

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

**Rendered to:**

**EAGLE WINDOW & DOOR, INC.**

**SERIES/MODEL: 5050 Series 03 French Casement Unit  
PRODUCT TYPE: Aluminum Clad Wood French Casement**

<b>Title</b>	<b>Summary of Results</b>
Primary Product Designator	LC-PG40-C 1524 x 1524 (60 x 60)
Design Pressure	1920 Pa (40.0 psf)
Operating Force (in motion)	19 N (4.3 lbf)
Air Infiltration	<0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Water Penetration Resistance Test Pressure	440 Pa (9.0 psf)
Uniform Load Structural Test Pressure	±2880 Pa (±60.0 psf)
Forced Entry Resistance	Grade 10

**Test Completion Date:** 08/07/07

Reference must be made to Report No. 75734.01-201-44, dated 12/04/08 for complete test specimen description and data.

**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.: 75734.01-201-44  
Test Dates: 08/07/07  
Through: 08/08/07  
Original Report Date: 08/21/07  
Revised Report Date: 12/04/08  
Expiration Date: 08/07/11

**Project Summary:** Architectural Testing, Inc. was contracted by Eagle Window & Door, Inc. to perform testing on a Series/Model 5050 Series 03 French Casement Unit, Aluminum Clad Wood French Casement. The sample tested successfully met the performance requirements for a LC-PG40-C 1524 x 1524 (60 x 60) rating. Test specimen description and results are reported herein. The sample was provided by the client.

**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:** 5050 Series 03 French Casement Unit

**Product Type:** Aluminum Clad Wood French Casement

**Overall Size:** 1524 mm (60") wide by 1524 mm (60") high

**Primary Sash Size:** 765 mm (30-1/8") wide by 1486 mm (58-1/2") high

**Secondary Sash Size:** 765 mm (30-1/8") wide by 1486 mm (58-1/2") high

**Overall Area:** 2.3 m<sup>2</sup> (25.0 ft<sup>2</sup>)

**Finish:** Interior wood was primed, exterior cladding was painted.

**Test Specimen Description:** (Continued)

**Frame Construction:** The wood frame was comprised of laminated veneer lumber with corners square-cut, butted, sealed with silicone and secured with two 16-gauge, 11 mm (7/16") by 38 mm (1-1/2") 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 #6 by 11 mm (7/16") screws per corner.

**Sash Construction:** Sash corners utilized mortise-and-tenon construction 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, sealed with silicone and secured with a nylon corner key and one #5 by 38 mm (1-1/2") screw per corner.

The primary sash astragal consisted of extruded aluminum cladding slip-fit over the wood profile and was secured to the sash with #8 by 38 mm (1-1/2") screws spaced 102 mm (4") from each corner and 203 mm (8") on center

The secondary sash astragal consisted of a wood profile secured to the sash eight #8 by 38 mm (1-1/2") screws through the lock keepers, three each on the top and bottom keepers, and two on the midspan keeper.

**Weatherstripping:**

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
TPE bulb weatherstrip	1 Row	Lock stile on primary sash and top rails of both sashes
5 mm (3/16") by 3 mm (1/8") closed-cell foam tape	1 Row	Back side of piano hinge
One-piece foam-filled TPE weatherstrip	1 Row	Interior frame stop perimeter
Neoprene foam block	1	Sill at meeting stile

**Glazing Details:** The window utilized a nominal 16 mm (5/8") thick insulating glass unit fabricated from two double strength sheets of annealed glass separated by a desiccant-filled metal spacer system. The glass was set from the interior against a hot-melt glazing sealant and back-filled with silicone. Wood glazing stops with single-sided adhesive foam tape were utilized on the interior and secured with 32 mm (1-1/4") 18-gauge brads spaced 25 mm (1") from each corner and 152 mm (6") to 203 mm (8") on center.

**Test Specimen Description:** (Continued)

**Hardware:**

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
Stainless steel piano hinge	2	Continuous length on hinge side
Sequential lock with keepers	1	610 mm (24") from jamb on head and sill. 102 mm (4") from head and sill, and midspan of lock stiles
Casement roto-operator	2	Sill

**Installation:** The window was installed within a wood test buck and secured with installation straps. The installation straps were secured to the window frame with two #8 by 16 mm (5/8") screws and to the buck with two #8 by 38 mm (1-1/2") screws, two on the interior and two on the exterior. The installation straps were spaced 152 mm (6") from each corner and midspan on all sides. The unit was additionally secured through the nail flange with 51 mm (2") roof nails spaced 102 mm (4") from each corner and 203 mm (8") on center. The nail flange was sealed to the buck with silicone.

**Test Results:** The temperature during testing was 26°C (78°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 per ASTM E 2068		
	Primary sash-Open		
	Initiate motion	32 N (7.3 lbf)	Report Only
	Maintain motion	10 N (2.3 lbf)	30 N (7.0 lbf)
	Close		
	Initiate motion	30 N (6.8 lbf)	Report Only
	Maintain motion	19 N (4.3 lbf)	30 N (7.0 lbf)
	Secondary sash-Open		
	Initiate motion	10 N (2.3 lbf)	Report Only
	Maintain motion	10 N (2.3 lbf)	30 N (7.0 lbf)
	Close		
	Initiate motion	10 N (2.3 lbf)	Report Only
	Maintain motion	10 N (2.3 lbf)	30 N (7.0 lbf)
	Latches	76 N (17 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 Leakage Resistance per ASTM E 283		
	75 Pa (1.6 psf)	<0.05 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.
	300 Pa (6.2 psf)	0.10 L/s/m <sup>2</sup> (0.02 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 Penetration Resistance per ASTM E 547 and E 331		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:	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	Sash Vertical Deflection Test		
	270 N (60 lbf)	2.3 mm (0.09")	15.5 mm (0.61") max.

5.3.6.6.2	Distributed Load Test		
	300 Pa (6.2 psf)	No damage	No damage

Optional Performance

4.3.2.1	Water Penetration Resistance per ASTM E 547 and E 331		
	440 Pa (9.0 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 were taken on the meeting stile) (Loads were held for 60 seconds)		
	1920 Pa (40.0 psf) (positive)	7.6 mm (0.30")	See Note #3
	1920 Pa (40.0 psf) (negative)	7.6 mm (0.30")	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 sets were taken on the meeting stile) (Loads were held for 10 seconds)		
	2880 Pa (60.0 psf) (positive)	0.5 mm (0.02")	5.8 mm (0.23") max.
	2880 Pa (60.0 psf) (negative)	0.3 mm (0.01")	5.8 mm (0.23") 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, Inc.
Mike Blum	Eagle Window & Door, Inc.
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 Forms (2)
- Appendix-C: Drawings (22)

### Revision Log

<u>Rev. #</u>	<u>Date</u>	<u>Page(s)</u>	<u>Revision(s)</u>
0	08/21/07	N/A	Original report issue. Report and drawings forwarded to AMS for Hallmark Certification.
1	12/04/08	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 #: 75734.01-201-44-R1

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-696.00

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 03 Axiom Clad French Casement 5050  
(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	_____
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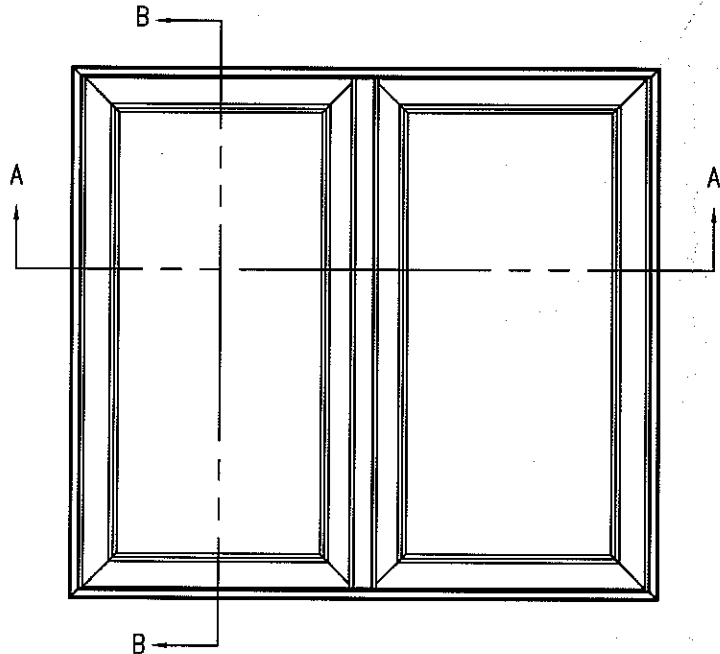
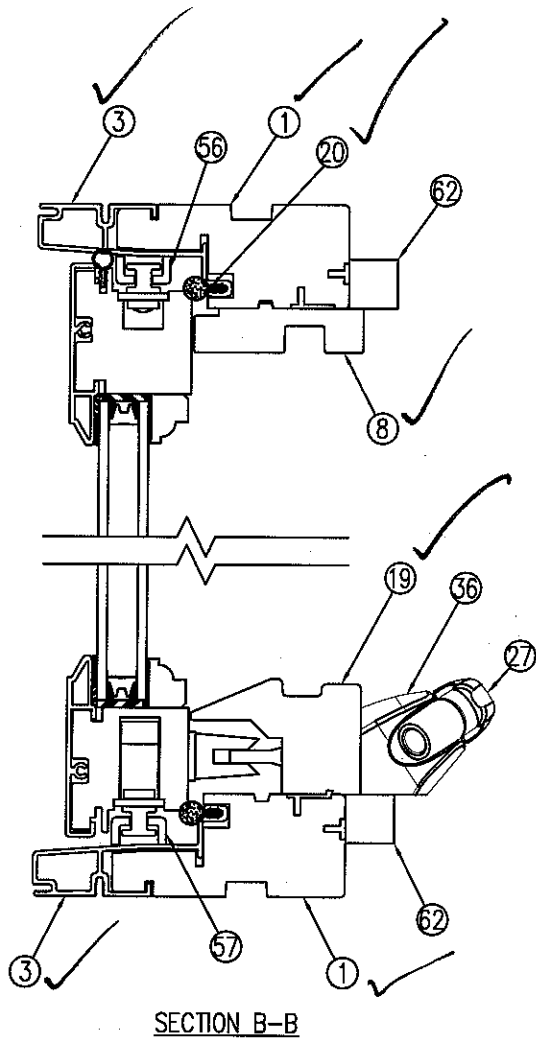
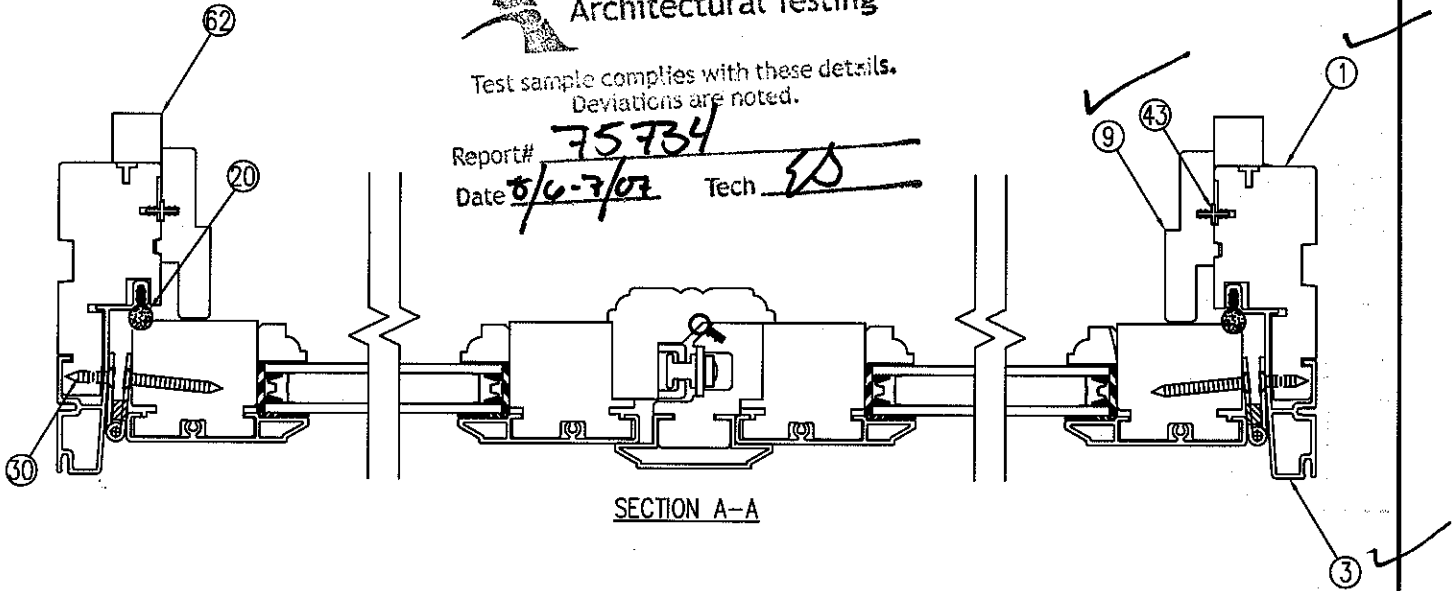
**Appendix-C**

**Drawings**

 **Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# 75734  
Date 8/6-7/07 Tech ES



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TITLE: FRENCH CSMT UNIT ASSEMBLY

FINISH:

MATL:

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DCN: 0710 DRWG: 054P

DATE: 7/25/07 A 01 OF 08

01					
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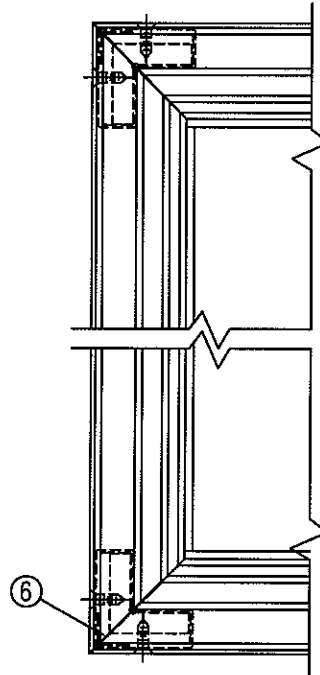
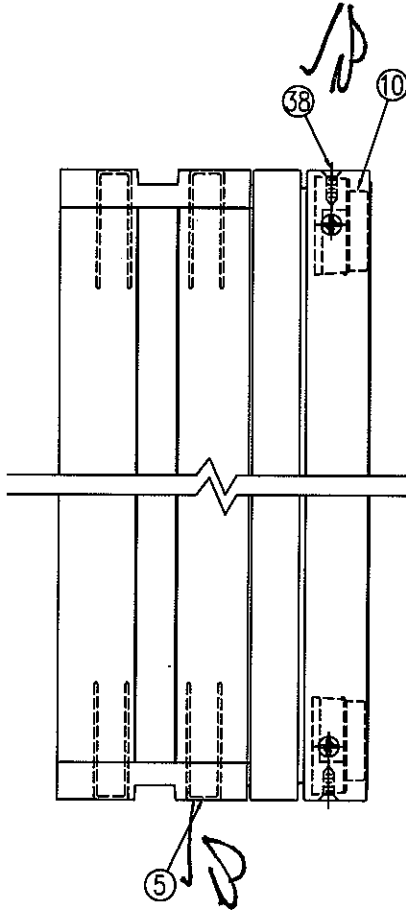
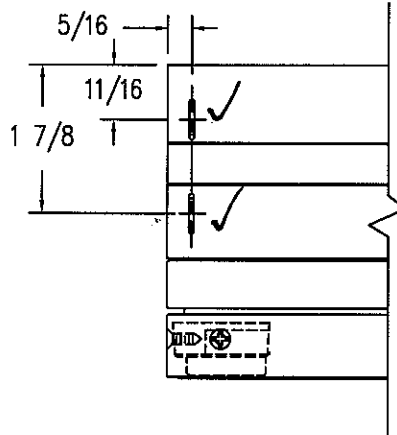
# Architectural Testing

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Report# 75734

Date 8/6-7/09

Tech. [Signature]



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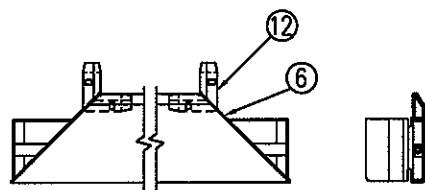
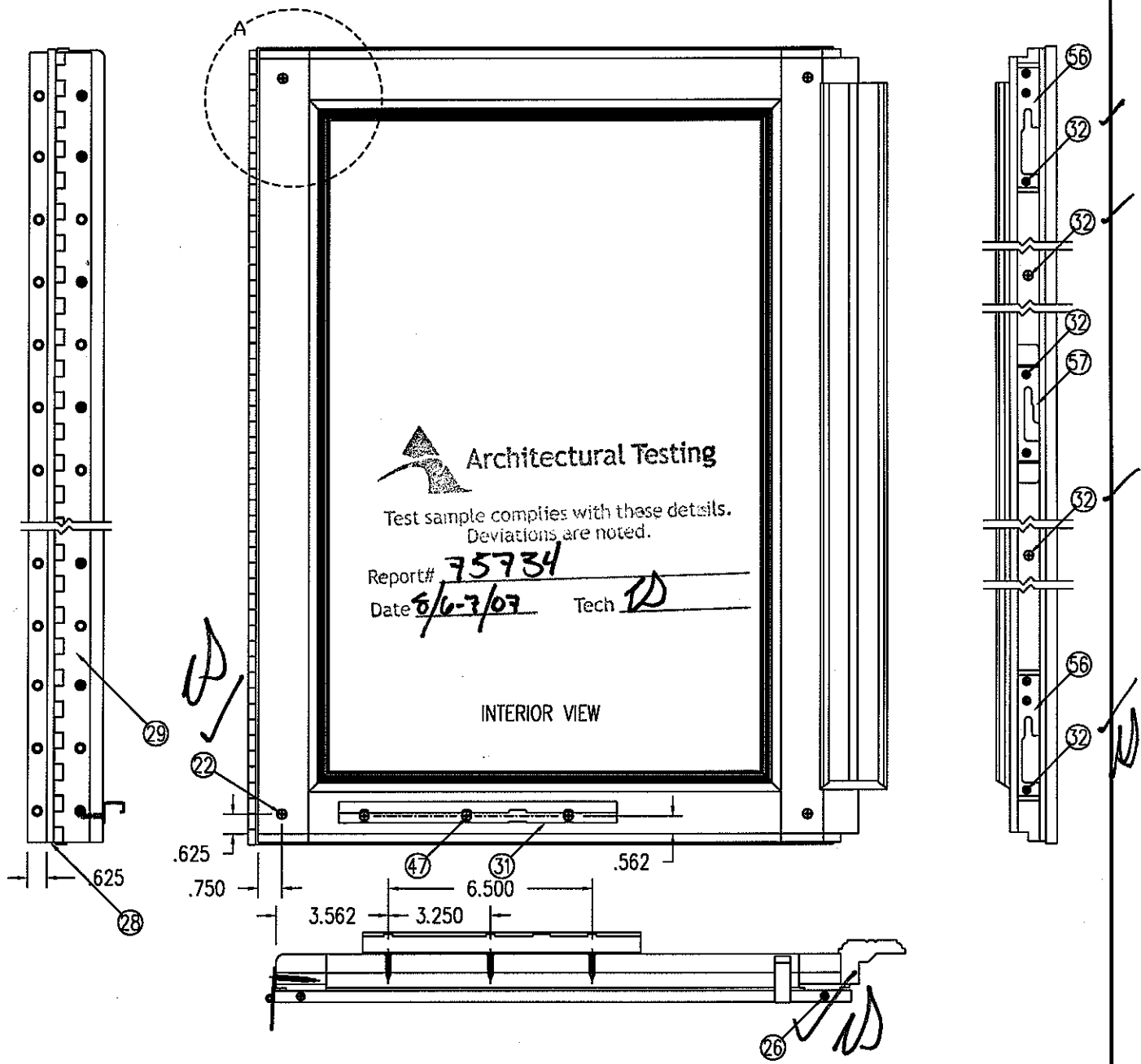
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TITLE: FRENCH CASEMENT RIGHT SASH ASSEMBLY

FINISH:

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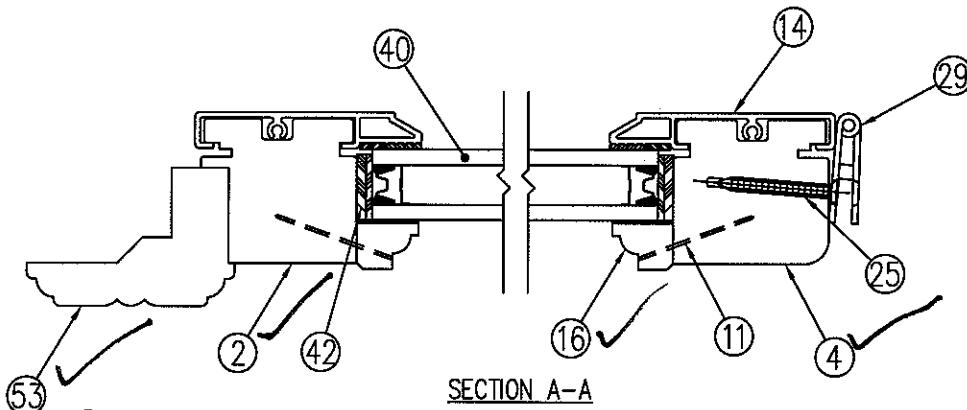
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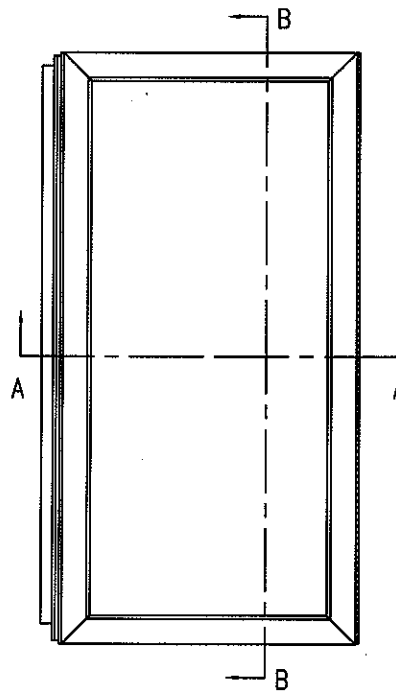
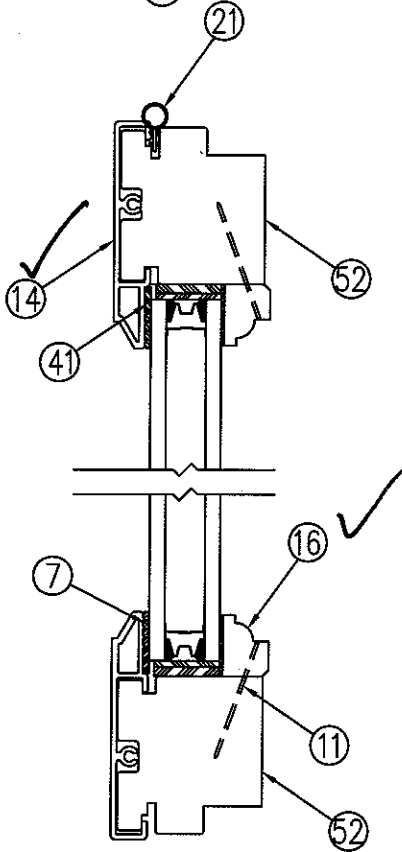
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GLAZING OPTIONS



SECTION B-B



Architectural Testing

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TITLE: FRENCH CASEMENT  
RIGHT SASH ASSEMBLY

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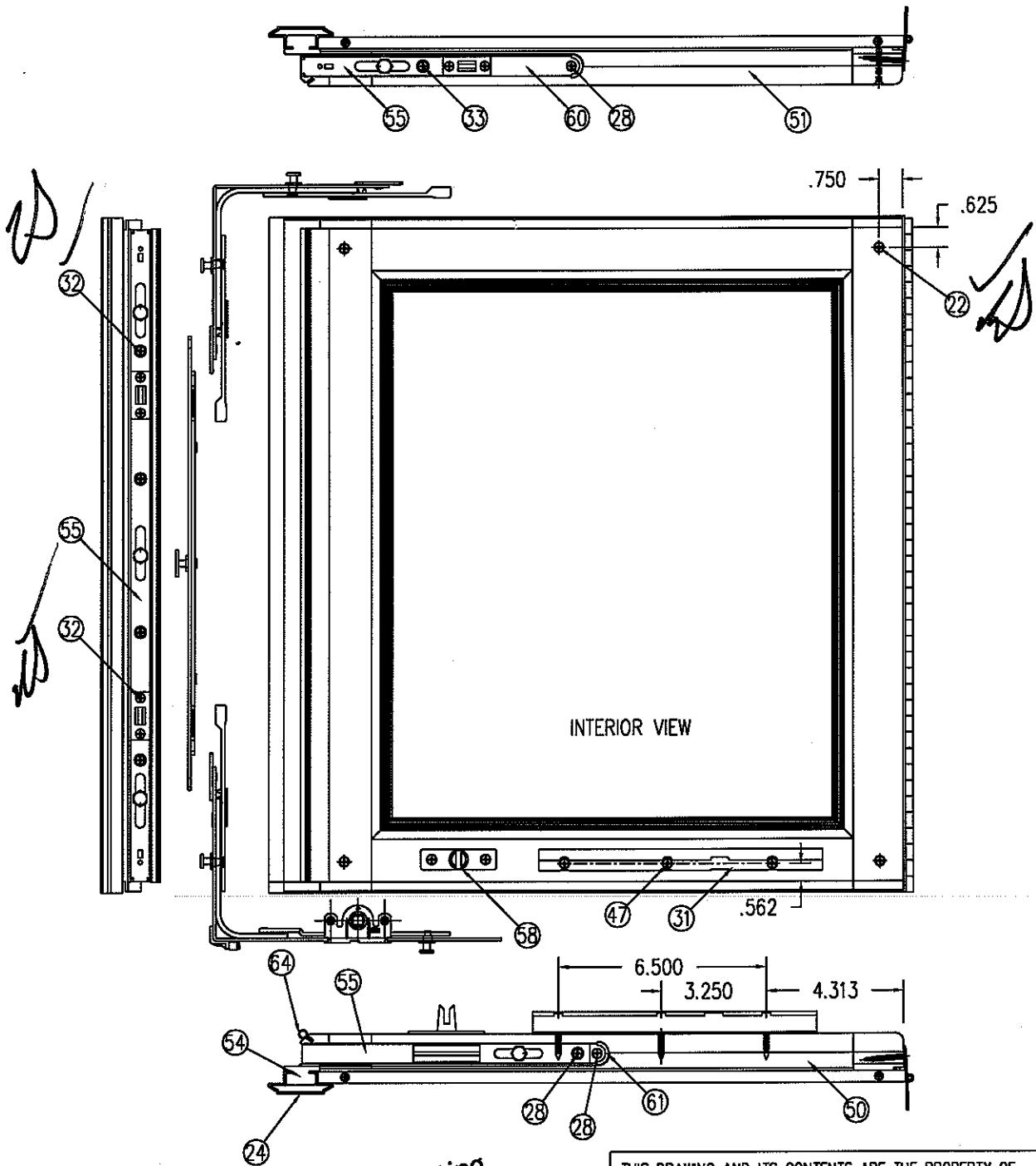
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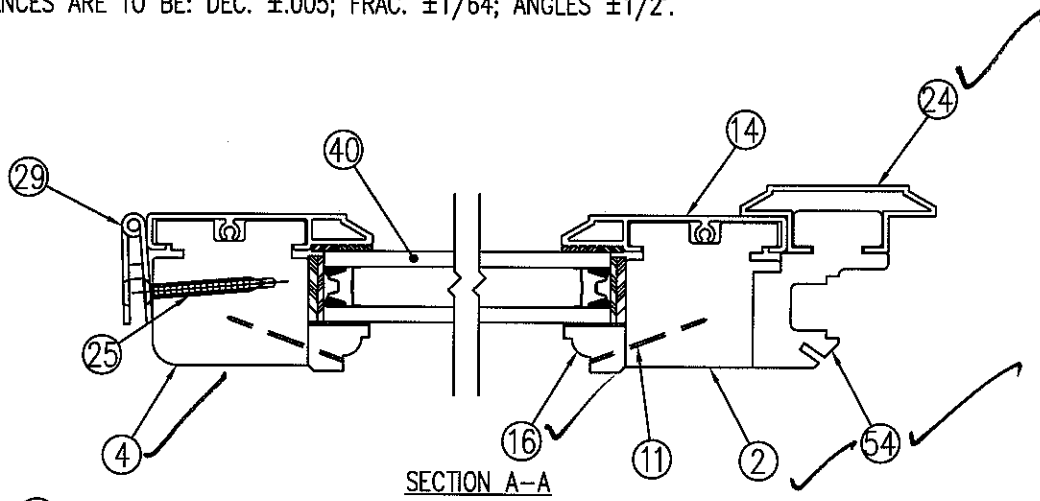
**Architectural Testing**  
 Test sample complies with these details.  
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 Report# 75731  
 Date 8/6-7/07 Tech *W*

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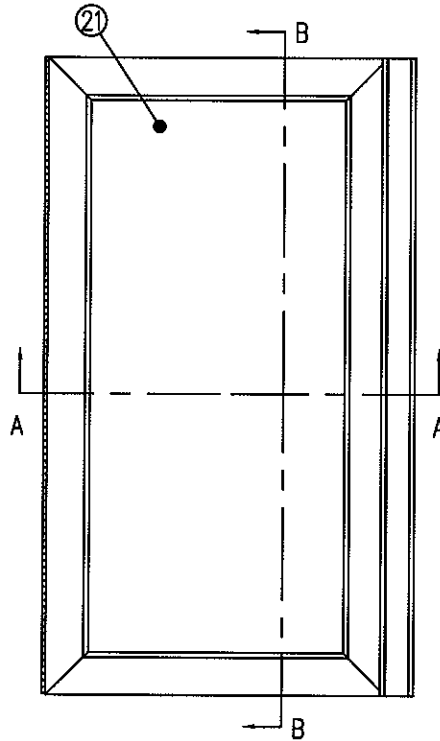
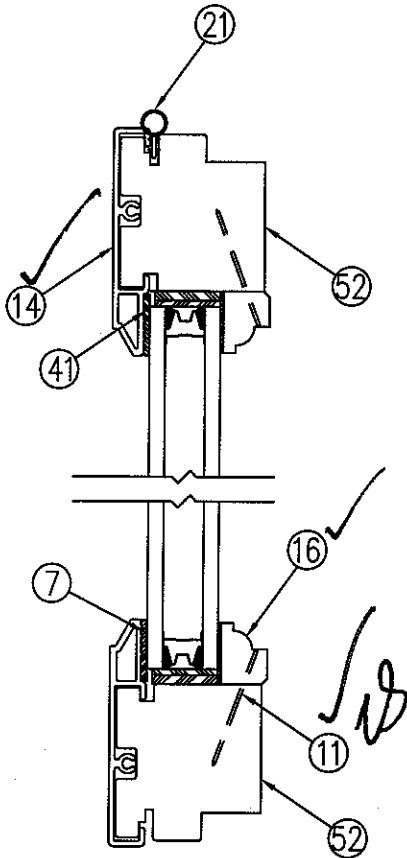
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NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.  $\pm 0.005$ ; FRAC.  $\pm 1/64$ ; ANGLES  $\pm 1/2^\circ$ .



GLAZING OPTIONS



SECTION B-B



Test sample complies with these details.  
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TITLE: FRENCH CASEMENT LEFT SASH ASSEMBLY

FINISH:

MATL:

DFT: CRC SCALE: 1=2

DCN: 0710 DRWG: 054P

DATE: 7/31/07 A 06

NO	DESCRIPTION	DFT	DOC	DATE

NO.	DWG. NO.	PART DESCRIPTION	QUANTITY	MATERIAL	SUPPLIER
1	220L	FRAME MEMBERS	4	WOOD (LVL)	EAGLE WINDOW & DOOR
2	221A	FRENCH CASEMENT CENTER STILE	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 (PECORA 896)	AS REQUIRED	SILICONE	DOW CORNING
7	A51H	INSTANT GLAZE II SEALANT	AS REQUIRED	SILICONE	DOW CORNING
8	220T	HEAD STOP	1	WOOD	EAGLE WINDOW & DOOR
9	20C0	SIDE STOP	2	WOOD	EAGLE WINDOW & DOOR
10	A100	CORNER KEY	4	NYLON	LAKE COUNTRY SALES
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 TAPE (5/8") (SINGLE SIDE)	AS REQUIRED	POLYTHYLENE	ADHESIVE RESEARCH
14	A07L	RAIL / STILE CLADDING	4	ALUMINUM	BONNELL
15	A00L	3/16 X 1 1/8 STAPLE	AS REQUIRED	GALVANIZED STEEL	ABILITY FASTENERS
16	220J	COLONIAL GLAZING STOP	4	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	1	CLOSED CELL FOAM	AMESBURY
21	A283	BULB WEATHERSTRIP - HEAD	2	PPR	INTEK
22	A39W	#7 X 1 1/4" FHSMS S.S.	4	STAINLESS STEEL	ABILITY FASTENERS
23	A66H	SINGLE ARM OPERATOR	1	STAINLESS STEEL	ASHLAND HARDWARE
24	A52G	FRENCH CASEMENT ASTRAGAL CVR	1	ALUMINUM	BONNELL
25	A261	#6 x 1 1/4" FHWS S.S.	1	STAINLESS STEEL	ABILITY FASTENERS
26	A08L	#5 X 1 1/2" FHES	4	STAINLESS STEEL	ABILITY FASTENERS
27	A66R	OPERATOR HANDLE	1	STEEL	ASHLAND HARDWARE
28	A25X	3/16" x 1 1/4" CLOSED CELL FOAM PAD	1	POLYETHYLENE	ADHESIVE RESEARCH
29	A387	2" PIANO HINGE	1	STAINLESS STEEL	TRUTH HARDWARE
30	A00R	#7 X 5/8" SS FH. WS.	3	STAINLESS STEEL	ABILITY FASTENERS
31	A66K	FRENCH CASEMENT SASH TRACK	2	STAINLESS STEEL	ASHLAND HARDWARE
32	A607	4.0 x 38 MM (1 1/2") SELF DRILL SCREW	14	STAINLESS STEEL	HOPPE
33	A608	4.0 x 32 MM (1 1/2") SELF DRILL SCREW	6	STAINLESS STEEL	HOPPE
34	A609	4.0 x 22MM (3/4" LENGTH)	3	STAINLESS STEEL	ABILITY FASTENERS
35	A00P	#8 X 1" FH SMS	AS REQUIRED	STEEL	ABILITY FASTENERS
36	A66T	OPERATOR COVER	1	PLASTIC	ASHLAND HARDWARE
37	A57E	LOCK HANDLE	1	DIE CAST ZINC	ASHLAND HARDWARE
38	A11K	#8 X 7/16" FHSMS W/ #6 HEAD	8	STAINLESS STEEL	ABILITY FASTENERS
39					
40		INSULATED GLASS	1	GLASS	CARDINAL IG
41	A08K	GLAZING SHIM, .250 x .065 x 4.000	AS REQUIRED	NEOPRENE RUBER	CLIM-A-TECH
42	A00E	NEOPRENE GLASS SETTING BLOCK	AS REQUIRED	NEOPRENE RUBER	CLIM-A-TECH
43	A67E	BLIND NAILING SPLINE	AS REQUIRED	VINYL	
44	A679	SHIM LIMITER TRACK	1	STAINLESS STEEL	ALLMETAL
45	A00N	#8 x 2 1/8" FHWS Z&Y	AS REQUIRED	STAINLESS STEEL	ABILITY FASTENERS
46	A69F	OPERATOR SHIM	1	RIGID PVC	
47	A00T	#7 x 7/8" FHWS S.S.	4	STAINLESS STEEL	ABILITY FASTENERS
48	A39K	#10 x 5/8" PFHMS S.S.	2	STAINLESS STEEL	ABILITY FASTENERS
49	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
50	221B	FRENCH CSCMT BOT RAIL LEFT SASH	1	WOOD	EAGLE WINDOW & DOOR
51	221C	FRENCH CSCMT TOP RAIL LEFT SASH	1	WOOD	EAGLE WINDOW & DOOR
52	221D	FR CSCMT TOP/BOT RAIL RIGHT SASH	2	WOOD	EAGLE WINDOW & DOOR
53	21YD	FRENCH CSCMT INT ASTRAGAL	1	WOOD	EAGLE WINDOW & DOOR
54	21YE	FRENCH CSCMT EXT ASTRAGAL	1	WOOD	EAGLE WINDOW & DOOR
55	A57A	FRENCH CASEMENT LOCKING SYSTEM	1	STAINLESS STEEL	HOPPE
	A578		1	STAINLESS STEEL	HOPPE
	A577		1	STAINLESS STEEL	HOPPE
56	A574	FRENCH CASEMENT STRIKE PLATE	2	STAINLESS STEEL	HOPPE
57	A57B	FRENCH CSMT TILT LCK STRIKE PLATE	1	STAINLESS STEEL	HOPPE
58	A57C	FRENCH CSMT HANDLE CONNECTOR	1	DIE CAST ZINC	HOPPE
59	A31D	FRENCH CASEMENT SILL PAD	1	VINYL	CLIM-A-TECH
60	A61B	FRCSMT EURO GROOVE CVR LONG	1	STAINLESS STEEL	HOPPE
61	A61C	FRCSMT EURO GROOVE CVR SHORT	1	STAINLESS STEEL	HOPPE
62	21RE	STEP JAMB	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
63	N/A	ADHESIVE FOAM TAPE	AS REQUIRED	POLYETHYLENE	CARDINAL
64	A32N	FRCSMT BULB WEATHER STRIP	AS REQUIRED	PPR	INTEK



### Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report#

75734

Date

8/10/07

Tech

*[Signature]*

TITLE: CLAD FRENCH CSMT  
UNIT ASSY.

FINISH:

MATL:

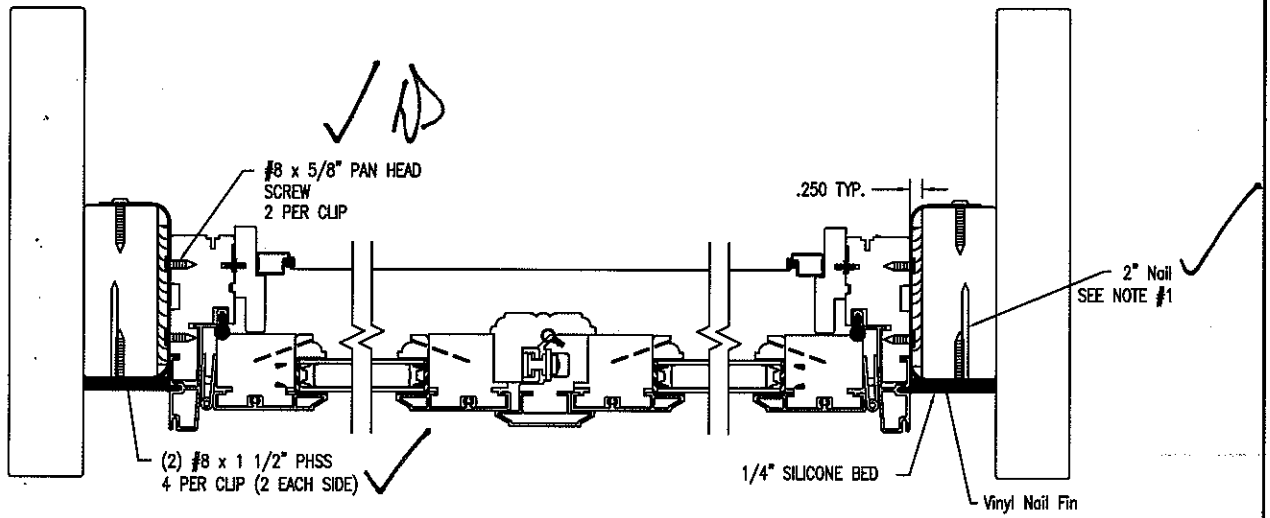
DFT: CRC SCALE: 1=1

DCN: 0710 DRWG: 054P

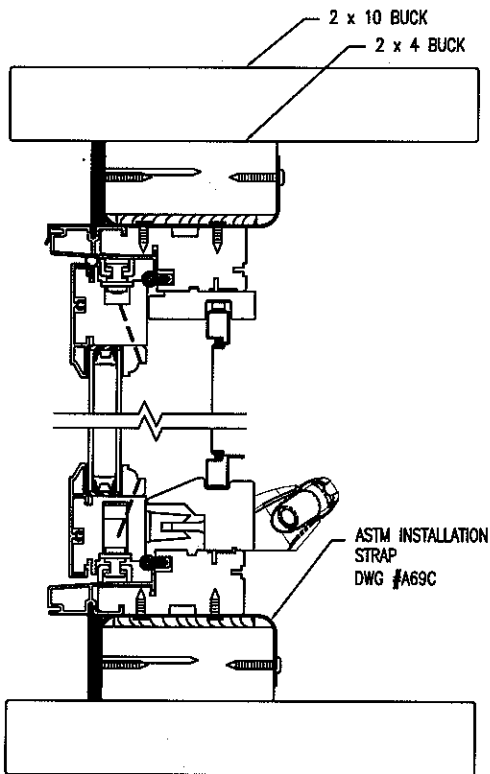
DATE: 7/26/07 C 08

NO	DESCRIPTION	DFT	DOC	DATE

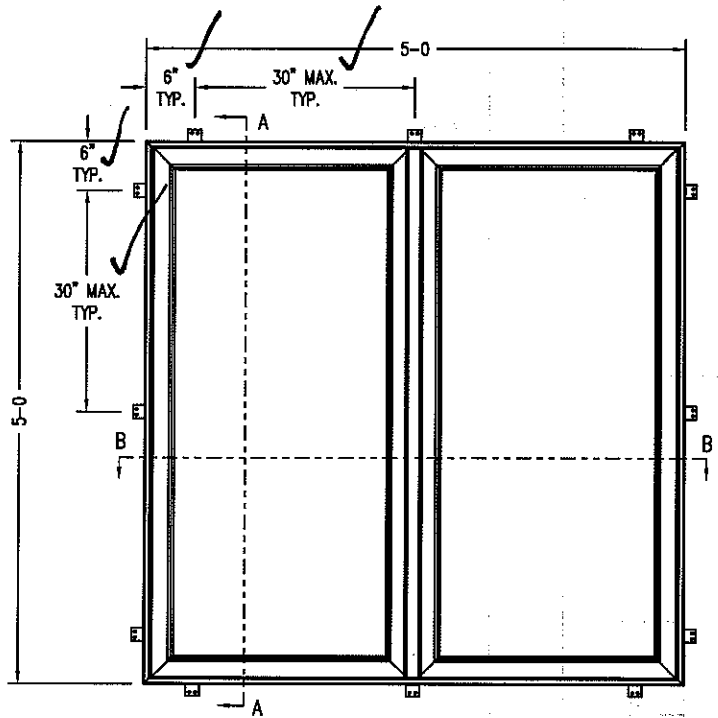
1. CENTER NAIL FIN, PLACE NAIL IN FIRST HOLE AND THEN EVERY OTHER THERE AFTER. 2" ROOFING NAILS THROUGH NAIL FIN INTO WALL.



SECTION B-B



SECTION A-A



CLAD FRENCH CASEMENT  
EXTERIOR VIEW



Architectural Testing

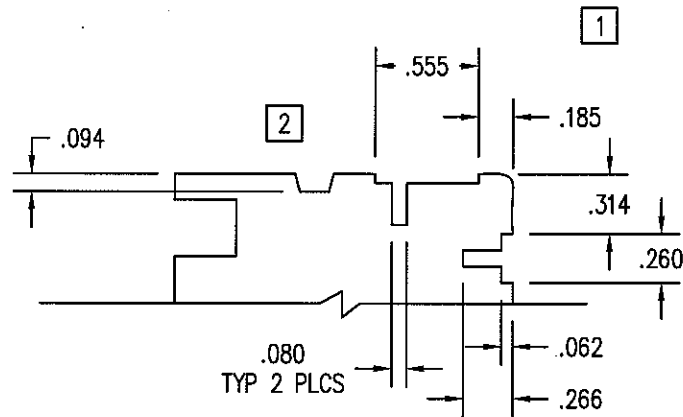
Test sample complies with these details.  
Deviations are noted.

Report# 75734  
Date 5/6-7/07 Tech ND

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TITLE: CLAD FRENCH CASEMENT INSTALLATION DETAIL	
FINISH:	
MAIL:	
DFT: CRC	SCALE: 1=4
DCN: 1099	DRWG: 054J
DATE: 7/5/07	C 03

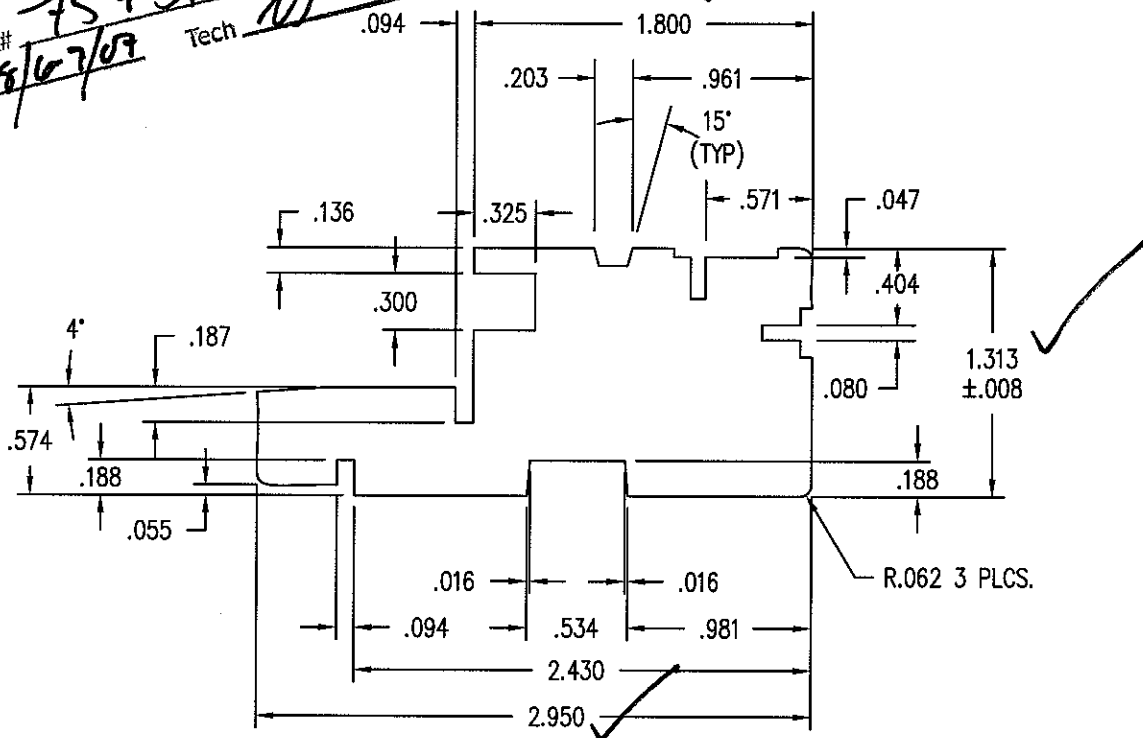
NO	DESCRIPTION	DFT	DOC	DATE

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.



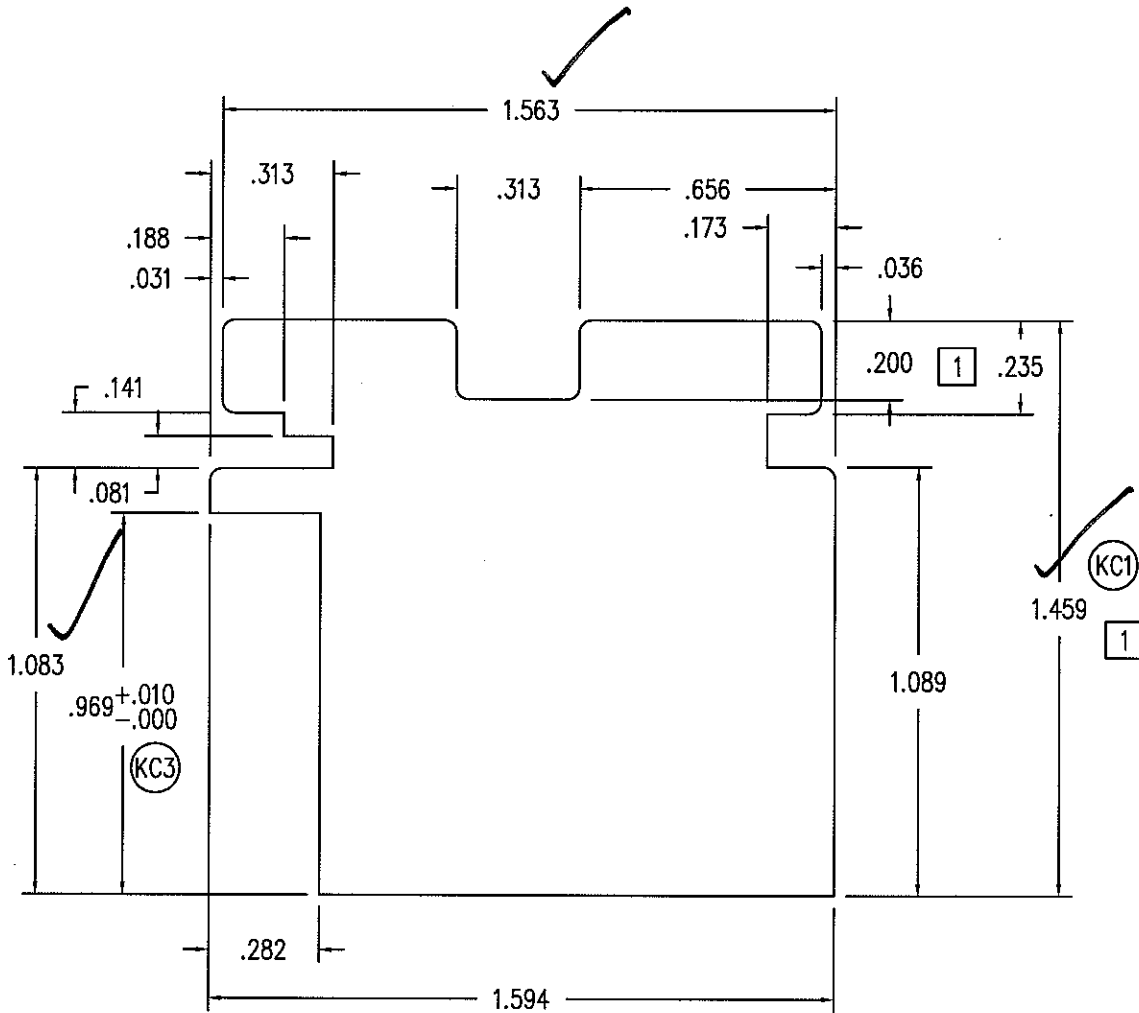
**Architectural Testing**  
 Test sample complies with these details.  
 Deviations are noted.

Report# 75734  
 Date 8/6/09 Tech [Signature]



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				

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. ALL RADII .031 UNLESS SPECIFIED.



(KC2)  
 Architectural Testing

Test sample complies with these details.  
 Deviations are noted.

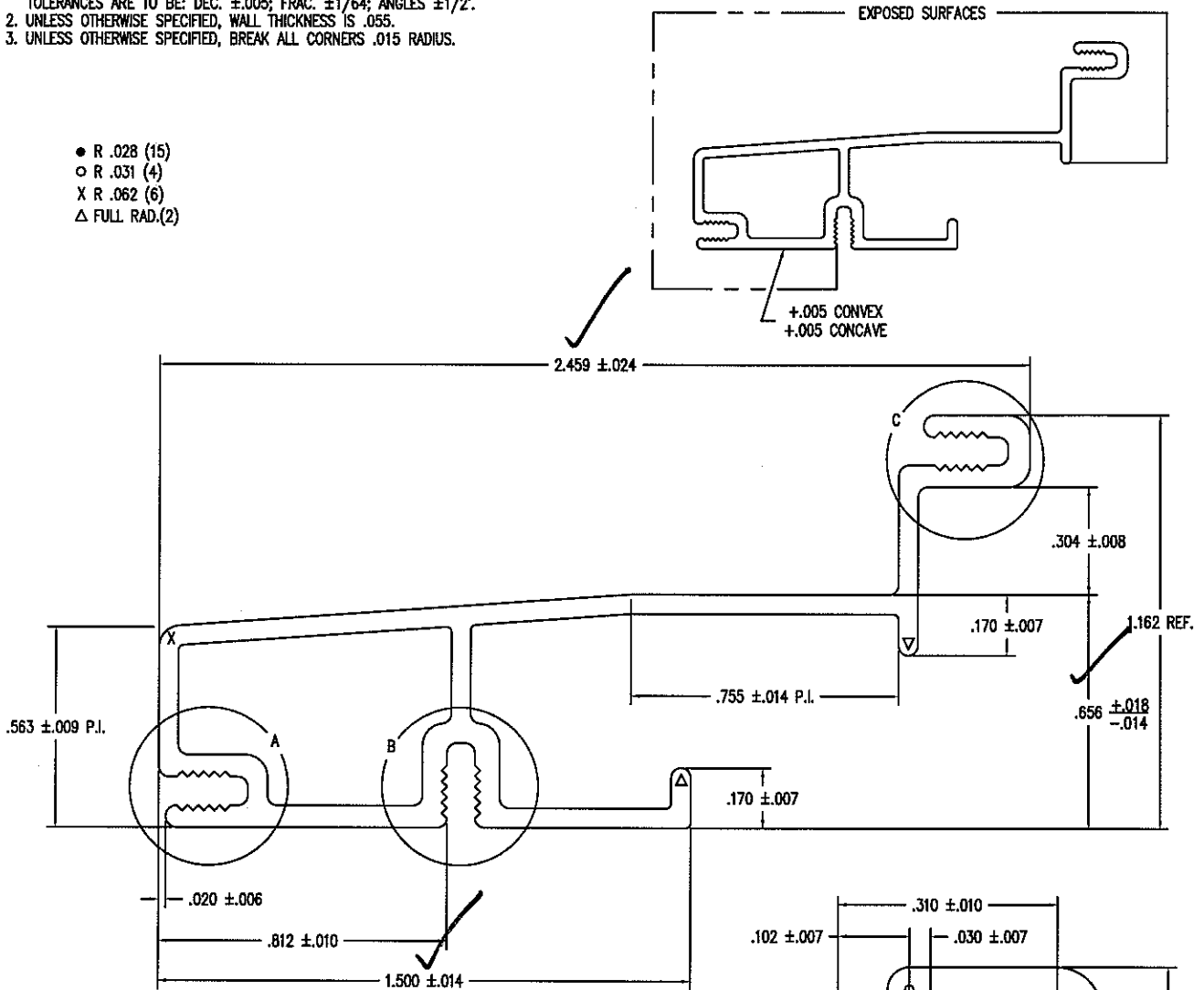
Report# 75734  
 Date 8/6-7/03 Tech [Signature]

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TITLE: FRENCH CASEMENT CENTER STILE	
FINISH:	
MATL: EAGLE'S STD WOOD SPECIES	
DFT: SCT	SCALE: 2=1
DCN: 0640	DRWG: 221A
DATE: 7/31/2003	A 01 OF 03

01	CHG'D DIMS TO MATCH CLAD CSMT STILE	JH	0943	2/17/2005
NO	DESCRIPTION	DFT	DOC	DATE

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.

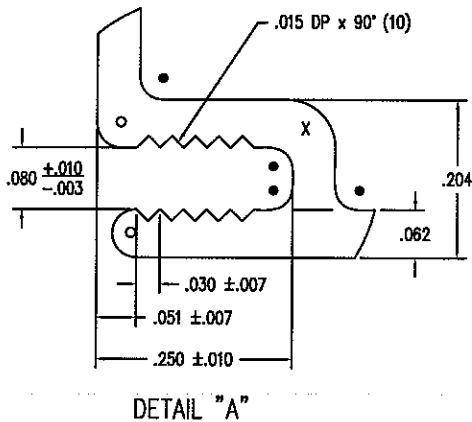
- R .028 (15)
- R .031 (4)
- X R .062 (6)
- △ FULL RAD.(2)



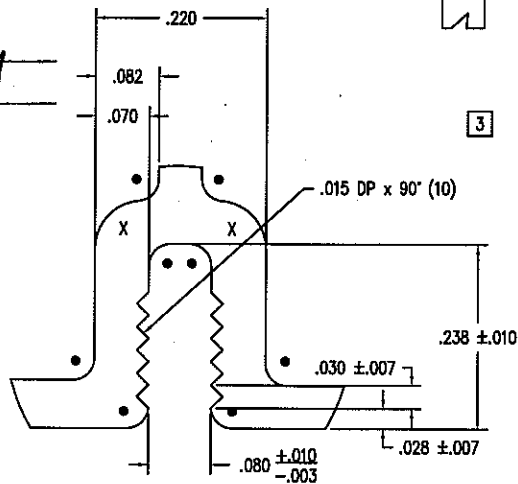
### Architectural Testing

Test sample complies with these details.  
 Deviations are noted.

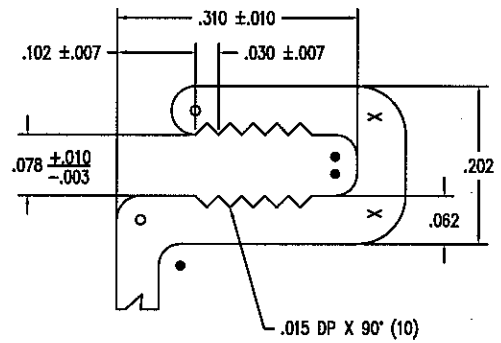
Report# 75734  
 Date 8/10-7/07 Tech AS



DETAIL "A"



DETAIL "B"



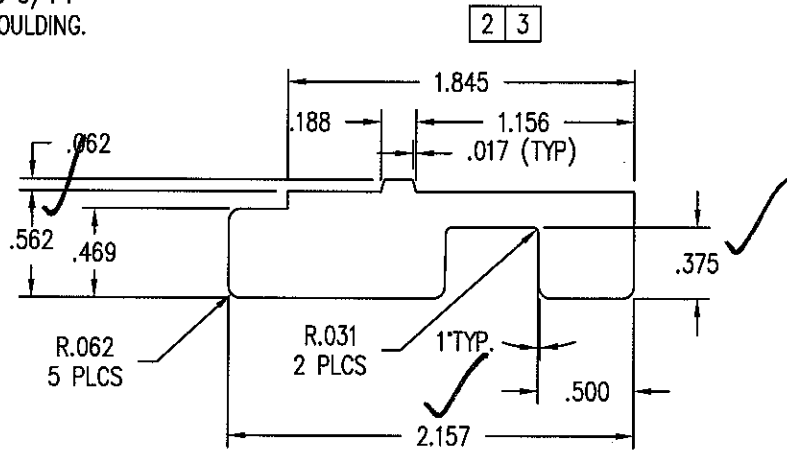
3 DETAIL "C"

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 TITLE: FRAME COVER CLADDING  
 FINISH: EAGLE'S STD. COLORS

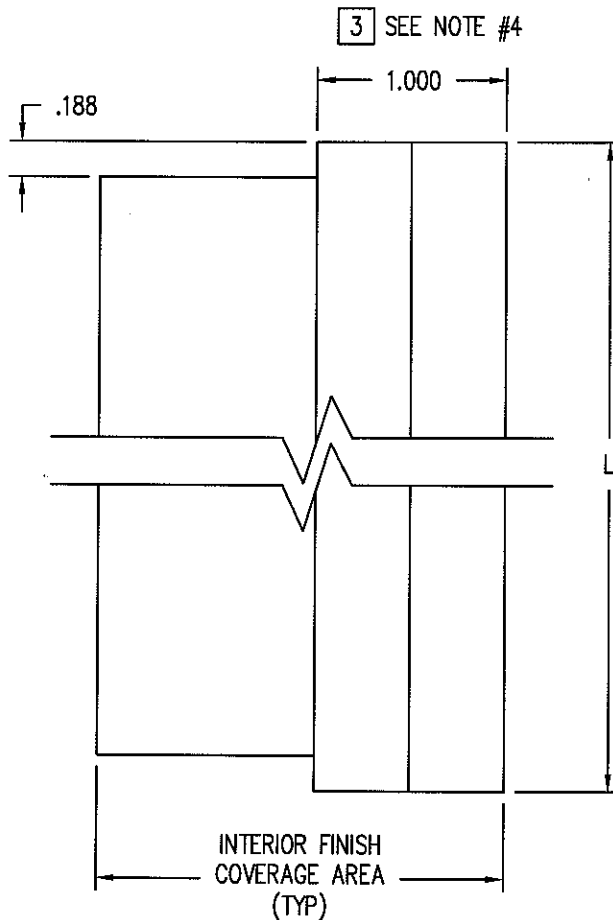
05	ADDED/CHG'D DIM. & TOLERANCE	TWN	0778	1/4/2003	MATL:	6063 T-6 ALUMINUM OR EQUIVALENT
04	ADDED TOLERANCE SPECS	TWN	0595	8/31/2001	REL	SCALE: 2=1
03	REVISED PROFILE	CEL	0368	1/27/1999	DCN:	0004
02	REVISED PROFILE	RDA	0272	9/17/1997	DRWG:	A04A
01	CHANGED NOTES	GDE	0048	8/7/1992	DATE:	7/21/1992
NO	DESCRIPTION	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

4

Architectural Testing

Test sample complies with these details.  
Deviations are noted.

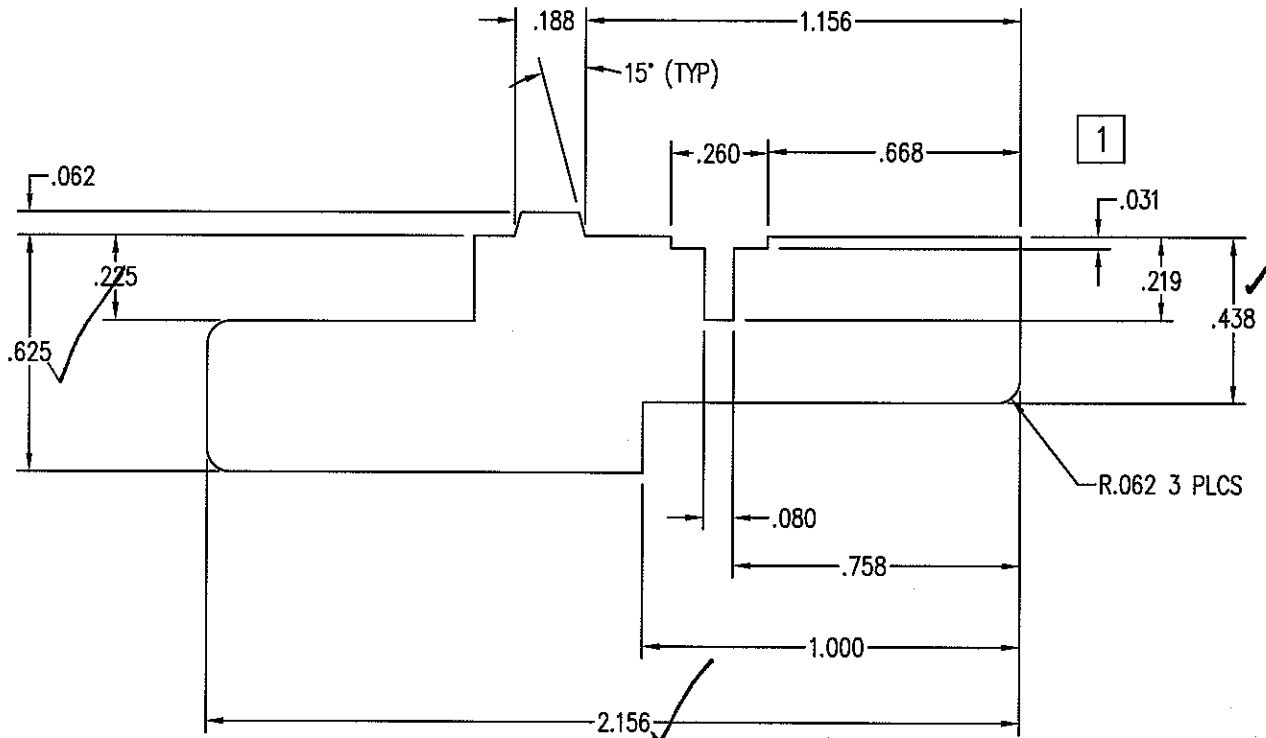
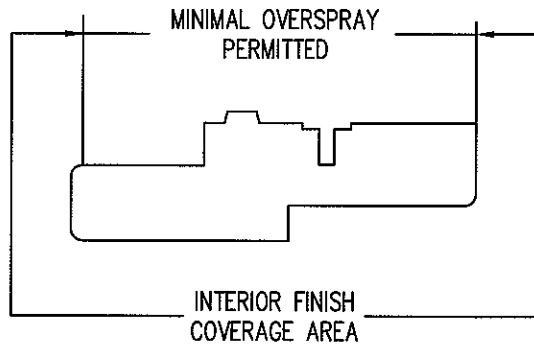
Report# 75734  
Date 5/6-3/07 Tech DS

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	Date: 01 of 01

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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.



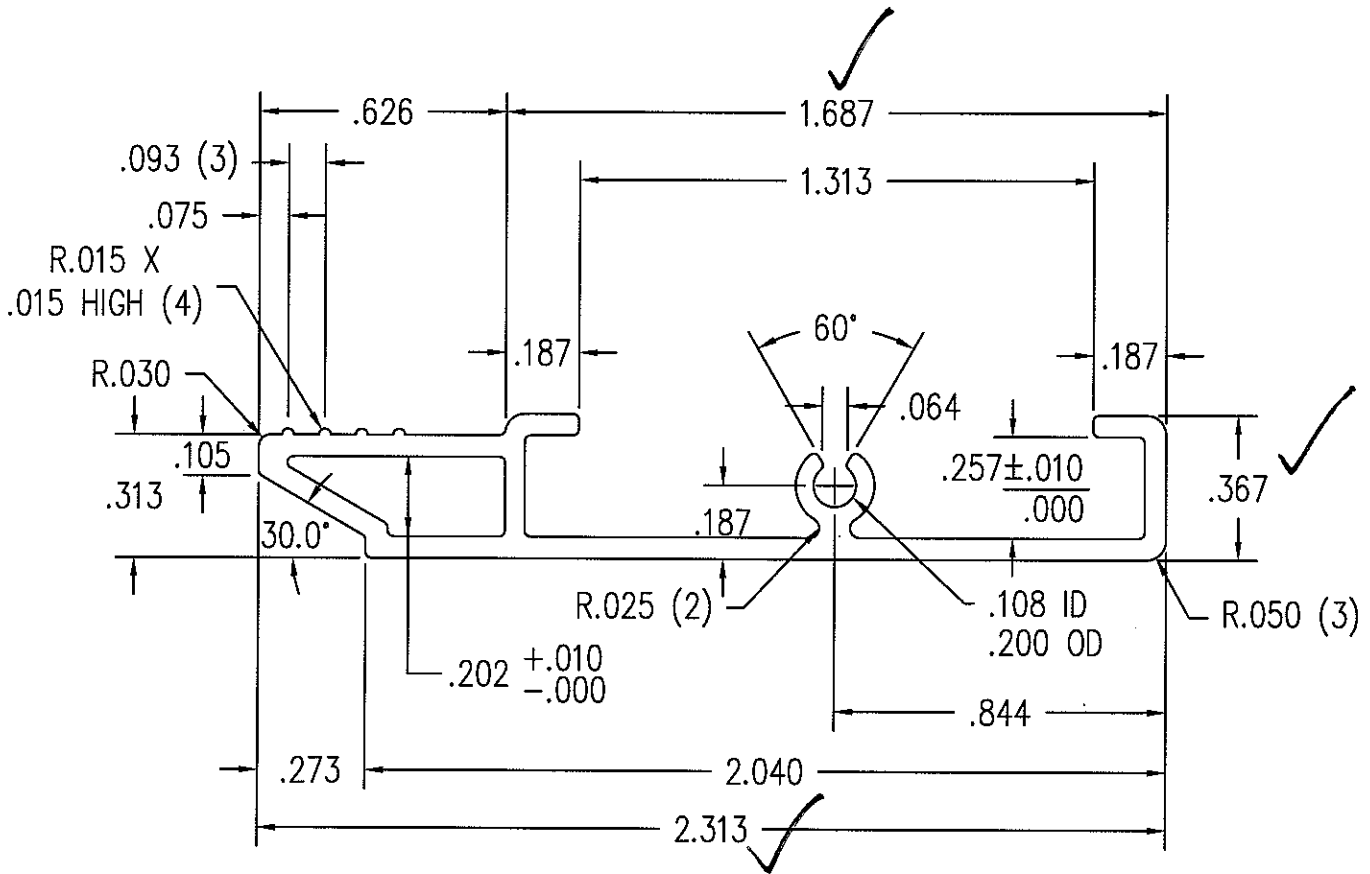
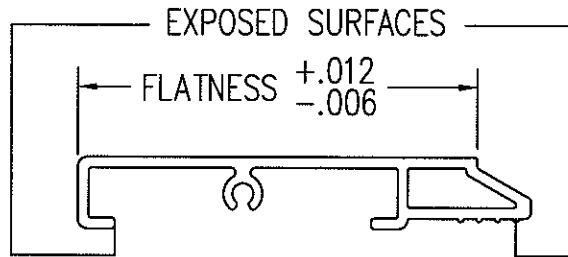
Architectural Testing

Test sample complies with these details.  
 Deviations are noted.

Report# 75734  
 Date 8/6-7/07 Tech [Signature]

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.		REVISION: 20C0
Drafter: AWW	DCN# 0681			2 01 of 03

- 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. WALL THICKNESS TO BE .055 UNLESS OTHERWISE SPECIFIED.  
 3. ALL RADII NOT DIMENSIONED TO BE .015.



Test sample complies with these details.  
 Deviations are noted.

Report# 75734  
 Date 8/6-7/07 Tech W

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TITLE:	SASH CLADDING
FINISH:	EAGLE'S STD. COLORS
MATL:	6063-T6 ALUMINUM OR EQUIVALENT
DFT:	REL
SCALE:	2=1
DCN:	0029
DRWG:	A07L
DATE:	4/14/1992
A	01 OF 02

01	ADDED TOLERANCE SPEC'S	REL	0595	1/28/2002
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

PANEL STOPS	
PRODUCT	A
WOOD OUTSWING SIDELITE	.469
WOOD OUTSWING TRANSOM	.469
WOOD INSWING SIDELITE	.469
WOOD INSWING TRANSOM	.469

2

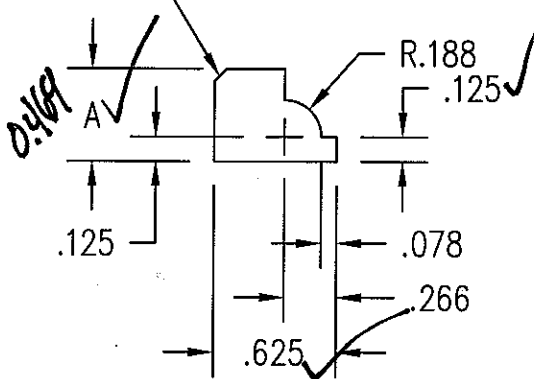
1

Architectural Testing

Test sample complies with these details. Deviations are noted.

Report# 75734  
Date 8/6-7/07 Tech [Signature]

.062 x .062 CHAMFER



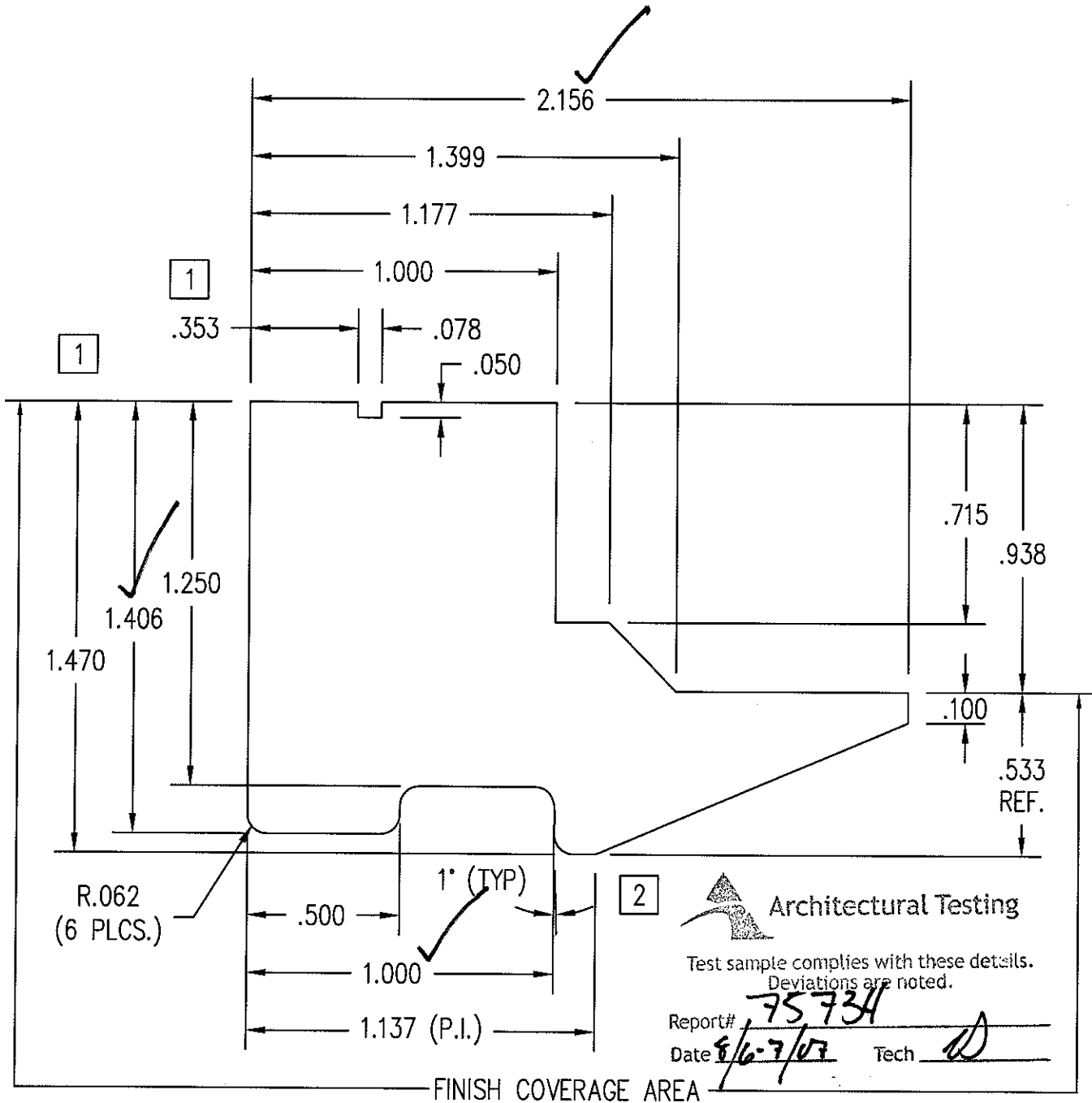
3

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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

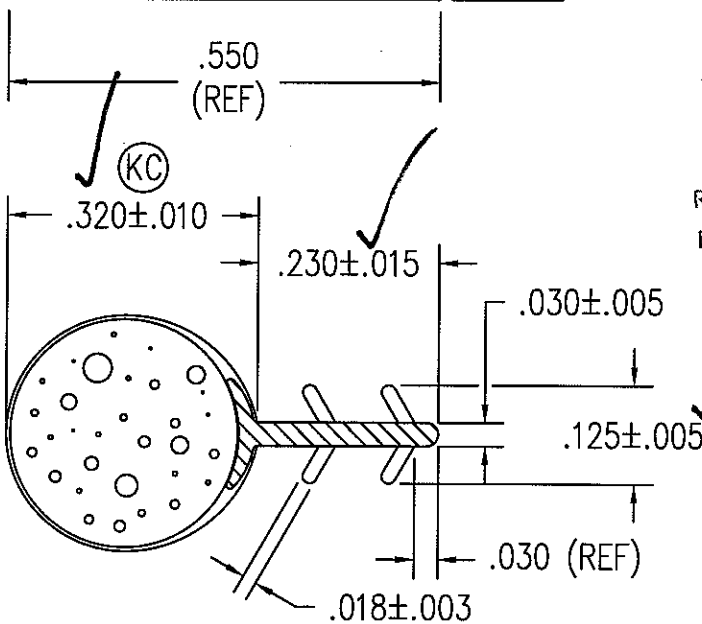
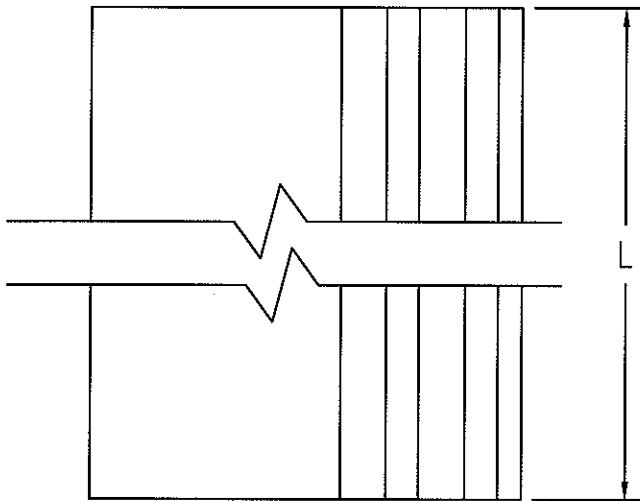
03	ADDED SIZE FOR IMPACT GLAZING	TWN	0972	9/1/05
02	CHG'D CLAD PANEL STOP "A" DIM	JH	0794	6/30/05
01	ADDED KYLER BLIND SIZE	TWN	0910	4/19/05
NO	DESCRIPTION	DFT	DOC	DATE

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.



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.		REVISION: <b>223N</b> 2 01 of 05
Drafter: pblasen	DCN# 0927			

- 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

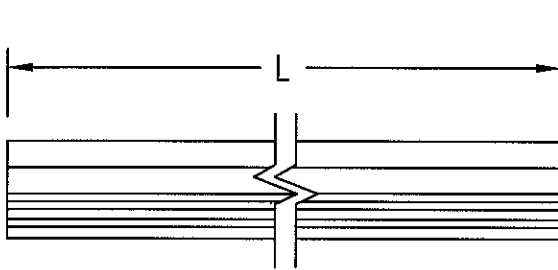
Test sample complies with these details.  
 Deviations are noted.

Report# 75734  
 Date 6/6-7/07 Tech AW

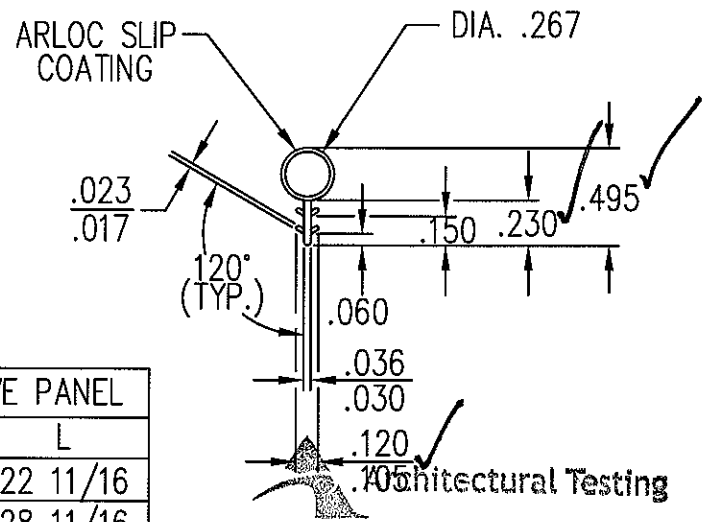
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TITLE: BULB WEATHERSTRIP (.320) CASEMENT	
FINISH:	TAN PART #12202
MATL:	SEE NOTE 3

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



Test sample complies with these details. Deviations are noted.

Report# 75734  
 Date 8/6-7/03  
 CLAD & WOOD SLIDING DRS.

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

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

FRAME HEIGHT	L
80	77
82	79
96	93

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TITLE: ARLOC BULB WEATHERSTRIP

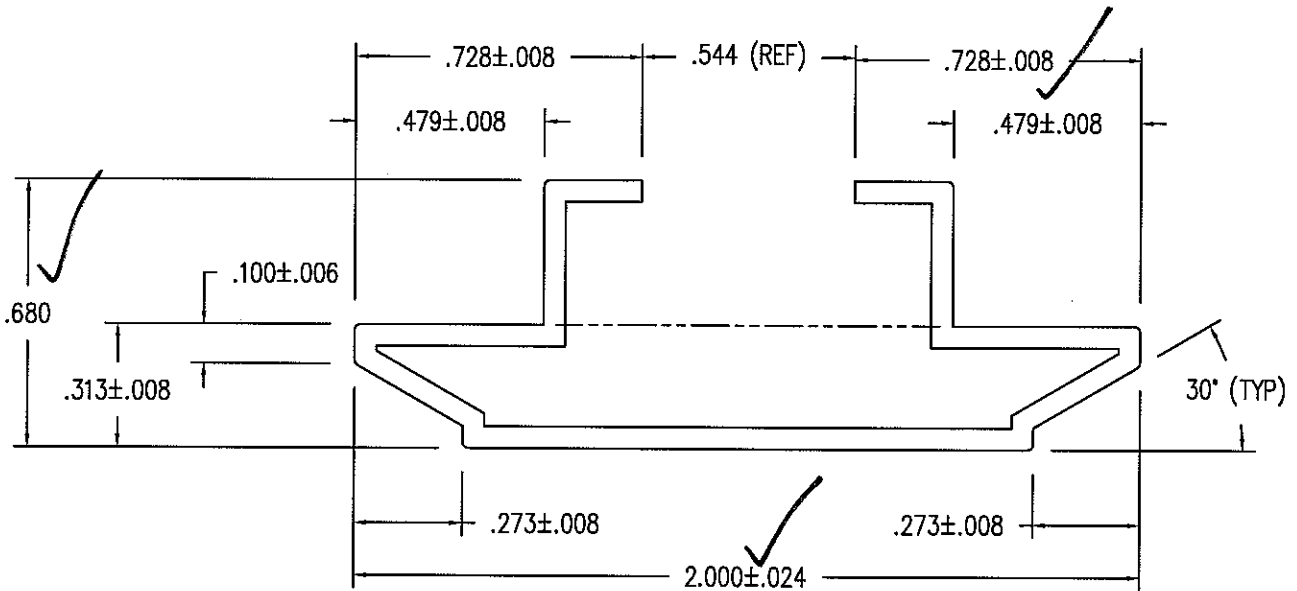
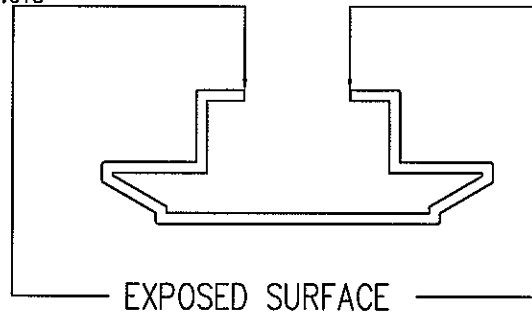
FINISH:	
MATL:	PPR PROPYLENO/ETHYLONE COPOLYMER
DFT:	TWN SCALE: 1=1
DCN:	0231 DRWG: A283
DATE:	1/16/1996 A 01 OF 04

NO	DESCRIPTION	DFT	DOC	DATE
05	CHANGED TO PAGE 01 OF 04	RJW	0640	10/1/2003
04	CHG'D SINGLE O/S DOOR WIDTH	TWN	0632	11/30/2000
03	ADDED PAGES/REMOVED CHARTS	TWN	0486	4/9/2001
02	ADDED SLIDING DR CHART	MJP	0444	4/3/2000
01	ADDED 6-10 DOOR HGT.	MJP	0243	8/13/1997

NOTE: 1. ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUDED SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE.

2. UNSPECIFIED WALL THICKNESS TO BE .055.

3. UNLESS OTHERWISE SPECIFIED ALL RADII AND FILLETS = .015



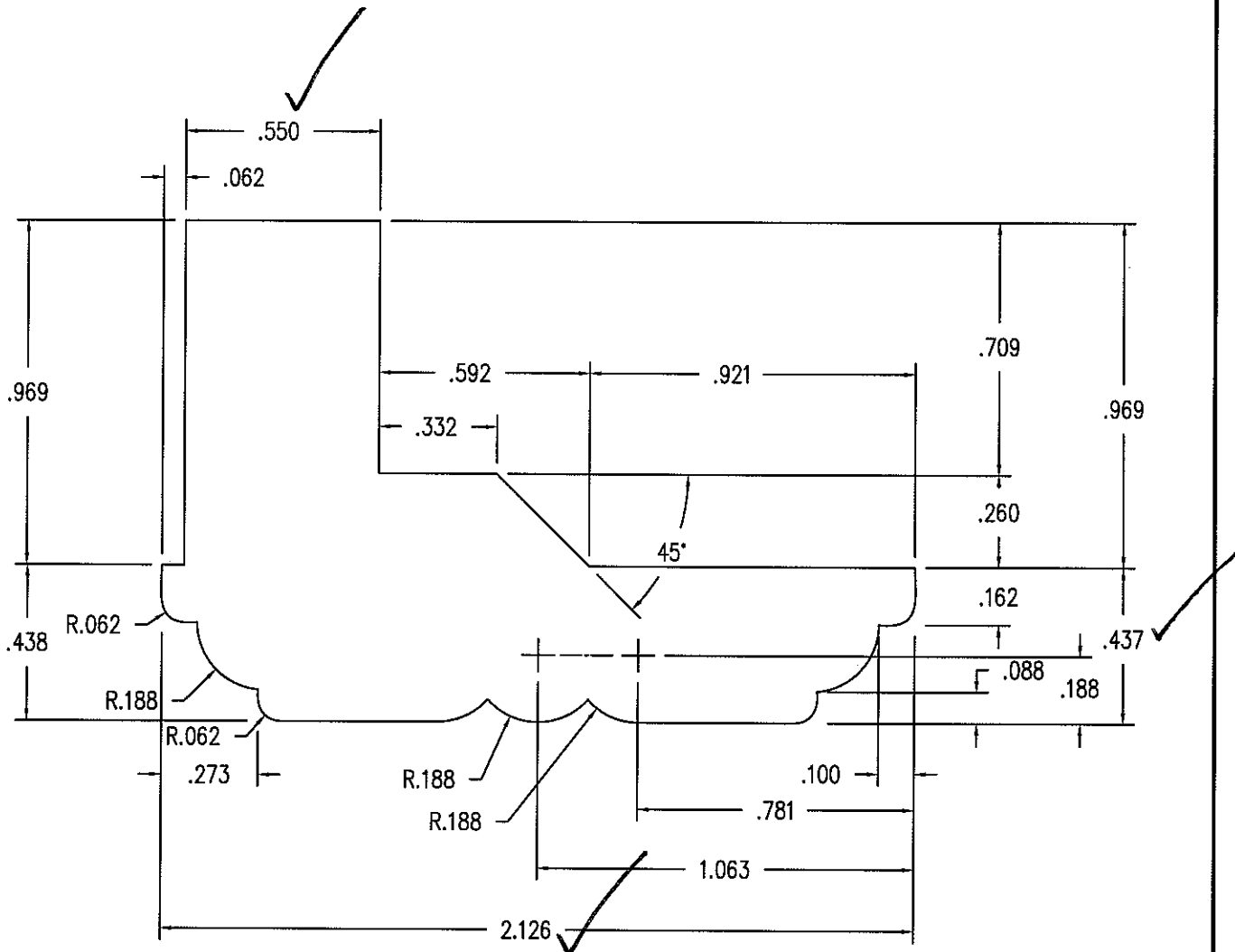
Test sample complies with these details.  
Deviations are noted.

Report# 75734  
Date 8/6-7/07 Tech W

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TITLE:	ASTRAGAL COVER FRENCH CASEMENT
FINISH:	EAGLE'S STD. COLORS PART# M7273, DIE# EWD-266
MATL:	6060 T-5 ALUMINUM
DFT:	SCT
DCN:	0640
DATE:	8/5/2002
SCALE:	2=1
DRWG:	A52G
	A 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE

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  $\pm 1/2^\circ$ .



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

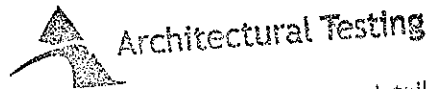
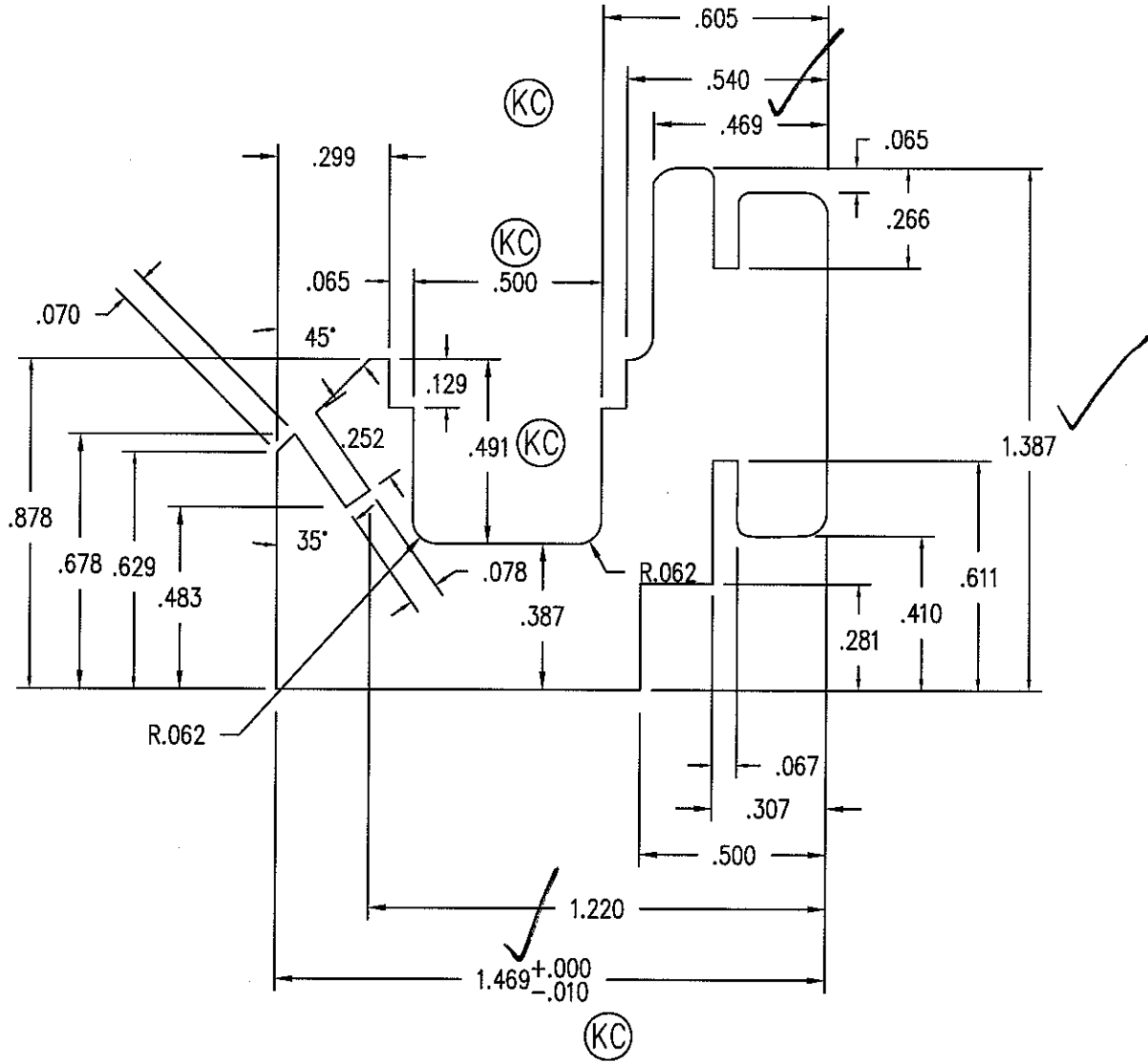
Report# 75734  
Date 8/10/07 Tech ES



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TITLE:	FRENCH CASEMENT INTERIOR ASTRAGAL
FINISH:	
MATL:	EAGLE'S STD WOOD SPECIES
DFT:	SCT
DCN:	0640
DATE:	7/31/2003
SCALE:	2=1
DRWG:	21YE
	A 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE
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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  $\pm 1/2^\circ$ .



Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report# 75734  
Date 6/6-7/07 Tech MS

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TITLE: FRENCH CASEMENT EXTERIOR ASTRAGAL	
FINISH:	
MATL: EAGLE'S STD WOOD SPECIES	
DFT: SCT	SCALE: 2=1
DCN: 0640	DRWG: 21YD
DATE: 7/31/2003	A 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE