

623.000 PD - 005 - BILL OF MATERIALS 2 LITE DP65

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
1	HEAD	1	10001100	10001100-F-01	A
2	JAMB	2	10001100	10001100-F-05	A
3	EXTERIOR FRAME COVER	1	10001104	10001104-F-01	A
4	INTERIOR FRAME COVER	1	10001104	STRAIGHT CUT	A
5	SILL	1	10001101	10001101-F-01	A
6	SILL THRESHOLD	1	10300171	10300171-F-01	PPPP
7	SILL RISER	2	10001105	10001105-F-01	A
8	SILL EXTENSION - DP65	1	20008052	STRAIGHT CUT	A
9	WEATHER-STRIPPING - .270 x .250	AS REQ'D	W21255MW		HHHH
10					
11	MISC SNUBBER	3	10300148	10300148-F-01	PPPP
12	ROLLER TRACK CAP	1	1A16719	STRAIGHT CUT	N
13	L - BRACKET	2	HD L Bracket		Eastern
14	SILL FRAME GASKET	2	G-A302-Z1-G600		CC
15					
16	KEEPER	1			F
17	2778 KEEPER - YZD MILD STEEL		DECU-2808-00		
18	2778 KEEPER - STAINLESS STEEL		DECU-2808-84		
19	T - BRACKET	1 OR 2	10300213		DDDD
20	SCREEN KEEPER	1	011H040		MMMM
21	BUMPER STOP	1 OR 2	2152.525		F
22					
23	SCREWS SNUBBER	9	#8 x 1.25" PFH - 410SS		
24	L - BRACKET - SASH	4	#8 x 1" PFH - 410SS		
25	L - BRACKET - HEAD	4	#8 x 0.75" PFH - 410SS		
26	L - BRACKET - HEAD	4	#8 x 2.5" PFH - 410SS		
27	SILL RISER	4	#8 x 1.25" PFH - 410SS		
28	FRAME ASSEMBLY	12	#8 x 2.5" PPH - 410SS		
29	SCREEN KEEPER	2	#6 x .375" PPH		
30	T - BRACKET	4 OR 18	#8 x 2.5" PFH - 410SS		
31					
32					

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4049-02A
TEST DATE: 09/23/16

REV	DATE	DESCRIPTION	BY

deceuninck
NORTH AMERICA

MONROE, OH COPYRIGHT 2017

NAME: 623.000 PD - 005
DWN BY: CRB
CHKD BY:
DWG NO.: 623000PD-005

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000.620 PD - 009 - BILL OF MATERIALS 2 LITE DP65

ITEM NO.	DESCRIPTION	QUANTITY	PART NO.	FAB DWG. NO	SOURCE
1	FXD 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	STRAIGHT CUT	A
6	GLAZING BEAD	4	10001111	10001111-F-01	A
7	STILE REINFORCEMENT - JAMB	1	10300150	STRAIGHT CUT	PPPP
8	STILE REINFORCEMENT - INTERLOCK	1	10300151	STRAIGHT CUT	PPPP
9	WEATHER-STRIPPING - 270 x 250	AS REQD	W21255MW		HHHH
10					
11	OPR PNL RAIL - TOP	1	10001102	10001102-F-01	A
12	STILE - INTERLOCK	1	10001102	10001102-F-03	A
13	STILE - ACTIVE LOCK	1	10001102	10001102-F-10	A
14	STILE - PASSIVE LOCK	1	10001102	10001102-F-16	A
15	RAIL - BOTTOM	1	10001102	10001102-F-05	A
16					
17	INTERLOCK	2	10001117	10001117-F-02	A
18	SCREW COVER	2	10001118	STRAIGHT CUT	A
19	GLAZING BEAD	4	10001111	10001111-F-01	A
20	STILE REINFORCEMENT - INTERLOCK	1	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	1	10300152	10300152-F-01	PPPP
24					
25	SQUARE TUBE REINFORCEMENT - VERTICAL INTERLOCK RAILS	1	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					
28	MISC LOCK SET ASSEMBLY - 2817 LOCK W/ TRIMPLATE	1	DECU-XXX4		F
29	HANDLE SET ASSEMBLY	1	DECU-XXX1		F
30	HANDLE SET - INTERIOR SWITCH		DECU-XXX2		F
31	HANDLE SET - INTERIOR SWITCH / KEY		DECU-XXX3		F
32	HANDLE SET - BLANK		1988PRS166REVSS		F
33	ROLLER ASSEMBLY - PRECISION 1.66" WHEEL	2	D6096AMWKC 0.810		HHHH
34	DRAFT PLUG - .810 DIA	2	9946		D
35	3/8" HOLE PLUG	2	DECU-2808-84		F
36	KEEPER - 2778 KEEPER - STAINLESS STEEL	1	011H055-D		MMMM
37	IMPACT BRACKET	2			
38	1" INSULATED GLASS	2	REFER TO APPLICABLE TEST REPORT		
39	SETTING BLOCKS (REFER TO SUPPLIER GUIDELINES)	AS REQD	REFER TO APPLICABLE TEST REPORT		
40	GLAZING COMPOUND	AS REQD	REFER TO APPLICABLE TEST REPORT		
41					
42	SCREWS LOCK SET	2	#10 x 1.25" PFH - 410SS		
43	ROLLER ASSEMBLY	4	#8 x 3/4" PPH - 410SS		
44	REINFORCEMENT TO PANEL	AS REQD	#8 x 1" PFH - 410SS		
45	INTERLOCK	AS REQD	#8 x 5/8" PPH - 410SS		
46	4 LITE ASTRAGAL	AS REQD	#8 x 2" PPH - PAINTED		
47	KEEPER	2	#8 x 3" PPH - 410SS		
48	IMPACT BRACKET	4	#8 x 2.5" PFH - PAINTED		
49					

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

4044-024

REV	DATE	DESCRIPTION	BY

CONFIDENTIAL
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DECEUNINCK NORTH AMERICA

deceuninck
NORTH AMERICA

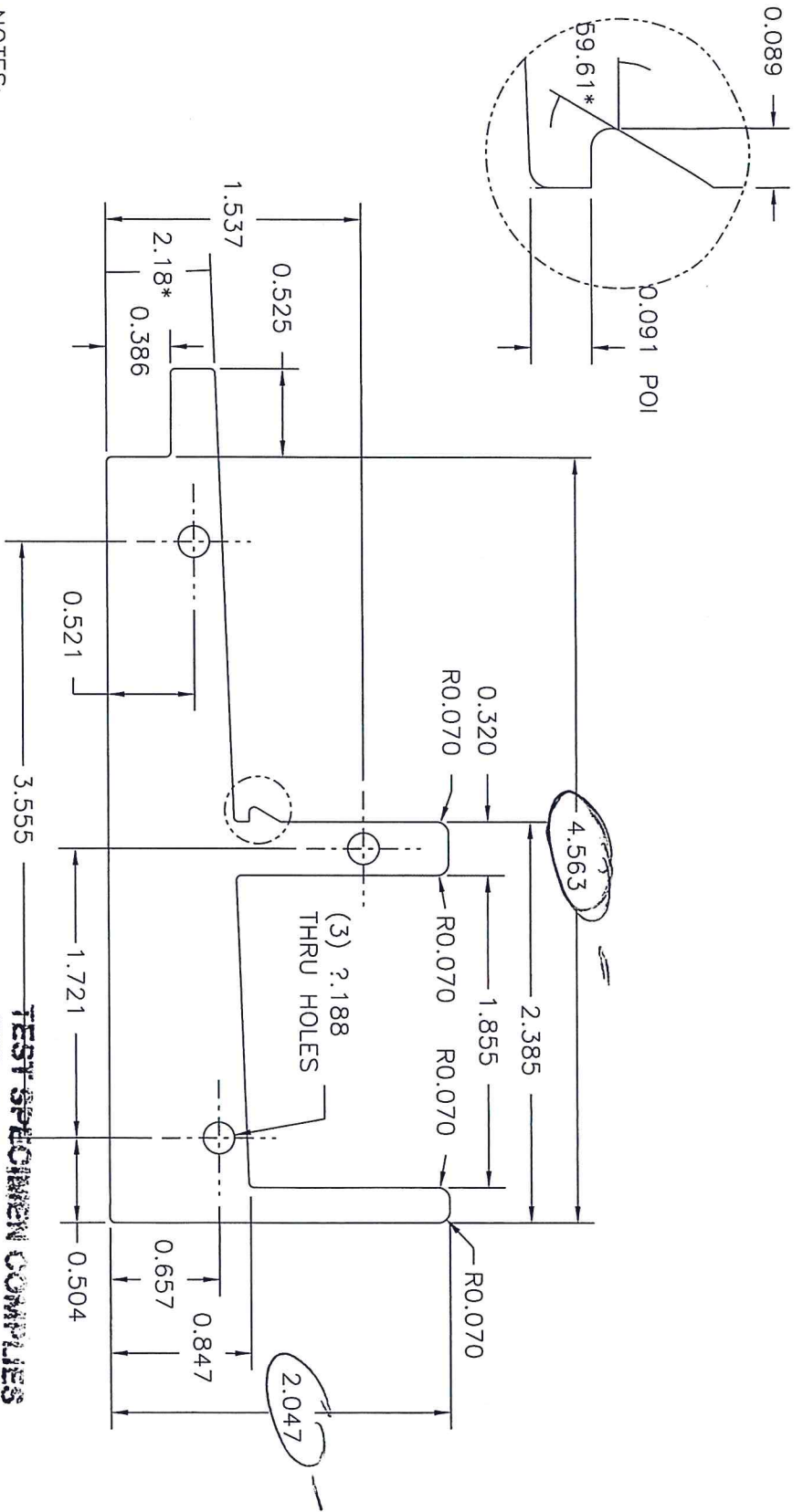
MONROE, OH COPY/RIGHT 2017

NAME: 000.620 PD - 009
OWN BY: CRB
CHKD BY: 17/01/03
DWG NO: 000620PD-009

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A 011H002



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCTL-210-444-02A
TEST DATE: 09/23/16

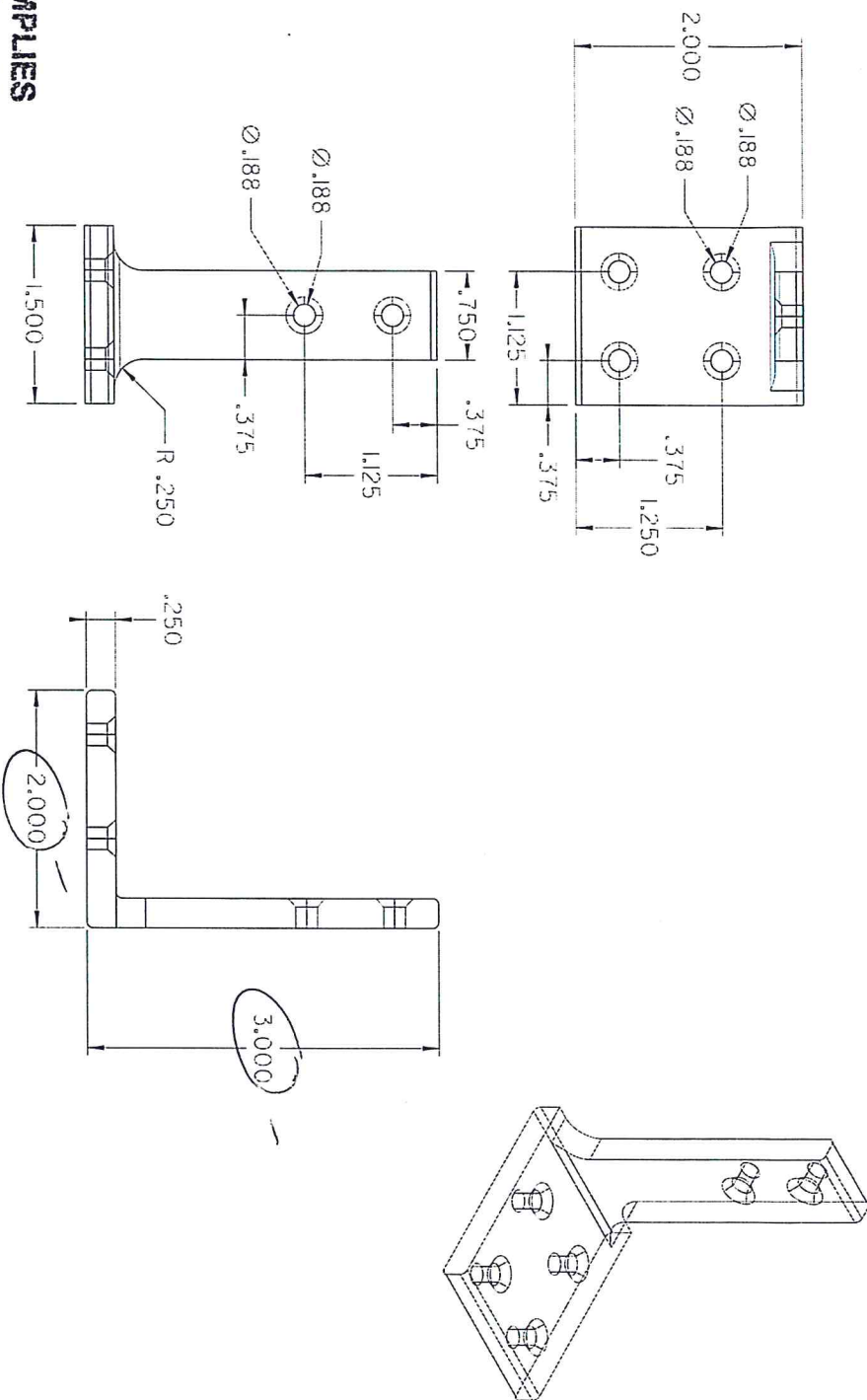
- NOTES:
- 1) MATERIAL: CLOSED CELL, CROSSLINKED POLYETHYLENE FOAM, 4-6 LB./CU. FT. DENSITY, COLORWHITE, UV STABILIZED.
 - 2) PERMANENT, PRESSURE SENSITIVE ADHESIVE, RUBBER OR ACRYLIC BASE, ONE SIDE WITH RELEASE PAPER BACKING. (BOTH SIDES REQUIRED).
 - 3) ALL RADII 0.030 UNLESS OTHERWISE SPECIFIED.
 - 4) H-0 Products part no. G-A302-Z1-G600



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 - 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 - 4044-22A
TEST DATE: 07/23/16

CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES	
UNPUBLISHED WORK © 2012 DECEUNNICK NORTH AMERICA		DIM ARE IN INCHES	
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THIRD ANGLE PROJECTION		THIRD ANGLE PROJECTION	
DESIGN BY: JOM		DATE: 12/05/30	
DRAWN BY: JOM		DATE: 12/05/21	
DATE: 12/05/21		DATE: 12/05/21	
AUTH: JOM		DATE: 12/05/21	
REVISION: 126071		DATE: 12/05/21	
SPEC DWG. NO: 62362070 R&D		DATE: 12/05/21	
SCALE: 1:1		DATE: 12/05/21	
SHEET: 1		DATE: 12/05/21	
REV: NEW		DATE: 12/05/21	

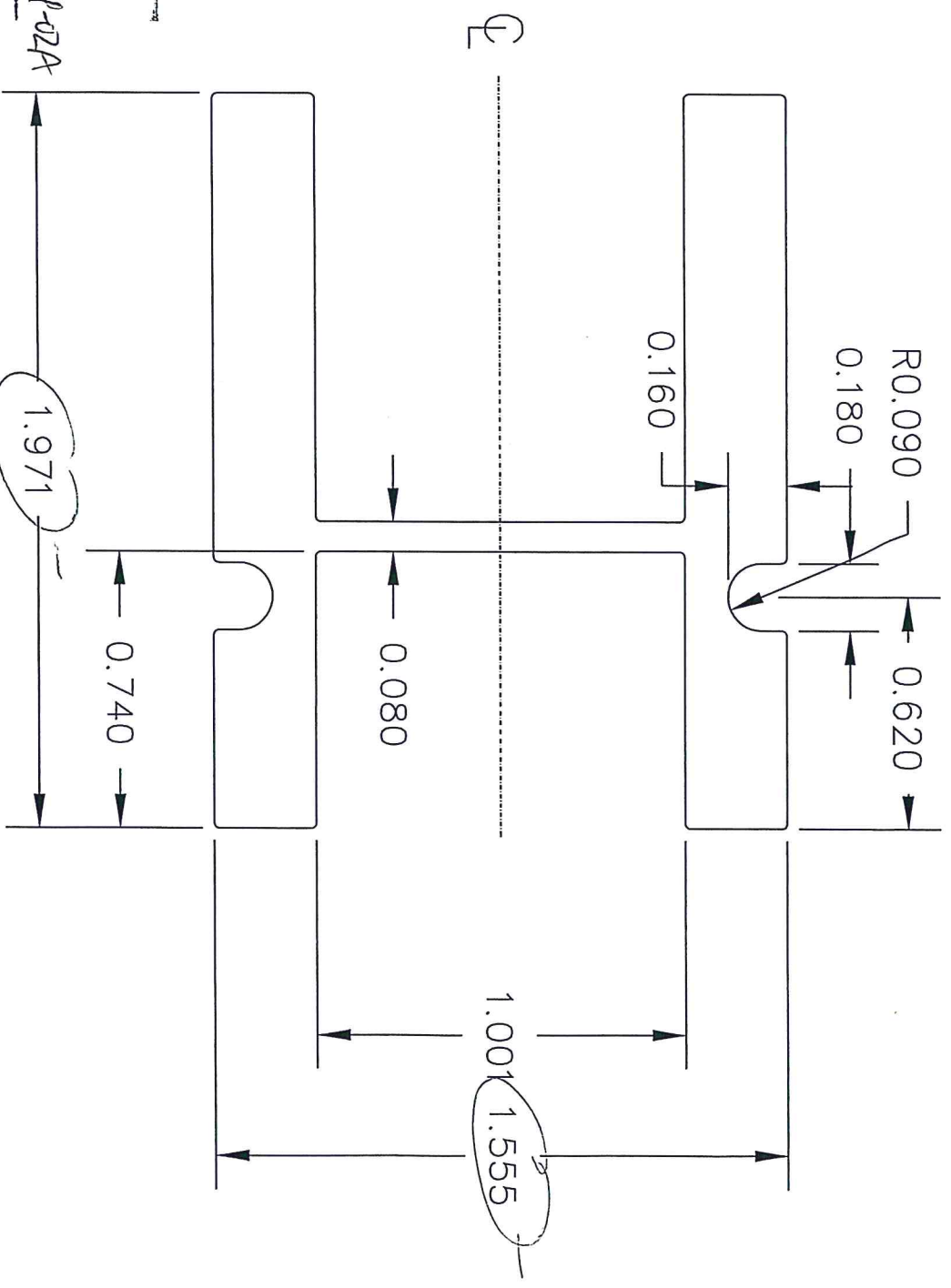
HD L BRACKET

deceunnick
 NORTH AMERICA
 2100 WILSON ROAD
 MONROE, LA 70501

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A 011H049

NO EXPOSED SURFACES



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

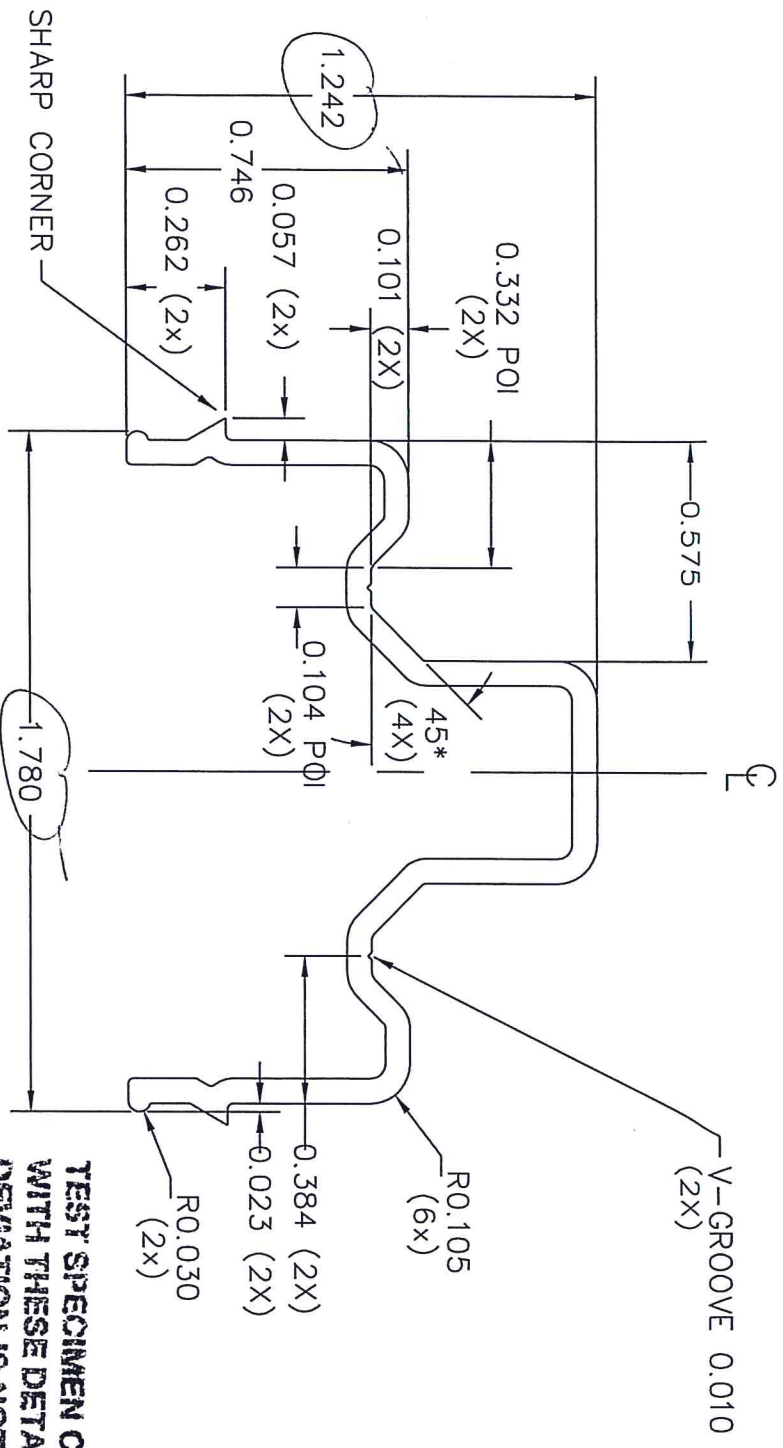
NOTES:
 1. ALL UNSPECIFIED RADII ARE 0.015.

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

DRAWN	MG	DATE	02/05/03	APPVD		MAT'L	6105-151	SCALE	2/1
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SASH REINFORCEMENT XHD A 10300151

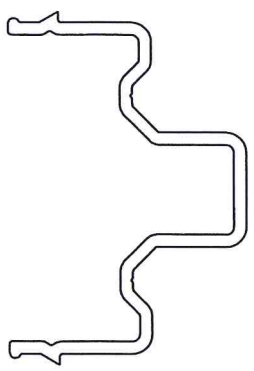
REV	BY	APPVD	DATE	CHANGE
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ACTUAL SIZE
NO EXPOSED SURFACES

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4644-024
 TEST DATE: 09/23/18

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



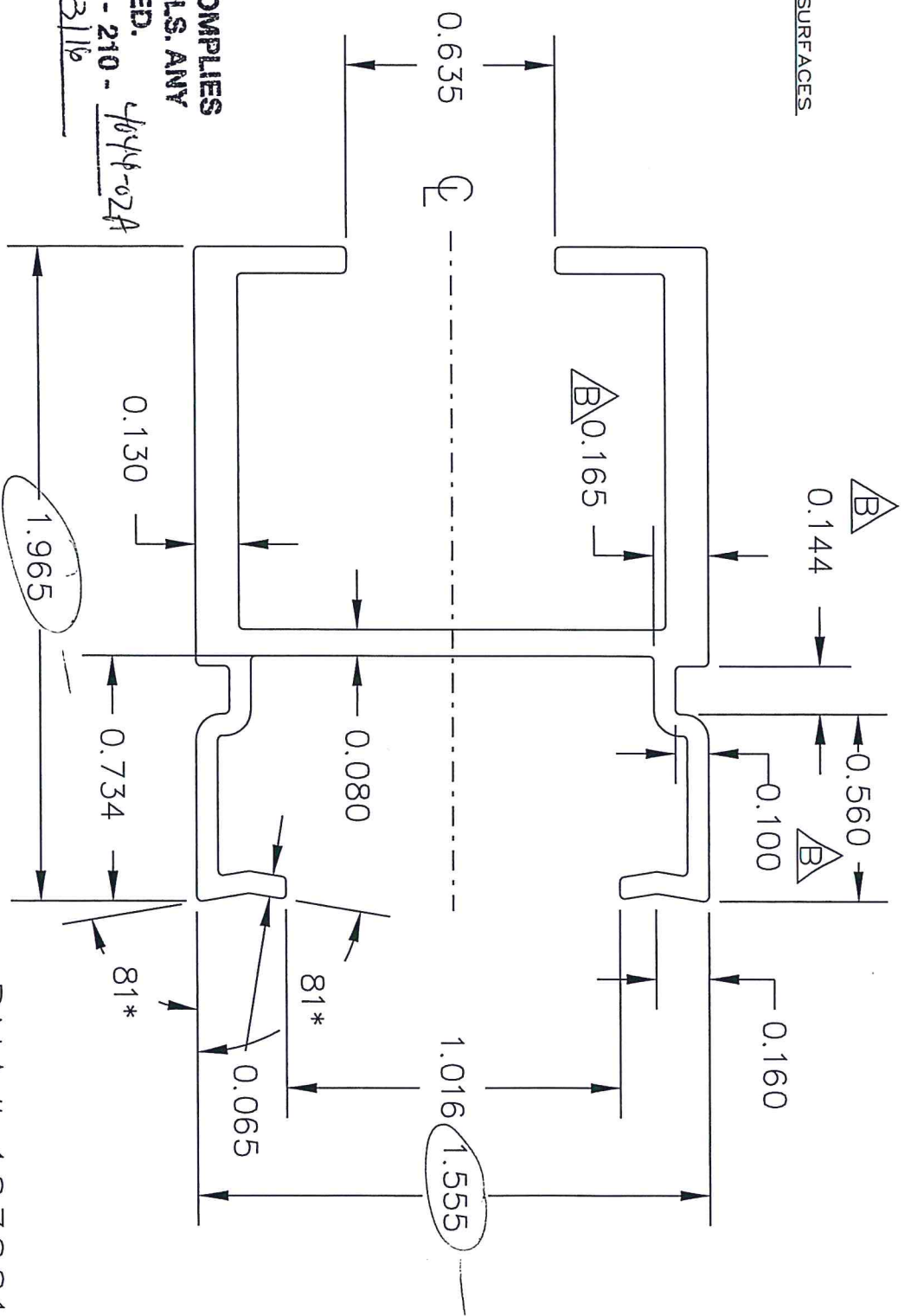
Vinylines®
VINYL BUILDING PRODUCTS INC.
 AREA = 0.269 sq in
 WEIGHT = 0.316 lb/ft
 TOLERANCES (EXCEPT AS NOTED)
 ±0.010

REV	BY	APP'VD	DATE	CHANGE
DRAWN	M/G	DATE	10/28/3	APP'VD
SNUBBER			MAT'L	SCALE
			6061-T6, 6105-T5	2/1
			10300148	

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A 011H035B

NO EXPOSED SURFACES.



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

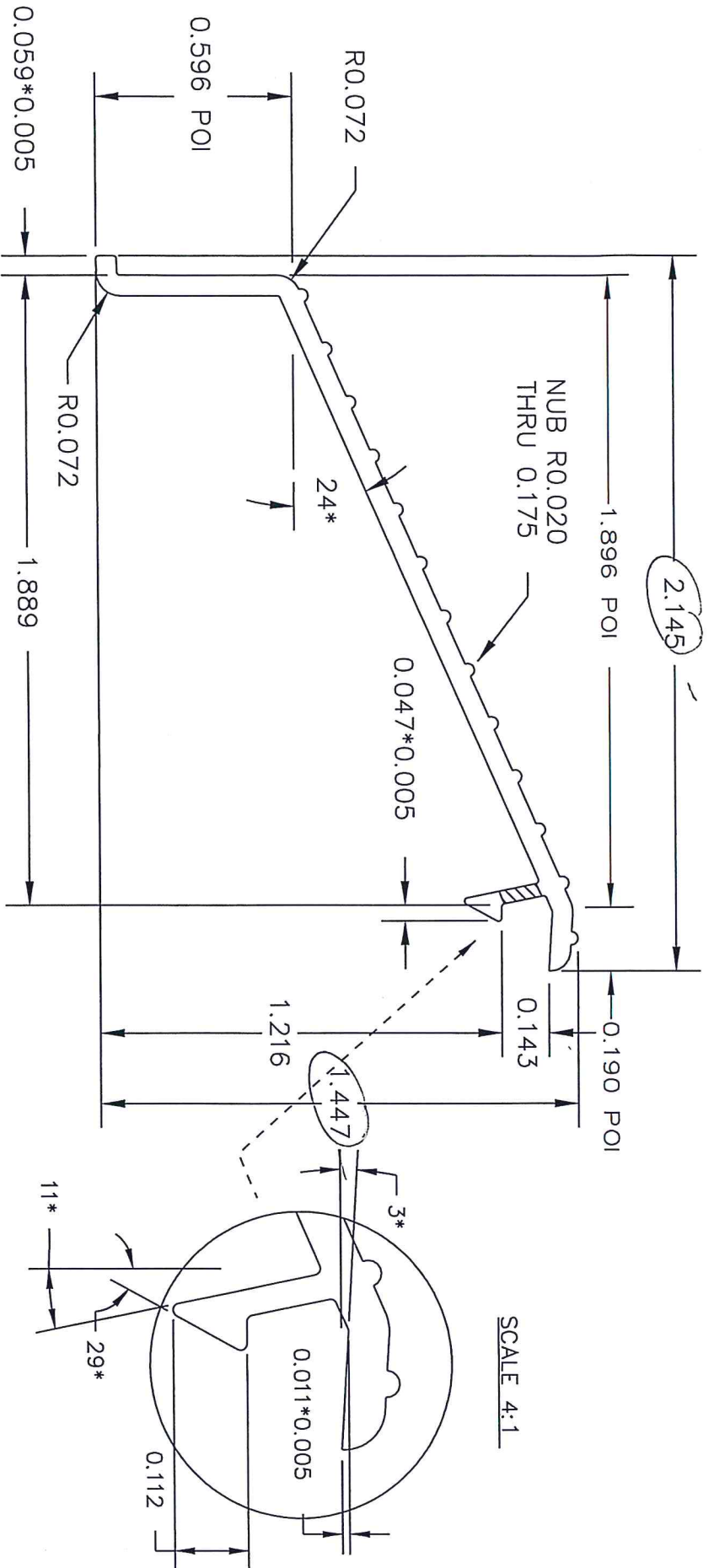
- NOTES:
 1. ALL UNSPECIFIED RADII ARE 0.015.
 2. MAKE FROM EITHER 6061-T6 or 6105-T6 ALUMINUM.
 3. ALCOA PART NUMBER 23441.

REV	BY	APP'VD	DATE	CHANGE
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

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

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

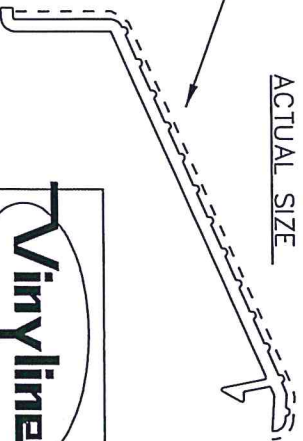
DNA# 10300150



- 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 - 4644-02A
 TEST DATE: 8/23/16

Vinylina®

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	APPV'D	MAT'L	606T-T6	SCALE	2/1
						6105-T5		

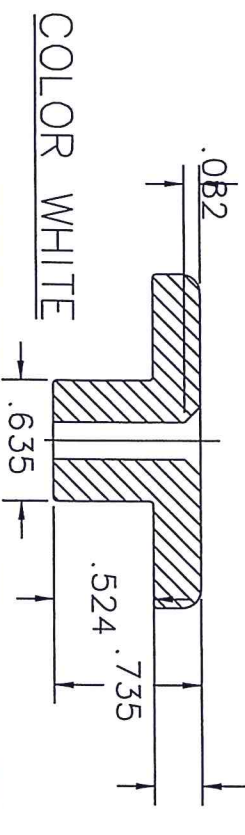
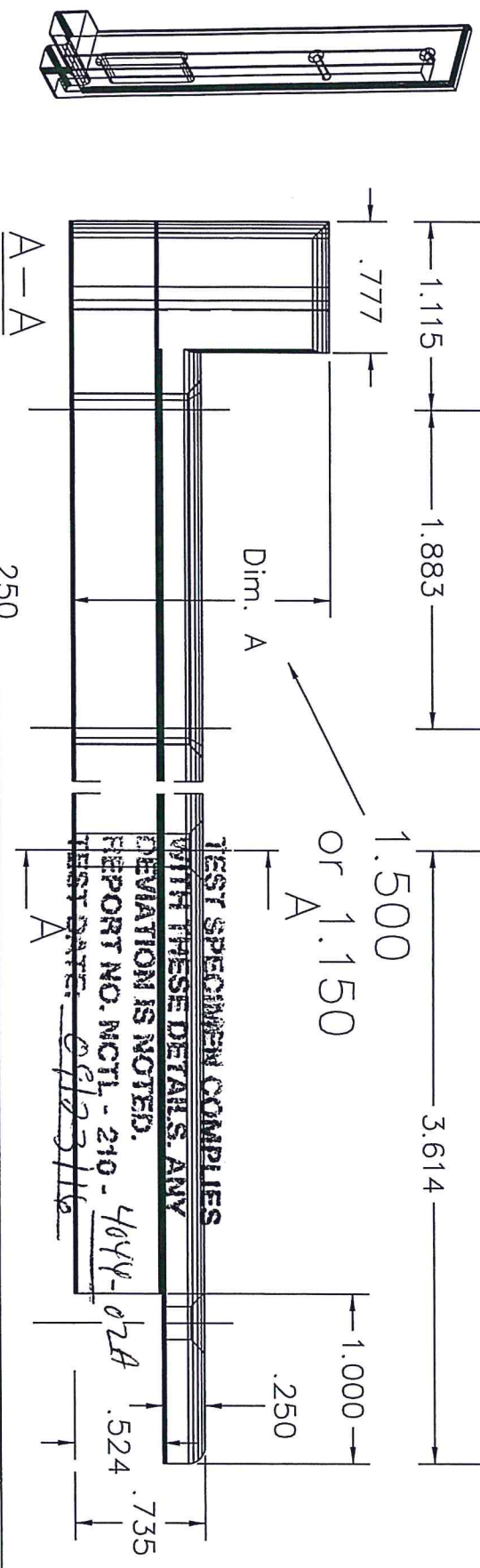
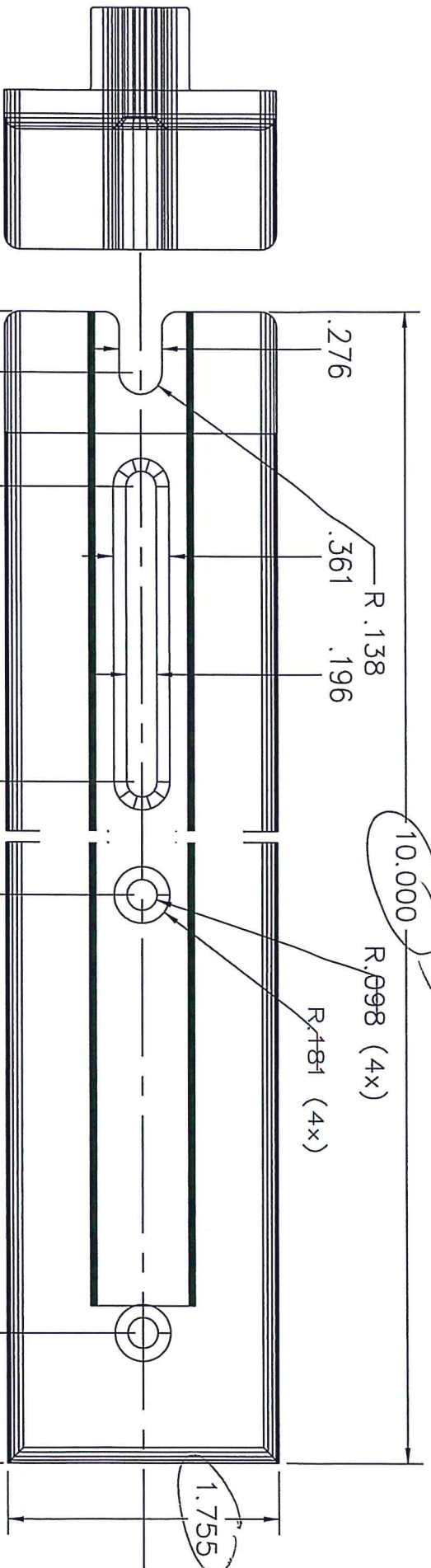
SILL COVER. SLIDER A 10300171

ADDED NOTE 3.

A	MB	2/13/03	DATE	CHANGE
REV	BY	APPV'D		

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A 011h055-D



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

REPORT NO. NCT1 - 210 - 4044 - 02A
 TEST DATE: 09/23/16



VINYL BUILDING PRODUCTS INC.

AREA = 8.109 cub in
 WEIGHT =
 TOLERANCES (EXCEPT AS NOTED)
 ±0.010

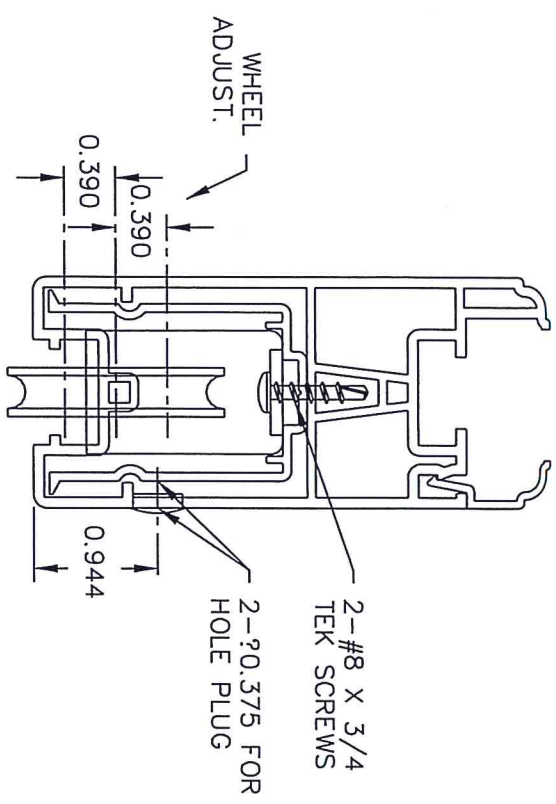
DRAWN MG DATE 2/25/05 APP'VD MAT'L NYLON SCALE 1/1

BRACKET 011h055-D

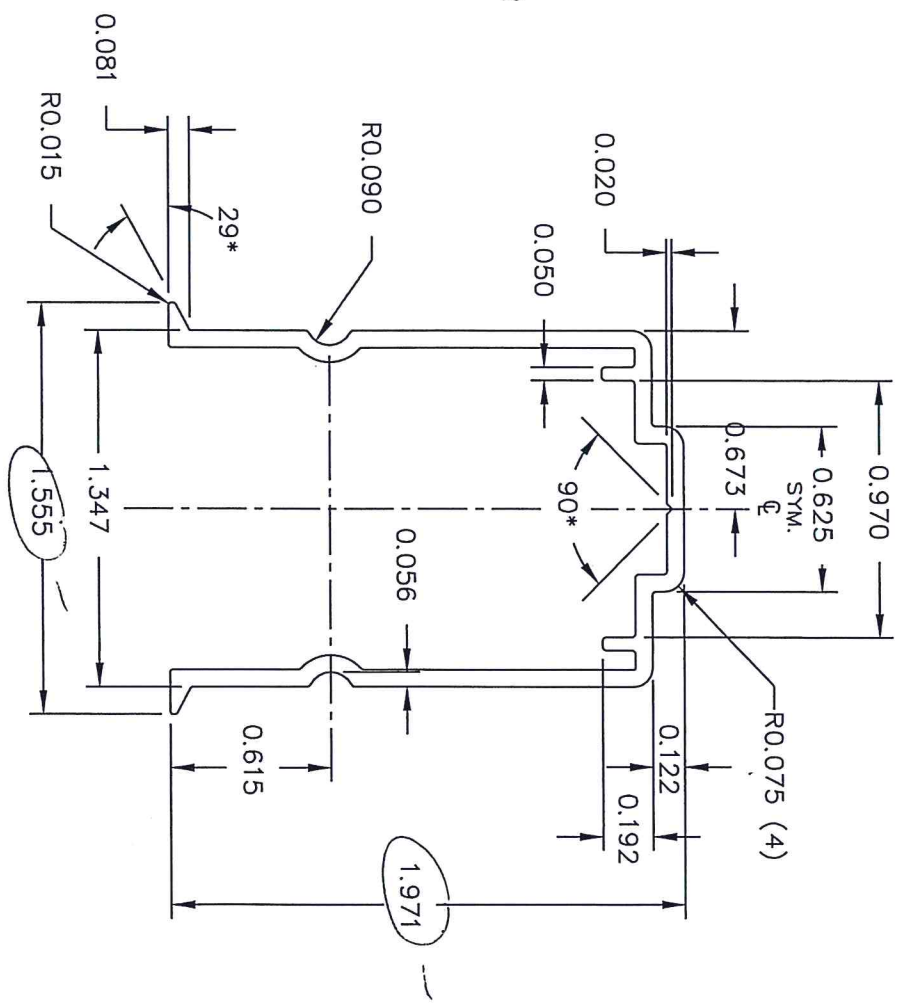
REV	BY	APP'VD	DATE	CHANGE
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011H074



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

REV	BY	DATE	TEST DATE
-	-	-	-
<p>DEVIATION IS NOTED. REPORT NO. NCRIP 20N - 4044-024 TEST DATE: 07/23/16</p>			



deuceuninck

VINYL BUILDING PRODUCTS LLC

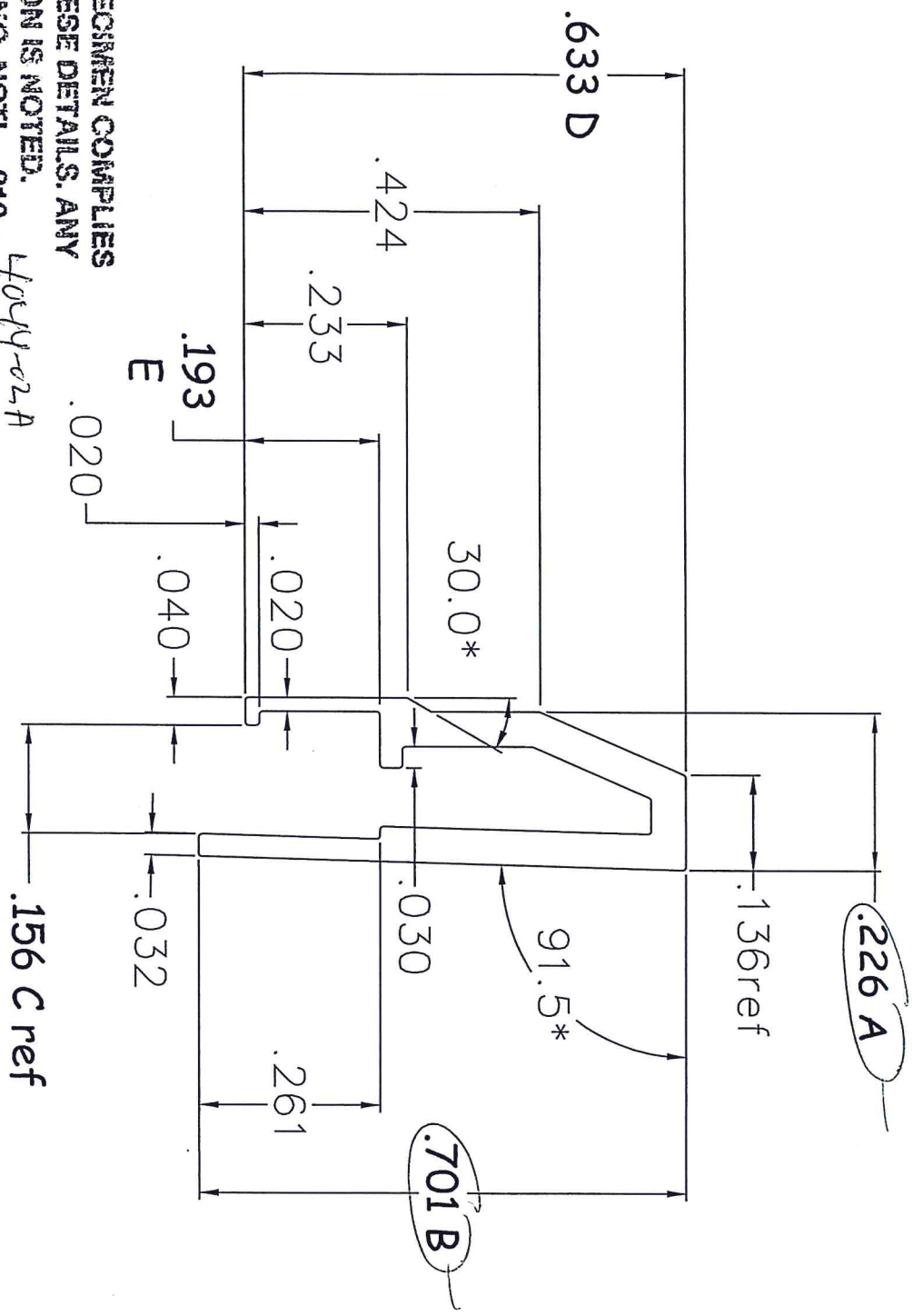
AREA = .359 sq. in.
 WT/FT = .431 lb.
 PERIM. = 11.200 in.
 FACTOR = 26

TOLERANCES (EXCEPT AS NOTED)
 AA STANDARDS

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 RADII	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 - 4044-02A
 TEST DATE: 09/23/16

PART #: 8052

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ANNUAL USAGE	
1st YEAR	
2nd YEAR	

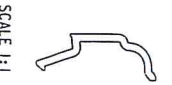
06/04/98	ADDED QC DIM'S	SMD
5/21/98	odd dims. for angle TC	
5/14/98	Redrawn for #1013	T.C.
DATE	REVISION RECORD	DRAWN BY

ACRO EXTRUSION CORP
 900 EAST 30th STREET
 WILMINGTON, DE 19809
 (800) 441-3859

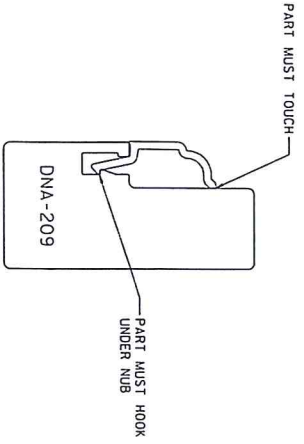
TITLE:	Sill Extender		
PROJECT:	8000 Series Double Hung		
DATE:	5/4/98	SCALE:	4 : 1
DRAWN BY:	T. Coleman	DWG NO.:	20008052
CHECKED BY:			

DO NOT SCALE

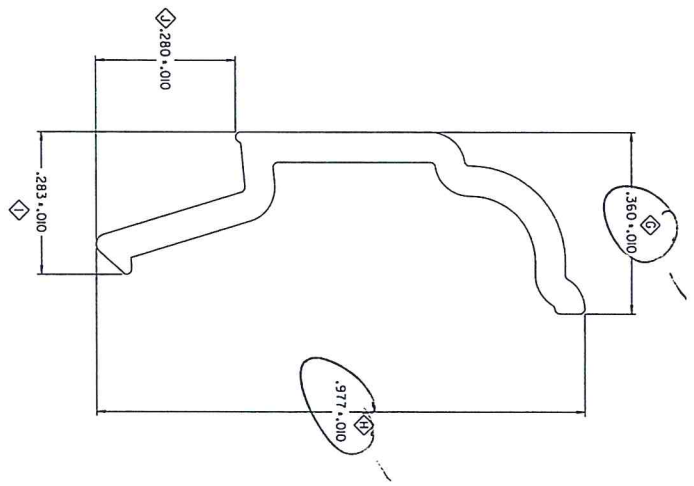
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.



SCALE 1:1



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



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

USE MYLAR 1000III.0P REV C



- NOTES:
1. 'STD0003' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD0003 (B)
 3. UNSPECIFIED EXTERNAL RADI = .XXX +.010 / -.005 (C)
 4. UNSPECIFIED INTERNAL RADI = .XXX +.020 / -.005 (D)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .XXX +/- .10% (E)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX +/- .20% (F)

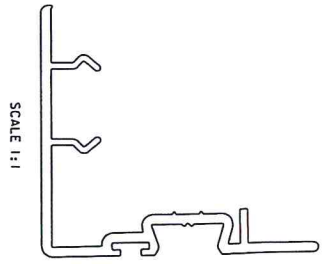
REVISION HISTORY		
REV	DESCRIPTION	DATE
0	ADDED GAUGE	09/10/15

KEY PRODUCT CHARACTERISTICS	
\diamond	GAUGE DNA-209
\diamond	GAUGE DNA-209
\diamond	GAUGE DNA-209
\diamond	GAUGE DNA-209

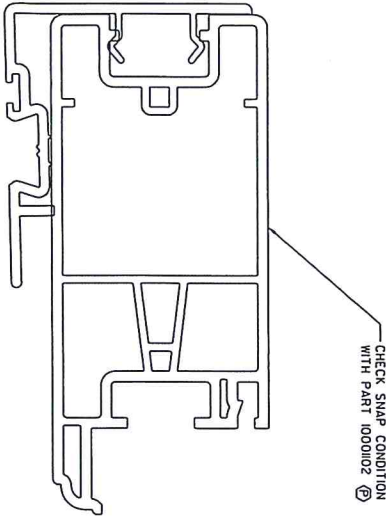
CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES	
UNPUBLISHED WORK @ 2007 DECEUNINCK NORTH AMERICA		2 PL. ± 0.010° 3 PL. ± 0.005° INTERPRET DIM AND TOL PER ASME Y14.5M - 1994	
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DESIGN BY:	MG	DATE:	00/12/01
DRAWN BY:	MG	DATE:	00/12/01
ADTH:	DATE:	ADTH:	DATE:
FILENAME:	1000III.SH.dgn	SIZE/DWG NO:	1000III.SH
deceuninck® NORTH AMERICA		GLAZING BEAD	
SHEET: 4 of 1		SCALE: 4:1	

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

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
D	UPDATE TO CURRENT STANDS	08/06/24	BMB

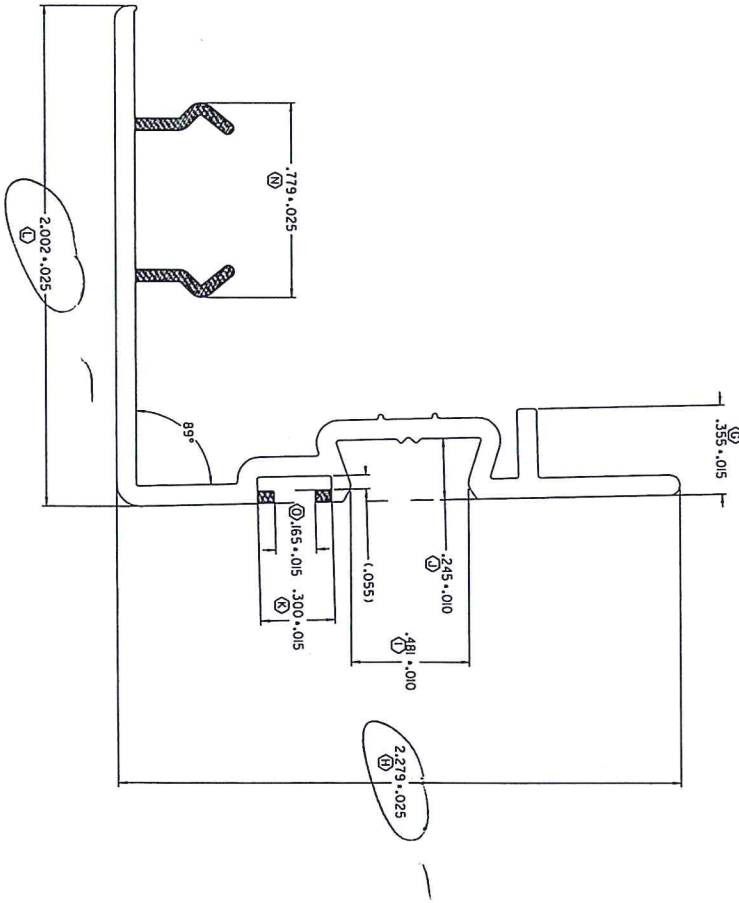


SCALE 1:1



WALL THICKNESS
 .080 -
 .050 -

TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL-210-4014-02A
 TEST DATE: 08/23/16



- NOTES:
1. 'STANDARD' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY. (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD0013. (B)
 3. UNSPECIFIED INTERNAL RADI = .xxx +.010 / -.005. (C)
 4. UNSPECIFIED INTERNAL RADI = .xxx +.020 / -.005. (C)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx +/- .02. (C)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx +/- .02. (C)

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UNLESS OTHERWISE SPECIFIED
 DIM ARE IN INCHES
 TOL ON ANGLES ± 1°
 2 PL: ± 0.010 3 PL: ± 0.005
 INTERPRET DIM AND TOL PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY: PGM
 DATE: 06/12/22
 DRAWN BY: JHM
 DATE: 07/01/02

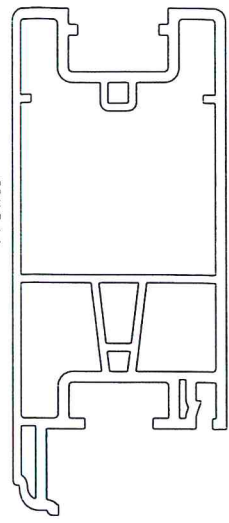
FILE NAME: \$FILE NAME\$

NAME: **deceuninck** 311 NORTH LAMAR ROAD
 NORTH AMERICA
 SASH ADAPTER

SIZE/DWG. NO: 1000117.SH
 SCALE: 2:1
 SHEET: 1 OF 1

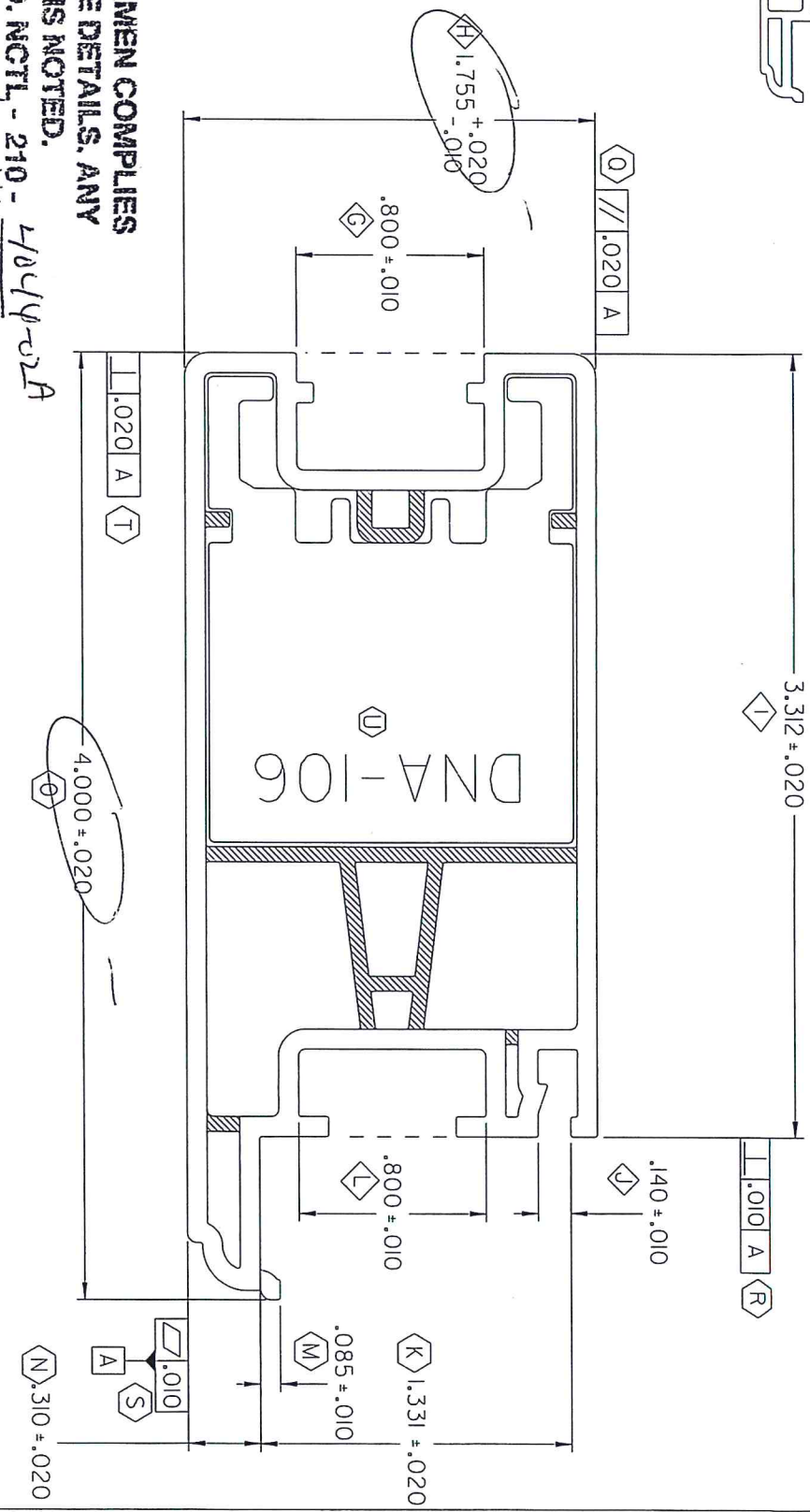
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
H	ADDED GAUGE	09/05/26	BMB



SCALE 1:1

KEY PRODUCT CHARACTERISTICS	
G	FRAME DIMENSION .790 - .810
H	FRAME DIMENSION 1.745 - 1.775
I	FRAME DIMENSION 3.292 - 3.332
J	FRAME DIMENSION .130 - .150
L	FRAME DIMENSION .790 - .810



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4044-22A TEST DATE: 09/23/16

- NOTES:
1. 'STD0003' STRAIGHTNESS CLASS B AND LENGTH TOLERANCES APPLY (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD003 (B)
 3. UNSPECIFIED EXTERNAL RADI = .xxx +.010 / -.005 (D)
 4. UNSPECIFIED INTERNAL RADI = .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: +.000° 3 PL: +.005°
INTERPRET DIM AND TOL PER
ASME Y14.5M - 1994

THIRD ANGLE PROJECTION

DESIGN BY:		SJD	
DATE:	01/06/21	DATE:	01/06/21
DRAWN BY:	SJD	DATE:	01/06/21
DATE:	01/06/21	DATE:	01/06/21
AUTH:		DATE:	
FILENAME:		FILE NAME:	

deceuninck 210 NORTH AMERICA
MAIN SASH - PD
SIZE DWG. NO: 1000002-SH
SCALE: 2:1 (B5/F7) .900 SHEET: 1 OF 1

SFILES

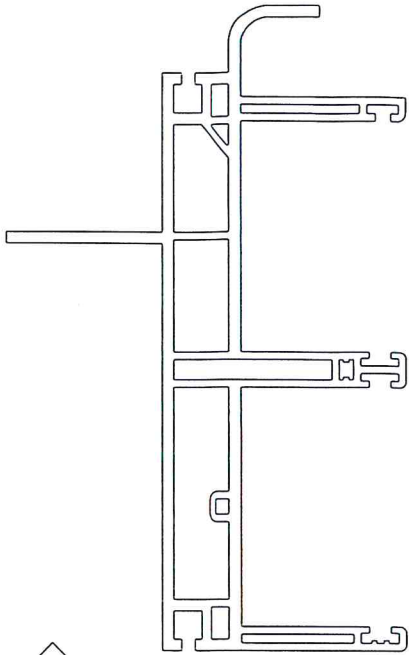
SUSERS

SPLDATES

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

REVISION HISTORY

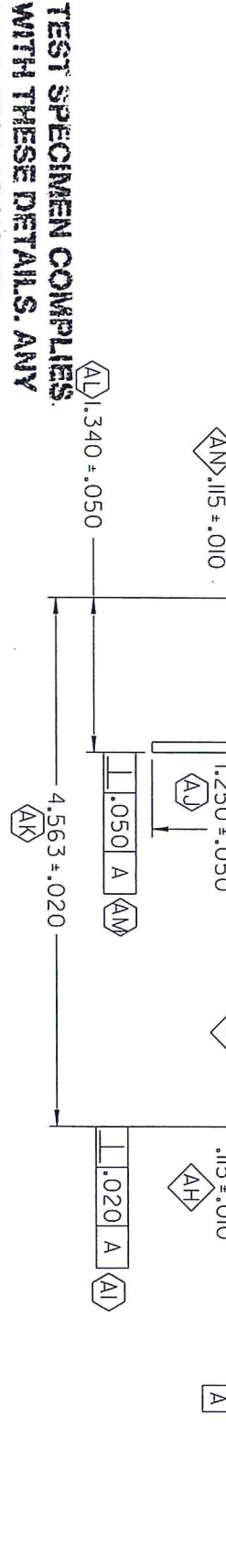
REV	DESCRIPTION	DATE	APPROVED
L	REMOVED INTERIOR WSS DIMENSIONS	10/05/26	BMB



- WALL THICKNESS**
- .090 - [Hatched Pattern]
 - .060 - [Diagonal Hatch Pattern]
 - .050 - [Horizontal Hatch Pattern]
 - .040 - [Vertical Hatch Pattern]

KEY PRODUCT CHARACTERISTICS

G	DIMENSION 1.282 - 1.322
J	DIMENSION .608 - .638
O	DIMENSION 1.810 - 1.830
V	DIMENSION 1.885 - 1.905
Z	GAUGE 1000100_01
AH	DIMENSION .105 - .125
AN	DIMENSION .105 - .125



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
REPORT NO. NCT1 - 210 - 4044-02A
TEST DATE: 09/23/16

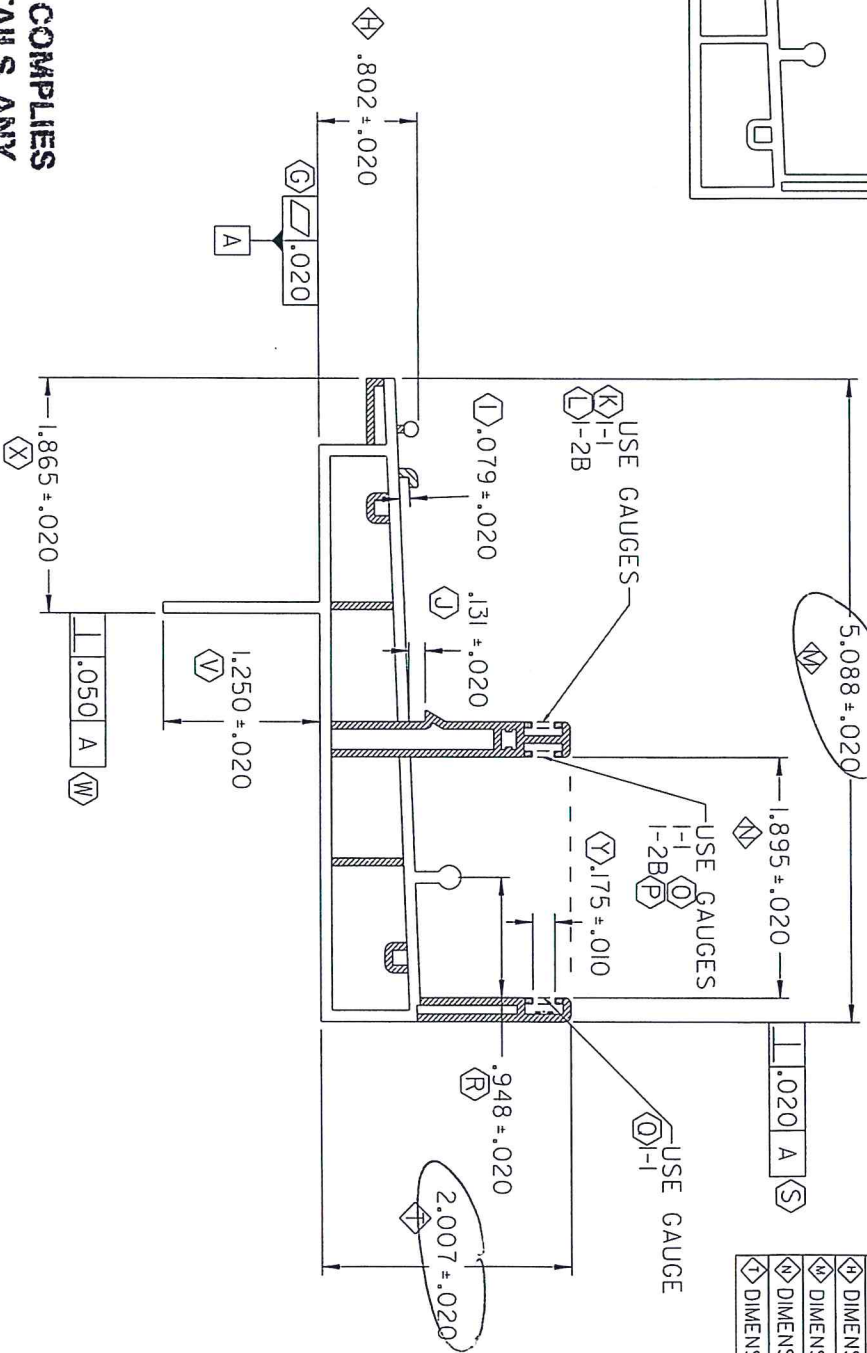
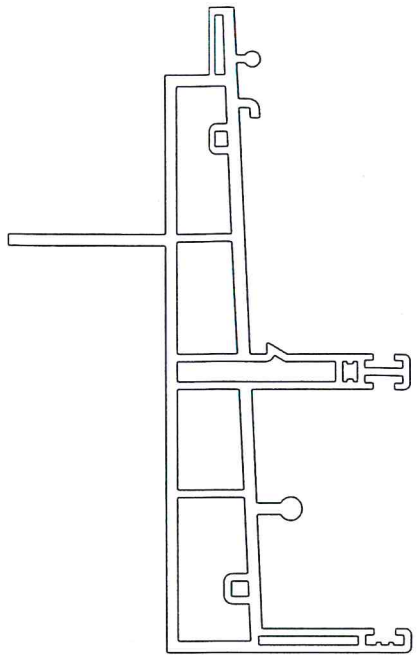
- NOTES:**
1. ST00003: STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY. Ⓞ
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER ST00002. Ⓞ
 3. UNSPECIFIED EXTERNAL RADIUS = .xxx ± .005 Ⓞ
 4. UNSPECIFIED EXTERNAL RADIUS = .xxx ± .020 Ⓞ
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx ± .010% Ⓞ
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx ± .010% Ⓞ

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	UNLESS OTHERWISE SPECIFIED DIM ARE IN INCHES. Ⓢ TOL. ON ANGLES: ± P 2 PL. ± 0.005 3 PL. ± 0.005 INTERPRET DIM AND TOL PER ASME Y14.5M - 1994		NAME: MAIN FRAME - PD SIZE DWG. NO.: 1000100_01 SCALE: 1:1 [LBS/FT] Lbl SHEET: 1 OF 1
	THIRD ANGLE PROJECTION		REV.: L

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

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

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
4	DIMENSION .782 - .822		
4	DIMENSION 5.068 - 5.108		
4	DIMENSION 1.875 - 1.915		
4	DIMENSION 1.987 - 2.207		



WALL THICKNESS

.090 -	[Symbol]
.070 -	[Symbol]
.060 -	[Symbol]
.050 -	[Symbol]
.040 -	[Symbol]

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

- NOTES:
1. 'ST00003' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER ST0003
 3. UNSPECIFIED EXTERNAL RADI = .xxx +.00 / -.005
 4. UNSPECIFIED INTERNAL RADI = .xxx +.020 / -.005
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx +/- .020
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx +/- .020

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

THIRD ANGLE PROJECTION

DESIGN BY: RUC DATE: 00/10/20 DRAWN BY: RUC DATE: 00/10/20

NAME: **deceuninck** 311 NORTH AMERICA NORTH AMERICA 311 NORTH AMERICA MONROE, LA 70002

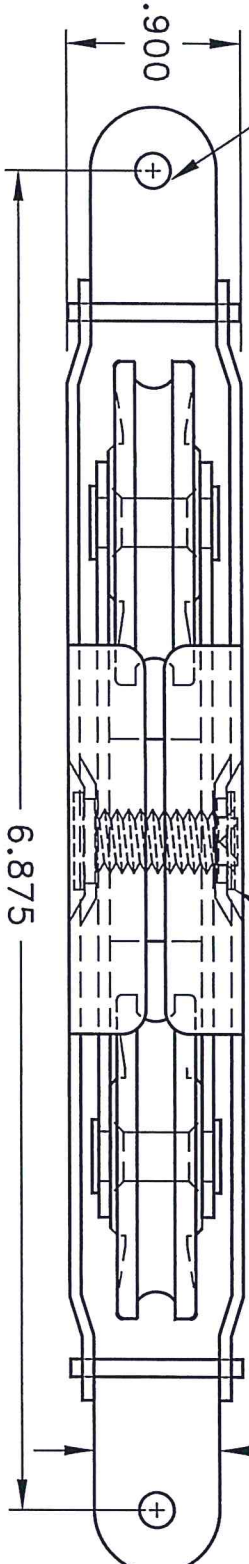
SIZE DWG. NO: 1000101L SH SCALE: 1:1 LBS/F/1.0 SHEET: 1 OF 1

FILE NAME: \$FILE NAME

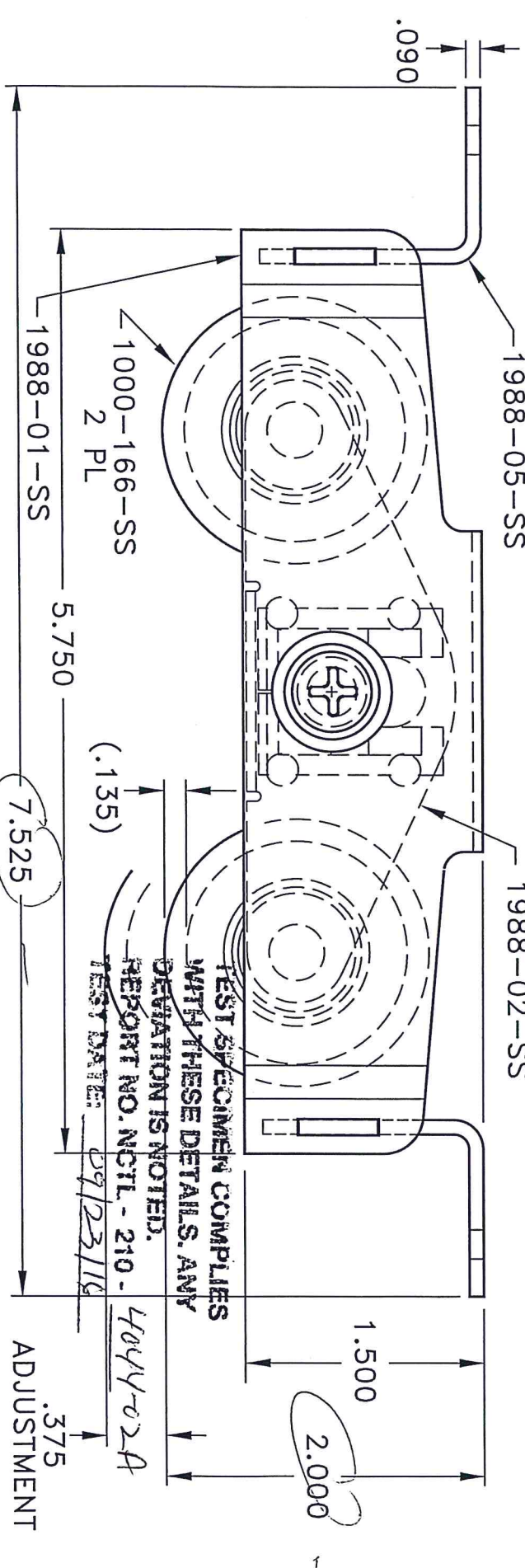
.181 DIA THRU
2 PL

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	



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CO. NAME: _____
APPR'D BY: _____ DATE: _____
(PRINT NAME): _____



TEST SPECIMEN COMPLEES WITH THESE DETAILS. ANY DEVIATIONS NOTED. REPORT NO. NCTL - 210 - 4044-02A
TEST DATE: 09/23/16

NOTES:

- INNER AND OUTER HSG'S ARE STAINLESS STEEL. ROLLERS AND SCREW ARE STAINLESS STEEL. INTERNAL SLIDES ARE STAINLESS STEEL AND CELCON.

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FILE NAME: 1988-8000-REV-SS

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

DRAWN JMS NOV-28-05

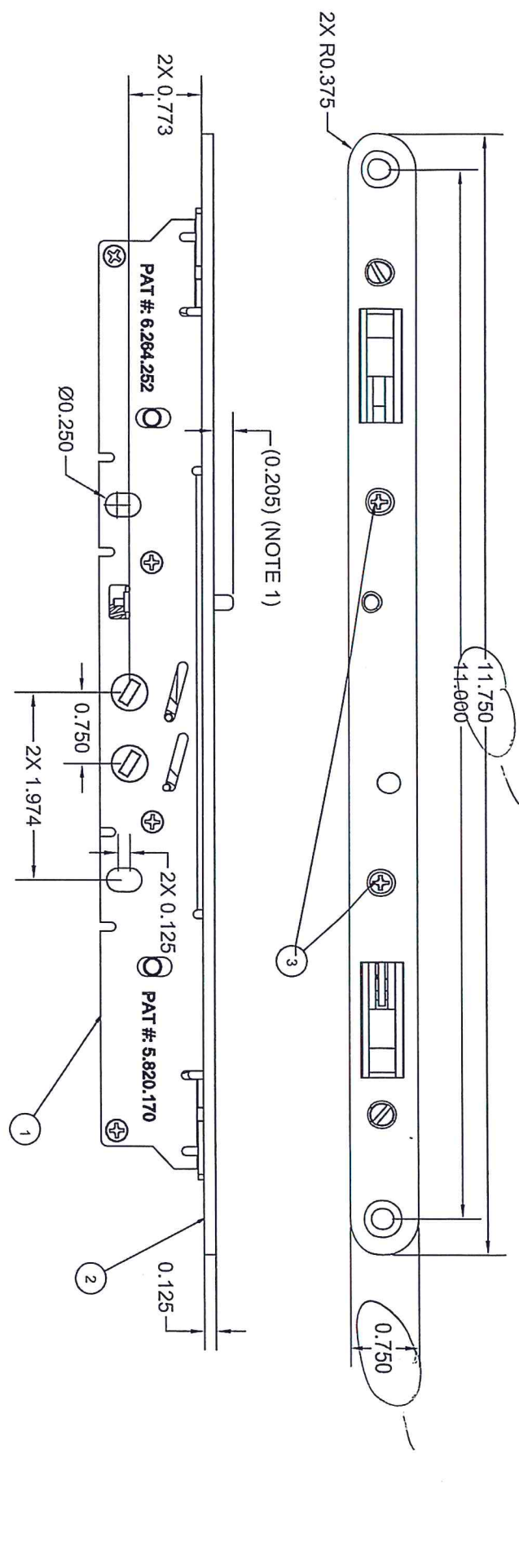
CHKD

APPD



DOOR HARDWARE
AMESBURY GROUP

TITLE TA-88-BSS-166
W/ REVERSED MTG TAB
SCALE 1/1
DWG. NO. 1988-8000-REV-SS



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

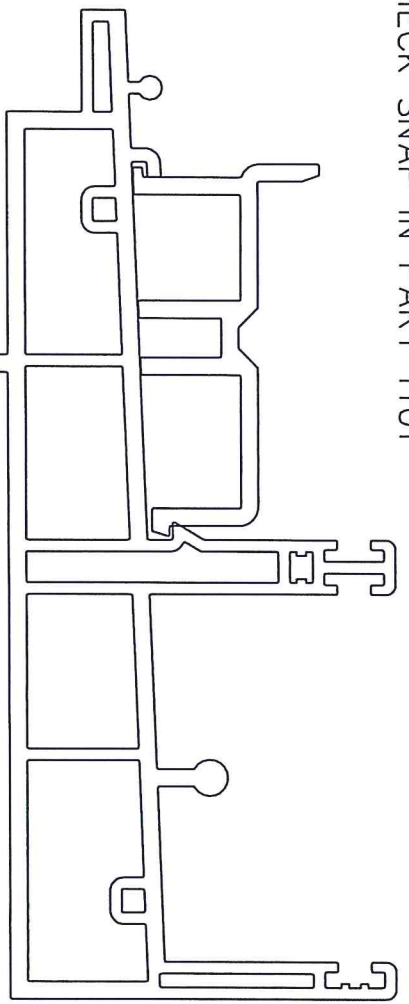
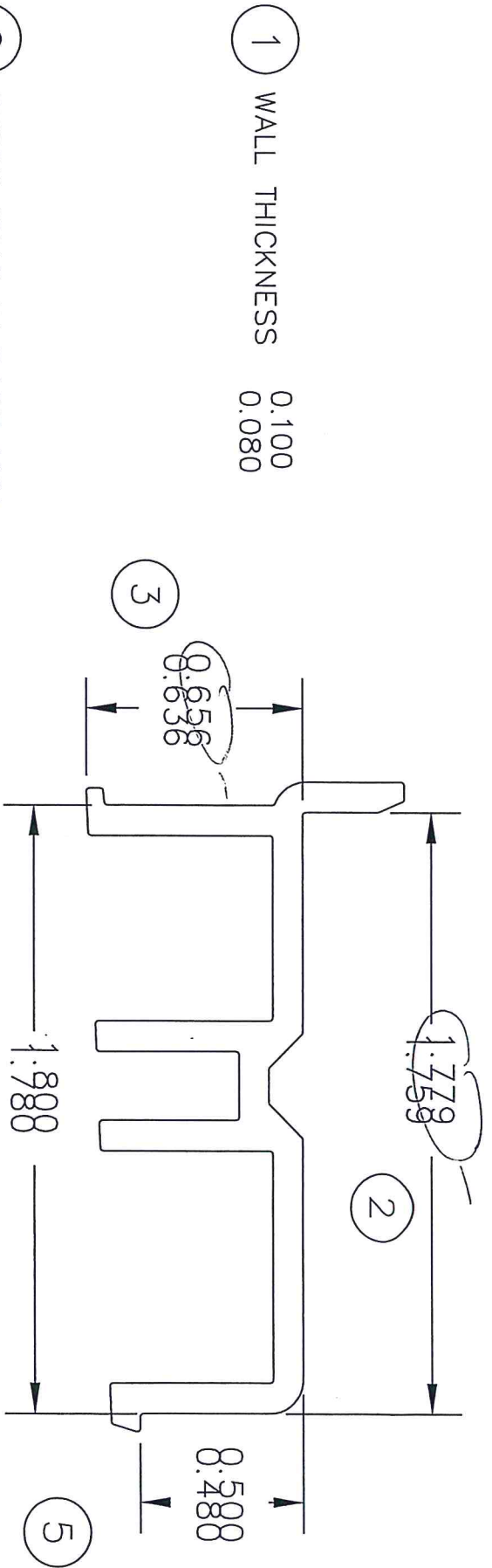
TEST OF DESIGN COMPLIES

- 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 DETAILS ANY REVISIONS WITH PART NUMBER MATRIX.	#	ECN #	BY	Date: 1/4/2007	Drawing Title: GEMINI II LOCK W/ 2450 TRIMPLATE
REPORT NO. NCTL - 210 - 4047-2A	TEST DATE: 09/23/16	A	0342	NG	Scale: N/A	Sheet of A
					Units: INCH	Rev.
					Tolerance Decimal: ± .010	
					Angular: ± 1'	
					Part #: 2817	
					Drawing Title: GEMINI II LOCK W/ 2450 TRIMPLATE	
					Part #: 2817	

POOR HARDWARE AMESBURY GROUP
 1111 West Algonquin Street - Sioux Falls, SD 57104
 Phone: (605) 330-1011 FAX: (605) 330-4229



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4044-2A TEST DATE: 09/23/16



Deceuninck® NORTH AMERICA/Oakland N.J.

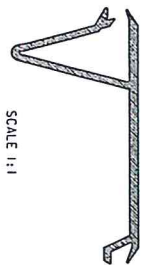
AREA= TOTAL WEIGHT= TOL: ±0.010

FILENAME: path		DATE		MATERIAL		SCALE	
BY	CTC	11/14/05		PVC		2:1	

SILL INSERT

10001105_SH

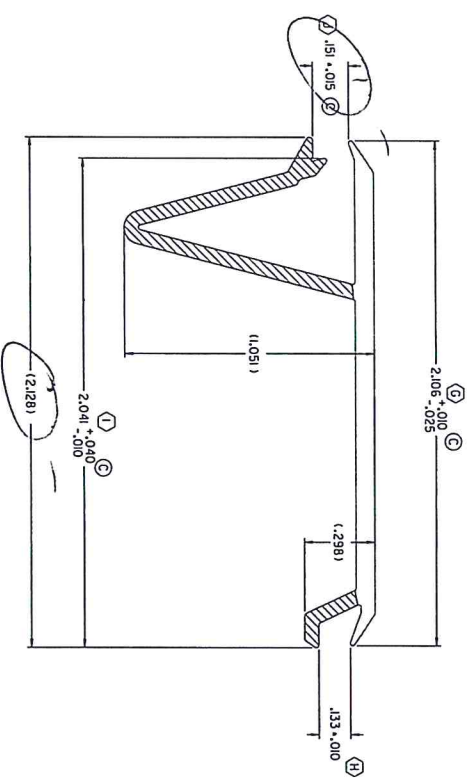
REV	BY	APPVD	DATE	CHANGE
-----	----	-------	------	--------



SCALE 1:1

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

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPROVED
B	G01-3	07/02/04	DBF
C	TOLERANCE CHANGE, WAS +/- .010	08/08/06	JGM



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

REPORT NO. NCTL - 210 - July-24

TEST DATE: 09/23/16

- NOTES:
1. ST00003 STRAIGHTNESS CLASS E AND LENGTH TOLERANCES APPLY (A)
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER ST00013 (B)
 3. UNSPECIFIED EXTERNAL RADI = .xxx +.010 / -.005 (C)
 4. UNSPECIFIED INTERNAL RADI = .xxx +.020 / -.005 (D)
 5. UNSPECIFIED EXTERNAL WALL THICKNESS = .xxx +/- .10X (E)
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .xxx +/- .20X (F)

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UNLESS OTHERWISE SPECIFIED
 2 PL ± 0.010° 3 PL ± 0.005°
 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:
FLAVOR:	DATE:
7396JDN	

NAME: **deceunick** NORTH AMERICA

FRAME ADAPTOR

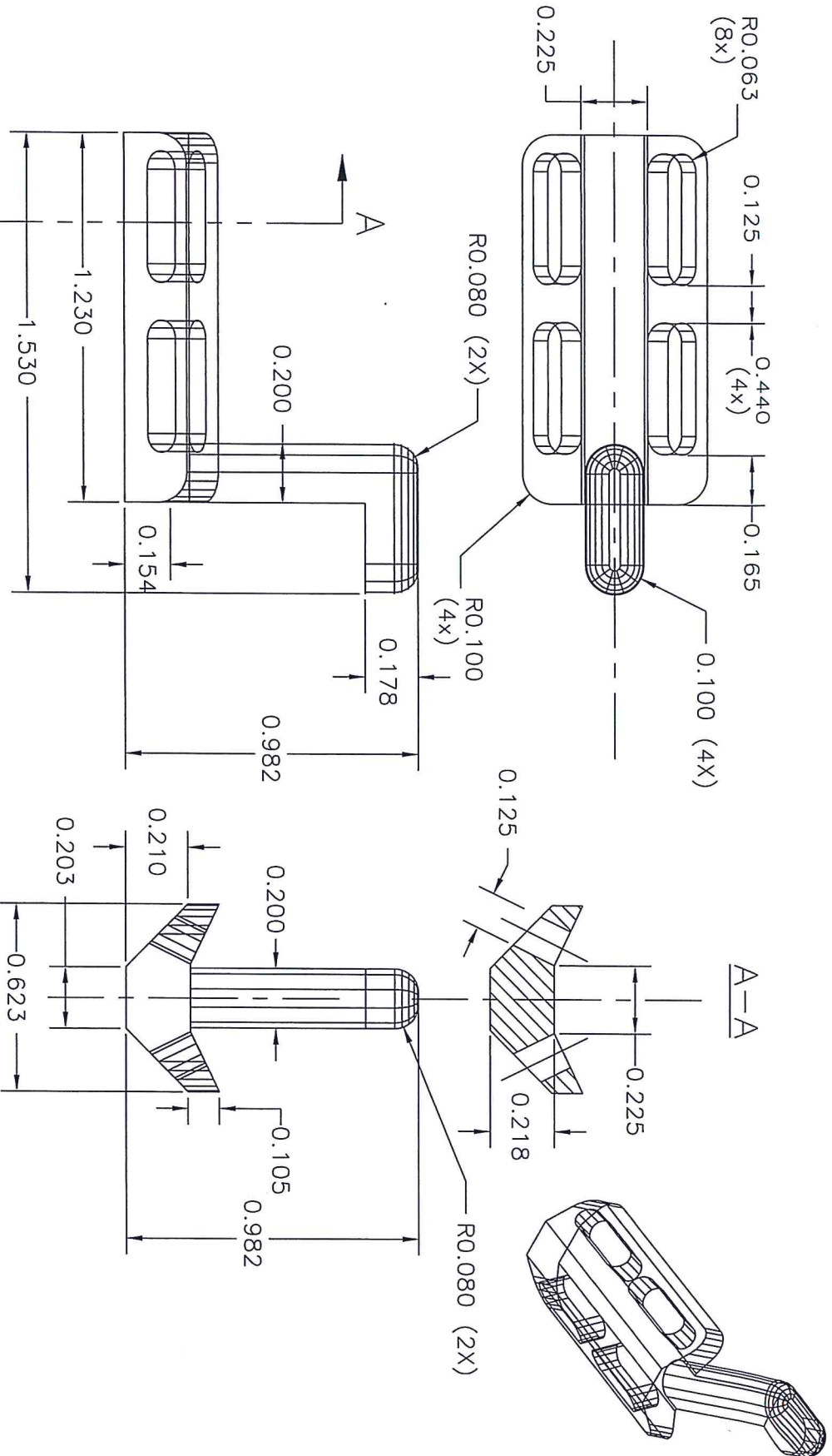
SIZE DWG. NO: 1000104.S4

SCALE: 2:1 (RESCALE) .87

SHEET: C

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A 011H040



TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED. REPORT NO. NCTL - 210 - 4044-01# TEST DATE: 07/23/16

Vinylline®
VINYL BUILDING PRODUCTS INC.
 AREA =
 WEIGHT = 0.143 cu in
 TOLERANCES (EXCEPT AS NOTED)
 ±0.010

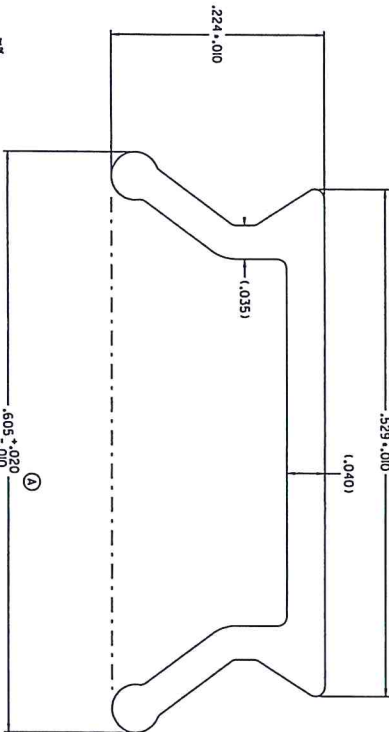
REV	BY	APPV'D	DATE	CHANGE
DRAWN <i>MG</i> DATE 7/15/02 APPV'D				
SCREEN KEEPER				
MATERIAL ZINC SCALE 2/1				
011H040				



SCALE 1:1

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

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

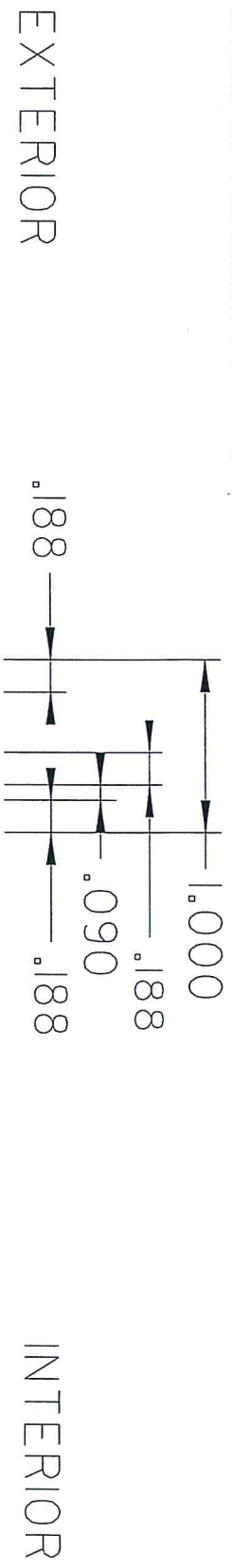


TEST SPECIMEN COMPLIES WITH THESE DETAILS. ANY DEVIATION IS NOTED.
 REPORT NO. NCTL - 210 - 4644-22A
 TEST DATE: 09/23/06

- NOTES:
1. 'STD0003' STRAIGHTNESS CLASS A AND LENGTH TOLERANCES APPLY
 2. INTERPRET ALL TOLERANCE APPLICATIONS PER STD0003
 3. UNSPECIFIED EXTERNAL RADI = .XXX ± .010 / -.005
 4. UNSPECIFIED INTERNAL RADI = .XXX ± .010 / -.005
 5. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX ± .10%
 6. UNSPECIFIED INTERNAL WALL THICKNESS = .XXX ± .20%

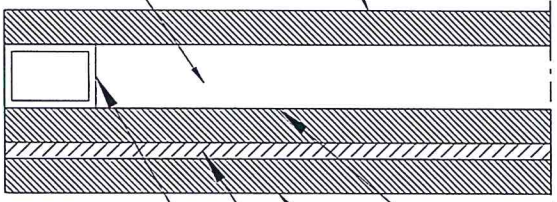
CONFIDENTIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS SHALL BE IN INCHES	
UNPUBLISHED WORK © 2007 DECEUNINCK NORTH AMERICA		2 PL ± 0.010 3 PL ± 0.005 INTERPRET DIM AND TOL PER ASME Y14.5M - 1994	
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DESIGN BY:	PGM:	DATE:	DATE:
DRAWN BY:	JGM	07/01/02	
AUTH:		DATE:	
AUTH:		DATE:	
FILENAME:	1000IIB.SH.dgn		
 241 NORTH WASHINGTON AVENUE MONROE, LA 70002		SCALE: 8:1 SHEET: 1 OF 1	

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



3/16" TEMPERED GLASS

3/8" AIR SPACE



3/16" ANNEALED GLASS

3/16" ANNEALED GLASS

.090" SGP BY DUPONT

QUANEX DURASEAL OR 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

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

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UNLESS OTHERWISE SPECIFIED
 DIM ARE IN INCHES
 TOL ON ANGLES = 1°
 2 PL.: ± 0.010" 3 PL.: ± 0.005"
 INTERPRET DIM AND TOL PER
 ASME Y14.5M - 1994

THIRD ANGLE PROJECTION



DESIGN BY: CRB

DATE: 16/09/08

DRAWN BY: CRB

DATE: 16/09/08

AUTH: DATE:

AUTH: DATE:

FILENAME: 182341

deceuninck

Deceuninck North America
 351 N. Garner Road
 Monroe, OH 45050

NAME: 1" OA IG WITH 3/16" PANELS

SIZE DWG. NO: 1" OA IG WITH 3/16" PANELS

SCALE: 1:1 (LBS/FT.) SHEET: REV. NEW

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.

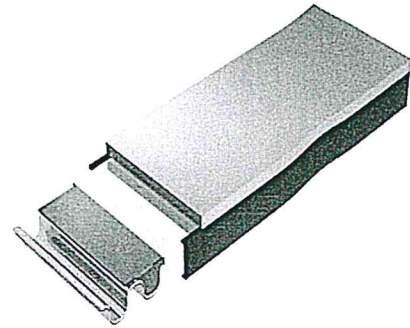


ISO 9001:2008 with design
Certificate Registration 08.185.1

**TEST SPECIMEN COMPLIES
WITH THESE DETAILS. ANY
DEVIATION IS NOTED.
REPORT NO. NCTL - 210 - 4044-02A
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.	

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

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

REPORT NO. N87L 210

4044-02A

TREMCO

Silicone

TEST DATE: 09/23/14

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.

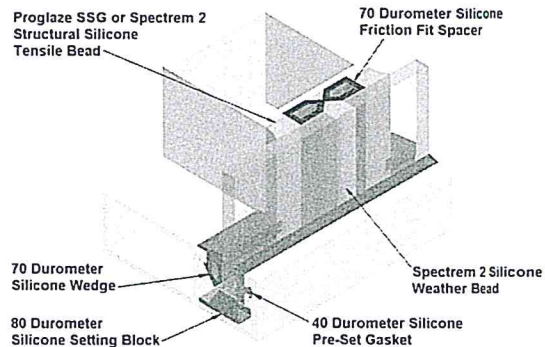
Availability/Cost

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.



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REPORT NO. NCTL - 210 - 4044-02A
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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.

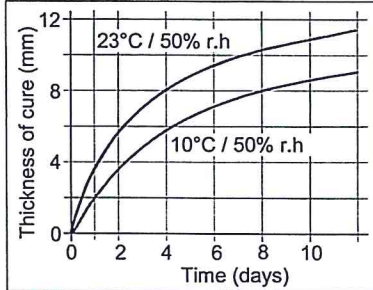


Diagram 1: Curing speed Sikaflex®-552

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 trials. 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:

Chemtec: 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



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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.

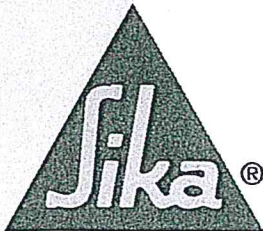
LIMITED WARRANTY

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.

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

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Industry Division
30800 Stephenson Highway
Madison Heights, Mi 48071
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Fax 248 577 0810



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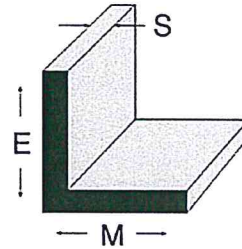
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Architectural Aluminum Angle

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.

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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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EMS TX

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 (281) 656-2297 - fax

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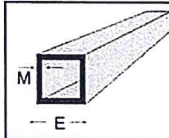
e-mail: info@EasternMetal.com

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.



Punched Picket Spear
(see below)



+ Post Stiffener
I-Beams Reinforcement Available See Railing p16



Ribbed Dock
Square Tube Used for Dock Applications (see below)



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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Additional Locations: West Palm Beach & Lakeland, FL, Newark, DE and Birmingham, AL
website: www.EasternMetal.com e-mail: info@EasternMetal.com Version: 07/14

TEST SPECIMEN COMPLIES WITH THESE DETAILS AND DEVIATION IS NOTED.

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