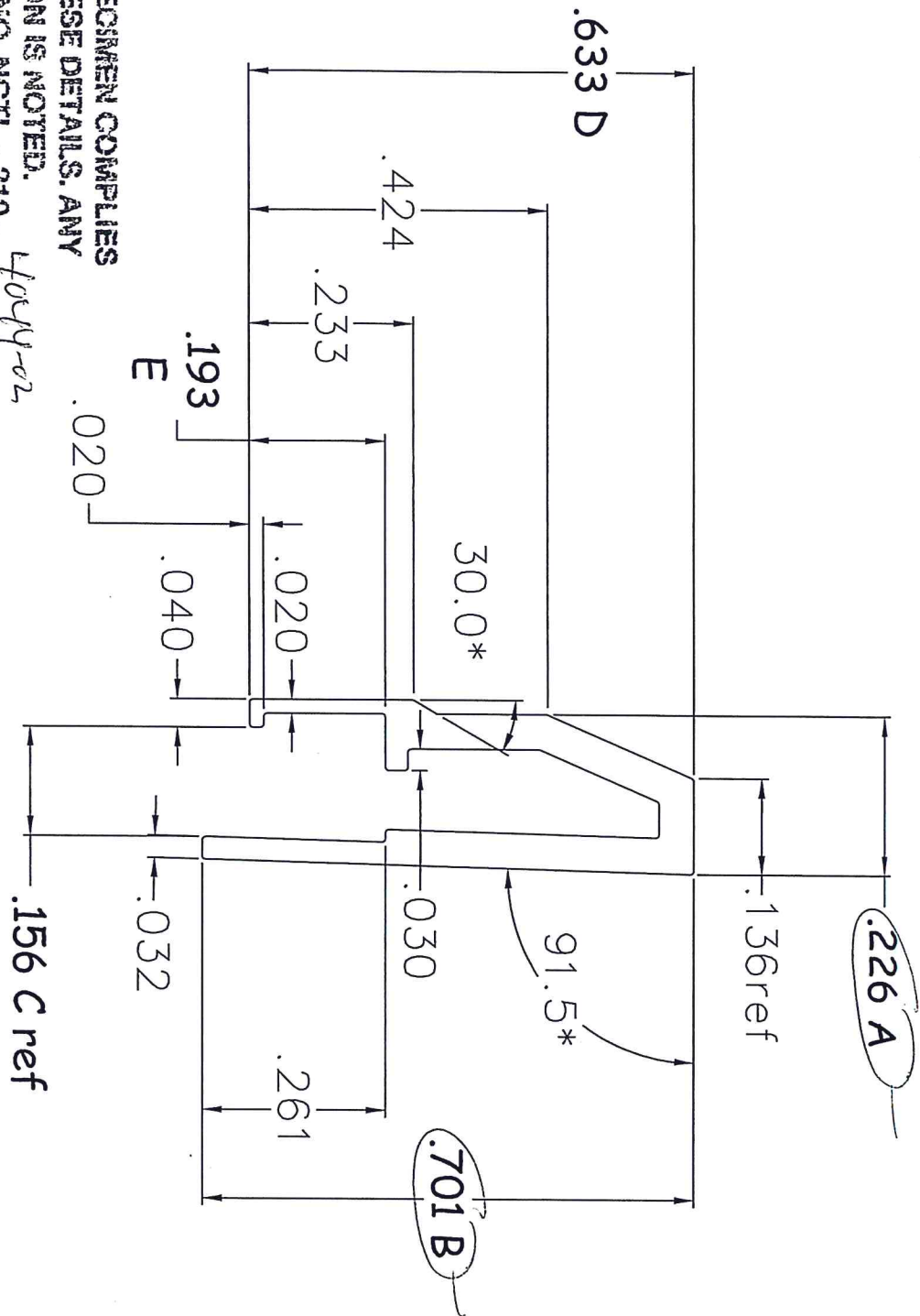
AREA = .359 sq. in.
WT/FT = .431 lb.
PERIM. = 11.200 in.
FACTOR = 26

TOLERANCES (EXCEPT AS NOTED)
AA STANDARDS

| | | | | | |
|--------------------------------|----------|--------|-------|------|-------|
| DRAWN | DATE | APPV'D | MAT'L | NOTE | SCALE |
| RJK | 11-30-05 | | | 1 | FULL |
| RAIL INSERT-SIDE ADJUST ROLLER | | | | | |
| 10300152 | | | | | |

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

| INSPECTION METHODS | |
|--------------------|--------------------|
| 1 | Snop 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 |

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4044-02
 TEST DATE: 09/23/16

PART #: 8052

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| ANNUAL USAGE | |
|--------------|--|
| 1st YEAR | |
| 2nd YEAR | |

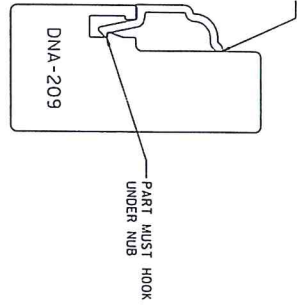
| | | |
|----------|------------------------|----------|
| 06/04/98 | ADDED QC DIM'S | SMD |
| 5/21/98 | odd dims. for angle TC | |
| 5/14/98 | Redrawn for #1013 | T.C. |
| DATE | REVISION RECORD | DRAWN BY |

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

DO NOT SCALE

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

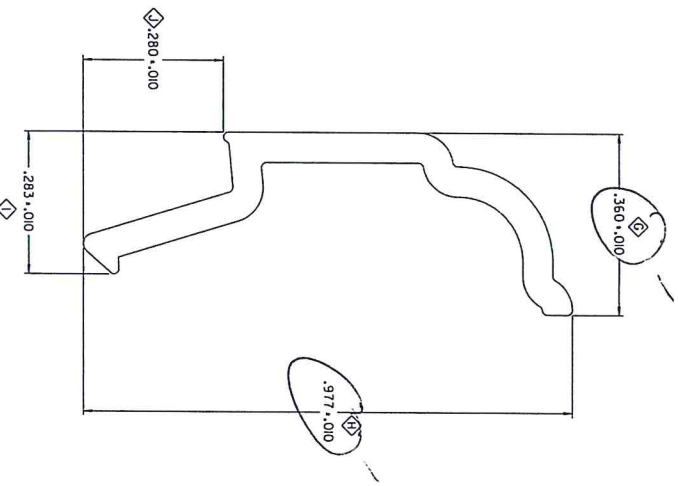
SCALE 1:1



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

WALL THICKNESS
 .060 -

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4044-02
 TEST DATE: 09/23/16



| REVISION HISTORY | | |
|------------------|-------------|----------|
| REV | DESCRIPTION | DATE |
| 0 | ADDED GAUGE | 09/10/15 |

| KEY PRODUCT CHARACTERISTICS | |
|-----------------------------|---------------|
| G | GAUGE DMA-209 |
| H | GAUGE DMA-209 |
| I | GAUGE DMA-209 |
| J | GAUGE DMA-209 |

- NOTES:
1. 'STD0003' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD003 (B)
 3. UNSPECIFIED EXTERNAL RADI = .XXX ± .020 / -.005 (D)
 4. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX ± .02 (E)
 5. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX ± .20 (E)

| | | | | | | | | | | | |
|--|--|---|--|---|--|----------------|--|----------------|--|----------------|--|
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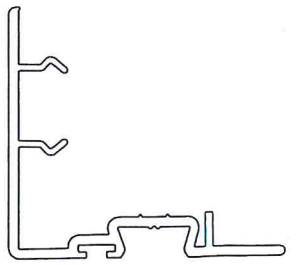
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GLAZING BEAD

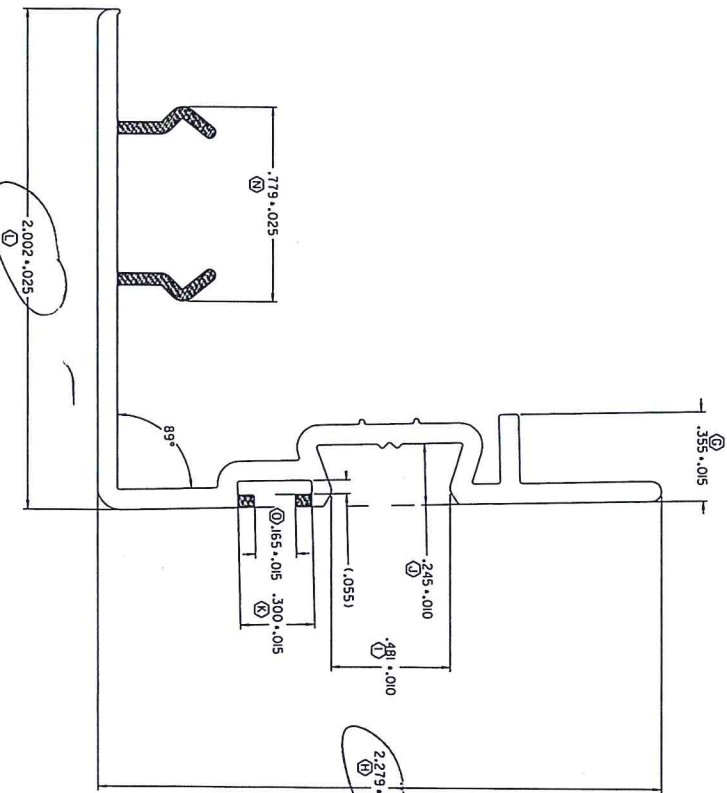
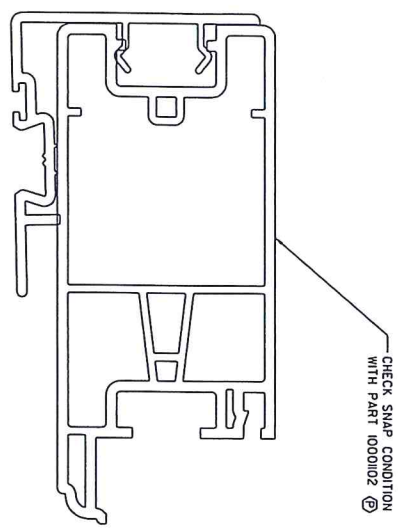
SIZE/DWG. NO: 1000III_SH
 SCALE: 4:1 (BS/FT) .049 SHEET: C

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

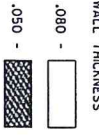
| REVISION HISTORY | | |
|------------------|--------------------------|----------|
| REV | DESCRIPTION | DATE |
| 0 | UPDATE TO CURRENT STANDS | 08/06/24 |
| | | APPROVED |
| | | BWB |



SCALE 1:1



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4019-02
TEST DATE: 09/23/16



- NOTES:
1. STANDARDS: STRUCTURAL CLASS A AND LENGTH TOLERANCES APPLY. (D)
 2. UNTEMPERED TOLERANCE APPLICATIONS PER STD00033 (D)
 3. UNSPECIFIED EXTERNAL RADIUS = .xxx +.020 / -.005 (D)
 4. UNSPECIFIED INTERNAL RADIUS = .xxx +.020 / -.005 (D)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx +/- .102 (D)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx +/- .202 (D)

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UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES
 TOL. ON ANGLES ± 1° 00'
 2 PL. COIN. 3 PL. 1 TO PER
 INTERFER DIA 3 PL. 1 TO PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

| DESIGN BY: | PGM |
|----------------|-----|
| DATE: 06/12/22 | |
| DRAWN BY: JGM | |
| DATE: 07/01/02 | |
| AUTH: DATE: | |
| AUTH: DATE: | |
| FILENAME: | |
| FILE NAME: | |

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 NORTH AMERICA MADE IN USA

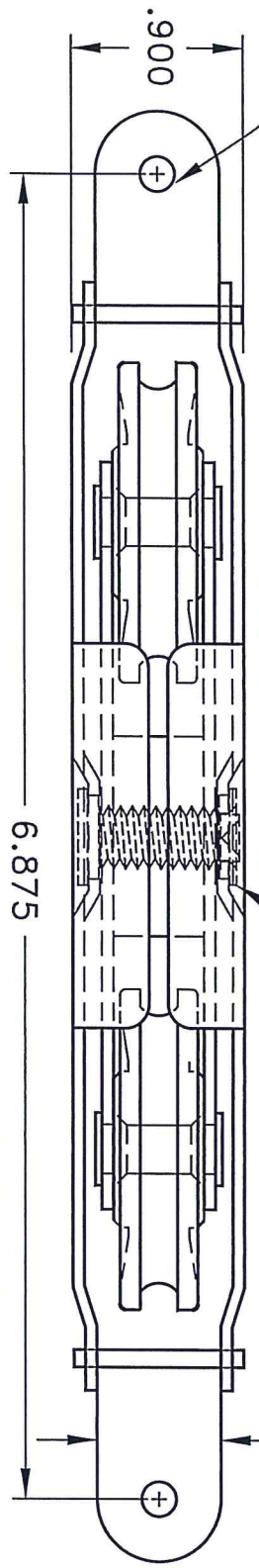
NAME: **SASH ADAPTER**

SIZE/DWG NO: 1000117.SH

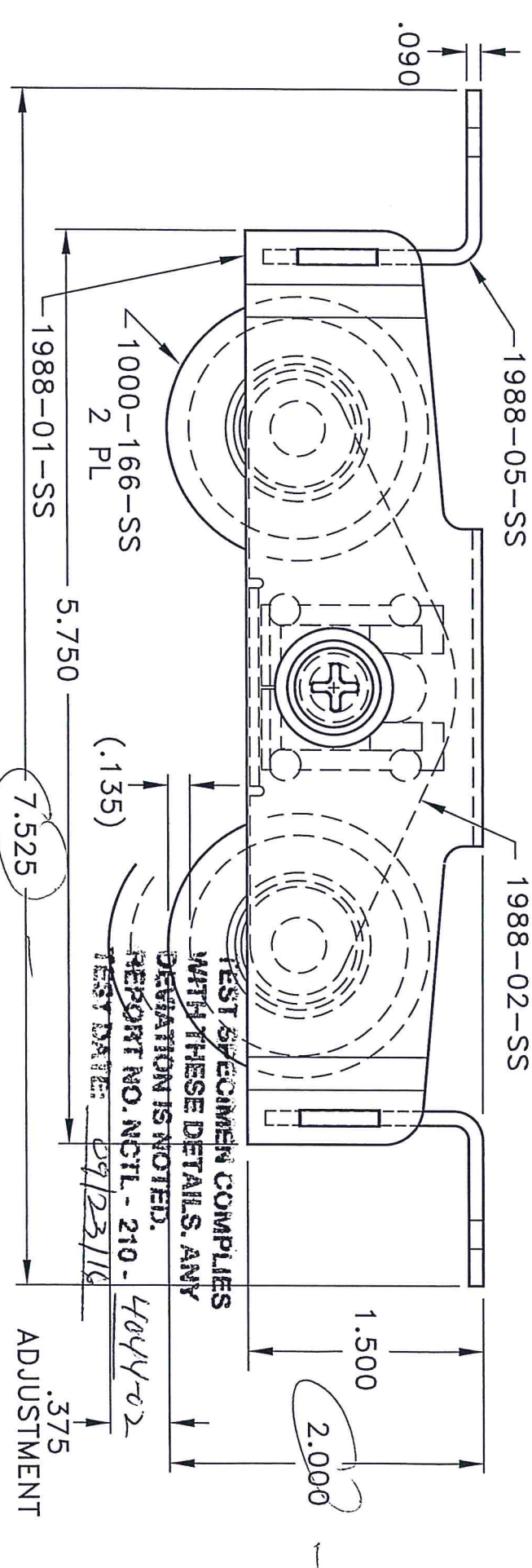
SCALE: 2:1 (BSZFT) .290 SHEET: 1 OF 1

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

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




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



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - TEST DATE: 09/23/16
 4044-02

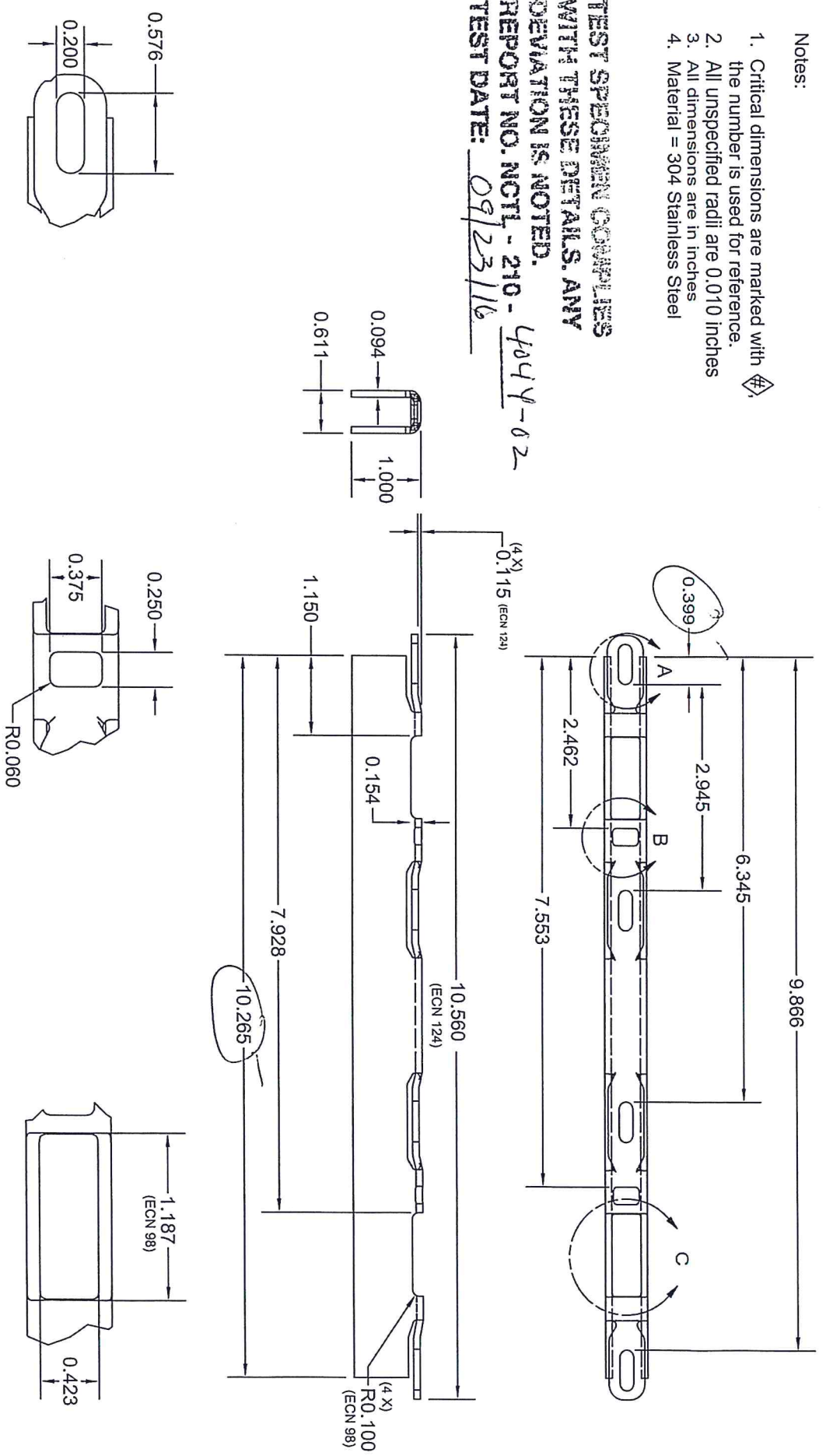
ADJUSTMENT

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 | |  DOOR HARDWARE AMESBURY GROUP | |
| FILE NAME: 1988-8000-REV-SS | APPD | CHKD | JMS NOV-28-05 | TITLE TA-88-BSS-166 W/ REVERSED MTG TAB | SCALE 1/1 |
| | | | DWG. NO. 1988-8000-REV-SS | | |

- Notes:
1. Critical dimensions are marked with \diamond , 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

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 404V-02
TEST DATE: 09/23/16

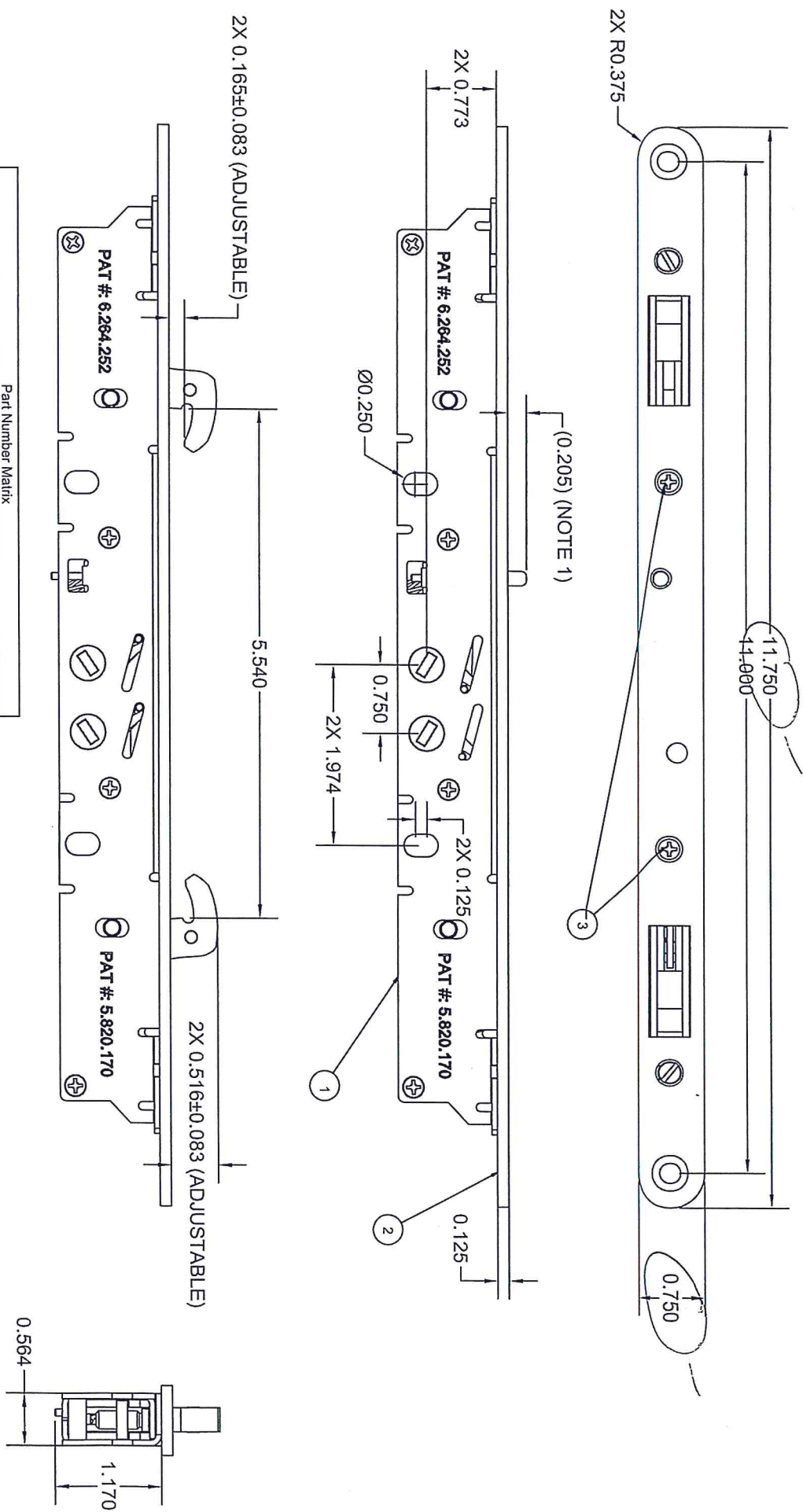


4X DETAIL A
SCALE 1 : 1

2X DETAIL B
SCALE 1 : 1

2X DETAIL C
SCALE 1 : 1

| | | | | | | |
|---|---|---|-------|-----|---|---|
| <p>The information contained in this drawing is the property of Ameshbury Group, Inc. - BSI Hardware and is confidential and proprietary to the company. This drawing is not to be copied or reproduced in whole or in part without the express written permission of the company. The information contained in this drawing is to be used solely for the benefit of Ameshbury Group, Inc. - BSI Hardware and is not to be disclosed or used in the performance of services or manufacture of goods for any other party without the express written permission of Ameshbury Group, Inc. - BSI Hardware.</p> | | | | | | |
| Date | Revision | # | ECN # | By | Date: | <p>DOOR HARDWARE AMESBURY GROUP 1111 West Algonquin Street - Sioux Falls, SD 57104 Phone# (605) 336-1011 FAX# (605) 336-3429</p> |
| 3/10/06 | INITIAL ISSUE | A | 90 | TAE | 1/30/2006 | |
| 3/22/06 | Changed lock and length from 1.170" to 1.187" Added lock slot and hole dimension | B | 98 | TAE | Drawn: leggebraaten Scale: 1:2 | |
| 5/8/06 | Adjusted screw flat depth from 0.037 to 0.115 and adjusted overall length from 10.875 to 10.560 | C | 124 | TAE | Tolerance Decimal: ± .015 Angular: ± 1' | |
| | | | | | Part #: 2778 | Drawing Title: KEEPER GEMINI 1" TALL |
| | | | | | Location: 2778.rdw | SHEET 1 OF 1 |
| | | | | | | Rev: C |



| 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 |

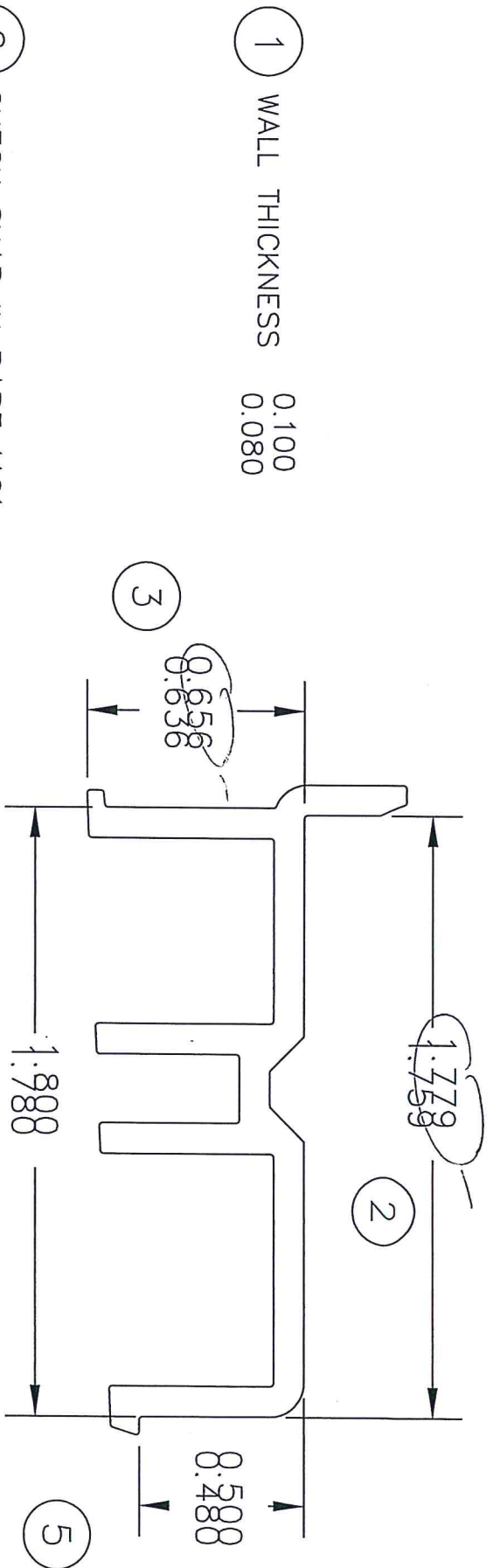
TEST APPROVALS COMPLETES

NOTES:
 1. ANTISLAM 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.

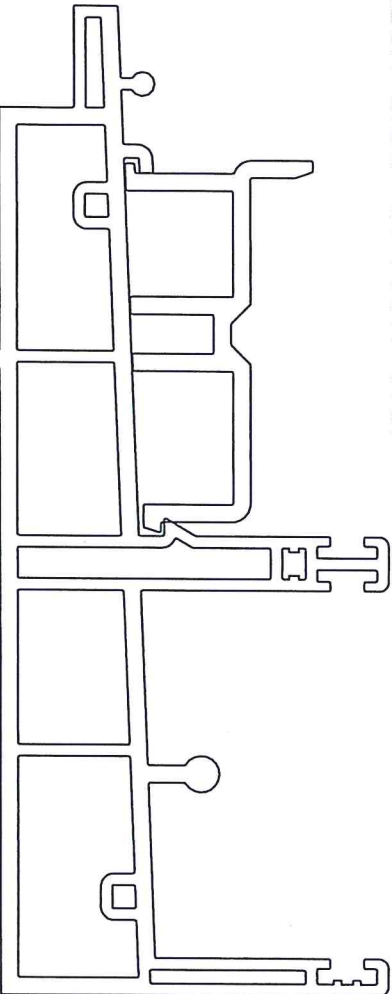
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| | | | | | | | | | | | | | | |
|------------|--------------------------|--|----------|-----------|-----------------|---------------|---------|------|----------------|----------------------------------|----------|-------|----------------|----------------------------------|
| Date | 01/04/07 | WITH THESE REPORTS, ANY REVISIONS TO THIS PART NUMBER MATRIX. REVISION IS NOTED. | # | A | ECN # | 0342 | By | NG | Date: | 1/4/2007 | Drawn: | ngnrf | Drawing Title: | GEMINI II LOCK W/ 2450 TRIMPLATE |
| REPORT NO. | NO. NOTL - 210 - 4644-02 | TEST DATE: | 09/23/16 | Tolerance | Decimal: ± .010 | Angular: ± 1' | Part #: | 2817 | Drawing Title: | GEMINI II LOCK W/ 2450 TRIMPLATE | Sheet of | A | Rev: | A |

POOR HARDWARE
 AMESBURY GROUP
 111 West Broadway Street
 Amesbury, MA 01024
 Phone: (978) 336-1111 Fax: (978) 336-1529



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 404402
TEST DATE: 09/23/16



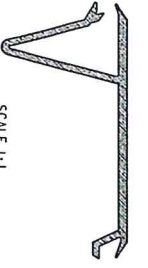
Deceuninck® NORTH AMERICA/Oakland N.J.

AREA= _____ TOL: ±0.010
 TOTAL WEIGHT= _____
 FILENAME: path
 BY DATE DATE MATL SCALE
 CTC 11/14/05 PVC 2:1

deceuninck

| | | | | |
|-----|----|--------|------|--------|
| REV | BY | APPV'D | DATE | CHANGE |
| | | | | |

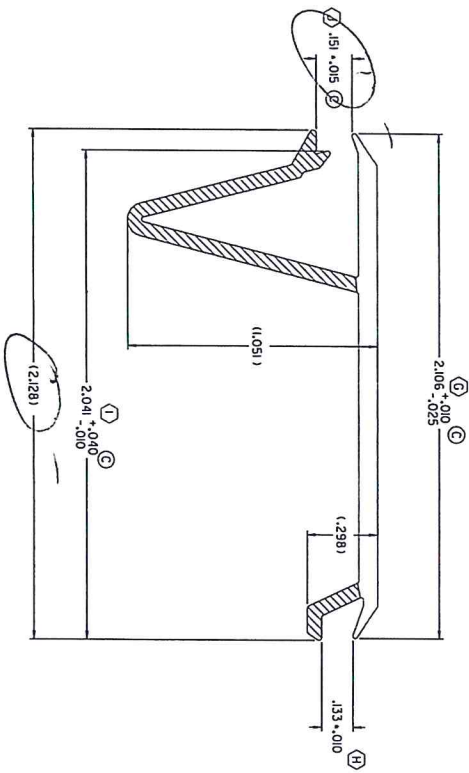
SILL INSERT 10001105_SH



SCALE 1:1

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

| REVISION HISTORY | | | |
|------------------|--------------------------------|----------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| B | ODT-3 | 07/12/04 | DBF |
| C | TOLERANCE CHANGE, WAS +/- .010 | 08/08/05 | JGM |



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4444-02
TEST DATE: 09/23/16

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

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UNLESS OTHERWISE SPECIFIED
 DIM ARE IN INCHES
 TOL ON ANGLES: ° P
 2 PL: +.010° 3 PL: +.0009°
 INTERPRET DIM AND TOL PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY: CTC
 DATE: 05/11/14
 DRAWN BY: CTC
 DATE: 05/11/14
 AUTH: DATE:
 AUTH: DATE:
 FLENAME: 7396.DGN

NAME: **deceuninck** NORTH AMERICA
 31 NORTH GAVEN ROAD
 LEVIE OHIO 43024

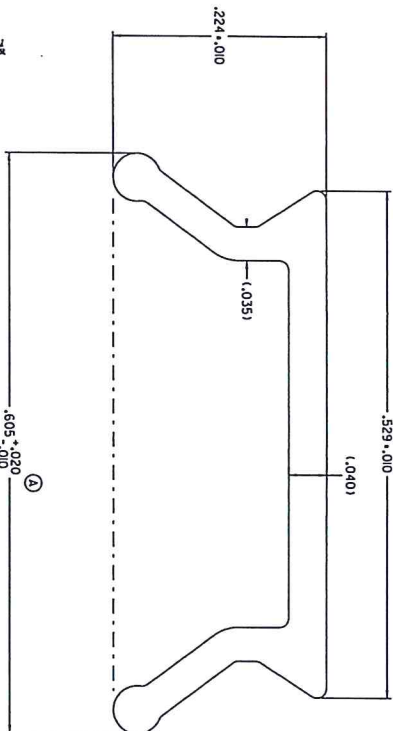
FRAME ADAPTOR
 SIZE DWG. NO: 1000104.SH
 SCALE: 2:1 | CLASS: T1 | .JBT | SHEET: 1

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

| REVISION HISTORY | | | |
|------------------|-------------------|----------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| A | CHANGED TOLERANCE | 07/01/04 | JSM |



SCALE 1:1



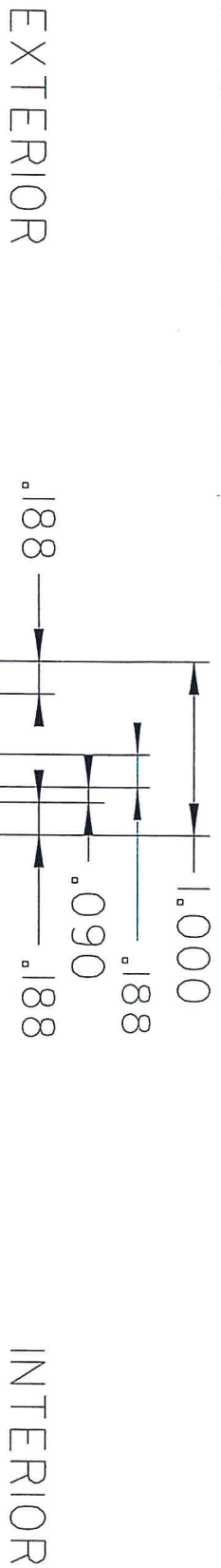
TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NOTL- 210 - 4044-02
TEST DATE: 09/23/16

- NOTES:
1. STANDARD STRAIGHTNESS, CLASS A AND LENGTH TOLERANCES APPLY
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STANDARD
 3. UNSPECIFIED EXTERNAL TOLERANCE FROM +.000 / -.005
 4. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .10%
 5. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .20%
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .10%

| | | | | | |
|---|--|--|--|--|--|
| CONFIDENTIAL | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 2 PL ± 0.010 3 PL ± 0.005 INTERPRET DIM AND TOL PER ASME Y14.5M - 1994 | | THIRD ANGLE PROJECTION | |
| UNPUBLISHED WORK © 2007 DECEUNINCK NORTH AMERICA | | DESIGN BY: PGM DATE: 06/12/22 DRAWN BY: JSM DATE: 07/01/02 AUTH: JSM DATE: AUTH: DATE: AUTH: DATE: FILTERNAME: 10000118_SH.dgn | | STATE: NORTH AMERICA SIZE DWG. NO: 10000118_SH SCALE: B 1:1 (1/8"=1") .023 SHEET: 1 OF 1 | |

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3/16" TEMPERED GLASS
3/8" AIR SPACE
3/16" ANNEALED GLASS
3/16" ANNEALED GLASS
.090" SGP BY DUPONT
QUANEX DURASEAL DR
CARDINAL XL EDGE SPACER
1" OVERALL IG
3/16" TEMPERED SACRIFICIAL PANEL -
3/16" ANNEALED - .090" SGP -
3/16" ANNEALED
QUANEX DURASEAL OR
CARDINAL XL EDGE

| | | | |
|---|---|--|--|
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| | <p>THIRD ANGLE PROJECTION</p> | <p>DATE: 16/09/08 AUTH: DATE: DATE: 16/09/08 AUTH: DATE: DATE: 16/09/08 AUTH: DATE:</p> | <p>DATE: 16/09/08 AUTH: DATE: DATE: 16/09/08 AUTH: DATE:</p> |

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.

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

Certification Standards

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



Quanex warm-edge IG spacer systems are used by our customers to assemble ENERGY STAR® qualified windows and doors.

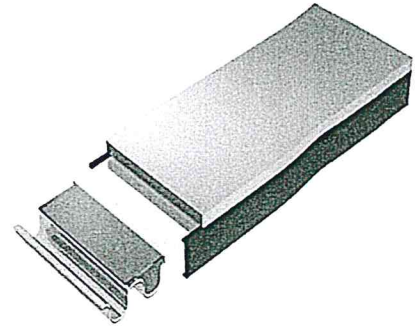


ISO 9001:2008 with design
Certificate Registration 08.185.1

**TEST SPECIMEN COMPLIES
WITH THESE DETAILS. ANY
DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4044-02
TEST DATE: 09/23/16**

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

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.



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.

Colors

Duraseal is available in gray and black.

Sizes

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

Packaging

Returnable/recyclable spools available in disposable packaging.

Shelf Life

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

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.

Availability/Cost

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

| Performance | Norm |
|--|--------------------------|
| Thermal Conductance (Klin) 0.32 W/m° C based on 1/2" (13mm) spacer | |
| Moisture Vapor Transmission Rate 0.09 g H ₂ O/m ² per 24 hrs. | ASTM F 1249 |
| Volatile Fogging Passes | ASTM E 2189 CGSB 12.8 |
| 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. | |

THIS SPECIFICATION COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4044-02
TEST DATE: 09/23/16

TEST SPECIMEN COMPLIES
WITH THESE DETAILS. ANY
DEVIATION IS NOTED.

TREMCO

REPORT NO. NOTL 210

4044-02

Silicone

TEST DATE: 09/23/16

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.

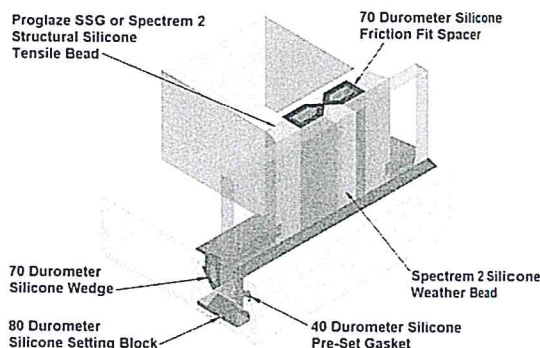
Availability/Cost

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.

Warranty

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 TEST METHOD | 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 (7.3 MPa) | 1139 psi (7.8 MPa) | 1075 psi (7.4 MPa) | 1095 psi (7.6 MPa) |
| Elongation @ Rupture | D 412 | 323% | 235% | 167% | 113% |
| Tear Strength | D 624 | 120 lb/in (21.0 kN/m) | 107 lb/in (18.7 kN/m) | 121 lb/in (21.2 kN/m) | 92 lb/in (16.1 kN/m) |
| Brittleness Temperature @ -40°K (-40°C) | D 746 | Pass | Pass | Pass | Pass |



Tremco Commercial Sealants & Waterproofing

3735 Green Road, Beachwood, OH 44122 // Phone: 216.292.5000 // 800.321.7906
220 Wicksteed Avenue, Toronto, ON M4H 1G7 // Phone: 416.421.3300 // 800.363.3213
1451 Jacobson Avenue, Ashland OH 44805 // Phone: 419.289.2050 // 800.321.6357

An **RPM** Company

www.tremcosealants.com

0612/SGSKTSD Page 1 of 1

Sikaflex® -552

High-Strength Structural Assembly Adhesive

Technical Product Data (typical values)

| | | |
|--|------------------------------------|----------------------------------|
| Chemical base | 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 ¹ | 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 | Permanent | -40°F to +190°F (-40°C to +90°C) |
| Short term | 4 hours | 284°F (140°C) |
| | 1 hour | 302°F (150°C) |
| Shelf life (storage below 80°F (25°C)) | Cartridge & Unipac | 9 months |
| | Drum & Hobbock | 6 months |

¹) 73°F (23°C) / 50% r.h.

Description

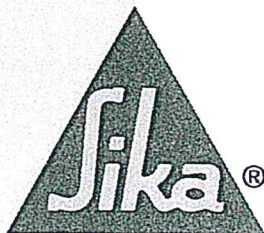
Sikaflex®-552 is a low VOC, high performance, elastic, gap-filling, one-part, silane-terminated polymer structural adhesive that cures on exposure to atmospheric moisture to form a durable elastomer. Sikaflex®-552 contains no isocyanate or solvent. Sikaflex®-552 is manufactured in accordance with the 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.



TEST SPECIMEN COMPLIES
WITH THESE DETAILS. ANY
DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4044-02
TEST DATE: 09/23/16

Cure Mechanism

Sikaflex®-552 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is lower and the curing reaction proceeds a little more slowly. If Sikaflex®-552 is used in combination with a PUR adhesive, the polyurethane adhesive must be fully cured before seam sealing with Sikaflex®-552.

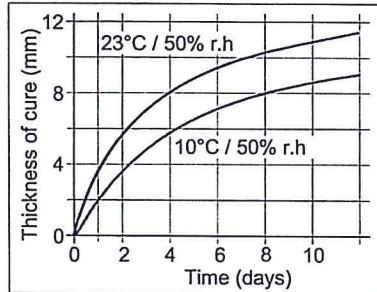


Diagram 1: Curing speed Sikaflex®-552

Chemical Resistance

Sikaflex®-552 is resistant to UV radiation, fresh water, seawater and proprietary aqueous cleaning agents; temporarily resistant to fuels, mineral oils, vegetable and animal fats and oils; not resistant to organic acids, concentrated mineral acids, caustic solutions or solvents. The above information is offered for general guidance only. Advice on specific applications will be given on request. Contact the Technical Service Department of Sika Industry 888-832-7452.

Method of Application

Surface preparation

The Surfaces must be clean, dry and free from all traces of grease, oil, wax and dust. The adhesion of Sikaflex®-552 can be improved by wiping the joint with Sika®Cleaner-226 (a cleaning and activating agent). Advice on specific applications is available from the Technical Service Department of Sika Industry at 888-832-7452. Substrate must have appropriate corrosion protection prior to application of sealant.

Application

To ensure satisfactory conditions for curing, do not apply at temperatures below 40°F (5°C) or above 95°F (35°C). The optimum temperature for substrate and sealant is between 60°F (15°C) and 75°F (25°C). For advice on selecting and setting up a suitable pump system please contact the System Engineering Department of Sika Industry at 248-577-0020.

Tooling and finishing

To facilitate tooling, wet pointing tool with soapy water. Do not use alcohol or alcohol-containing agents.

Removal

Uncured Sikaflex®-552 may be removed from tools and equipment with suitable solvent. Follow solvent manufacturer's instructions for use and warnings. Once cured, the material can only be removed mechanically. Wash hands thoroughly with soap and water after handling. Do not use solvents!

Overpainting

Sikaflex®-552 can be overpainted before becoming tack-free. The paint, and paint process must be tested for compatibility by carrying out preliminary trails. It should be understood that the hardness and film thickness of the paint may impair the elasticity of the sealant and lead to cracking of the paint film over time.

Limitations

Avoid application below 40°F (5°C) and above 95°F (35°C) as improper surface properties could result. Since the material is moisture cured, provide sufficient exposure to air. Do not apply over cured silicones or in the presence of curing silicones or urethanes. Avoid contact with excessive amounts of alcohols or alcohol-containing mixtures, as some temporary initial surface tackiness may result. Not designed for direct glazing applications.

CAUTION: IRRITANT. - Contains Silane-Terminated Prepolymer (CAS: Mixture). May cause eye/skin/respiratory irritation.

HMIS

| | |
|---------------------|---|
| Health | 2 |
| Flammability | 1 |
| Reactivity | 0 |
| Personal Protection | C |

FIRST AID

Eyes - Hold eyelids apart and flush thoroughly with tepid water for 15 minutes. **Skin** - Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and tepid water. **Inhalation** - Remove to fresh air. **Ingestion** - Do not induce vomiting. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

Further Information

Copies of the following publications are available on request at SikaFax: 877-663-9727

- Material Safety Data Sheets
- Technical Data Sheets

In case of emergency call:

Chemtrec: 800-424-9300
International: 703-527-3887

**KEEP OUT OF REACH OF CHILDREN
NOT FOR INTERNAL CONSUMPTION
FOR INDUSTRIAL USE ONLY
KEEP CONTAINER TIGHTLY CLOSED**

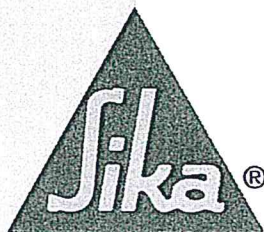
Packaging Information

| | |
|-----------|-------------|
| Cartridge | 10.5 ounce |
| Unipac | 20 ounce |
| Hobbock | 6 gallon |
| Drum | 51.5 gallon |

HANDLING AND STORAGE: Store product in closed container in cool dry place (below 77°F, 25°C) when not in use. Protect from frost and humidity. Avoid direct contact. Wear personal protective equipment (chemical resistant gloves/goggles/clothing) to prevent contact with skin and eyes. Use with adequate

Further information available at:
www.sikaindustry.com
SikaFax: 877-663-9727

Sika Corporation
Industry Division
30800 Stephenson Highway
Madison Heights, MI 48071
USA
Tel. 248 577 0020
Fax 248 577 0810



**TEST SPECIMEN COMPLIES
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REPORT NO. NCTL - 210 - 4044-02
TEST DATE: 09/23/16



general and local exhaust. Use properly fitted NIOSH respirator if ventilation is poor. Remove contaminated clothing and launder before reuse.

CLEANUP: Avoid contact. Uncured material can be removed from tools and equipment using suitable solvent. Follow solvent manufacturer's warnings and instructions for use. Cured product can only be removed mechanically. Wash thoroughly with soap and water after handling. Do not use solvents! In case of spill, wear personal protective equipment (chemical resistant goggles/clothing/gloves). Ventilate area and collect spill. If ventilation is poor use properly fitted NIOSH respirator. Contain spill and collect with absorbent material. Dispose of in accordance with applicable local, state and federal regulations.

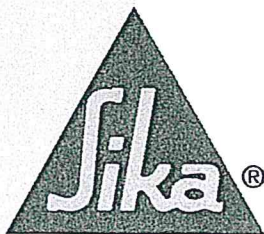
LIMITED WARRANTY

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Technical Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor.

NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.

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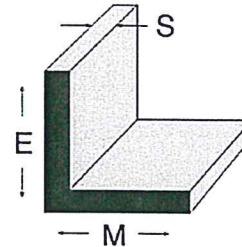
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TEST DATE: 09/23/14



Architectural Aluminum Angle

6063-T52 x 20' Equal Leg

| <u>Stock Code</u> | <u>Size in Inches (E x M x S)</u> | <u>Approx. Wt/Lin ft.</u> |
|-------------------|---|---------------------------|
| 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 |



6063-T52 Unequal Leg

| <u>Stock Code</u> | <u>Size in Inches (E x M x S)</u> | <u>Approx. Wt/Lin ft.</u> |
|----------------------------------|------------------------------------|---------------------------|
| 11-63-350 | 1/2 x 1 x 1/8 | 0.206 |
| <u>MILL ORDER</u> 11-63-479 (NC) | 1/2 x 1-1/4 x 1/8 | 0.244 |
| <u>MILL ORDER</u> 11-63-351 (NC) | 1/2 x 1-1/2 x 1/8 | 0.281 |
| 11-63-351A | 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 |
| 11-63-269 | 1 x 1-1/2 x 1/8 | 0.356 |
| 11-63-365 | 1 x 2 x 1/16 | 0.218 |
| 11-63-370 | 1 x 2 x 1/8 | 0.431 |
| 11-63-375 | 1 x 3 x 1/8 | 0.582 |
| 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 |

**TEST SPECIMEN DOWNPLING
WITH THESE DETAILS. ANY
DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4648-02
TEST DATE: 09/23/16**

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 09



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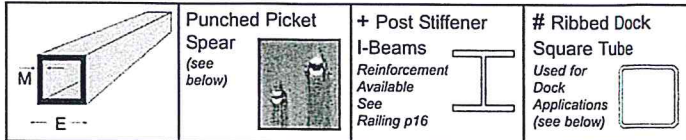
e-mail: info@EasternMetal.com

version: 12/05/13

Square Aluminum Tube

6063-T52 x 24' (Unless noted otherwise)

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.



| Stock Code | Size in Inches (E x M x S) | Approx. Wt/Lin ft. | Stock Code | Size in Inches (E x M x S) | Approx. Wt/Lin ft. |
|-------------------|--|--------------------|--------------------|---|--------------------|
| 19-63-100 | .500 x .062 x 20' | 0.131 | 19-63-208 (FL) | 2 x .125 (w/ .25 Outside Rad - .125 Inside Rad) | 1.076 |
| 19-63-471 | .625 x .062 x 20' | 0.168 | 19-63-209 | 2 x .125 (w/.125 radius) | 1.109 |
| 19-63-090 (FL) | .735 x .045 x 16' 6" | 0.168 | 52-61-1768 (NC/DE) | 2 x .125 x 32' (6005-T5) (w/.125 rad) | 1.109 |
| 19-63-095 | .735 x .045 | 0.168 | 19-63-210 | 2 x .125+ | 1.126 |
| 19-63-085 (FL) | .750 x .040 (w/ .093 radius) | 0.131 | 25-BD-315 | 2 x .125 Polished BDA (w/radius) x 20' | 1.126 |
| 19-63-089 | .750 x .045 x 16' 8" (w/radius) | 0.168 | 19-61-210 | 2 x .125 x 22' 6" (6061-T6)+ | 1.126 |
| 19-63-101 | .750 x .045 x 18' 8" (w/radius) | 0.168 | 52-61-936 (FL) | 2 x .125 (6061-T6)+ | 1.126 |
| 19-63-105PS1 | .750 x .062 x 58" Punched Picket Spear | | 30-05-200 (NC/DE) | 2 x .125 (Ribbed Dock Tube, w/rad) x 32' # | 0.994 |
| 19-63-105PS2 | .750 x .062 x 70" Punched Picket Spear | | 19-61-208 (FL) | 2 x .188 (6061-T6) | 1.634 |
| 19-63-525 (NC) | .750 x .062 x 16' | 0.206 | 19-63-211 | 2 x .188+ | 1.627 |
| 19-63-106 (MO) | .750 x .062 x 21' (w/radius) | 0.196 | 52-61-1128 | 2 x .188 x 20' (w/radius/6061-T6)+ | 1.530 |
| 19-63-108 (MO) | .750 x .062 x 22' (w/radius) | 0.196 | 19-61-212 | 2 x .250 (6061-T6) | 2.100 |
| 19-63-105 | .750 x .062 | 0.206 | 52-61-1520 | 2 x .250 (w/radius/6061-T6) | 2.052 |
| 19-63-107 | .750 x .062 (w/.090 radius) | 0.206 | 19-63-215 | 2.250 x .095 | 0.982 |
| 19-63-110 | .750 x .093 | 0.293 | 52-61-1040 | 2.45 x .250 x 18' (w/radius/6061-T6) | 2.640 |
| 19-63-113 | .750 x .093 (w/radius) | 0.293 | 19-63-714 | 2.500 x .075 | 0.855 |
| 19-63-115 | .750 x 1/8 | 0.374 | 19-63-807 (DE) | 2.500 x .093 | 1.074 |
| 19-63-116 | .750 x 1/8 (.062 radius) | 0.374 | 19-63-221 | 2.500 x .125 | 1.425 |
| 19-63-821 (DE) | 1 x .047 | 0.214 | MILL ORDER | 2.500 x .188 (6063-T6) 52-61-3402 (FL)+ | 2.076 |
| 19-63-130 | 1 x .062 | 0.278 | 19-61-534 (NC/DE) | 2.7 x .125 x 20' (w/radius/6061-T6) | 1.490 |
| 19-63-130PS1 | 1 x .062 x 58" Punched Picket Spear | | 19-63-230 (FL) | 3 x .093 | 1.298 |
| 19-63-130PS2 | 1 x .062 x 70" Punched Picket Spear | | 19-63-231 | 3 x .093 x 27' | 1.298 |
| 19-63-131 | 1 x .062 (w/radius) | 0.268 | MILL ORDER | 3 x .100 (T5 w/rad) 242-005 (MO) | 1.380 |
| 19-63-136 (NC/MO) | 1 x .075 (w/radius) | 0.317 | 19-63-235 | 3 x .125 | 1.726 |
| 19-63-341 | 1 x .093 | 0.405 | 19-61-535 (NC/MO) | 3 x .125 x 20' (w/rad/6061-T6) | 1.670 |
| 19-63-345 | 1 x .093 (w/radius) | 0.392 | 19-63-237 (FL) | 3 x .125 (w/.125 radius) | 1.709 |
| 19-63-140 | 1 x .125 | 0.524 | 30-05-205 (NC/DE) | 3 x .125 (Ribbed Dock Tube, w/rad) x 20' # | 1.546 |
| 19-61-140 | 1 x .125 (6061-T6) | 0.524 | 52-61-749 | 3 x .188 x 18' (w/rad/6061-T6) | 2.502 |
| 19-63-141 | 1 x .125 (w/radius) | 0.509 | 52-63-8188 (FL) | 3 x .188 (w/rad/6063-T6) x 25' | 2.502 |
| 25-BD-310 | 1 x .125 Polished BDA (w/rad) x 20' | 0.509 | 19-63-240 (NC) | 3 x .188 | 2.533 |
| 19-63-153 | 1.250 x .062 | 0.353 | 19-61-340 | 3 x .250 (6061-T6) | 3.300 |
| 19-63-150 | 1.250 x .093 | 0.516 | 51-63-897 | 3 x .250 x 18' 3" (w/rad) | 3.204 |
| 19-61-150 | 1.250 x .093 (6061-T6) | 0.516 | 52-63-8441 | 3 x .250 x 25' (w/rad/6063-T6) | 3.204 |
| 19-63-155 | 1.250 x .125 | 0.675 | 52-61-750 | 3 x .250 x 18' (w/rad/6061-T6) | 3.204 |
| 19-63-157 | 1.250 x .125 x 20' (w/radius) | 0.643 | 19-63-245 | 4 x .125 | 2.324 |
| 19-63-160 | 1.500 x .060 | 0.430 | 56-63-003 (FL) | 4 x .125 (w/rad 204R1 Anod) x 24' 2" | 2.374 |
| 19-63-161 (FL) | 1.500 x .062 (w/ .093 radius) | 0.420 | 56-63-010 (FL) | 4 x .150 (w/rad 204R1 Anod) x 22' | 2.772 |
| 19-63-161 (TX) | 1.500 x .062 (w/ .125 radius) | 0.416 | 19-61-250 | 4 x .250 (6061-T6) | 4.500 |
| 19-63-165 | 1.500 x .093 | 0.632 | 56-MF-035 (FL) | 4.5 x .093 (w/.125 radius) | 1.955 |
| 19-63-170 | 1.500 x .125 | 0.824 | 19-63-255 | 5 x .125 | 2.925 |
| 19-61-170 | 1.500 x .125 (6061-T6) | 0.824 | 19-61-258 | 5 x .250 (6061-T6) | 5.700 |
| 19-63-172 | 1.500 x .125 (w/.125 radius) | 0.809 | MILL ORDER | 5.5 x .204 (T6 w/rad) 19-63-721 (NC) | 5.173 |
| 19-63-174 (TX) | 1.500 x .188 | 1.184 | 19-63-260 | 6 x .125 | 3.525 |
| 19-61-173 | 1.500 x .250 (6061-T6) | 1.500 | 56-63-037 (FL) | 6 x .150 x 24' 6" (6063-T6 w/rad 204R1 Anod) | 4.204 |
| 52-61-1045 | 1.500 x .250 x 18' (w/rad/6061-T6) | 1.461 | MILL ORDER | 6 x .180 x 20' (T6 w/rad) 52-63-1843 (FL) | 5.076 |
| 19-63-180 | 1.750 x .093 | 0.732 | MILL ORDER | 6 x .188 (w/rad, 6063-T6) 52-63-12856 (FL) | 5.245 |
| 19-61-180 | 1.750 x .093 (6061-T6) | 0.732 | 19-61-260 | 6 x .25 | 6.900 |
| 19-63-185 | 1.750 x .125 | 0.975 | MILL ORDER | 6 x .50 x 12' (w/rad/6063-T6) 19-63-480 (NC) | 12.936 |
| 19-63-192 (FL) | 2 x .062 | 0.604 | MILL ORDER | 6.75 x .188 | 5.804 |
| 19-63-191 | 2 x .062 x 26' | 0.604 | 19-63-262 | 7 x .156 (6063-T6) | 5.120 |
| 19-61-206 (FL) | 2 x .093 (6005 T5) | 0.851 | 19-63-265 | 8 x .188 | 7.050 |
| 19-61-205 | 2 x .093 x 26' (6005-T5) | 0.851 | MILL ORDER | 8 x .50 x 40' (6061-T6 w/rad) 52-61-3166 (FL) | 17.650 |
| 52-63-11425 (FL) | 2 x .093 (with radius) | 0.836 | 19-63-300 (FL) | 10 x .250 x 24' (6063-T6 w/rad) | 11.700 |

Standards 15



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