



element™

Element Materials Technology
115 South 84th Ave
Wausau, WI 54401, USA
407-505-8102

Report Number: ESP009160P-7
Report Date: April 23, 2012

STRUCTURAL PERFORMANCE TEST REPORT

Test Requested By: Deceuninck North America, LLC
351 North Garver Road
Monroe, Ohio 45050

Product Type and Series: Series 623.620PD-005 Vinyl Rep. Equal Leg Frame Non Impact Sliding Glass Door
4877mm x 2438mm (192.00" x 96.00")

Test Specifications: Test Specifications: AAMA/WDMA/CSA 101/I.S.2/A440-05
"Standard/Specification for Windows, Door and Unit Skylights".

Primary Product Designator: SD-C50 4877mm x 2438mm (192" x 96")
Positive Design Pressure = 2403 Pa. (50.0 psf.)
Negative Design Pressure = 2403 Pa. (50.0 psf.)
Water Penetration Resistance Test Pressure = 362 Pa. (7.5 psf.)

Test Specimen

Configuration: O/X/X/O Two (2) operable panels / Two (2) fixed panels.

Frame Construction: The extruded vinyl main equal leg frame measured 4877mm wide x 2438mm high (192.00" wide x 96.00"). The frame corners utilized coped and butted corner construction, secured with three (3) # 8 x 76mm(3.00") Phillips PH fasteners. The frame head and jamb extrusions measured 5.008" wide x 51mm(2.007") high (refer to drawing # 10001100_SH). The frame sill extrusion measured 127mm(5.088") wide x 51mm(2.007") high (refer to drawing #10001101_SH). The frame sill had vinyl fixed panel riser running full length of each fixed panel that measured 46mm(1.800") wide x 26mm(1.020") high and secured to frame utilizing #8 x 32mm(1.250") Phillips CS self-drilling SMS (refer to drawing # 10001105_SH).



Panel Construction: The operable panels measured 1243mm(48.9375") wide x 2369mm(93.250") high overall. The fixed panels measured 1243mm(48.9375") wide x 2369mm(93.250") high overall. The panels utilized mitered and welded corner construction. The vinyl sash stiles and rails measured 45mm(1.755") wide x 102mm(4.000") high (*refer to drawing # 10001102_SH*). The operable and fixed panel interlock stiles had an interlocking vinyl sash adapter measuring 51mm(2.002") wide x 58mm(2.279") high (*refer to drawing # 10001117_SH*) secured through the stile with nine (9) #8 x 16mm(0.625") Phillips PH self-drilling SMS located 102mm(4") from top and bottom of panel and a maximum of 305mm(12") on center thereafter. The fixed panels were secured to frame head/sill with an aluminum (L) shaped bracket measuring 40mm(1.575") wide x 85mm(3.346") high overall (*refer to drawing # 011H027*) and was secured to fixed panel interlock stile with two (2) #8 x 25mm(1.00") Phillips CS self-drilling SMS and to frame head/sill utilizing two (2) #8 x 19mm(0.750") Phillips CS self-drilling SMS and two (2) #8 x 64mm(2.500") Phillips CS fasteners. The fixed panels each had three (3) aluminum snubbers each measuring 45mm(1.780") wide x 32mm(1.242") high x 762mm(30") long. Two (2) were secured to the top and bottom of the frame jamb at each fixed panel location with six (6) #8 x 32mm(1.250") Phillips F.H. self-tapping S.M.S. The other one (1) aluminum snubber was located at the frame head at the corner of each fixed panel and interlock. This one (1) snubber utilized no fasteners and was inserted between the frame head pocket and fixed panel sash rail (*refer to drawing # 10300148*). Two (2) vinyl brackets measuring 45mm(1.755") wide x 254mm(10.00") high x 6mm(.250") thick located at top and bottom of interlock stile secured to the operable panel with three (3) #8 x 52mm(2.50") Phillips CS self-drilling SMS (*refer to drawing # 011H055*). Two (2) aluminum tracks/guides were located at frame head of the operable panel track pocket c/l of the operable panel. The tracks/guides measured 47mm(1.856") wide x 29mm(1.160") high x 305mm(12.00") long. Each track/guide was secured to the frame head with eight (8) #8 x 64mm(2.500") Phillips F.H self-tapping S.M.S. The four (4) lite vinyl astragal measured 58mm(2.275") wide x 60mm(2.354") high (*refer to drawing # 10001116*). The four (4) lite vinyl astragal was secured to the panel with eight (8) #8 x 52mm(2.00") Phillips P.H.S.M.S. The fasteners were located at 127mm(5.00") from the each end of the vertical astragal and 305mm(12.000") on center thereafter.

Daylight opening: Daylight opening for the operable panels measured 1035mm(40.750") wide x 2159mm(85.000") high. The daylight opening for the fixed panels measured 1035mm(40.750") wide x 2159mm(85.000") high.

Glazing: 25mm (1.000") overall insulated glass consisting of the following: One (1) exterior piece of 3.2mm (.125") tempered glass/ Super Seal Spacer System and one (1) Interior piece of 3.2mm (.125") tempered glass. Exterior glazed with silicone back bedding compound. The glazing utilized an exterior vinyl snap-in glazing bead measuring 7.2mm (.283") wide x 25mm (.977") high overall with a 16mm (.625") glass bite.

Reinforcement: One (1) H shaped aluminum reinforcement measuring 50mm (1.971") wide x 39mm (1.555") high x full length was located in each fixed panel astragal stile, fixed panel interlock stile and operable panel interlock stile. The fixed panel interlock reinforcement and the operable interlock reinforcement were secured with nine (9) #8 x 25mm (1.00") Phillips PH self-drilling SMS (*refer to drawing # 10300151*). The fixed panel astragal reinforcement was free floating with no fasteners. One (1) free floating aluminum reinforcement measuring 50mm (1.965") wide x 39mm (1.555") high x full length was located in each fixed panels jamb stile and operable panel interlock stile (*refer to drawing # 10300150*).



Weep System: Four (4) weep notches that measured 25mm(1.00") wide x 6mm(.250") high were located as follows. One (1) at the corner of the exterior face of the frame sill and one (1) at the corner of the interior track leg of the frame sill. Each weep notch measured 76mm(3.00") c/l from the frame jamb/sill corner connection.

Weather-stripping:

<u>Quantity</u>	<u>Description</u>	<u>Location</u>
Three (3) strips	Fin seal 9mm(.270") wide x 6mm(.250") high	Two (2) operable panel track and one (1) fixed panel track of frame head
Three (3) strips	Fin seal 9mm(.270") wide x 6mm(.250") high	Two (2) operable panel track and one (1) fixed panel track of frame sill
Four (4) strips	Fin seal 9mm(.270") wide x 6mm(.250") high	Interior panel tracks of frame jambs and frame head
One (1) strip	Fin seal 9mm(.270") wide x 6mm(.250") high	Operable and fixed panel interlock

Hardware:

<u>Quantity</u>	<u>Description</u>	<u>Location</u>
Four (4)	Steel front adjustable tandem roller, 42mm(1.66") OD wheels, each secured with two (2) # 8 x 25mm(1.00") Phillips PH SMS	Each operable panel bottom rail corner
Two (2)	Inside/Outside Pull Handle	Located at lock stile of the operable panel
One (1)	Gemini II Lock with 2450 Trimplate, secured with two (2) # 10 x 32mm(1.250") Phillips flat head screws.	Lock stile of the operable panel located 972mm(38.250") c/l measuring from bottom of panel.
One (1)	Steel keeper (Gemini 1") secured with four (4) #8 x 76mm(3.00") Phillips P.H. screws.	Latch stile of the operable panel located 972mm(38.250") c/l measuring from bottom of panel.

Installation: The specimen was secured to the 51mm x 305mm (2" x 12") wood test buck utilizing fourteen (14) #8 x 38mm (1.500") Phillips PH SMS. Seven (7) in each frame jamb located at 152mm (6.00"), 508mm (20.00"), 864mm (34.00"), 1219mm (48.00"), 1575(62.00"), 1930mm (76.00") and 2134mm (84.00") measuring from frame sill to frame head. The frame head and sill utilized no fasteners and was secured to the wood buck with silicone.

Sealant: Silicone caulking on hairline joinery and as needed to seal the test unit to the wood buck.

Surface Finish: White

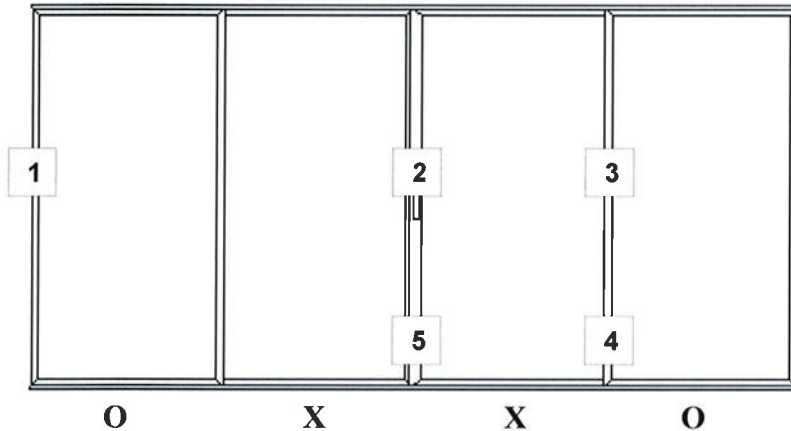


Performance Test Results

Uniform Structural Load **ASTM E330-02**
 Deflection / Permanent Set were measured with five (5) CDI Dial Indicators

- Location (1) -Center mid-span of frame jamb fasteners
- Location (2) -Center mid-span of the astragal/operable panel
- Location (3) -Center mid-span of the fixed/operable panel interlock
- Location (4) -51mm(2") from bottom of the fixed/operable panel interlock
- Location (5) -51mm(2") from bottom of the astragal/operable panel

Measurement Locations



<u>Paragraph</u>	<u>Title of Test</u>	<u>Method</u>	<u>Measured</u>	<u>Allowed</u>	<u>Result</u>
5.3.1.1.1	Operating Force	ASTM E2068			
		Max. Force to maintain motion	19 lbs	25 lbs	Passed
		Max. Force to initiate motion	15 lbs	40 lbs.	Passed
5.3.2	Air Infiltration @ 75 Pa. (1.6 psf.)	ASTM E283-04			
			0.22 cfm/ft ²	0.30 cfm/ft ²	Passed
	*Note: Results recorded to two decimal precision at client's request.				
	*The tested specimen meets the performance levels specified in AAMA/WDMA/CSA101/I.S.2/A440-05.				
5.3.3.2	Water Resistance 5.0 gph/ft ² WTP= 362 Pa. (7.5 psf.)	ASTM E547-00 Four (4) 5 min. cycles			
			No Entry	No Entry	Passed
	*tested with and without insect screen				
5.3.4.2	Uniform Structural Load	ASTM E330-02	Results recorded are net numbers.		
5.3.4.3	Permanent Deformation Ten (10) second duration				

<u>Positive</u>		<u>Deflection @ Design</u>	<u>Set @ Test</u>	<u>Allowable Set</u>
D/P @ 2403 Pa. (50.0 psf.)	Loc. 2	37.8mm (1.490")	1.4mm (.054")	9.8mm (0.384")
Test pressure @ 3345 Pa. (75.0 psf.)	Loc. 3	28.7mm (1.130")	4.8mm (.190")	9.8mm (0.384")
Negative				
D/P @ 2403 Pa. (50.0 psf.)	Loc. 2	42.1mm (1.658")	1.9mm (.075")	9.8mm (0.384")
Test Pressure @ 3345 Pa. (75.0 psf.)	Loc. 3	33.5mm (1.320")	3.3mm (.130")	9.8mm (0.384")
Location (2): Maximum allowable permanent set after test load at center mid-span of exterior left interlock space: (0.4% of 2438mm (96") span) = 9.8mm (0.384")				
Location (3): Maximum allowable permanent set after test load at center mid-span of exterior right interlock space: (0.4% of 2438mm (96") span) = 9.8mm (0.384")				



Performance Test Results (Continued)

<u>Paragraph</u>	<u>Title of Test</u>	<u>Method</u>			<u>Result</u>
5.3.5	Forced Entry Resistance Type "C" Sliding Door Assembly T ₁ = 10 minutes Tools used: A spatula (7.5.1) and a piece of stiff wire (7.5.2). The test specimen meets the performance Grade 10.	ASTM F 842-04			Passed
5.3.6.2	Welded Corner Test Note: When loaded to failure, the break did not extend along the entire weld line.	ASTM D618-00			Passed
5.3.6.3	Deglazing	ASTM E 987-94	<u>Measured</u>	<u>Allowed</u>	<u>Result</u>
	Top Rail 70 lbs.		0.1mm (.006") = 1.3%	< 90%	Passed
	Bottom Rail 70 lbs.		0.1mm (.006") = 1.3%	< 90%	Passed
	Left Stile 50 lbs.		0.1mm (.005") = 1.1%	< 90%	Passed
	Right Stile 50 lbs.		0.1mm (.004") = 0.9%	< 90%	Passed

Drawings to be submitted:

Submittal drawings numbered as listed and marked with the Element Materials Technology stamp are a part of this report submitted by our client (Deceuninck NA): 000620PD-008, 011H027, 011H055-D, GLASS/1" IG TEMPERED, 10001100-SH, 10001101-SH, 10001102-SH, 10001104-SH, 10001105-SH, 10001111-SH, 10001116-SH, 10001117-SH, 10300148, 10300150, 10300152, 10300171, 623000PD-004, 623.620PD-003, 1988-8000-REV-SS, KEEPER GEMINI 1" TALL, GEMINI II LOCK W/2450 TRIMPLATE, 623.620PD-005.

Test Date: April 14th thru April 28th, 2010

Remarks: Detailed drawings were available for laboratory records and comparison to the test specimen at the time of this report. A copy of this report along with representative sections of the test specimen will be retained by Element Materials Technology for a period of four (4) years. The results obtained apply only to the specimen tested.

This test report does not constitute certification of this product, but only that the above test results were obtained using the designated test methods and they indicate compliance with the performance requirements (paragraphs as listed) of the above referenced specifications.

Element Materials Technology assumes that all information provided by the client is accurate and that the physical and chemical properties of the components are as stated by the manufacturer.

Element Materials Technology.



Testing Performed By:

Steve Gibbs Element Materials Technology
Washington Romero Element Materials Technology

Client Present:

Jonathan Morton Deceuninck NA



James Blakely
Operations Manager
Element Materials Technology



cc: Deceuninck NA (3)
 NAMI (2)
 Ramesh Patel P.E. (1)
 File (1)