

**AAMA/WDMA/CSA 101/I.S.2/A440-08  
TEST REPORT**

**Rendered to:**

**EAGLE WINDOW & DOOR, INC**

**SERIES/MODEL: Series 02 Axiom Clad Casement  
Vent 2460 with Egress Hardware**

**PRODUCT TYPE: Aluminum Clad Casement Window**

<b>Title</b>	<b>Summary of Results</b>
AAMA/WDMA/CSA 101/I.S.2/A440-08	LC-PG40-C 711 x 1829 (28 x 72)*
Design Pressure	2160 Pa (45.0 psf)
Negative Design Pressure	1920 Pa (40.0 psf)
Operating Force (in motion)	22 N (5.0 lbf)
Air Infiltration	<0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Water Penetration Resistance Test Pressure	330 Pa (6.75 psf)
Uniform Load Structural Test Pressure	+3240, -2880 psf (+67.6, -60.0 psf)
Forced Entry Resistance	Grade 10

**Test Completion Date:** 02/08/08

Reference must be made to Report No. 80181.01-201-44, dated 12/03/08 for complete test specimen description and data. Reference Architectural Testing, Inc. Report No. 67836.01-201-44, dated 12/03/08 for complete *Gateway* test specimen description and test results

**AAMA/WDMA/CSA 101/I.S.2/A440-08 TEST REPORT**

Rendered to:

EAGLE WINDOW & DOOR, INC.  
2045 Kerper Boulevard  
Dubuque, Iowa 52004-1072

Report No.: 80181.01-201-44  
Test Dates: 02/06/08  
Through: 02/08/08  
Report Date: 03/03/08  
Revision Report Date: 12/03/08  
Expiration Date: 02/06/12

**Project Summary:** Architectural Testing, Inc. was contracted by Eagle Window & Door, Inc. to perform testing on a Series 02 Axiom Clad Casement Vent 2460 with Egress Hardware, Aluminum Clad Casement Window. The sample tested successfully met the performance requirements for a LC-PG40-C 711 x 1829 (28 x 72)\* rating. Test specimen description and results are reported herein.

Reference Architectural Testing, Inc. Report No. 67836.01-201-44, dated 12/03/08 for complete *Gateway* test specimen description and test results.

**General Note:** *An asterisk (\*) next to the size designation indicates that the size tested for optional performance was smaller than the Gateway test size for the product type and class.*

**Test Specification:** The test specimen was evaluated in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-08, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights.*

**Test Specimen Description:**

**Series/Model:** Series 02 Axiom Clad Casement Vent 2460 with Egress Hardware

**Product Type:** Aluminum Clad Casement Window

**Overall Size:** 711 mm (28") wide by 1828 mm (72") high

**Sash Size:** 631 mm (26-1/2") wide by 1790 mm (70-1/2") high

**Overall Area:** 1.3 m<sup>2</sup> (14.0 ft<sup>2</sup>)

**Test Specimen Description:** (Continued)

**Finish:** Interior wood was natural and the exterior aluminum cladding was white.

**Frame Construction:** The wood frame was of laminated veneer lumber (LVL) with corners rabbet jointed, butted, sealed with silicone and secured with two 11 mm (7/16") crown by 38 mm (1-1/2") long staples per corner. Extruded aluminum cladding was slip-fit over the wood frame members with the corners miter cut, sealed with silicone and secured with a nylon corner key and two #8 by 11 mm (7/16") screws. The head stop was secured with 5 mm (3/16") by 29 mm (1-1/8") long staples spaced approximately 152 mm (6") on center. The side stops were secured with glue and a vinyl spline. The sill operator cover was secured with three #8 by 54 mm (2-1/8") screws.

**Sash Construction:** The sash members were of molded pine. The corners utilized mortise and tenon construction and were secured with glue and one #7 by 32 mm (1-1/4") screw per corner. Extruded aluminum cladding was slip-fit over the wood sash members with the corners miter cut, silicone sealed and secured with a nylon corner key and one #5 by 38 mm (1-1/2") screw per corner.

**Weatherstripping:**

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
0.267" diameter hollow bulb	1 Row	Sash stiles and top rail
0.320" diameter foam filled bulb	1 Row	Interior frame perimeter
Vinyl spline	1 Row	Between frame jambs and stop

**Glazing Details:** The window utilized a nominal 18 mm (11/16") thick insulating glass fabricated from two sheets of nominal 3 mm (1/8") annealed glass separated by an aluminum spacer system. The glass was set from the interior against hot melt silicone. Wood glazing stops with single sided adhesive foam tape were utilized on the interior and secured with 32 mm (1-1/4") brads spaced 25 mm (1") from each corner and 152 mm to 203 mm (6" to 8") on center.

**Test Specimen Description:** (Continued)

**Hardware:**

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
Casement egress operator with track	1	Frame sill/bottom rail
Casement operator bracket	1	Bottom rail of sash
3-point lock system with keeper	1	Locking jamb/stile 64 mm (12-1/2") and from head and sill and midspan
254 mm (10") metal egress hinge with track	2	Frame head and sill/rails

**Installation:** The window was installed within wood test buck. The window was secured to the buck with an applied nailing fin which was set in silicone and secured with 51 mm (2") nails spaced approximately 152 mm (6") on center. Silicone sealant was also applied over the fastener heads. Masonry clips were utilized 610 mm (24") from each end of jamb and secured to the frame with four #8 by 16 mm (5/8") screws and to the wood surround with two #8 by 38 mm (1-1/2") screws.

**Test Results:** The temperature during testing was 21°C (70°F). The results are tabulated as follows:

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
5.3.1	Operating Force		
	Open		
	Breakaway	31 N (7.0 lbf)	--
	Maintain Motion	22 N (5.0 lbf)	45 N (10 lbf)
	Close		
	Breakaway	27 N (6.0 lbf)	--
	Maintain Motion	22 N (5.0 lbf)	45 N (10 lbf)
	Lock		
Open	27 N (6.0 lbf)	100 N (22.5 lbf)	
Close	31 N (7.0 lbf)	100 N (22.5 lbf)	

**Test Results:** (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
5.3.2.1	Air Infiltration per ASTM E 283		
	75 Pa (1.6 psf, 25 mph)	<0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.30 cfm/ft <sup>2</sup> ) max.
	300 Pa (6.2 psf, 50 mph)	<0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	-- --

**Note #1:** The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 for air leakage resistance.

5.3.3.2	Water Resistance per ASTM E 547		See Note #2
5.3.4.2	Uniform Load Deflection per ASTM E 330		See Note #2
5.3.4.3	Uniform Load Structural per ASTM E 330		See Note #2

**Note #2:** The client opted to start at a pressure higher than the minimum required. Those results are listed under Optional Performance.

5.3.5	Forced Entry Resistance per ASTM F 588		
	Type: B	Grade: 10	
	Disassembly Test	No entry	No entry
	Tests B1 through B3	No entry	No entry
	Sash/Panel Manipulation Test	No entry	No entry
	Lock Hardware Manipulation Test	No entry	No entry
5.3.6.4.3	Vertical Deflection Test Sash Vertical Deflection Test		
	270 N (60.0 lbf)	1.3 mm (0.05")	13.5 mm (0.53")
5.3.6.6.6	Hardware Load Test Distributed Load Test		
	300 Pa (6.24 psf)	No damage	No damage

Optional Performance

4.3.2.1	Water Resistance per ASTM E 547		
	330 Pa (6.75 psf)	No leakage	No leakage

**Test Results:** (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
<u>Optional Performance</u> (Continued)			
4.3.2.1	Uniform Load Deflection per ASTM E 330 (Deflections reported were taken on the sash stile) (Loads were held for 60 seconds)		
	2160 Pa (45.0 psf) (positive)	3.1 mm (0.12")	See Note #3
	1920 Pa (40.0 psf) (negative)	28.2 mm (1.11")	See Note #3

***Note #3:** The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440-08 for this product designation. The deflection data is recorded in this report for special code compliance and information only.*

4.3.2.1	Uniform Load Structural per ASTM E 330 (Permanent set reported were taken on the sash stile) (Loads were held for 10 seconds)		
	3240 Pa (67.5 psf) (positive)	1.0 mm (0.04")	5.1 mm (0.20") max.
	2880 Pa (60.0 psf) (negative)	1.5 mm (0.06")	5.1 mm (0.20") max.

Tape and film were used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

**Drawing Reference:** The test specimen drawings have been reviewed by Architectural Testing, Inc. and are representative of the test specimen reported herein.

**List of Official Observers:**

<u>Name</u>	<u>Company</u>
Chad Cornell	Eagle Window & Door
Jim Welter	Eagle Window & Door
Anthony D. Gavin	Architectural Testing, Inc.
Karl A. Lips-Eakins	Architectural Testing, Inc.
Eric J. Schoenthaler	Architectural Testing, Inc.

Detailed drawings, data sheets, representative samples of test specimens, a copy of this report, or other pertinent project documentation will be retained by Architectural Testing, Inc. for a period of four years from the original test date. At the end of this retention period, such materials shall be discarded without notice and the service life of this report will expire.

Results obtained are tested values and were secured by using the designated test methods. No conclusions of any kind regarding the adequacy or inadequacy of the glass in the test specimen can be made. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimens tested. This report may not be reproduced, except in full, without the written approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, INC.

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Eric J. Schoenthaler  
Project Manager

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Daniel A. Johnson  
Director - Regional Operations

EJS/mb

Attachments (pages): This report is complete only when all attachments listed are included.

- Appendix-A: Alteration Addendum (1)
- Appendix-B: WDMA Submittal Form (2)
- Appendix-C: Drawings (18)

### Revision Log

<u>Rev. #</u>	<u>Date</u>	<u>Page(s)</u>	<u>Revision(s)</u>
0	03/03/08	N/A	Original report issue. Report and drawings forwarded to AMS for Hallmark Certification.
1	04/08/08	Page 3	Removed unnecessary hardware. Report and drawings forwarded to AMS for Hallmark Certification.
2	12/03/08	All	Test report results conducted prior to 2008 standard being published, report is as compared to 2008 standard. Report and drawings forwarded to AMS for Hallmark Certification.

**Appendix A:**  
**Alteration Addendum**

*Note: No alterations were required,*

**Appendix B**  
**WDMA Submittal Forms**



# WDMA HALLMARK CERTIFICATION PROGRAM REPORT SUBMISSION FORM

THIS FORM IS TO BE COMPLETED BY THE MANUFACTURER AND SUBMITTED TO AMS PRIOR TO OR ALONG WITH SUBMISSION OF EACH NEW OR REVISED TEST REPORT FOR CERTIFICATION TO THE HALLMARK PROGRAM. ANY QUESTIONS PLEASE CONTACT AMS AT 315-646-2234 OR [staff@amscert.com](mailto:staff@amscert.com).

Manufacturer: Eagle Window and Door, Inc.

Contact: Todd Bergstrom

Plant Location(s):  
(list all plants where product is made)  
2045 Kerper Blvd. Dubuque, IA 52004-1072

Phone: 563-556-2270

Test Report #: 80181.01-201-44-R2

Email: tbergstrom@eaglewindow.com

Product Relationship:

Extension of currently certified product?  yes  no  n/a      Recertification  New  (check one)

If yes, what CCL # ? 099-H-655.06

Difference from Certified Product: Report re-written to A440.08 standard.

Is this a Gateway Test ?  yes  no  n/a

Does this report require a Gateway Report # ?  yes  no  n/a      Report #: \_\_\_\_\_

Impact Report:

If this is not an impact report check here:

AWS Report # \_\_\_\_\_

Test Plan # ?  yes  no  n/a \_\_\_\_\_

Installation Instructions submitted ?  yes  no  n/a

Certification to Florida:

If this will not be submitted to Florida check here:

AMS to Input to Database  yes  no  n/a

Manufacturer to input  yes  no  n/a



# WDMA HALLMARK CERTIFICATION PROGRAM REPORT SUBMISSION FORM

Product Name: Series 02 Axiom Clad Casement Vent 2460 with egress hardware.  
(as to be listed on CCL)

Product Type: Casement

Additional Manufacturer ID #: \_\_\_\_\_

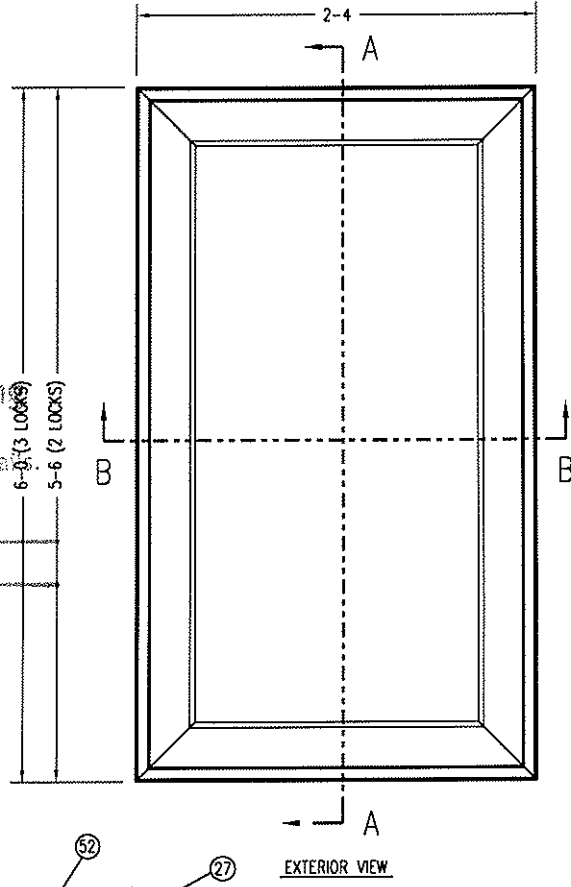
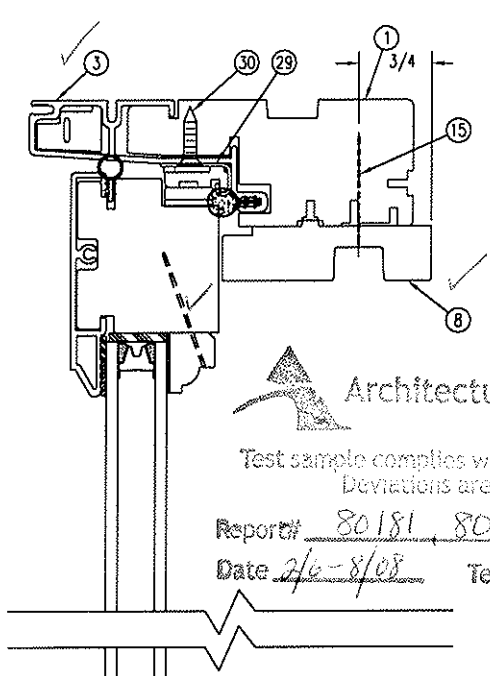
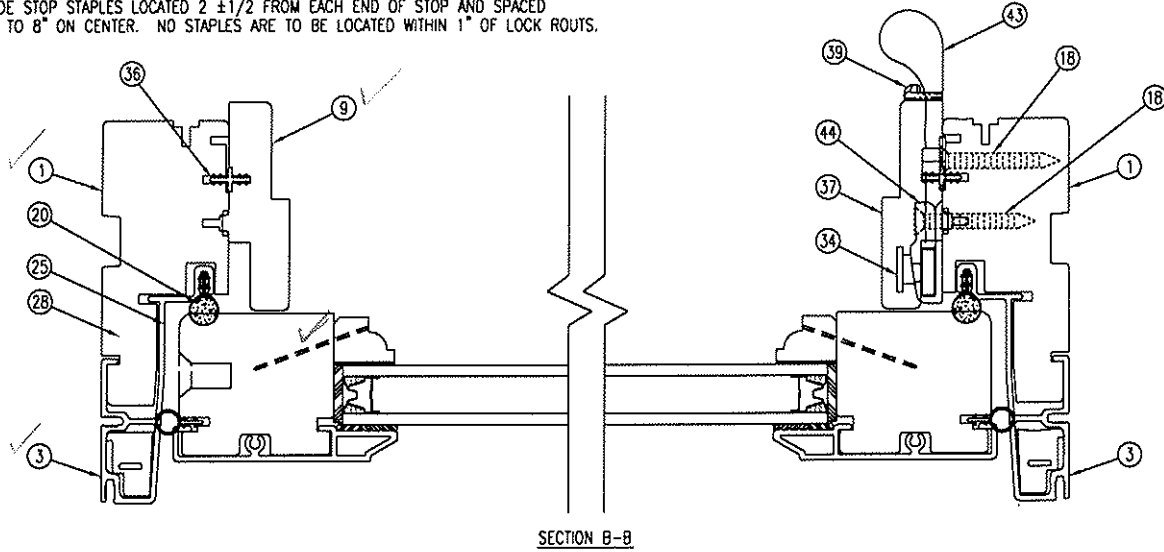
n/a

<u>Hallmark CCL</u>	<u>Standard</u>	<u>Rating</u>
<input type="checkbox"/>	ANSI/AAMA/NWWDA 101/I.S. 2 97	_____
<input type="checkbox"/>	101/I.S.2/NAFS-02	_____
<input type="checkbox"/>	AAMA/WDMA/CSA/101/I.S.2/A440-05	_____
<input checked="" type="checkbox"/>	AAMA/WDMA/CSA/101/I.S.2/A440-08	LC-PG40-C +45 / -40
<input type="checkbox"/>	ASTM E 1996 99 / E1886-97	_____
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<input type="checkbox"/>	ASTM E 1996 05 / E1886-05	_____
<input type="checkbox"/>	ASTM E330 02	_____
<input type="checkbox"/>	ANSI A250.13-03	_____
<input type="checkbox"/>	TAS 201-94	_____
<input type="checkbox"/>	TAS 202-94	_____
<input type="checkbox"/>	TAS 203-94	_____
<input type="checkbox"/>	Other:	_____

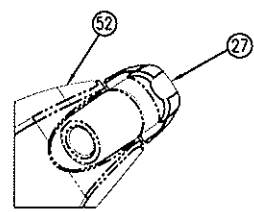
## **Appendix C**

### **Drawings**

NOTE: 1. STAPLES TO BE 0 TO 1/32" BELOW SIDE STOP SURFACE.  
 2. SIDE STOP STAPLES LOCATED 2 ± 1/2 FROM EACH END OF STOP AND SPACED 6" TO 8" ON CENTER. NO STAPLES ARE TO BE LOCATED WITHIN 1" OF LOCK ROUTS.



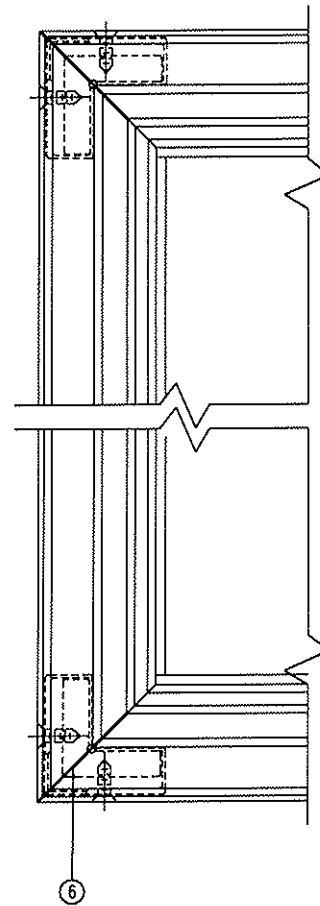
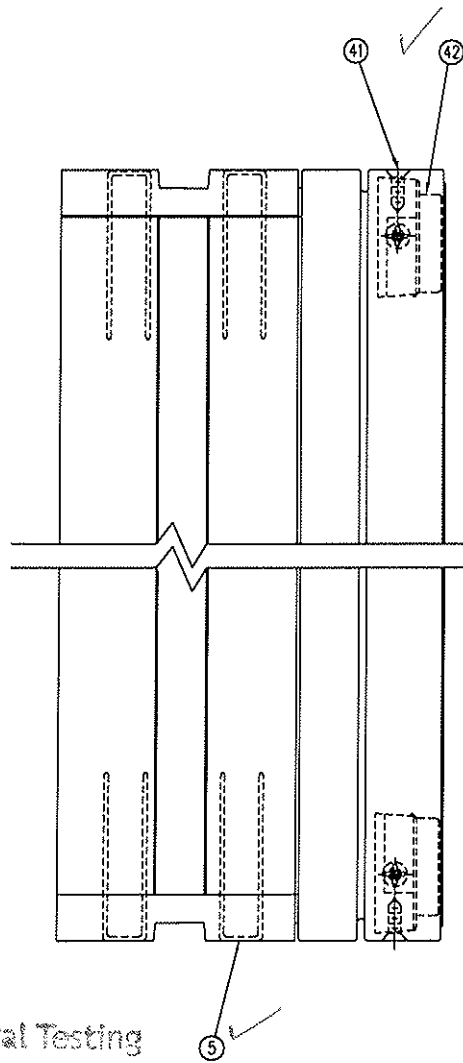
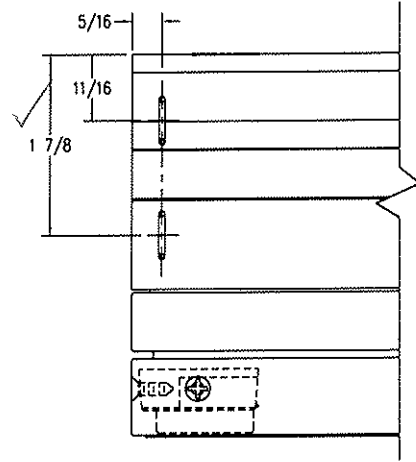
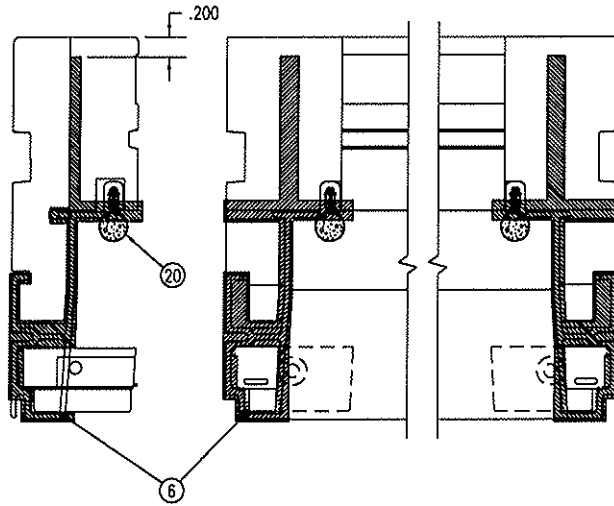
Architectural Testing  
 Test sample complies with these details.  
 Deviations are noted.  
 Report# 80181, 80182  
 Date 2/6-8/08 Tech gfk



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TITLE: CLAD CASEMENT VENT W/ EGRESS HDWE UNIT ASSEMBLY			
FINISH:			
MATERIAL:			
DFT: CRC	SCALE: 1=2		
DCN: 0710	DRWC: 055H		
DATE: 1/4/08	C	01 OF 09	

NO	DESCRIPTION	DFT	DOC	DATE

NOTE: 1. INSERT CORNER KEY BEFORE APPLYING SEALANT.



Architectural Testing

Test sample complies with these details.  
Deviations are noted.

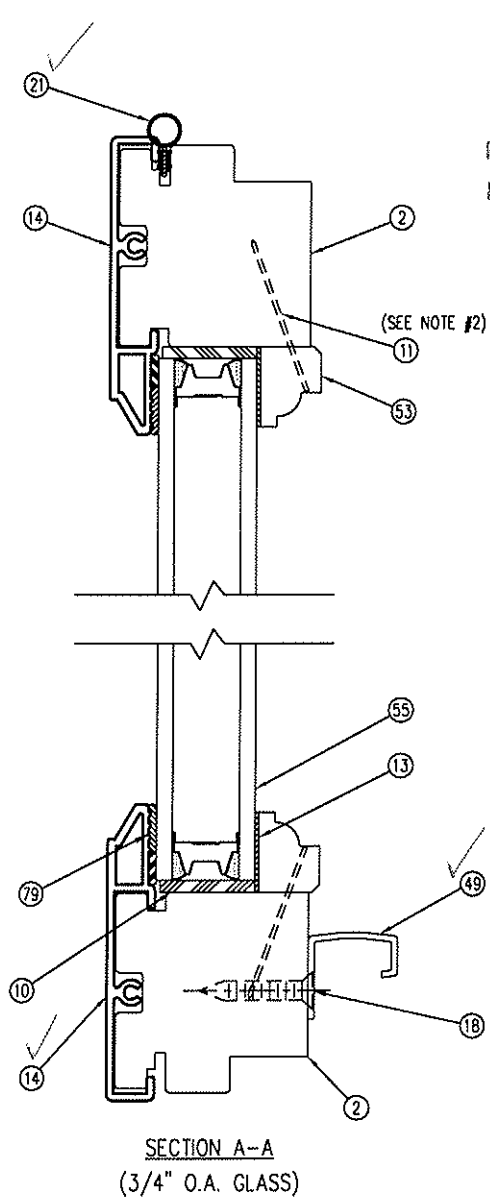
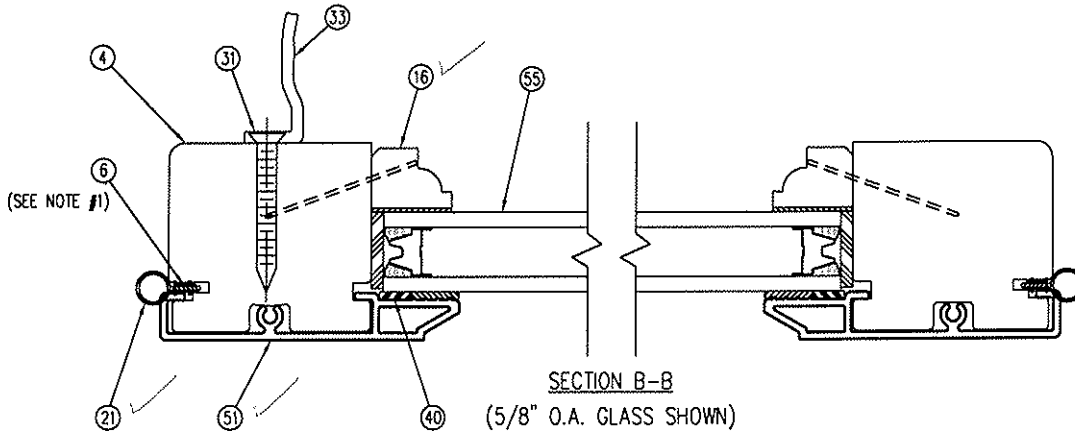
Report# 80181, 80182

Date 2/6-8/08 Tech JPK

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TITLE: CLAD CASEMENT VENT W/ EGRESS HDWE UNIT ASSEMBLY			
FINISH:			
MATERIAL:			
DFT:	CRC	SCALE:	1=2
DCN:	0710	DRWG:	055H
DATE:	1/4/08	C	02

NO	DESCRIPTION	DFT	DOC	DATE

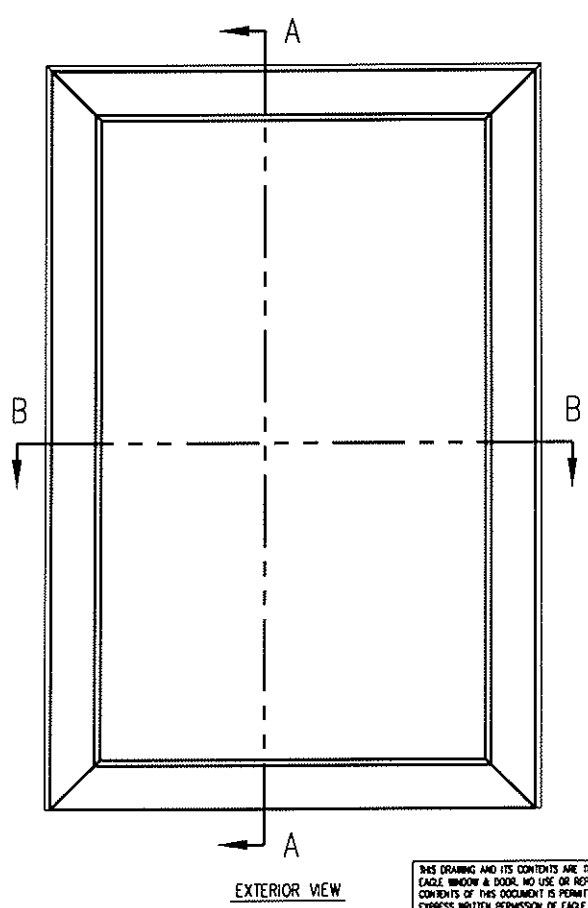
NOTE: 1. SILICONE SEALANT TO BE APPLIED TO THE CORNERS OF THE SASH BULB GROOVE PRIOR TO INSERTING THE BULB WEATHERSTRIP. THE SEALANT SHOULD FILL THE GROOVE FOR APPROX. 1/8" LENGTH FROM EACH CORNER.  
 2. BRADS TO BE 1/32" TO 1/16" BELOW GLAZING STOP SURFACE.



**Architectural Testing**

Test sample complies with these details.  
 Deviations are noted.

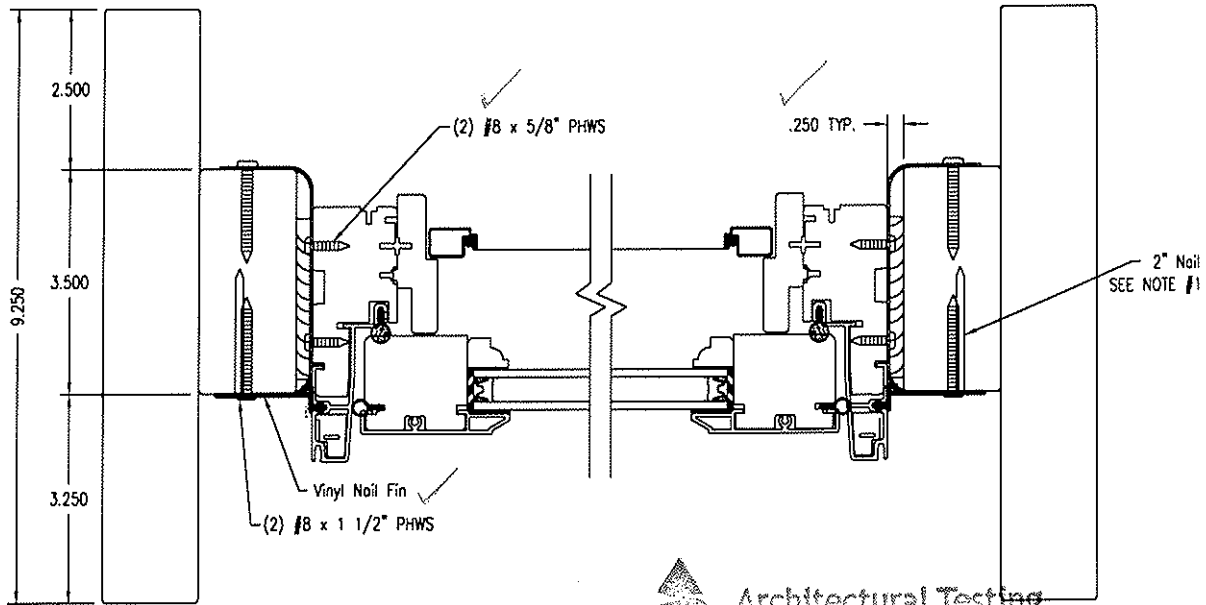
Report# 80181, 80182  
 Date 2/6-8/08 Tech JPK



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TITLE: CLAD CASEMENT VENT W/ EGRESS HDWE SASH ASSEMBLY			
FINISH:			
MATERIAL:			
DFT:	CRC	SCALE:	1=1 1/2
DCN:	0710	DRWG:	055H
DATE:	1/4/08	C	03

NO	DESCRIPTION	DFT	DOC	DATE

1. CENTER NAIL FIN, PLACE NAIL IN FIRST HOLE AND THEN EVERY OTHER THERE AFTER. 2" ROOFING NAILS THROUGH NAIL FIN INTO WALL.

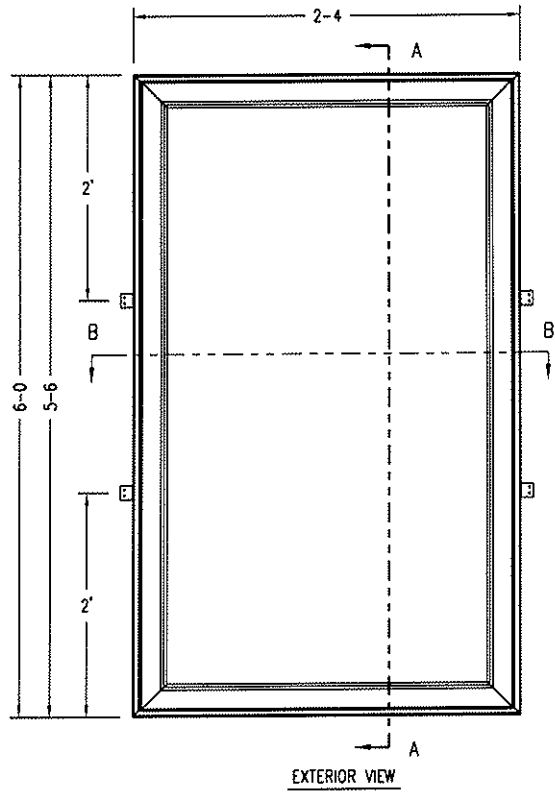
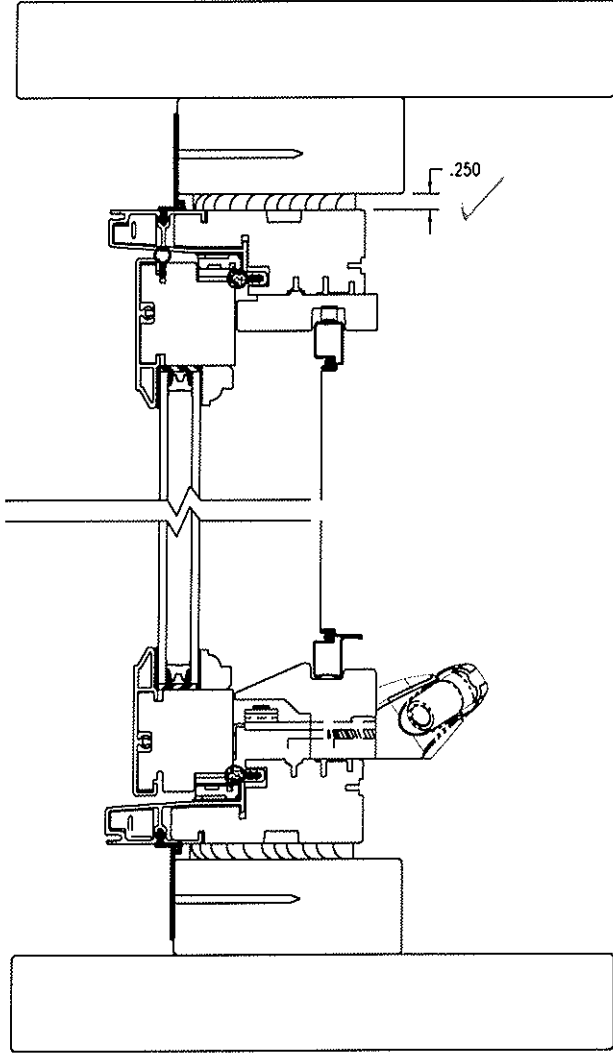


**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# 80181, 80182

Date 2/16-8/08 Tech gpk



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TITLE: CLAD CASEMENT VENT  
INSTALLATION DETAIL

FINISH:

MATL:

DFT: CRC SCALE: 1=3  
DCN: 0710 DRWG: 0550  
DATE: 12/21/07 C 01 OF 02

NO.	DESCRIPTION	DFT	DOC	DATE

NO.	DWG. NO.	PART DESCRIPTION	QUANTITY	MATERIAL	SUPPLIER
✓ 1	220L	SIDE JAMB	4	WOOD (LVL)	EAGLE WINDOW & DOOR
✓ 2	21DE	RAIL	2	WOOD	EAGLE WINDOW & DOOR
✓ 3	A04A	FRAME CLADDING	4	ALUMINUM	BONNELL
✓ 4	21DF	STILE	2	WOOD	EAGLE WINDOW & DOOR
5	A15Y	7/16 X 1 1/2" 16GA. STAPLE	AS REQUIRED	STEEL	PACKAGING CORP.
6	A030	SILICONE SEALANT	AS REQUIRED	SILICONE	DOW CORNING
7	A01A	GLAZING TAPE	AS REQUIRED	BUTYL RUBBER	PTI INC.
✓ 8	220T	HEAD STOP	1	WOOD	EAGLE WINDOW & DOOR
✓ 9	20C0	HINGE SIDE STOP	1	WOOD	EAGLE WINDOW & DOOR
10	A00E	GLASS SETTING BLOCK	AS REQUIRED	NEOPRENE RUBBER	CLIM-A-TECH
11	A40F	1 1/4" HARDENED STEEL BRAD - 18 GA.	AS REQUIRED	STEEL	ABILITY FASTENERS
12	A08W	CORNER KEY	4	ABS COMPOUND	LAKE COUNTRY SALES
13	A67M	ADHESIVE FOAM TAPE	AS REQUIRED	POLYETHELENE	ADHESIVE RESEARCH
✓ 14	A07L	RAIL CLADDING	2	ALUMINUM	BONNELL
15	A00L	3/16 X 1 1/8 STAPLE	AS REQUIRED	GALVANIZED STEEL	ABILITY FASTENERS
16	220J	VERTICAL GLAZING STOP	2	WOOD	EAGLE WINDOW & DOOR
17	A01D	WOOD ADHESIVE	AS REQUIRED	COPOLYMER	NATIONAL STARCH
18	A070	#7 X 1 1/4" FHSMS Z&Y	AS REQUIRED	STAINLESS STEEL	ABILITY FASTENERS
✓ 19	223N	SILL COVER	1	WOOD	EAGLE WINDOW & DOOR
✓ 20	A55N	FRAME WEATHERSTRIP	4	CLOSED CELL FOAM	AMESBURY
✓ 21	A283	BULB WEATHERSTRIP - HEAD	1	PPR	INTEK
✓ 21	A32N	BULB WEATHERSTRIP - SIDES	2	PPR	INTEK
22					
23	A66D	CSMT DUAL ARM EGRESS OPERATOR	1	STEEL	ASHLAND HARDWARE
24	A00N	#8 X 2 1/8" FHWS Z & Y	AS REQUIRED	STEEL	SILCOVRSR
25					
26	A08L	#5 X 1 1/2" FHES	4	STAINLESS STEEL	ABILITY FASTENERS
27	A66R	FOLDING CRANK HANDLE	1	STEEL	ASHLAND HARDWARE
28	A279	#8 X 5/8" PH WS	2	STAINLESS STEEL	ABILITY FASTENERS
29	A673	HINGE TRACK - 10" S.S.	1	STEEL	ALLMETAL
30	A00R	#7 X 5/8" SS FH. WS.	3	STAINLESS STEEL	ABILITY FASTENERS
31	A39W	#7 x 1 1/4 FHSMS S.S.	4	STAINLESS STEEL	ABILITY FASTENERS
32	A35M	CASEMENT HINGE SHIM	1	RIGID PVC	CLIM-A-TECH
33	A549	LOCK KEEPER	2	STEEL	ASHLAND HARDWARE
34	A567	LOCK BAR ASSEMBLY (47.250 - 2 PT.)		STEEL	ASHLAND HARDWARE
34	A568	LOCK BAR ASSEMBLY (53.250 - 3 PT.)		STEEL	ASHLAND HARDWARE
35	A00P	#8 X 1" FH SMS	AS REQUIRED	STEEL	ABILITY FASTENERS
✓ 36	A67E	CONCEALED FASTENER SPLINE	AS REQUIRED		
37	20C2	LOCK SIDE STOP	1	WOOD	EAGLE WINDOW & DOOR
38	A672	HINGE ARM - 10" (EGRESS) (S.S.)	2	STEEL	ALLMETAL
39	A543	CSMT / AWNING - PLASTIC BEZEL	1	PLASTIC	ASHLAND HARDWARE
39	A544	CSMT / AWNING - ZINC BEZEL		PLASTIC	ASHLAND HARDWARE
40	A08K	GLAZING SHIM	AS REQUIRED	NEOPRENE RUBBER	CLIM-A-TECH
41	A11K	#8 X 7/16" FHSMS W/ #6 HEAD	8	STAINLESS STEEL	ABILITY FASTENERS
42	A100	CORNER KEY	4	NYLON	LAKE COUNTRY SALES
43	A551	CSMT / AWNING STD. LOCK HANDLE	1	DIE CAST ZINC	ASHLAND HARDWARE
44	A550	TIE BAR GUIDE	4	PLASTIC	ASHLAND HARDWARE



### Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report# 80181, 80182  
Date 2/6-8/08 Tech gpk

TITLE: CCV UNIT ASSEMBLY W/ EGRESS HARDWARE	
FINISH:	
MATL:	
DFT: CRC	SCALE: 1=1
DCN: 0710	DRWG: 055H
NO	DESCRIPTION
DFT	DOC
DATE	DATE: 1/4/08
	C 08

NO.	DWG. NO.	PART DESCRIPTION	QUANTITY	MATERIAL	SUPPLIER
46	A39W	#7 x 1 1/4" FHSMS S.S.	4	STAINLESS STEEL	ABILITY FASTENERS
	A54N	#6 x 1 1/4" 410 S.S. FH (TEKS TIP) (FOR HA		STAINLESS STEEL	ABILITY FASTENERS
47	A66J	SASH TRACK	1	STEEL	ALLMETAL
48	A00T	#7 x 7/8" FLAT HEAD WOOD SCREW	8	STAINLESS STEEL	ABILITY FASTENERS
49	A66E	DUAL ARM EGRESS OPERATOR BRACKET	1	STEEL	ASHLAND HARDWARE
50	A39K	#10 x 5/8" PFHMS S.S.	2	STAINLESS STEEL	ABILITY FASTENERS
51	A13C	STILE CLADDING	2	ALUMINUM	BONNELL
52	A66T	OPERATOR COVER (PLASTIC)	1	PLASTIC	ASHLAND HARDWARE
	A66W	OPERATOR COVER (ZINC DIE-CAST)		ZINC	ASHLAND HARDWARE
53	220N	HORIZONTAL GLAZING STOP	2	WOOD	EAGLE WINDOW & DOOR
54					
55	A019	3/4" INSULATED GLASS	1	GLASS	CARDINAL IG
	A08J	5/8" INSULATED GLASS		GLASS	CARDINAL IG
56	H-40	5/8" BETWEEN GLASS MUNTIN	AS REQUIRED	ALUMINUM	ALLMETAL
57	P/PD	1" CONTOUR MUNTIN	AS REQUIRED	ALUMINUM	ALLMETAL
58	220H	1 1/2" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
59	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
60	A507	1 1/2" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
61	A67X	1 1/2" MDL ADHESIVE TAPE (EXTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
62	A67L	1 1/2" MDL ADHESIVE TAPE (INTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
63	220H	1 1/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
64	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
65	A507	1 1/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
66	A67W	1 1/8" MDL ADHESIVE TAPE (EXTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
67	A67R	1 1/8" MDL ADHESIVE TAPE (INTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
68	220H	7/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
69	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
70	A507	7/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
71	A67T	7/8" MDL ADHESIVE TAPE (EXTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
72	A67N	7/8" MDL ADHESIVE TAPE (INTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
73	N/A	ADHESIVE TAPE	AS REQUIRED	POLYETHYLENE	CARDINAL IG
74	20FA	5/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
75	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
76	A72D	5/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
77	A75N	5/8" MDL ADHESIVE TAPE (EXTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
78	A75M	5/8" MDL ADHESIVE TAPE (INTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
79	A51H	INSTANT GLAZE II SEALANT	AS REQUIRED	SILICONE	DOW CORNING



## Architectural Testing

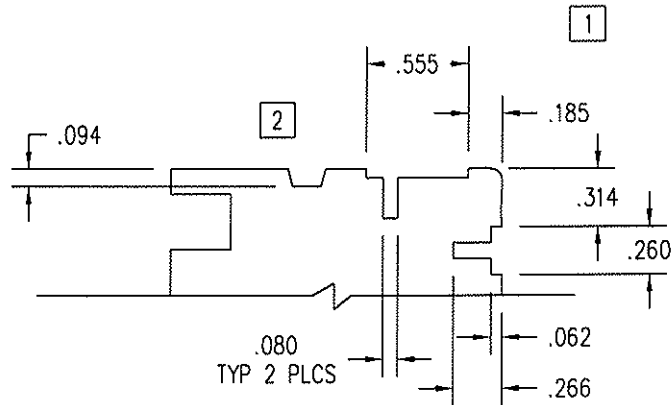
Test sample complies with these details.  
Deviations are noted.

Report# 80181, 80182  
Date 2/6-8/08 Tech JK

TITLE: CCV UNIT ASSEMBLY FOR CONCEALED LOCK	
FINISH:	
MATL:	
DFT: CRC	SCALE: 1=1
DCN: 0710	DRWG: 055H
DATE: 1/4/08	C 09

NO	DESCRIPTION	DFT	DOC	DATE
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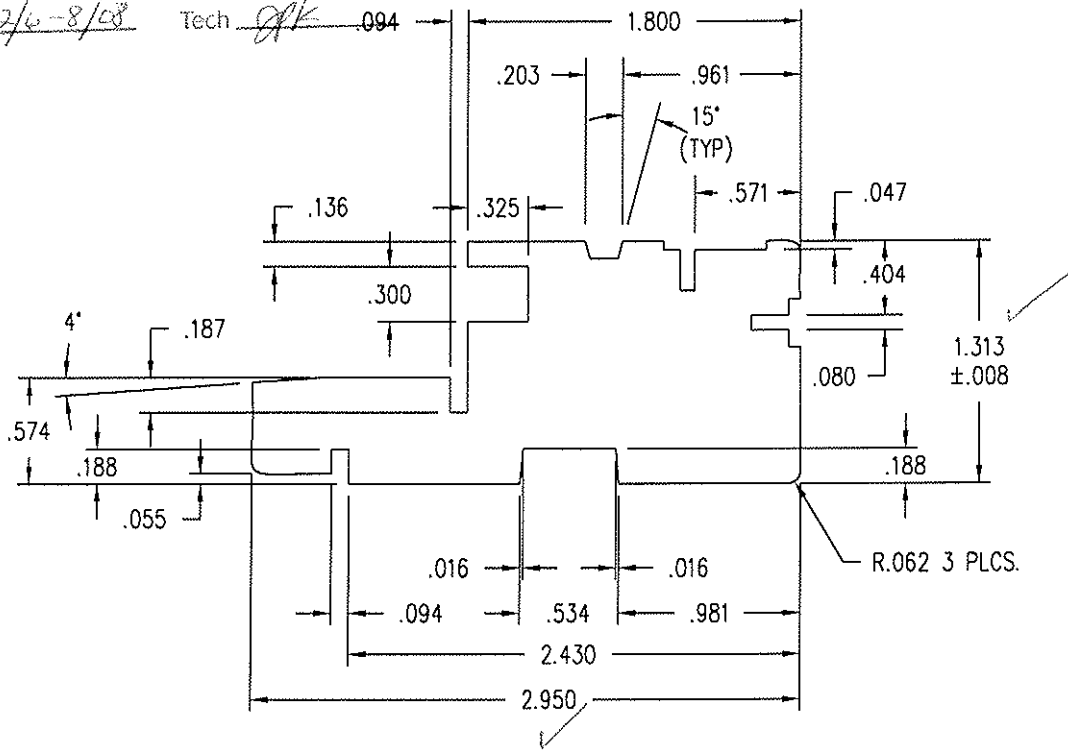
1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE:  
 DEC.+/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.



**Architectural Testing**

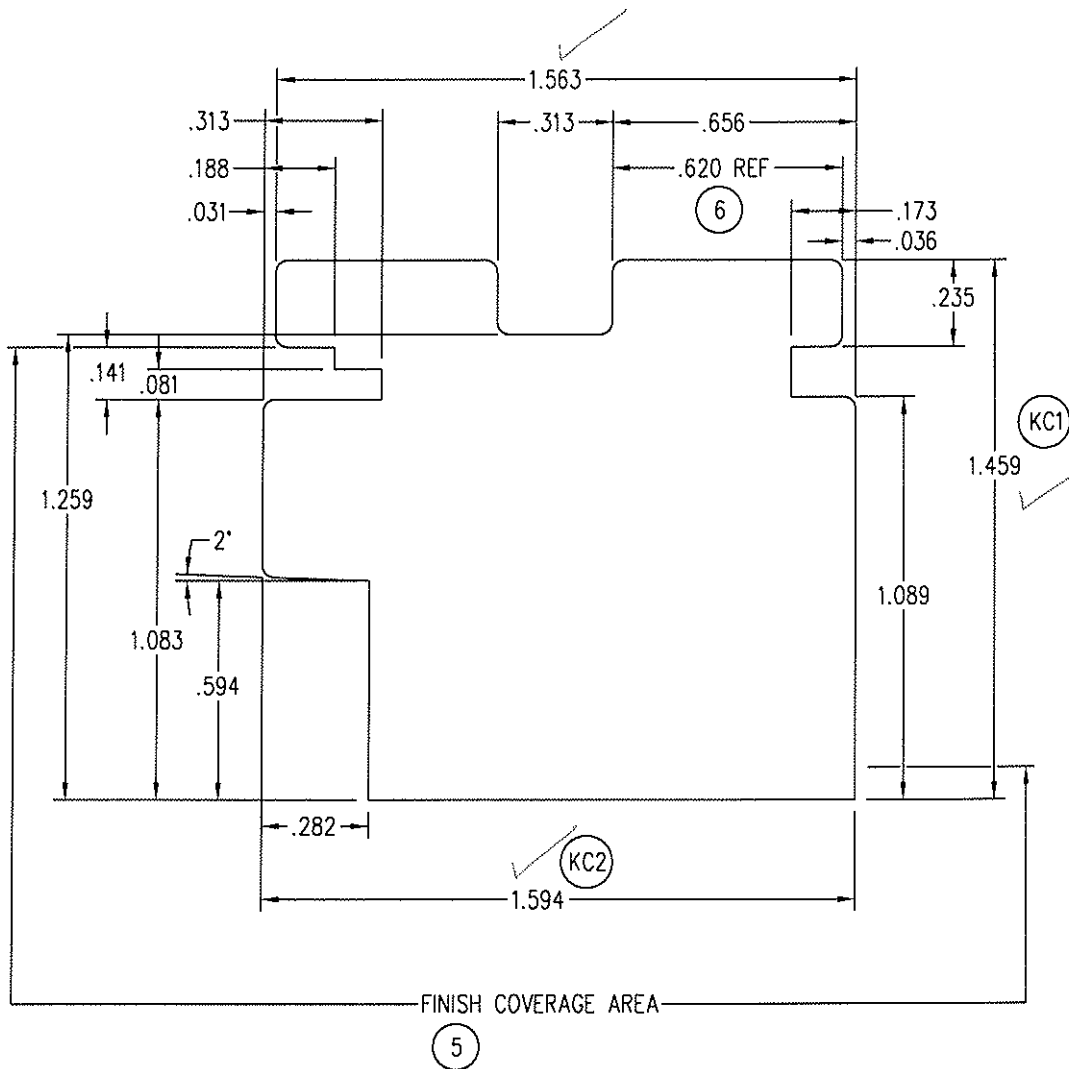
Test sample complies with these details.  
 Deviations are noted.

Report# 80181, 80182  
 Date 2/6-8/08 Tech AK



02	REMOVED 2 KERFS	RDA	1005	11/30/05
01	REVISED PROFILE - ADDED CONCEALED FASTENER ROUT	RDA	0925	09/30/04
NO	Description of Change	Drafter	DCN#	Date
Title: JAMB CCV-CCF-CAV		Finish:		Material: SEE PAGE 02
Scale: 1=1		Date: 5/28/2002		THIS DRAWING AND ITS CONTENTS ARE THE PROPERTY OF EAGLE WINDOW & DOOR. NO USE OR REPRODUCTION OF THE CONTENTS OF THIS DOCUMENT IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF EAGLE WINDOW & DOOR.
Drafter: JMH		DCN# 0925		
			REVISION: 2	220L 01 of 03

Note: 1 UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.+/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.



Architectural Testing

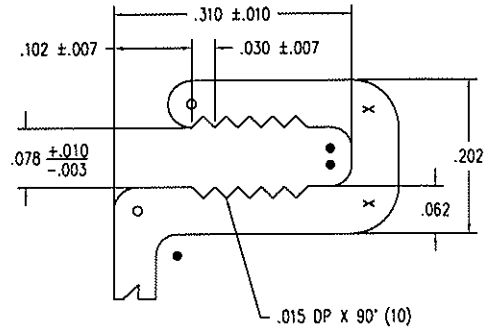
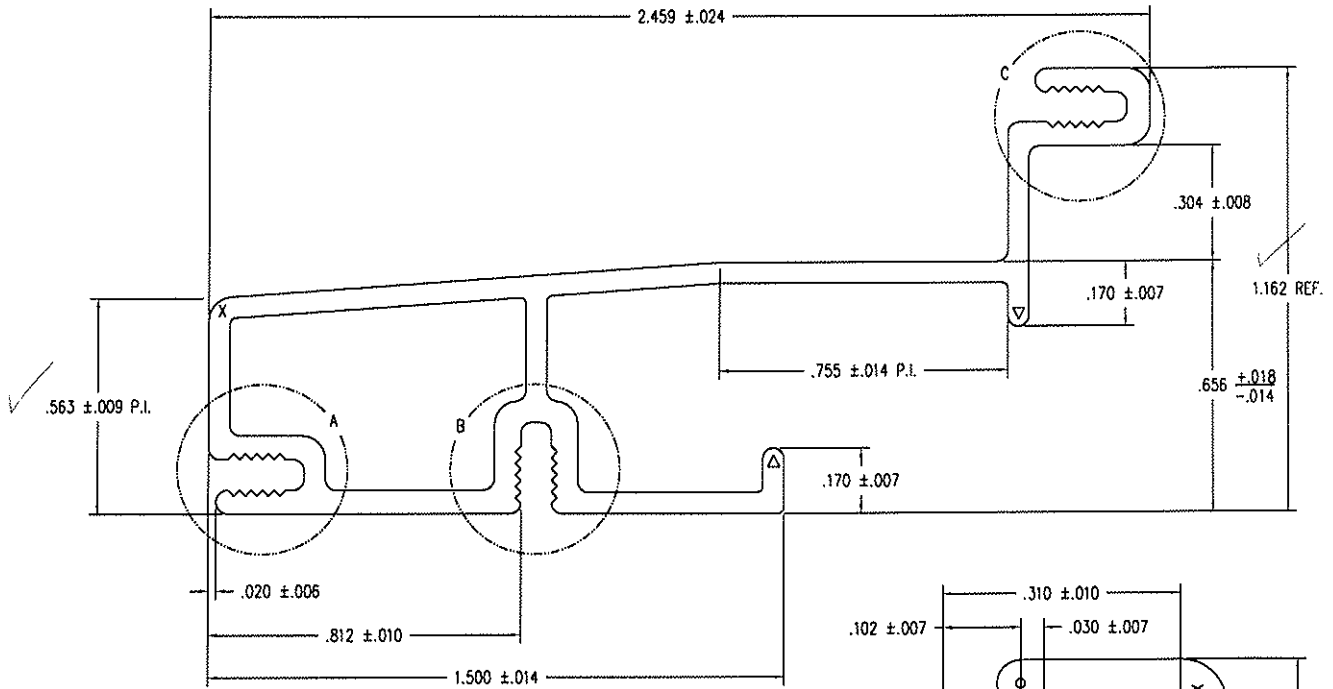
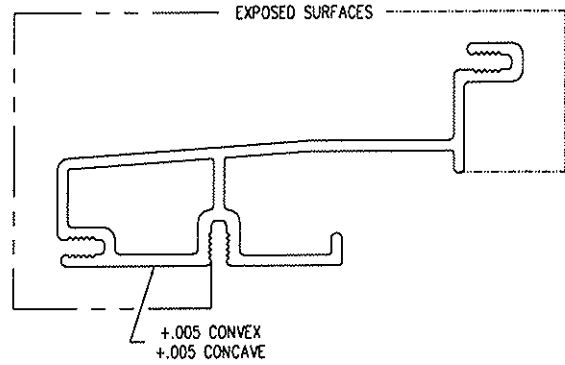
Test sample conforms with these details.  
Deviations are noted.

Report# 80181, 80182  
Date 2/6 - 8/08 Tech JPK

06	ADDED DIMENSION	TWN	TRKR	9/13/2006
05	ADDED COVERAGE AREA	JH	0924	9/17/2004
NO	Description of Change	Drafter	DCN#	Date
Title: CLAD CSMT RAIL		Finish:		Material EAGLE'S STD WOOD SPECIES
Scale: 1/2"=1"		Date: 8/7/1995		THIS DRAWING AND ITS CONTENTS ARE THE PROPERTY OF EAGLE WINDOW & DOOR. NO USE OR REPRODUCTION OF THE CONTENTS OF THIS DOCUMENT IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF EAGLE WINDOW & DOOR.
Drafter: CEL		DCN# 0154		
			REVISION: 6	21DE 01 of 02

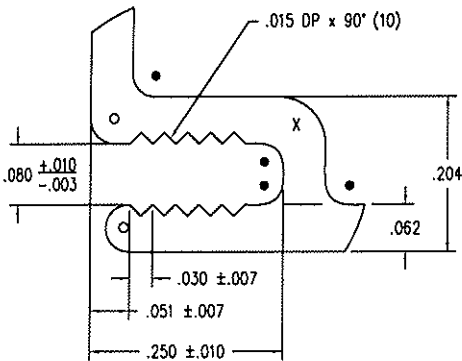
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.  $\pm 0.005$ ; FRAC.  $\pm 1/64$ ; ANGLES  $\pm 1/2^\circ$ .  
 2. UNLESS OTHERWISE SPECIFIED, WALL THICKNESS IS  $.055$ .  
 3. UNLESS OTHERWISE SPECIFIED, BREAK ALL CORNERS  $.015$  RADIUS.

- R .028 (15)
- R .031 (4)
- X R .062 (6)
- △ FULL RAD.(2)

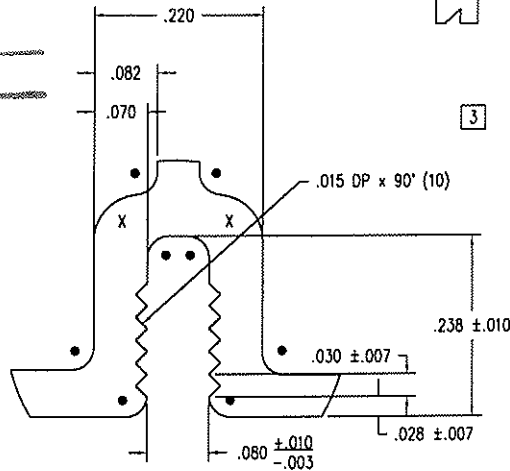


**Architectural Testing**  
 Test sample complies with these details.  
 Deviations are noted.

Report# 80181, 80182  
 Date 7/6-8/08 Tech off



DETAIL "A"



DETAIL "B"

3 DETAIL "C"

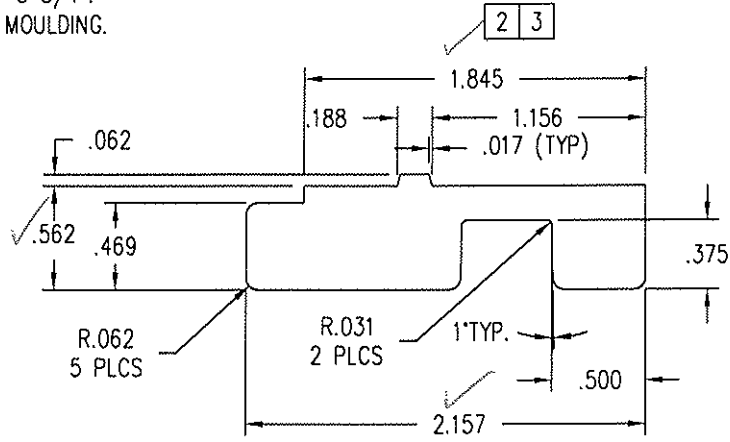
THIS DRAWING AND ITS CONTENTS ARE THE PROPERTY OF EAGLE WINDOW & DOOR. NO USE OR REPRODUCTION OF THE CONTENTS OF THIS DOCUMENT IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF EAGLE WINDOW & DOOR.  
 TITLE: FRAME COVER CLADDING

FINISH: EAGLE'S STD. COLORS

05	ADDED/CHG'D DIM. & TOLERANCE	TWN	0778	14/4/2003		
04	ADDED TOLERANCE SPECS	TWN	0595	18/31/2001	MAIL:	6063 1-6 ALUMINUM OR EQUIVALENT
03	REVISED PROFILE	CEL	0368	1/27/1999		
02	REVISED PROFILE	ROA	0272	9/17/1997	DF1:	REL SCALE: 2=1
01	CHANGED NOTES	GDE	0048	18/7/1992	DCN:	0004 DRWG: A04A
NO	DESCRIPTION	DFT	DOC	DATE	DATE: 7/21/1992	C 01 OF 02

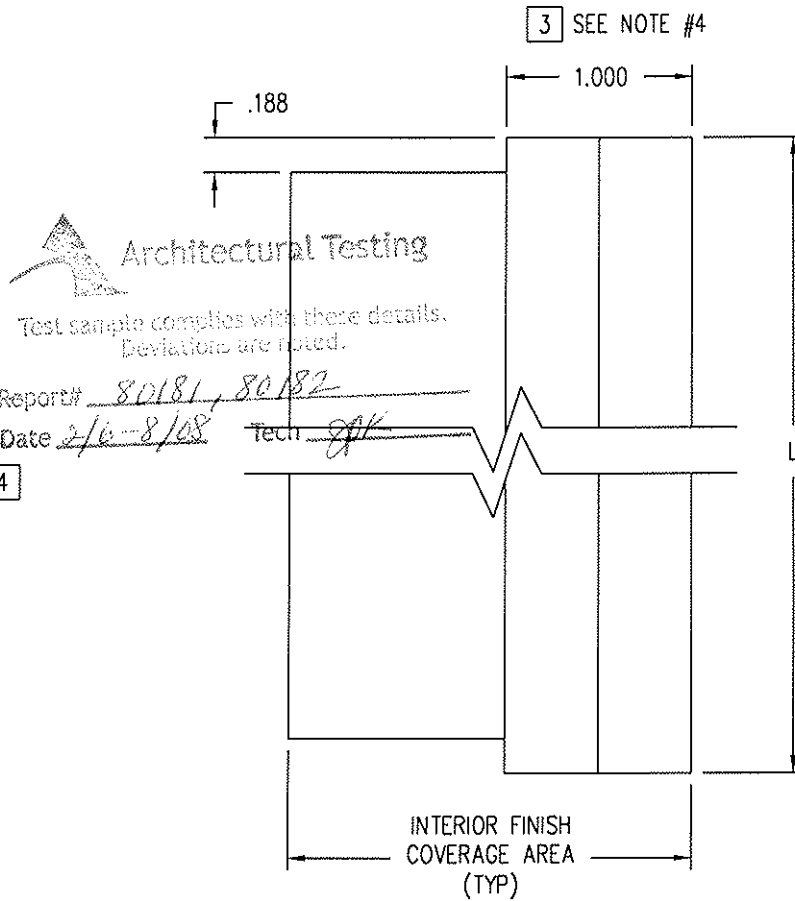


- NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. +/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.
2. CASEMENT, L = FRAME WIDTH - 3 1/2".
3. O/S VENTING SDLT, L = AFH - 3 3/4".
4. HOLD 1.062 AT TENON BEFORE MOULDING.



CSMT HEAD STOP	
FRAME WIDTH	L
17 3/4	14 1/4
20	16 1/2
24	20 1/2
28	24 1/2
30	26 1/2
32	28 1/2
36	32 1/2
40	36 1/2
48	44 1/2

O/S VENTING SDLT SIDE STOP	
FRAME WIDTH	L
79 5/16	75 9/16
81 5/16	77 9/16
83 5/16	79 9/16
95 5/16	91 9/16

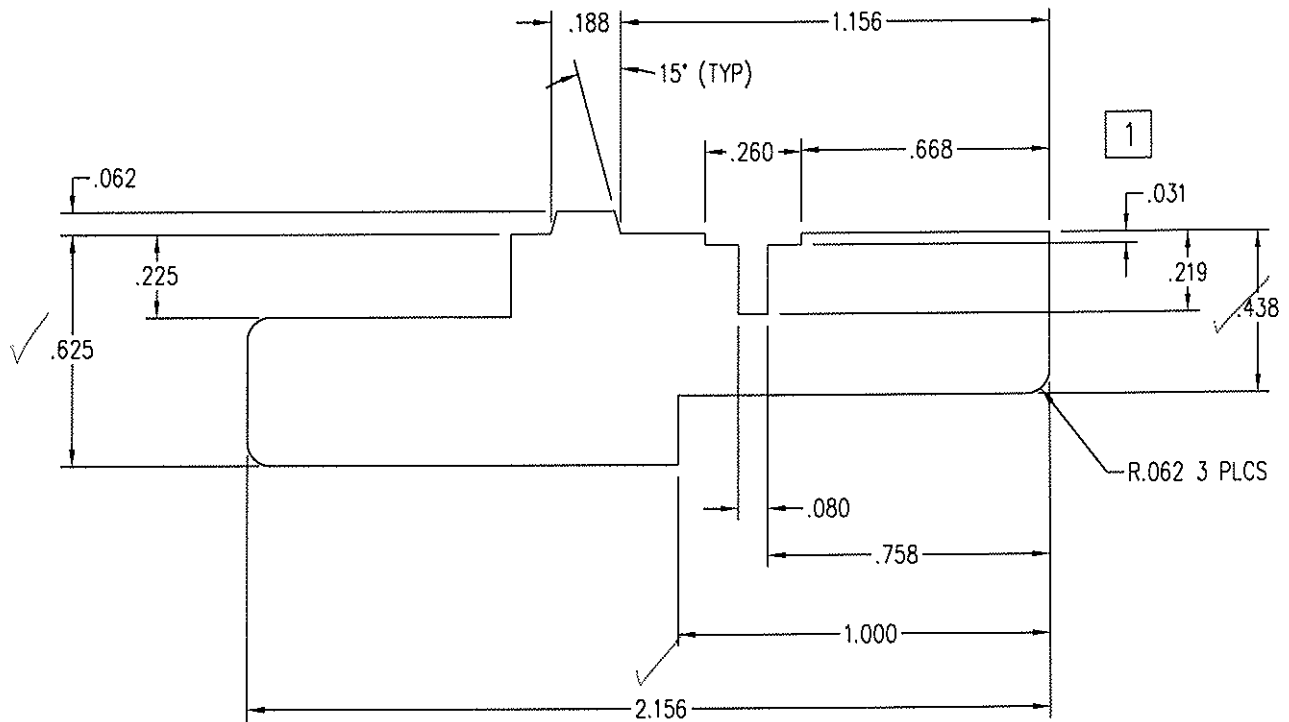
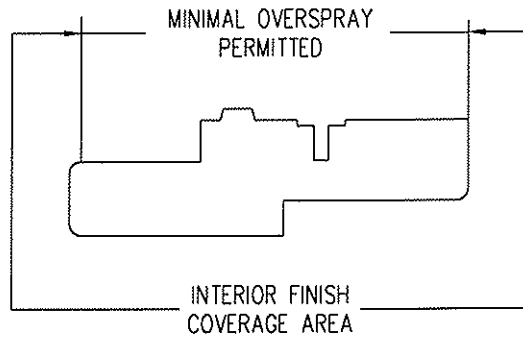


NO	Description of Change	Drafter	DCN#	Date
04	ADDED OUTSWING VENTING SIDELITE CHART	TWN	0952	03/31/06
03	REMOVE KERF	RDA	1000	01/10/05
02	REVISED PROFILE - ADDED CONCEALED FASTENER KERF	RDA	0925	02/22/05
01	ADDED NOTE #3	JH	0893	06/11/04

Title: HEAD STOP	Finish: INTERIOR FINISH SEE A02F	Material: EAGLE STANDARD SPECIES
Scale: 1=1	Date: 5/29/2002	Revision: 4
Drafter: JMH	DCN#: 0681	220T 01 of 01

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 DEC. +/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.



Architectural Testing

Test sample complies with these details.  
 Deviations are noted.

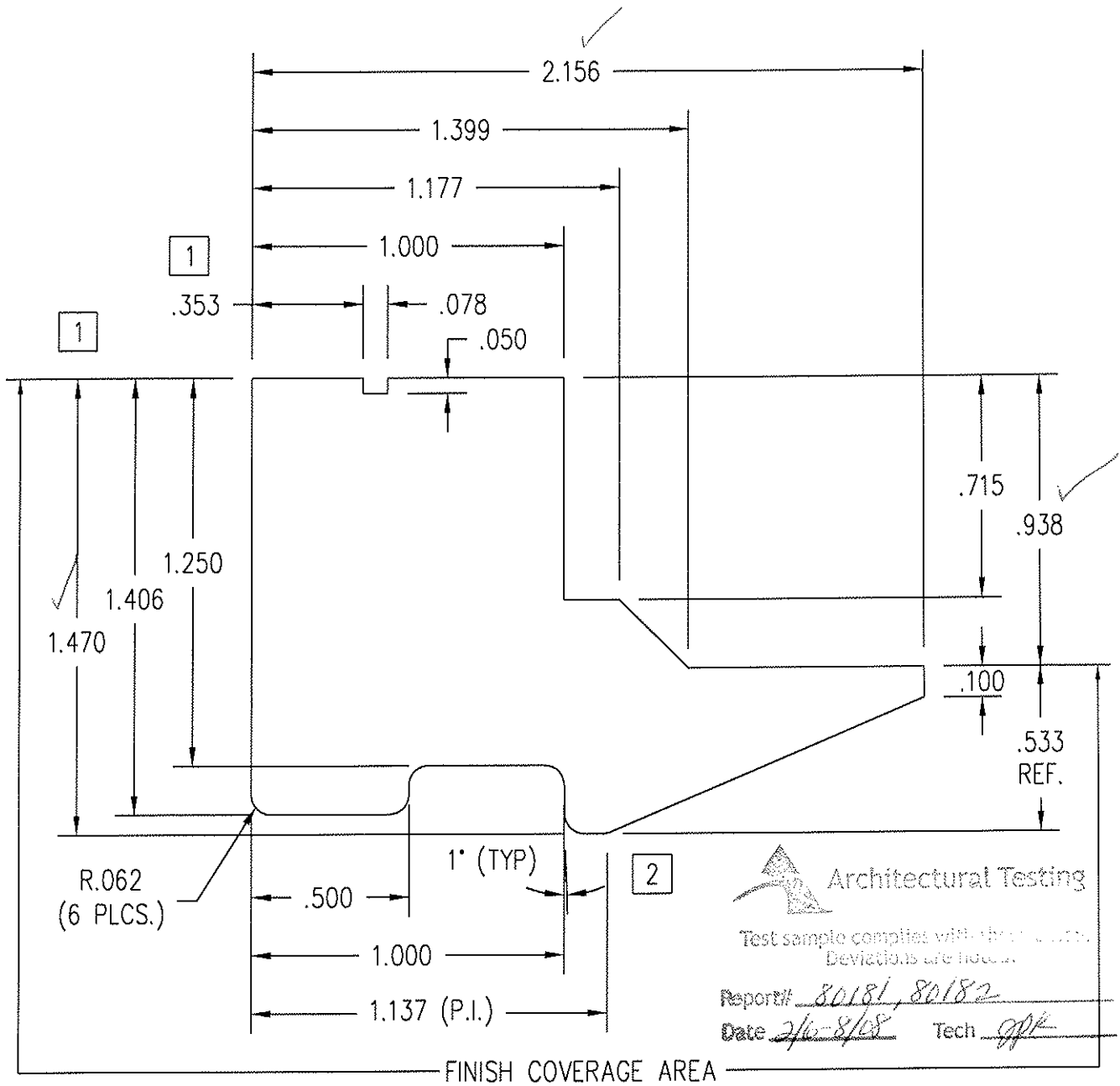
Report# 80181, 80182

Date 2/6-8/08 Tech SAK

02	REVISED PROFILE - ADDED CONCEALED FASTENER KERF	RDA	0925	09/30/04
01	ADDED COVERAGE AREA AND CHANGED TITLE BLOCK	JH	0893	06/11/2004
NO	Description of Change	Drafter	DCN#	Date
Title: CASEMENT CONCEALED LOCK HINGE SIDE STOP		Finish: STD. EAGLE FINISHES		Material: STD WOOD SPECIES
Scale: 2=1		Date: 3/6/2002		THIS DRAWING AND ITS CONTENTS ARE THE PROPERTY OF EAGLE WINDOW & DOOR. NO USE OR REPRODUCTION OF THE CONTENTS OF THIS DOCUMENT IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF EAGLE WINDOW & DOOR.
Drafter: AWW		DCN# 0681		
				REVISION: <b>20C0</b> 2 01 of 03



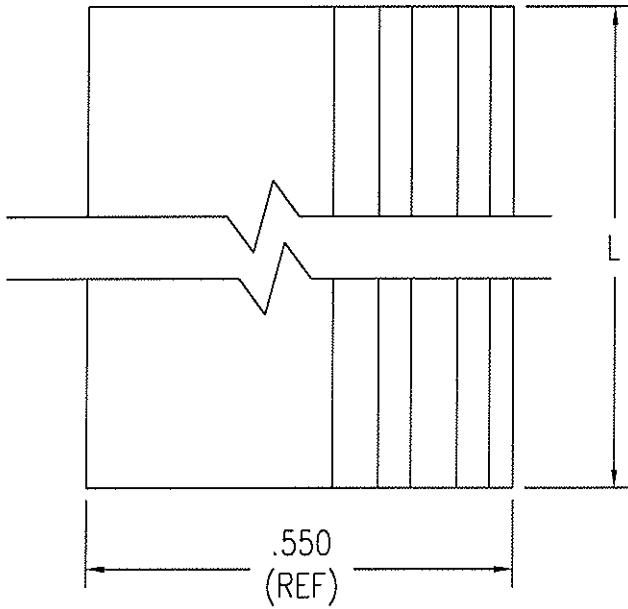
Note:1 UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE SHOWN ARE IIN INCHES AND ALL TOLERANCES ARE TO BE: DEC.+/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.



02	CHANGED OVERALL PART HEIGHT, 1.470 WAS 1.485	TWN	1105	5/16/2007
01	CHANGED OVERALL HEIGHT AN ADDED I.D. NOTCH	TWN	0927A	3/9/2005
NO	Description of Change	Drafter	DCN#	Date
Title: CSMT/AWN SILL COVER CONCEALED LOCK		Finish:		Material
Scale: 1/2"=1"		Date: 9/23/2004		THIS DRAWING AND ITS CONTENTS ARE THE PROPERTY OF EAGLE WINDOW & DOOR. NO USE OR REPRODUCTION OF THE CONTENTS OF THIS DOCUMENT IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF EAGLE WINDOW & DOOR.
Drafter: pblasen		DCN# 0927		
			REVISION: 2	223N 01 of 05

56,57,58,59

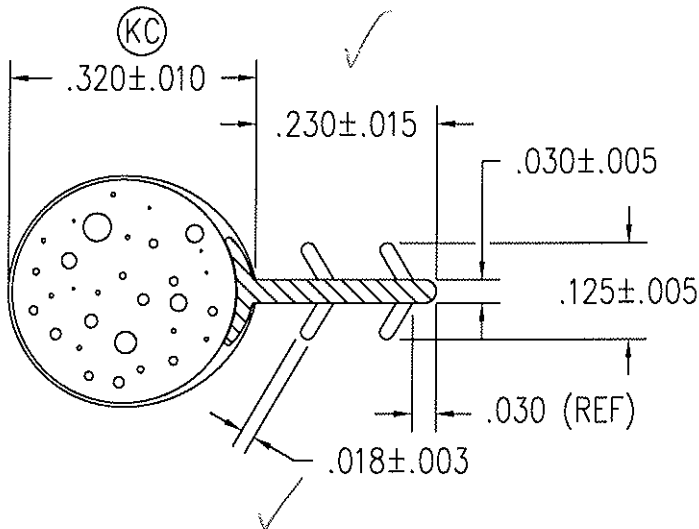
- NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.  $\pm 0.005$ ; FRAC.  $\pm 1/64$ ; ANGLES  $\pm 1/2^\circ$ .
2.  $L = ((\text{FRAME HEIGHT} + \text{FRAME WIDTH}) \times 2) - 8 \frac{11}{16}"$  (CASEMENT, AWNING, AND CLAD FRENCH CSMT)  
 L (RADIUS CSMT) = USE THE SAME DIMENSIONS AS A NON-RADIUS UNIT OF SAME OVERALL SIZE.
3. MATERIAL: CORE - CLOSED CELL TSE FOAM  
 BASE - POLYPROPYLENE COATING  
 SKIN - #60 DUROMETER (15% SLIP ADDITIVE) 1  
 COMPRESSION FORCE (BY .150) = 13-19 LB/FT.



Architectural Testing

Test sample complies with these details.  
 Deviations are noted.

Report# 80181, 80182  
 Date 2/6-8/08 Tech gjt



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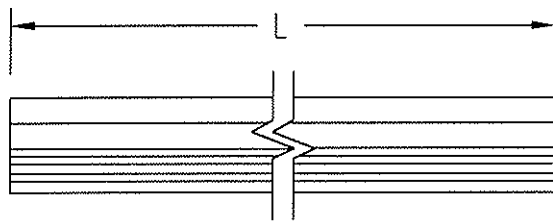
TITLE: BULB WEATHERSTRIP (.320)  
 CASEMENT

FINISH: TAN  
 PART #12202

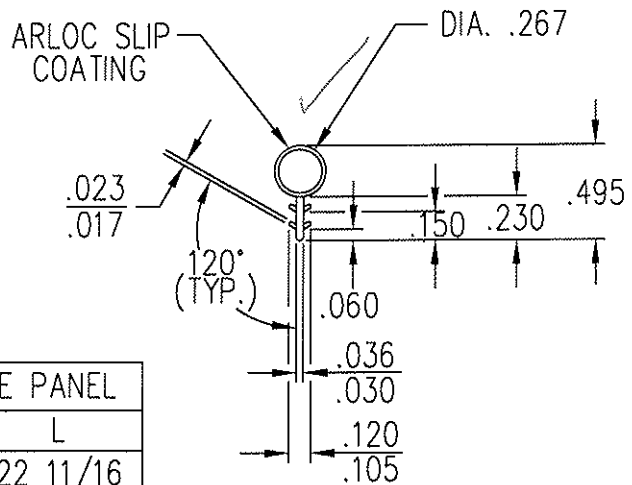
MATL: SEE NOTE 3

02	ADDED FRENCH CASEMENT	RJW	0640	10/14/03	DFT: AWW	SCALE: 4=1
01	ADDED SLIP NOTE	AWW	0795	6/4/2003	DCN: 0679	DRWG: A55N
NO	DESCRIPTION	DFT	DOC	DATE	DATE: 5/15/2002	A 01 OF 01

- NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. APPROVED VENDOR: INTEK, PART #50135A.
3. .023/.017 TYP. WALL FLEX. .036/.030 TYP. WALL RIGID.
4. CHDVO, WHDVO, SINGLE PANEL:  $L = \text{FRAME WIDTH} - 1.812$ .  
 CHDVO, ACTIVE PANEL:  $L = (\text{FRAME WIDTH} / 2) - 1.343$ .  
 CHDVO, INACTIVE PANEL:  $L = (\text{FRAME WIDTH} / 2) - .593$ .  
 WHDVO, ACTIVE PANEL:  $L = (\text{FRAME WIDTH} / 2) - 1.312$ .  
 WHDVO, INACTIVE PANEL:  $L = (\text{FRAME WIDTH} / 2) - .562$ .
5. SIDE JAMB FOR CLAD & WOOD SLIDING DOORS ( $L = \text{FRAME WIDTH} - 3$ ).



4



CHDVO, ACTIVE PANEL	
FRAME WIDTH	L
24 1/2	22 11/16
30 1/2	28 11/16
32 1/2	30 11/16
36 1/2	34 11/16
48 1/16	22 11/16
60 1/16	28 11/16
64 1/16	30 11/16
72 1/16	34 11/16

WHDVO, ACTIVE PANEL	
FRAME WIDTH	L
24 1/2	22 11/16
30 1/2	28 11/16
32 1/2	30 11/16
36 1/2	34 11/16
48	22 11/16
60	28 11/16
64	30 11/16
72	34 11/16

CLAD & WOOD SLIDING DRS.	
FRAME HEIGHT	L
80	77
82	79
96	93

CHDVO, INACTIVE PANEL	
FRAME WIDTH	L
48 1/16	23 7/16
60 1/16	29 7/16
64 1/16	31 7/16
72 1/16	35 7/16

WHDVO, INACTIVE PANEL	
FRAME WIDTH	L
48	23 7/16
60	29 7/16
64	31 7/16
72	35 7/16

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TITLE: ARLOC BULB WEATHERSTRIP  
 BLK #205400

FINISH: WHITE - #4099  
 BLACK - #205400 (CSMT ONLY)

MATL: PPR  
 PROPYLENO/ETHYLENE COPOLYMER

Architectural Testing

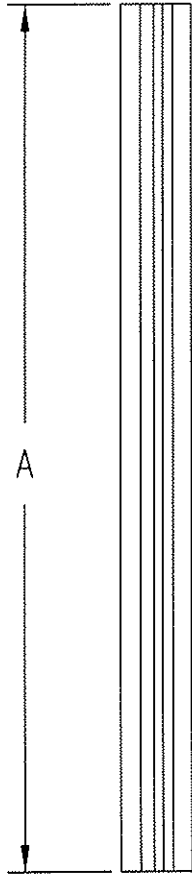
Test sample complies with these details.  
 Deviations are noted.

Report# 80181, 80182

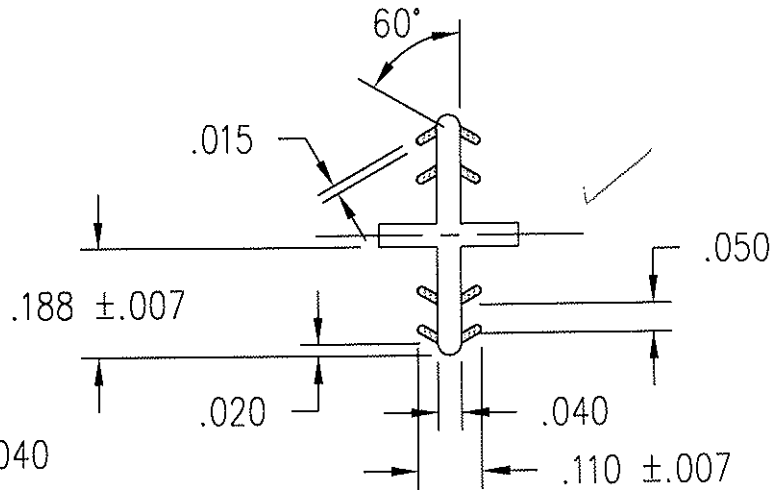
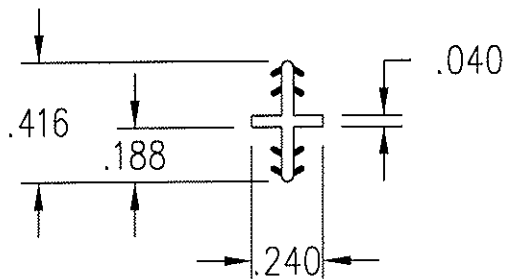
Date 2/6-8/08 Tech JPK

06	ADDED FINISH COLORS	KJS	1134	10/18/07	DFT: TWN	SCALE: 1=1
05	CHANGED TO PAGE 01 OF 04	RJW	0640	10/1/2003	DCN: 0231	DRWG: A283
NO	DESCRIPTION	DFT	DOC	DATE	DATE: 1/16/1996	A 01 OF 04

NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.  $\pm 0.005$ ; FRAC.  $\pm 1/64$ ; ANGLES  $\pm 1/2^\circ$ .



SPLINE LENGTH	P/N
1"	CFS1
3"	CFS3
6"	CFS6
12"	CFS12
20"	CFS20
34"	CFS34
55"	CFS55
70"	CFS70



Architectural Testing

Test sample complies with these drawings.  
Deviations are noted.

Report# 80181, 80182  
Date 2/12-8/08 Tech SPK

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TITLE: CONCEALED FASTENER SPLINE

FINISH:

MATL:

DFT: bager

SCALE: 1.5=1

DCN: 0925

DRWG: A67E

DATE: 9/21/2004

A 01 OF 01

NO	DESCRIPTION	DFT	DOC	DATE

NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2'.

PRODUCT	GLASS	A
(PRE '96 & NG) CLAD CASEMENT & AWNING	5/8"	.469
(PRE '96 & NG) CLAD CASEMENT PICTURE	3/4"	.469
CLAD PIANO HINGE CASEMENT	5/8"	.469
CLAD PIANO HINGE CASEMENT (3056 & ABOVE)	3/4"	.469
CLAD RADIUS CASEMENT	5/8" & 3/4"	.469
(PRE '96 & NG) CLAD DOUBLE / SINGLE HUNG	5/8"	.469
(PRE '96 & NG) CLAD DOUBLE HUNG PICTURE	5/8"	.469
CLAD DOUBLE HUNG TRANSOM	5/8"	.469
CLAD DOUBLE HUNG REPLACEMENT SASH	5/8"	.469
ALL CLAD (NON-RADIUS) AUXILIARY (0-15 SQ. FT.)	3/4"	.469
ALL CLAD (NON-RADIUS) AUXILIARY (15+ SQ. FT.)	1"	.469
CLAD SLIDING WINDOW	5/8"	.469
CLAD INSWING / OUTSWING FRENCH DOOR	3/4"	.469
CLAD FRENCH DOOR TRANSOM	3/4"	.469
CLAD PATIO / FRENCH SLIDING DOOR	3/4"	.469
(PRE '98) WOOD CASEMENT & AWNING	3/4"	.680
(PRE '98) WOOD CASEMENT PICTURE	3/4"	.680
(NG) WOOD CASEMENT & AWNING	5/8"	.469
(NG) WOOD CASEMENT PICTURE	5/8" & 3/4"	.469
WOOD PIANO HINGE CASEMENT	5/8"	.469
WOOD PIANO HINGE CASEMENT (3056 & ABOVE)	3/4"	.469
(PRE '96 & NG) WOOD DOUBLE / SINGLE HUNG	5/8"	.469
(PRE '96 & NG) WOOD DOUBLE HUNG PICTURE	5/8"	.469
WOOD SLIDING WINDOW	5/8"	.469
WOOD DOUBLE HUNG TRANSOM	5/8"	.469
WOOD DOUBLE HUNG REPLACEMENT SASH	5/8"	.469
WOOD (NON-RADIUS) AUXILIARY (0-15 SQ. FT.)	3/4"	.469
WOOD (NON-RADIUS) AUXILIARY (15+ SQ. FT.)	1"	.469
WOOD INSWING / OUTSWING FRENCH DOOR	3/4"	.469
WOOD FRENCH DOOR TRANSOM	3/4"	.469
WOOD PATIO / FRENCH SLIDING DOOR	3/4"	.469
CLAD & WOOD PATIO/FR. SLIDING DOOR (BLIND GLASS)	1"	.406
ALL CLAD AND WOOD WINDOWS AND DOORS EXCEPT AUXILIARY UNITS WHICH ALWAYS USES	SINGLE GLAZED H. MSTR MONO	.680

 **Architectural Testing**  
 Test sample complies with these details.  
 Deviations are noted.

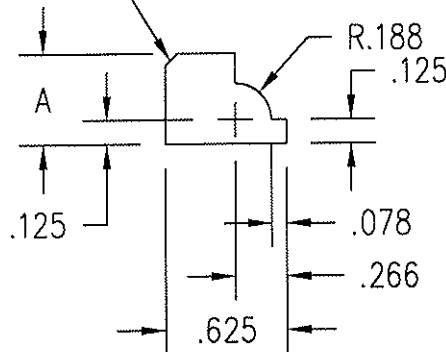
Report# 80181, 80182  
 Date 2/6-8/08 Tech SPK

PANEL STOPS		
PRODUCT	A	
WOOD OUTSWING SIDELITE	.469	2
WOOD OUTSWING TRANSOM	.469	
WOOD INSWING SIDELITE	.469	4
WOOD INSWING TRANSOM	.469	
CLAD DHG PICTURE	.406	

1

.062 x .062 CHAMFER

3



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TITLE: COLONIAL GLAZING STOP

FINISH:

MATL: EAGLE STD WOOD OFFERINGS  
 DFT: JMH SCALE: 1=1  
 DCN: 0650 DRWG: 220J  
 DATE: 5/29/2002 A 01 OF 03

04	ADDED CDHG PICT TO CHART	KJS	0881	3/6/07
03	ADDED SIZE FOR IMPACT GLAZING	TWN	0972	9/1/05
02	CHGD CLAD PANEL STOP "A" DIM	JH	0794	6/30/05
01	ADDED KYLER BLIND SIZE	TWN	0910	4/19/05
NO	DESCRIPTION	DFT	DOC	DATE