Architectural Testing

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

Rendered to:

EAGLE WINDOW & DOOR, INC.

SERIES/MODEL: Double Hung 5086
PRODUCT TYPE: Aluminum Clad Wood Double Hung

Title	Summary of Results
Primary Product Designator	LC-PG30-H 1524 x 2591 (60 x 102)
Design Pressure	1440 Pa (30.0 psf)
Operating Force (in motion)	99 N (22.3 lbf)
Air Infiltration	<0.05 L/s/m^2 (<0.01 cfm/ft^2)
Water Penetration Resistance Test Pressure	400 Pa (8.25 psf)
Uniform Load Structural Test Pressure	±2160 Pa (45.0 psf)
Forced Entry Resistance	Grade 10

Test Completion Date: 05/03/07

Reference must be made to Report No. 73119.01-201-44 dated 12/03/08 for complete test specimen description and data.

849 Western Avenue North
St. Paul, MN 55117
phone: 651-636-3835
fax: 651-636-3843
www.archtest.com

Architectural Testing

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

Rendered to:

EAGLE WINDOW & DOOR, INC.
2045 Kerper Boulevard
Dubuque, Iowa 52001

Report No.:	73119.01-201-44
Test Dates:	05/30/07
Through:	06/01/07
Original Report Date:	06/27/07
Revised Report Date:	12/03/08
Expiration Date:	05/30/11

Project Summary: Architectural Testing, Inc. was contracted by Eagle Window & Door, Inc. perform testing on a Series/Model Double Hung 5086, Aluminum Clad Wood Double Hung window The sample tested successfully met the performance requirements for a LC-PG30-H 1524 x 2591 (60 x 102) rating. Test specimen description and results are reported herein.

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: Double Hung 5086

Product Type: Aluminum Clad Wood Double Hung window

Overall Size: 1524 mm (60") wide by 2591 mm (102") high

Lower Sash Size: 1429 mm (56-1/4") wide by 1302 mm (51-1/4") high

Upper Sash Size: 1429 mm (56-1/4") wide by 1251 mm (49-1/4") high

Screen Size: 1448 mm (57") wide by 2540 mm (100") high

Overall Area: 3.9 m^2 (42.5 ft^2)

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Test Specimen Description: (Continued)

Finish: Exterior cladding was painted white, interior wood was natural.

Frame Construction: Head frame corners were coped, butted, sealed with silicone, and secured with three 11 mm (7/16") by 44 mm (1-3/4") long staples per corner. Sill frame corners were coped, butted, sealed with a corner gasket and silicone, and secured with two #8 by 44 mm (1-3/4") screws. Aluminum cladding was slip-fit over wood members, miter-cut at head corners and secured with a corner key and two #6 by 11 mm (7/16") screws per corner. Sill corners were coped, butted sealed with a corner gasket and silicone, and secures with a #7 by 32 mm (1-1/4") screw and a #6 by 11 mm (7/16") screw.

Sash Construction: The lower sash and upper sash, top rail and stiles consisted of molded pine sections, the lower sash meeting rail was LVL. Upper sash corners were mortise-and-tenon construction and secured with glue and one 5 mm (3/16") by 38 mm (1-1/2") staple per corner. Aluminum cladding was slip-fit over wood members, upper sash corners were miter-cut, sealed with butyl and secured with a corner key and two #4 by 13 mm (1/2") screws per corner. Lower sash corners were mortise-and-tenon construction; meting rail corners were secured with glue and two 5 mm (3/16") by 38 mm (1-1/2") staples per corner; bottom rail corners were secured with glue and one #8 by 57 mm (2-1/4") screw per corner. Aluminum cladding was slip-fit over wood members, corners were coped, butted and sealed with butyl.

Screen Construction: The screen was comprised of roll-formed aluminum with plastic corner keys. Fiberglass screen cloth was attached with a vinyl spline.

Glazing Details: The sash were glazed with nominal 19 mm (3/4") insulating glass comprised of two nominal 4 mm (5/32") annealed sheets separated by a desiccant-filled stainless steel spacer system. The glass was set from the interior against InstantGlaze II silicone sealant and secured with wood glazing beads set on the interior, secured with 25 mm (1") brad nails spaced 152 mm to 203 mm (6" to 8") on center.

Weatherstripping:

Description	Quantity	Location
Hollow vinyl bulb	1 Row	Lower sash bottom rail; upper sash meeting rail
Foam filled bulb	1 Row	Head jamb and side jambs
Wool pile	2	Side jambs at check rail

Test Specimen Description: (Continued)

Hardware:

Description	Quantity	Location
Vinyl jamb liner with block-and-tackle balance	2	Jamb pockets
Sweep locks and keepers with integrated tilt latches	2	203 mm (8") from sash corner
Metal tilt pins	4	Bottom corners of stiles

Installation: The window was installed within a wood test frame with installation clips that were secured to the window with two #8 by 16 mm (5/8") screws and to the buck on the interior and exterior with two #8 by 38 mm (1-1/2") screws that were spaced 610 mm (24") from corners on side jambs, with 51 mm (2") roofing nails 203 mm (8") on center through flange. The unit was sealed to the buck with silicone.

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

Paragraph	Title of Test - Test Method	Results	Allowed
5.3.1	Operating Force per ASTM E 2068		
	Upper sash		
	Open		
	Initiate motion	63 N (14.2 lbf)	--
	Maintain motion	86 N (19.3 lbf)	180 N (40.0 lbf)
	Close		
	Initiate motion	70 N (15.8 lbf)	--
	Maintain motion	56 N (12.7 lbf)	180 N (40.0 lbf)
	Lower sash		
	Open		
	Initiate motion	78 N (17.5 lbf)	--
	Maintain motion	72 N (16.2 lbf)	180 N (40.0 lbf)
	Close		
	Initiate motion	92 N (20.8 lbf)	--
	Maintain motion	99 N (22.3 lbf)	180 N (40.0 lbf)
	Latches		
	Lock	7 N (1.5 lbf)	100 N (22.5 lbf)
	Unlock	16 N (3.5 lbf)	100 N (22.5 lbf)

Test Results: (Continued)

Paragraph	Title of Test - Test Method	Results	Allowed
5.3.2.1	Air Leakage Resistance per ASTM E 283		
	75 Pa (1.6 psf)	<0.05 L/s/m^2 (<0.01 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2 max.)
	300 Pa (6.2 psf)	0.81 L/s/m^2 (0.16 cfm/ft^2)	-- --

***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: A Grade: 10

Disassembly Test	No entry	No entry
Tests A1 through A5; A7	No entry	No entry
Sash/Panel Manipulation Test	No entry	No entry
Lock Hardware Manipulation Test	No entry	No entry

5.3.6.3 Deglazing Test

In operating direction - 320 N (70 lbf)		
Upper sash-top rail	1.8 mm (0.07")	11.4 mm (0.45")
Upper sash-meeting rail	2.0 mm (0.08")	11.4 mm (0.45")
Lower sash-meeting rail	2.0 mm (0.08")	11.4 mm (0.45")
Lower sash-bottom rail	1.5 mm (0.06")	11.4 mm (0.45")
In remaining direction - 230 N (50 lbf)		
Upper sash-left stile	1.5 mm (0.06")	11.4 mm (0.45")
Upper sash-right stile	1.5 mm (0.06")	11.4 mm (0.45")
Lower sash-left stile	1.3 mm (0.05")	11.4 mm (0.45")
Lower sash-right stile	1.3 mm (0.05")	11.4 mm (0.45")

Test Results: (Continued)

Paragraph	Title of Test - Test Method	Results	Allowed
	Optional Performance		
4.3.2.1	Water Penetration Resistance per ASTM E 547 and E 331 (with and without insect screen) 400 Pa (8.25 psf)	No leakage	No leakage
4.3.2.1	Uniform Load Deflection per ASTM E 330 (Deflections were taken on the sash stile) (Loads were held for 60 seconds)		
	1440 Pa (30.0 psf) (positive)	15.2 mm (0.60")	See Note #3
	1440 Pa (30.0 psf) (negative)	17.3 mm (0.68")	See Note #3
4.3.2.1	Uniform Load Structural per ASTM E 330 (Permanent sets were taken on the sash stile) (Loads were held for 10 seconds)		
	2160 Pa (45.0 psf) (positive)	1.8 mm (0.07")	5.1 mm (0.20") max.
	2160 Pa (45.0 psf) (negative)	<0.3 mm (<0.01")	5.1 mm (0.20") max.

***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.*

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 ATI and are representative of the test specimen reported herein.

List of Official Observers:

Name	Company
Thad McKinley	Eagle Window & Door, Inc.
Joe Cogan	Eagle Window & Door, 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.

Digitally Signed by: Eric Schoenthaler

Eric J. Schoenthaler
Project Manager

Digitally Signed by: Daniel A. Johnson

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-B: Drawings (41)

Revision Log

Rev. #	Date	Page(s)	Revision(s)
0	06/27/07	N/A	Original report issue. Report and drawings forwarded to AMS for Hallmark Certification.
1	07/06/07	2	Corrected glazing sealant in glazing paragraph. 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.

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 # : 73119.01-201-44-R2

Email: tbergstrom@eaglewindow.com

Product Relationship:

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

If yes, what CCL # ? 099-H-685.00

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

Is this a Gateway Test ? ❒ yes ❒ no X n/a

Does this report require a Gateway Report # ? ❒ yes ❒ no X n/a Report # : _____

Impact Report:

If this is not an impact report check here: X

AWS Report # _____

Test Plan # ? ❒ yes ❒ no X n/a _____

Installation Instructions submitted ? ❒ yes ❒ no X 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 X yes ❒ no ❒ n/a

WDMA HALLMARK CERTIFICATION PROGRAM
REPORT SUBMISSION FORM

Product Name: T7 Talon Double Hung Vent
(as to be listed on CCL)

Product Type: Hung Window – Vertical Sliding

Additional Manufacturer ID # : _____ ❒ n/a

Hallmark CCL	Standard	Rating
❒	ANSI/AAMA/NWWDA 101/I.S. 2 97	
❒	101/I.S.2/NAFS-02	
❒	AAMA/WDMA/CSA/101/I.S.2/A440-05	
X	AAMA/WDMA/CSA/101/I.S.2/A440-08	LC-PG30-H +30 / -30
❒	ASTM E 1996 99 / E1886-97	
❒	ASTM E 1996 01 / E1886-97	
❒	ASTM E 1996 02 / E1886-02	
❒	ASTM E 1996 03 / E1886-02	
❒	ASTM E 1996 04 / E1886-04	
❒	ASTM E 1996 05 / E1886-05	
❒	ASTM E330 02	
❒	ANSI A250.13-03	
❒	TAS 201-94	
❒	TAS 202-94	
❒	TAS 203-94	
❒	Other:	

Appendix C

Drawings

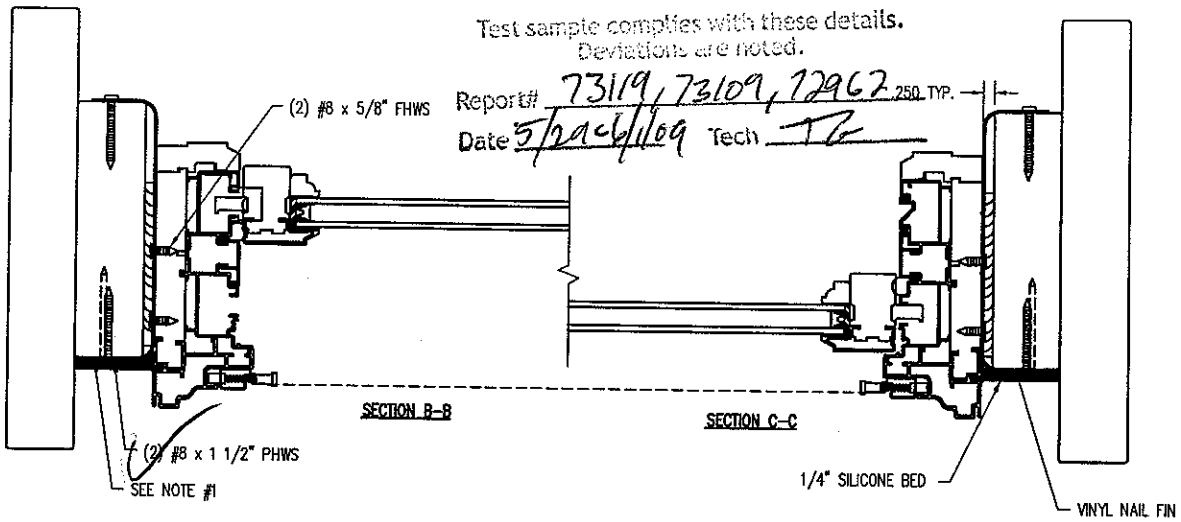
1. (36) 2" ROOFING NAILS THROUGH NAIL FIN INTO BUCK SPACES 3 1/2" FROM EACH END AND 6" ON CENTER THEREAFTER.

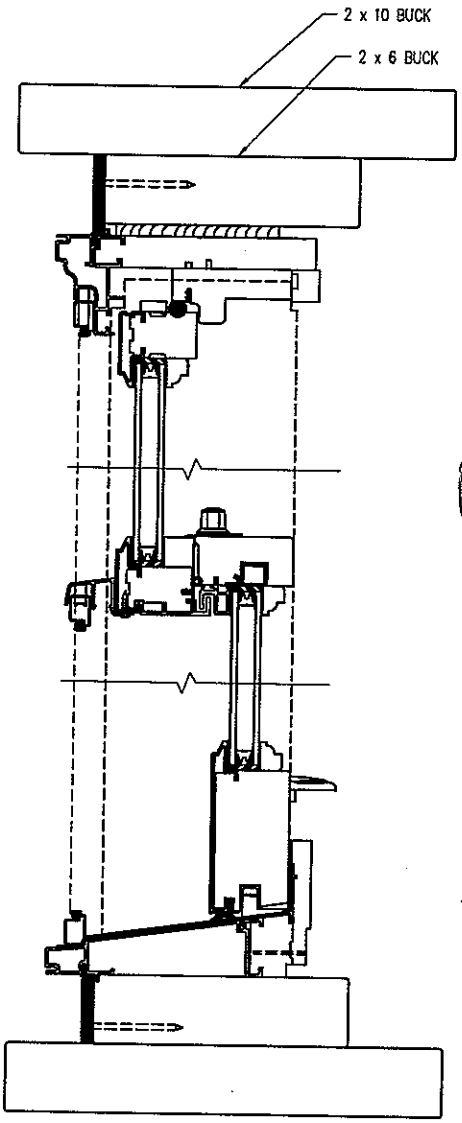
Architectural Testing

Test sample complies with these details.
Deviations are noted.

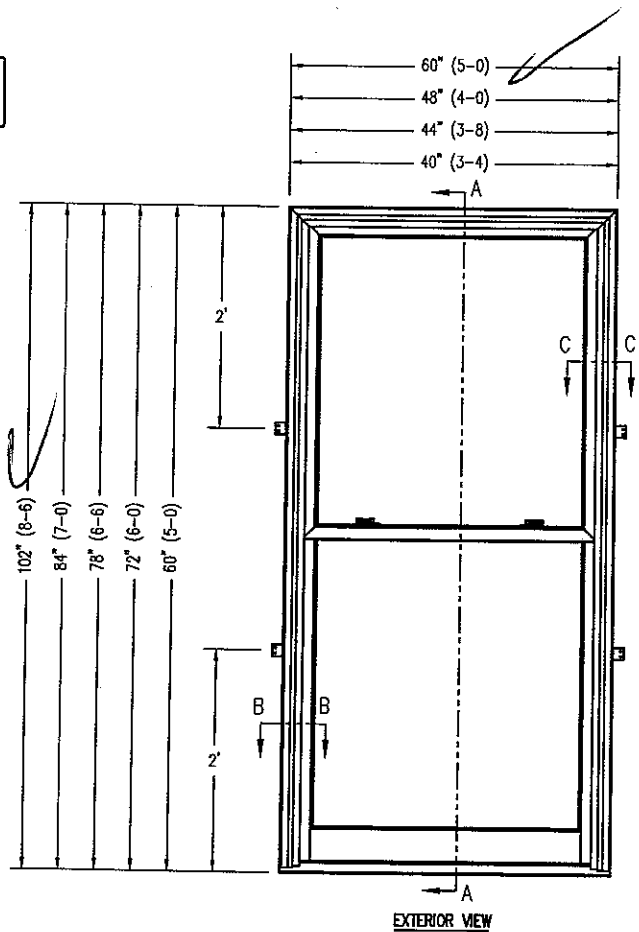
Report# 73119, 73109, 72962

Date 5/26/09 Tech TC





SECTION A-A



EXTERIOR VIEW

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DCN: 0881	DRWG: 0535
DATE: 3/19/07	C 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE

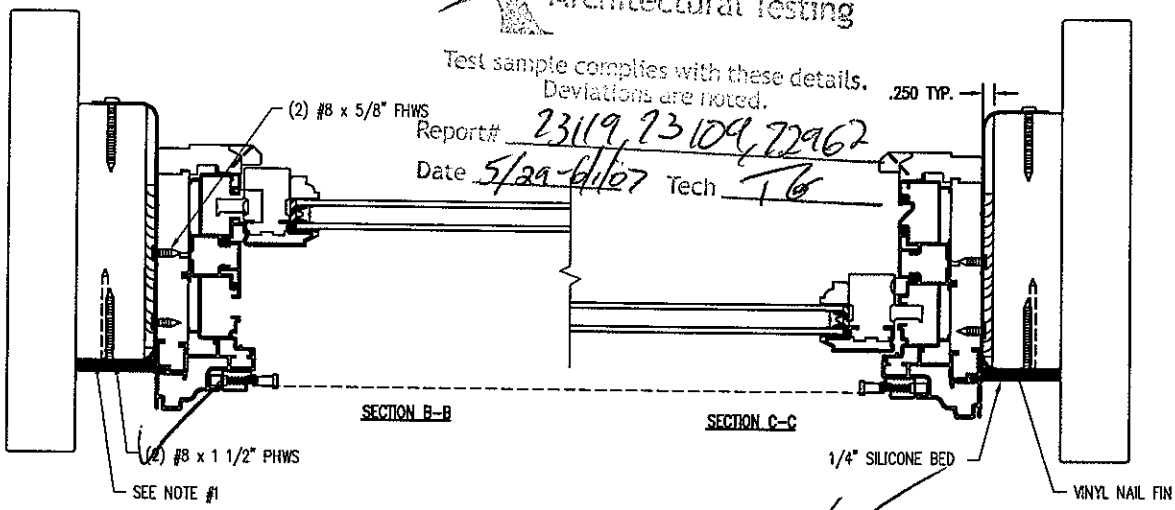
1. (36) 2" ROOFING NAILS THROUGH NAIL FIN INTO BUCK SPACES 3 1/2" FROM EACH END AND 6" ON CENTER THEREAFTER.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

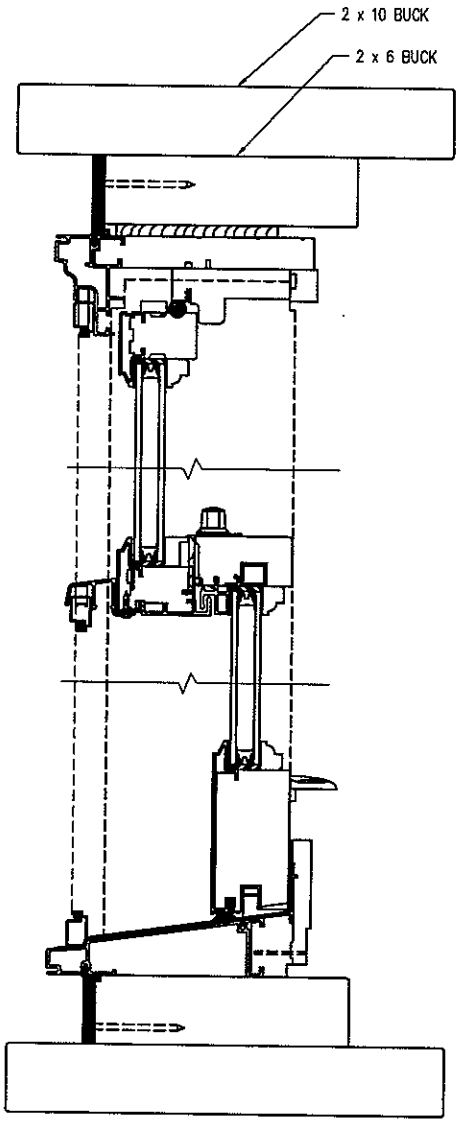
Report# 23119, 23109, 22962

Date 5/29-6/1/07 Tech TG



SECTION B–B

SECTION C–C



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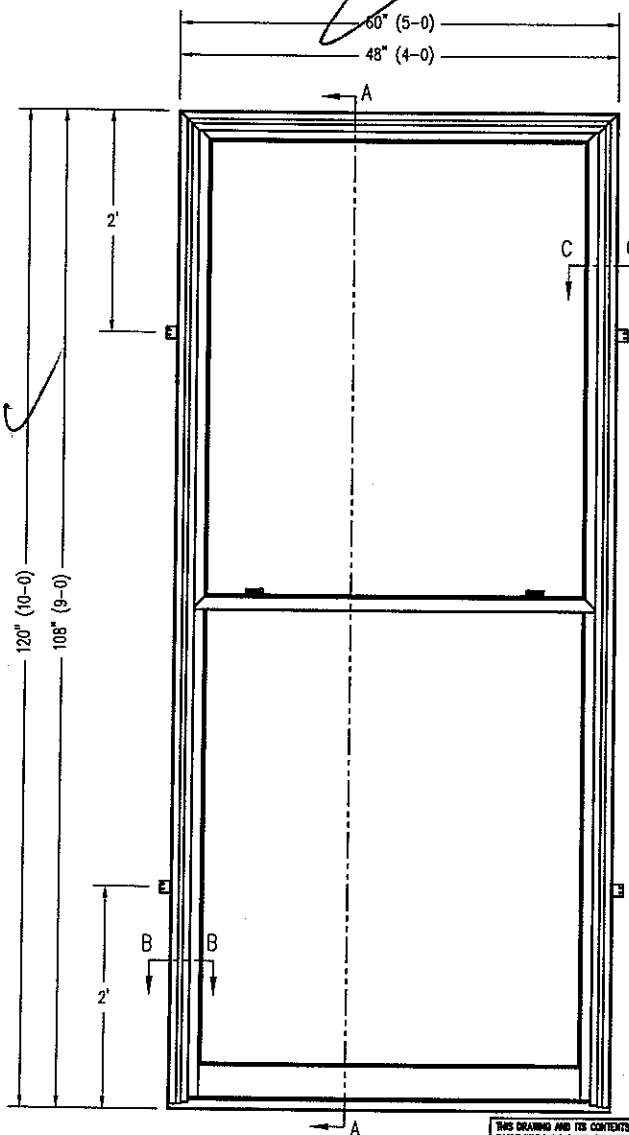

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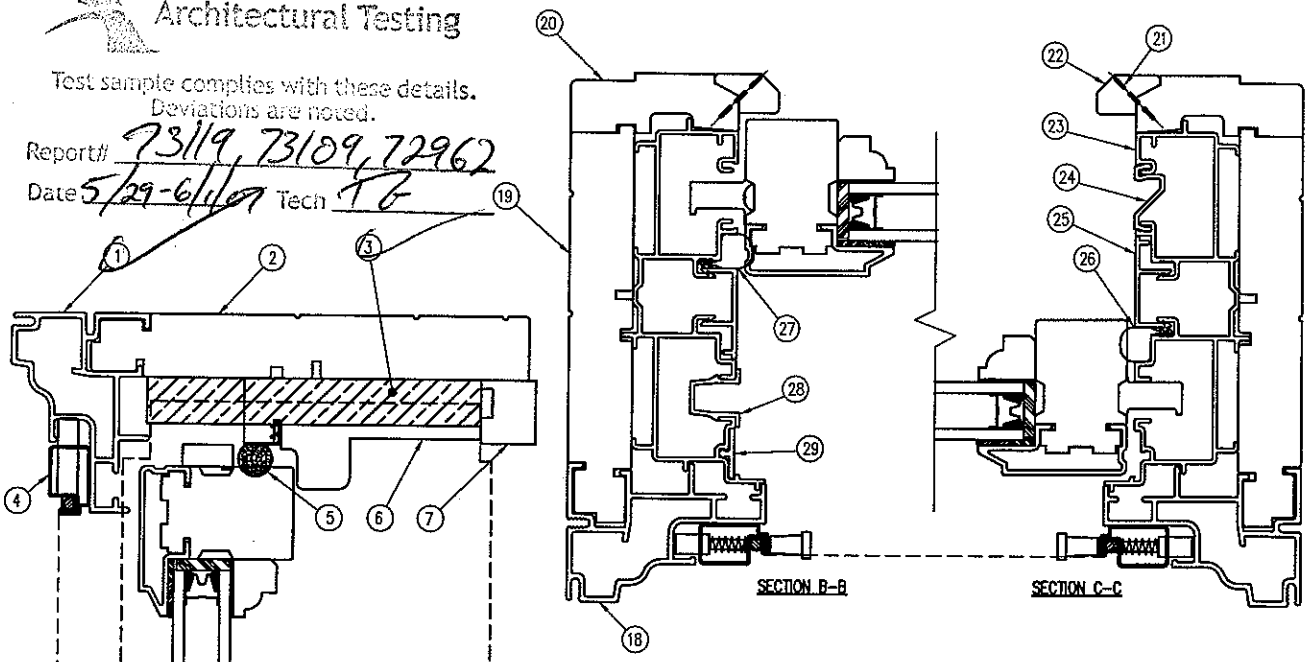
DATE:	3/19/07	C	02

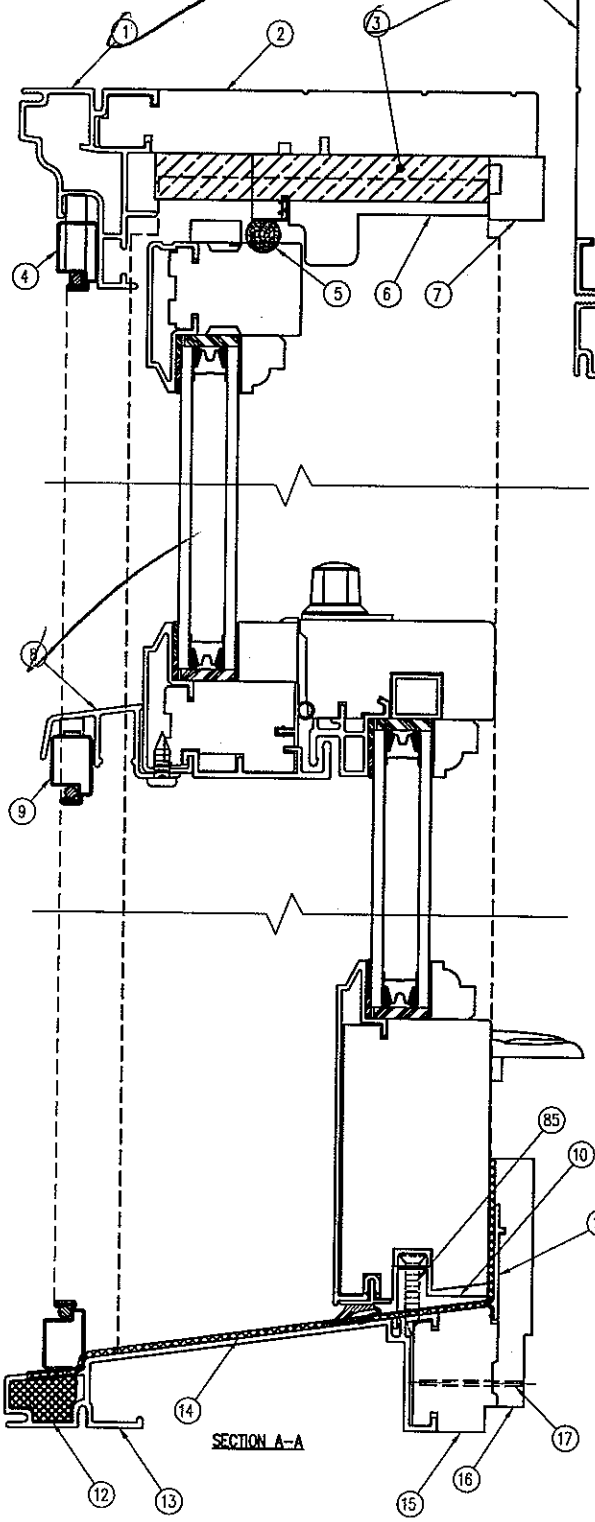
Architectural Testing

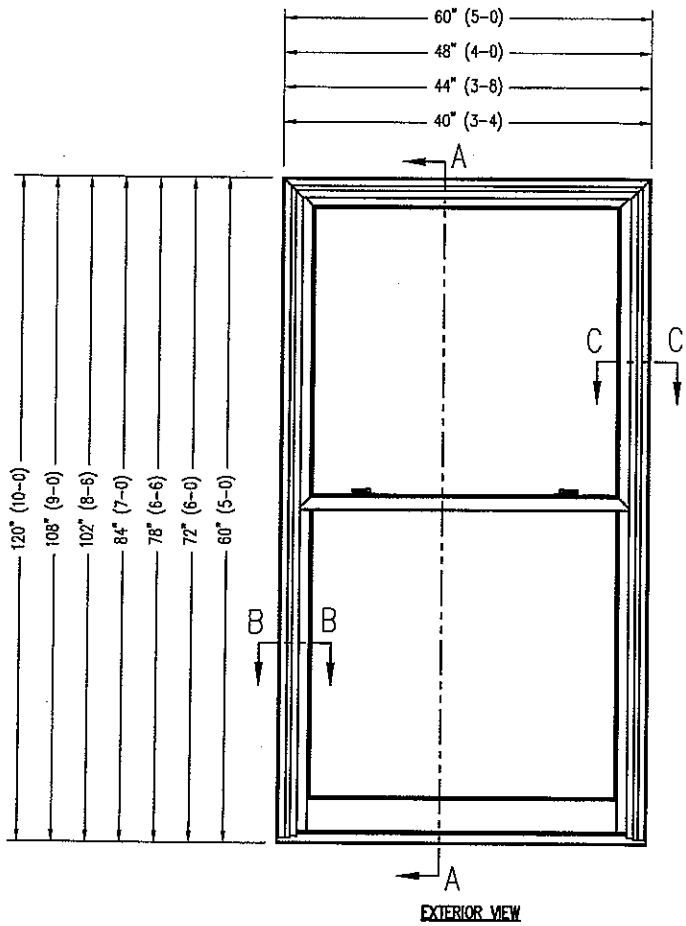
Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TT







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DATE: 3/19/07	C 01 OF 12

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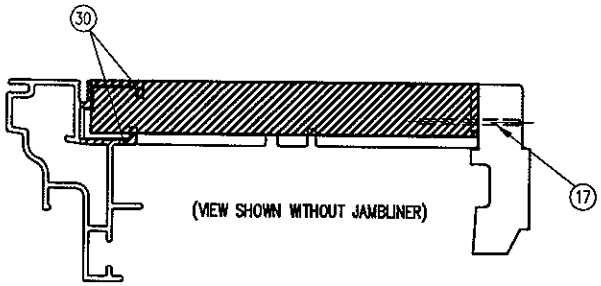
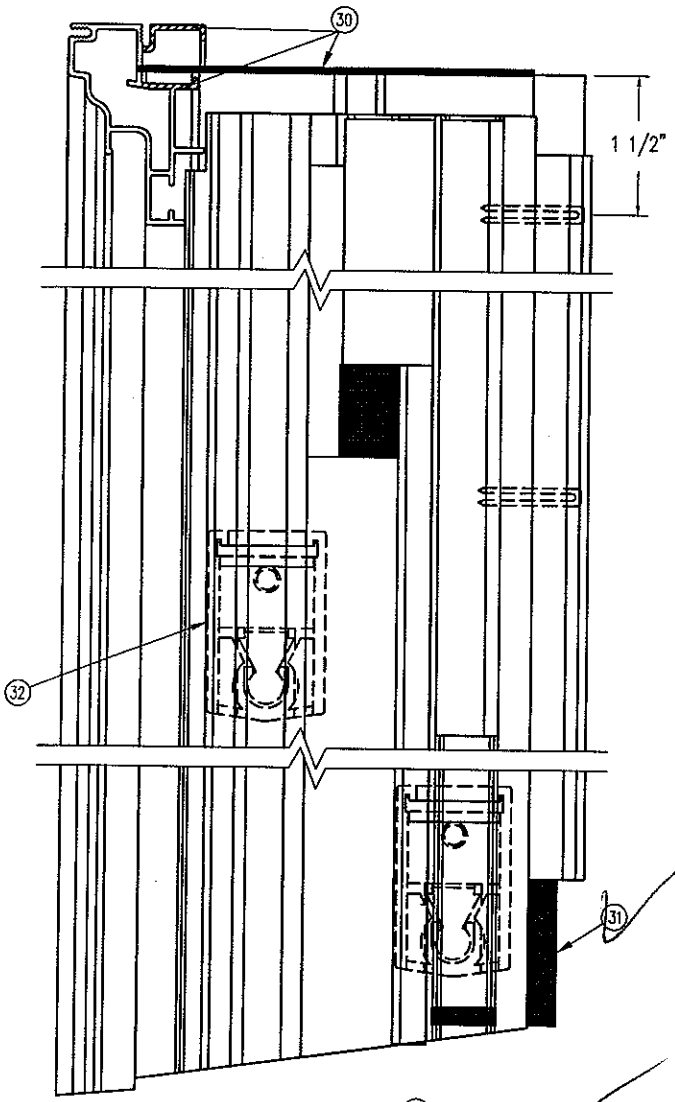


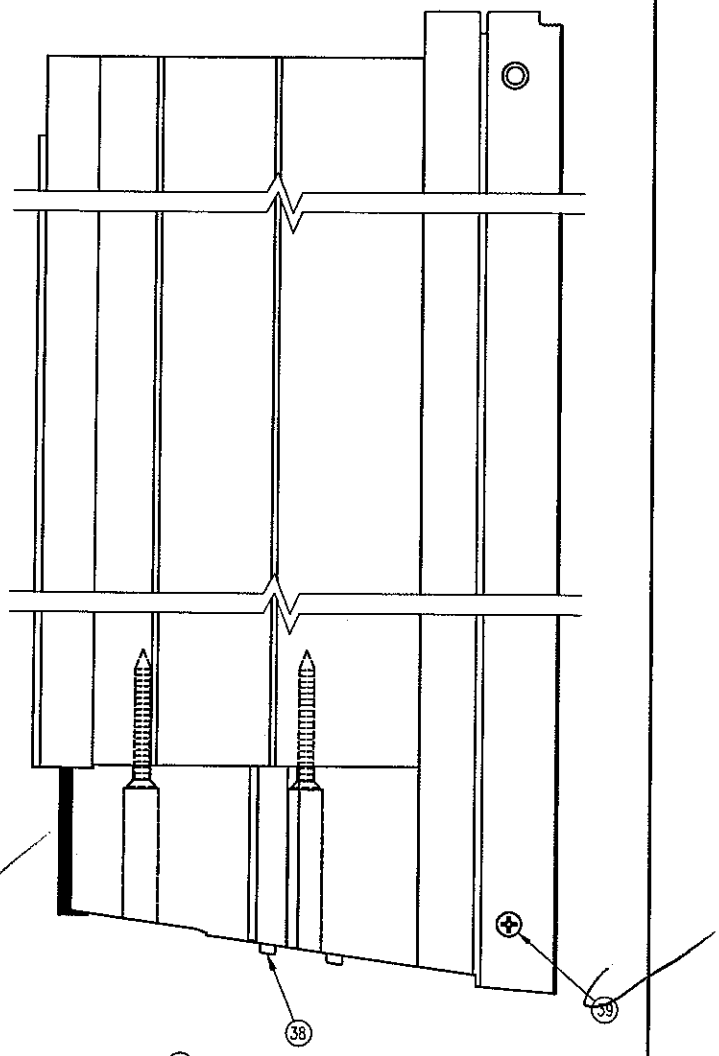
Architectural Testing

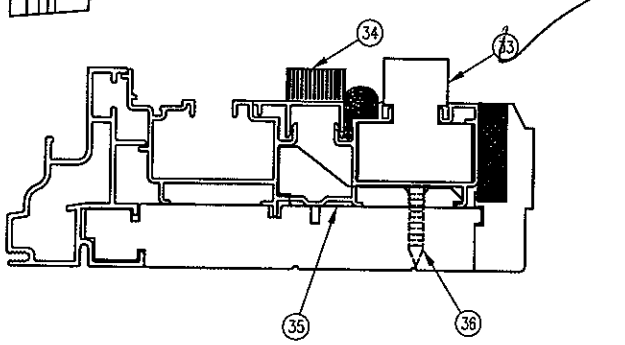
Test sample complies with these details.
Deviations are noted.

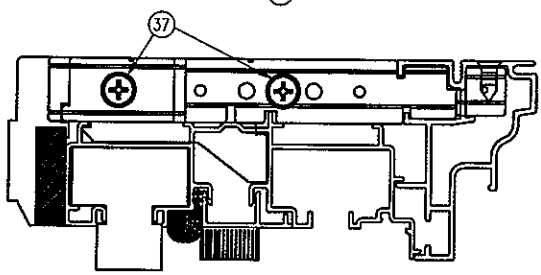
Report# 73119, 73109, 72962

Date 5/24-6/1/07 Tech TG









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DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 02

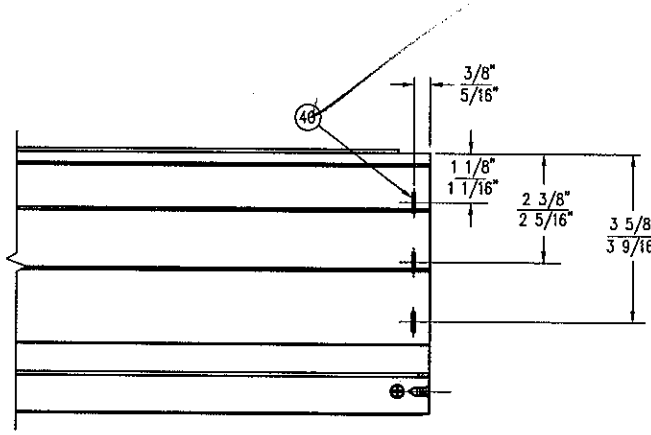
NO	DESCRIPTION	DFT	DOC	DATE

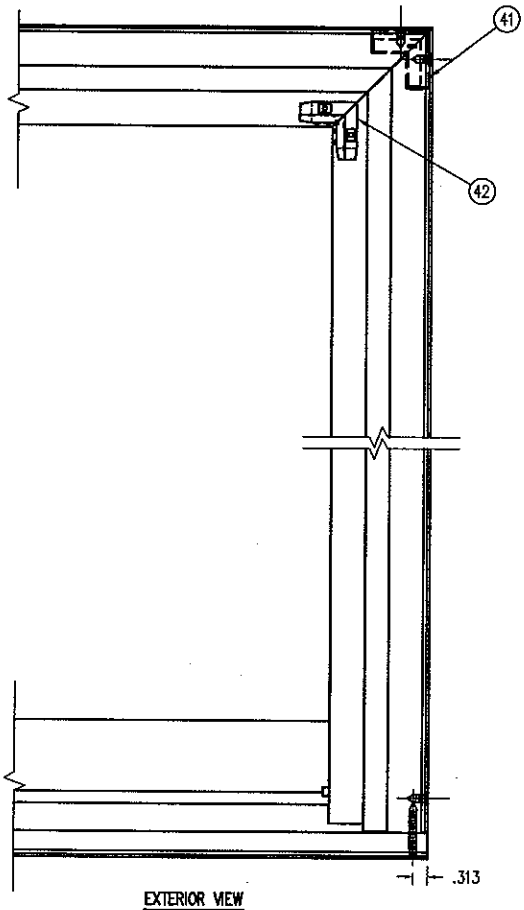
Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/07 Tech TG





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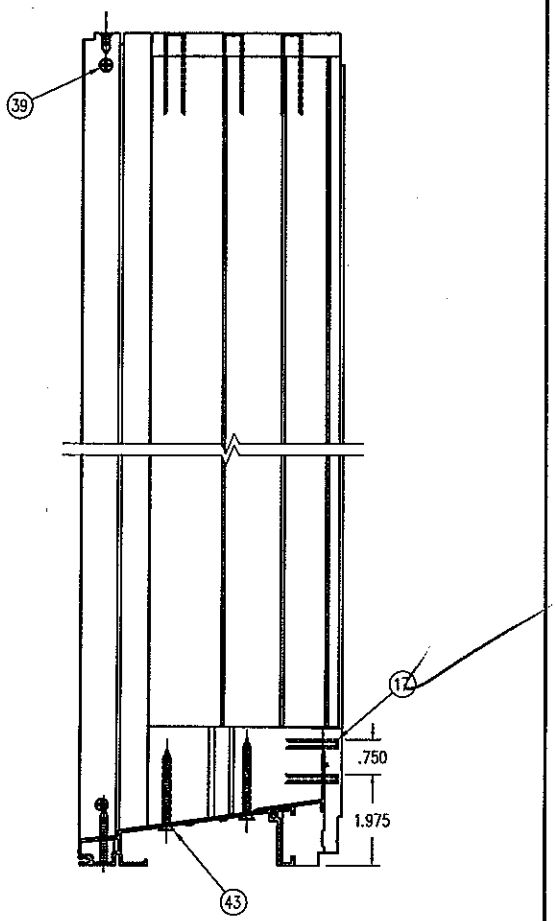

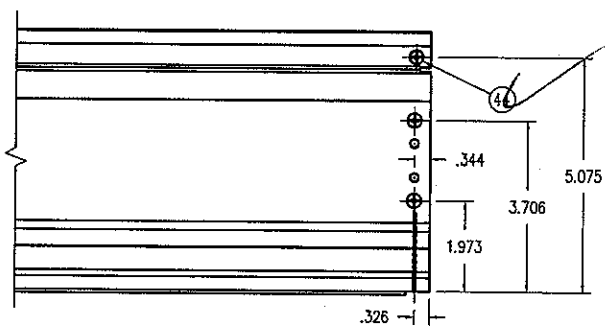

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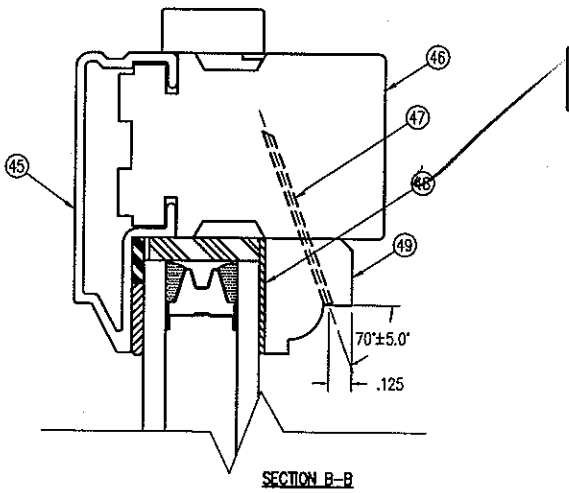
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 03

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962
Date 5/29-6/1/07 Tech TG



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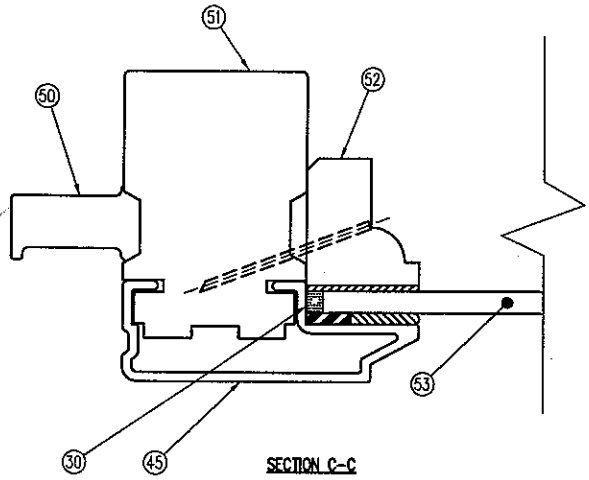

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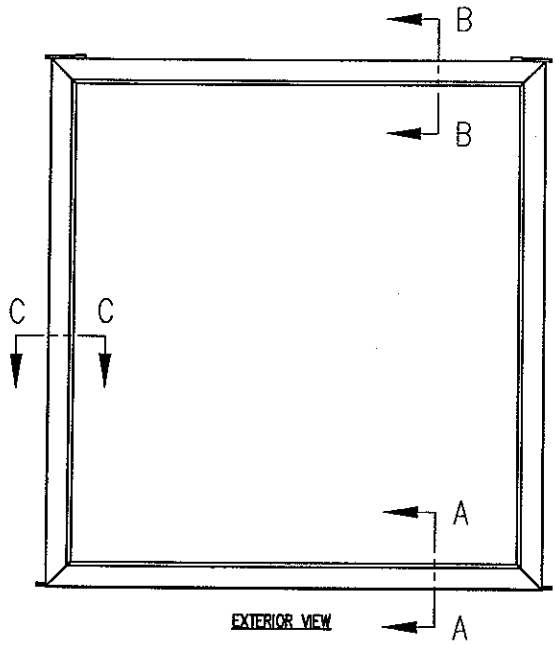
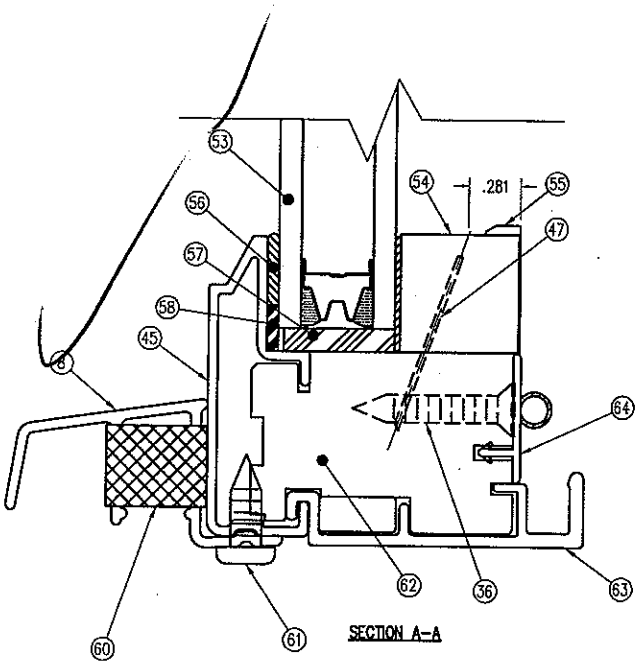


EXTERIOR VIEW



SECTION A–A

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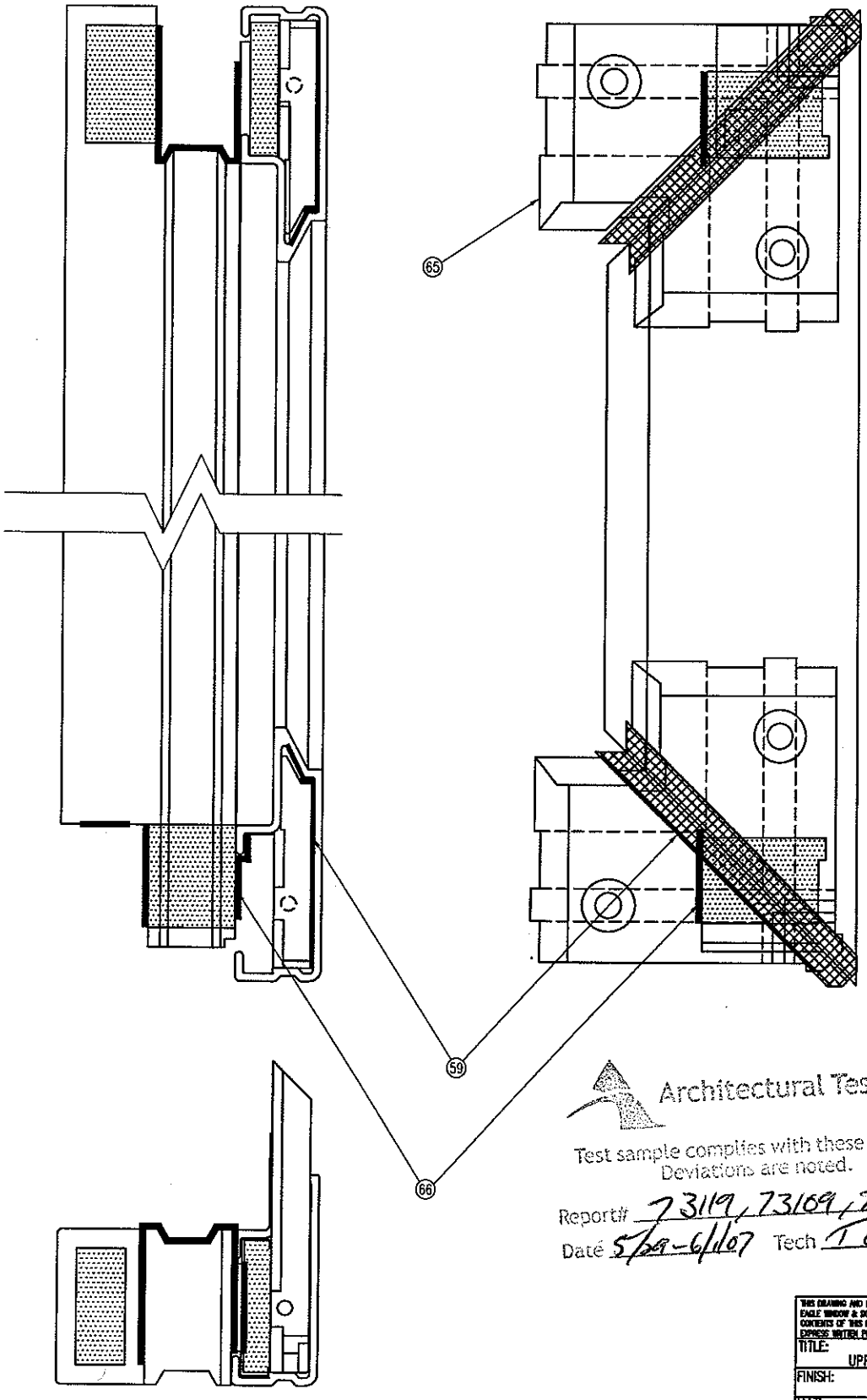
MATL:	
DFT: KJS	SCALE: 1=1
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 04

NO	DESCRIPTION	DFT	DOC	DATE



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

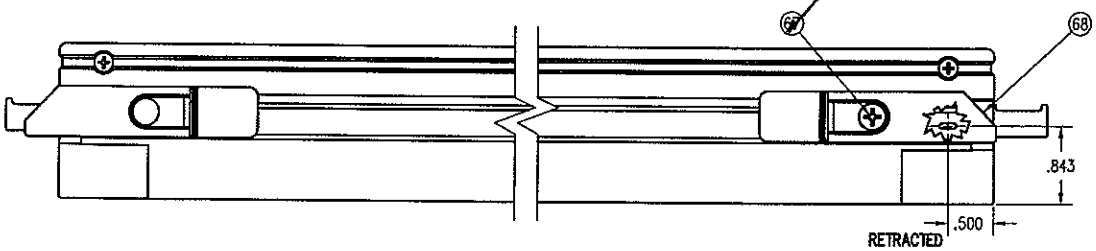
TITLE: CDHV
UPPER SASH ASSEMBLY

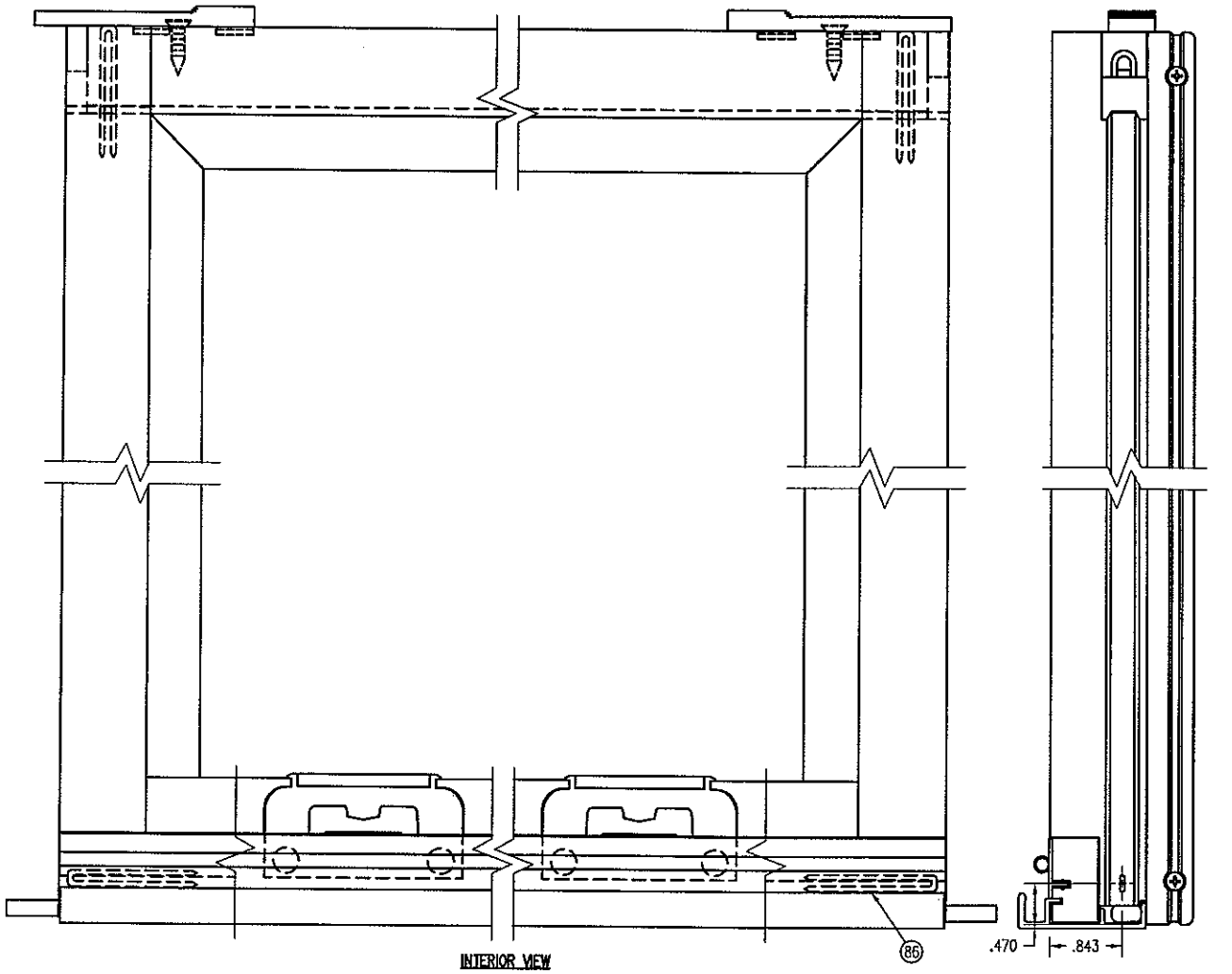
FINISH:

MATL:

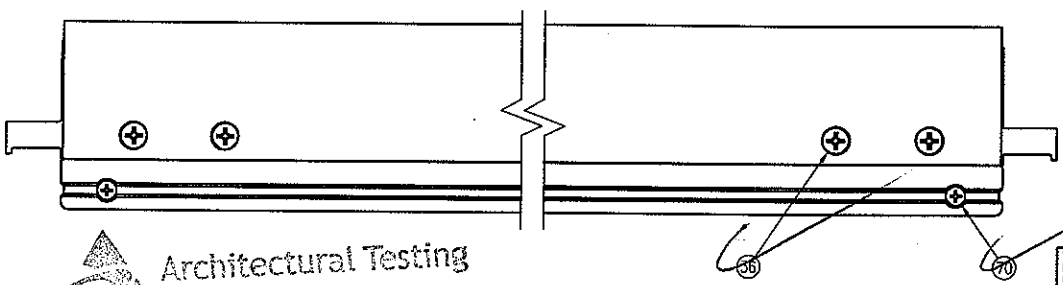
DFT: KJS	SCALE: 1=1
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 05

NO	DESCRIPTION	DFT	DOC	DATE





INTERIOR VIEW



Architectural Testing

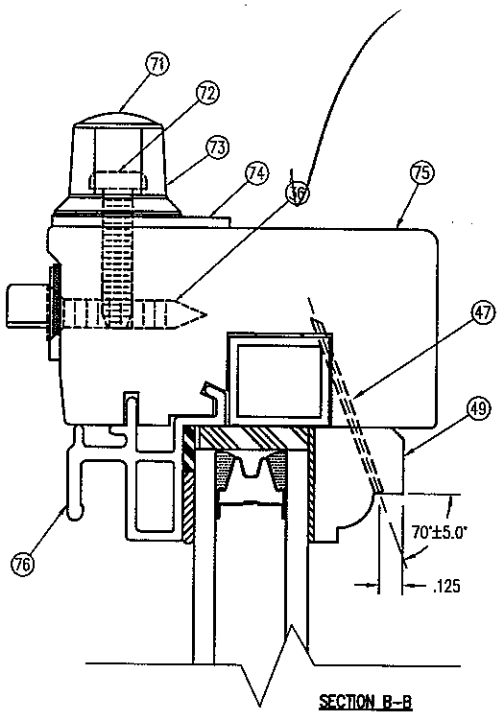
Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

NO	DESCRIPTION	DFT	DOC	DATE

TITLE:	CDHV UPPER SASH ASSEMBLY
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=2
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 06



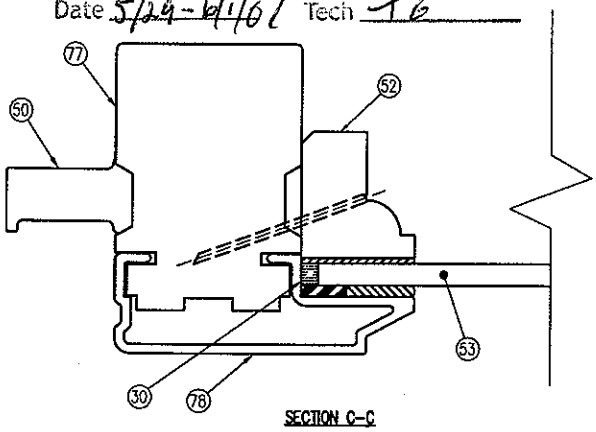
SECTION B-B

Architectural Testing

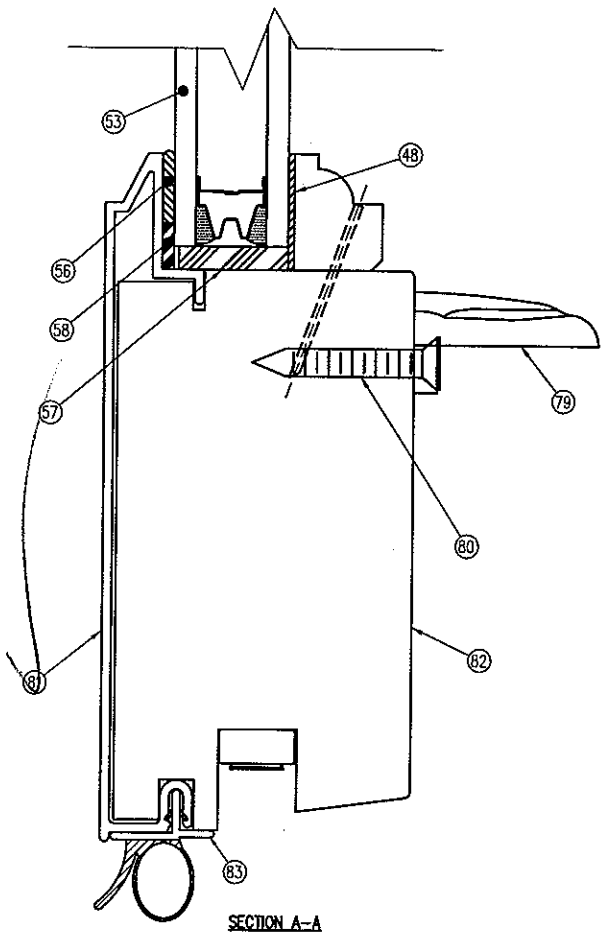
Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

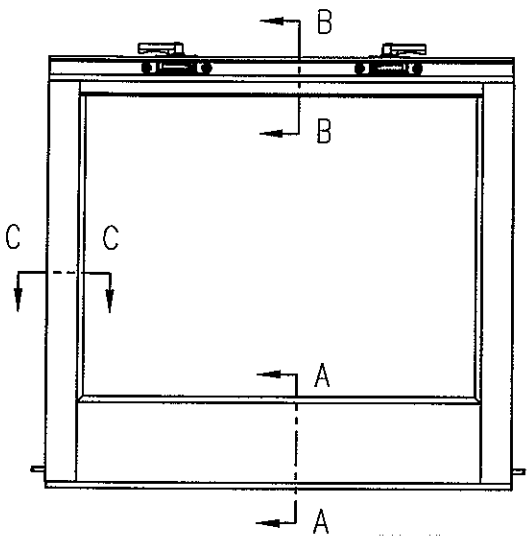
Date 5/29-6/4/07 Tech TG



SECTION C-C



SECTION A-A



EXTERIOR VIEW

TITLE:	CDHV LOWER SASH ASSEMBLY
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=1
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 07

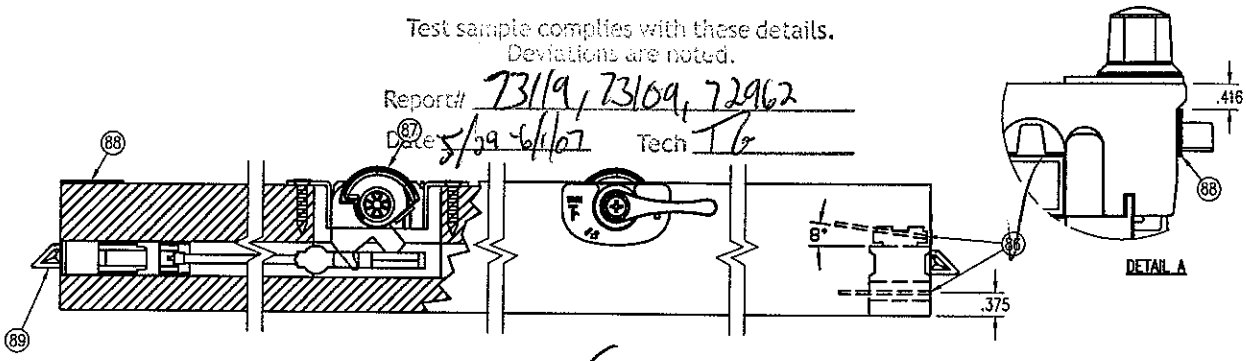
NO	DESCRIPTION	DFT	DOC	DATE

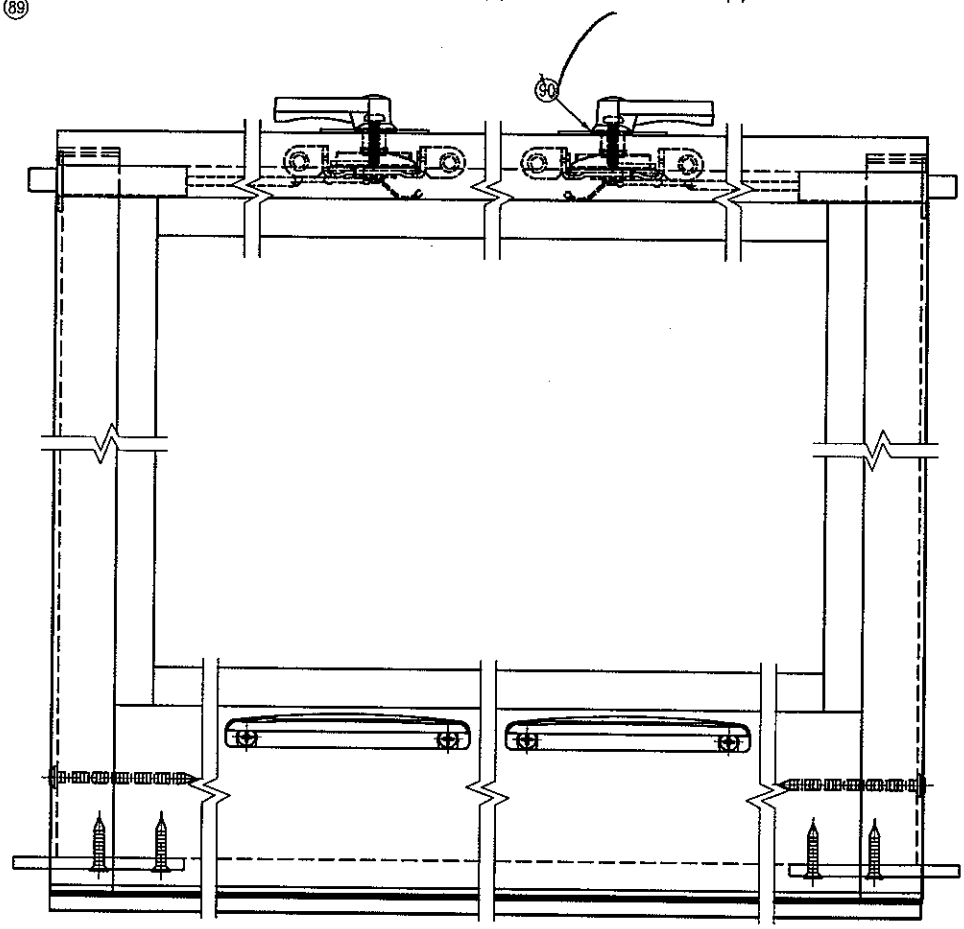
Architectural Testing

Test sample complies with these details.
Deviations are noted.

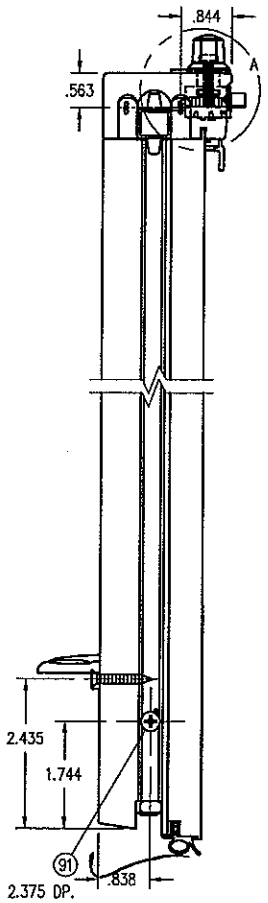
Report# 73119, 73109, 72962

Date 5/29 6/1/07 Tech TG

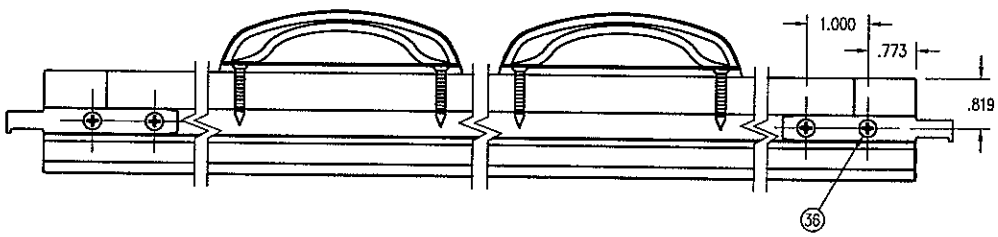




INTERIOR VIEW



.109 DIA. X 2.375 DP.



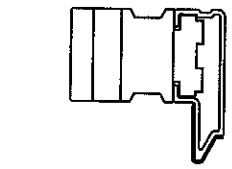
TITLE:	CDHV LOWER SASH ASSEMBLY
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=3
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 09

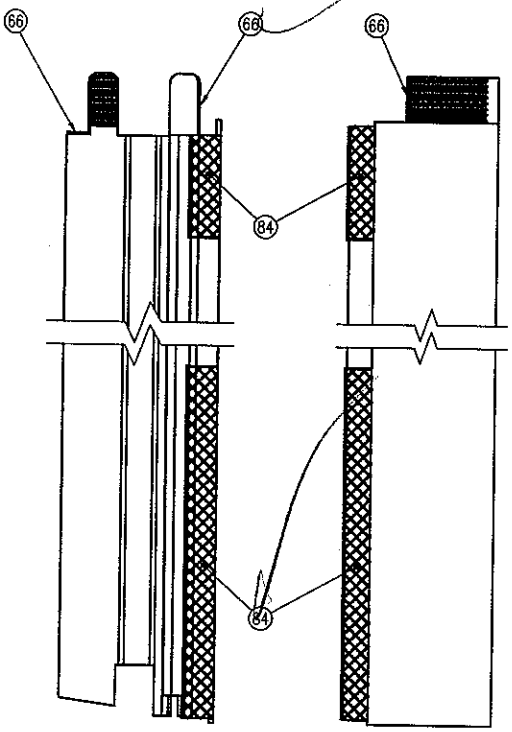
NO	DESCRIPTION	DFT	DOC	DATE

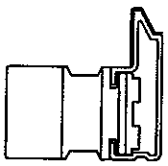
Architectural Testing

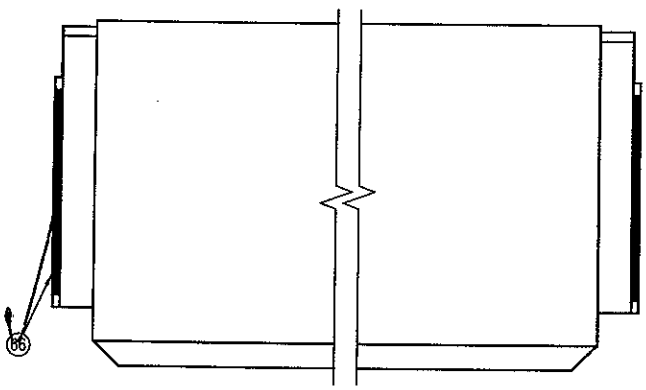
Test sample complies with these details.
Deviations are noted.

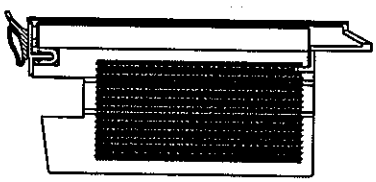
Report# 73119, 73109, 72962
Date 5/29-6/1/07 Tech TG

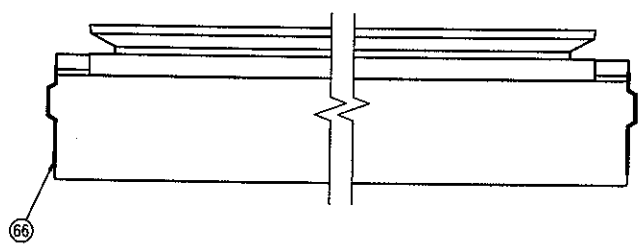












TITLE:	CDHV LOWER SASH ASSEMBLY
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=2
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 08

NO	DESCRIPTION	DFT	DOC	DATE

NO.	DWG NO.	DESCRIPTION	QUANTITY	MATERIAL	SUPPLIER
1	A514	HEAD FRAME CLADDING	1	ALUMINUM	BONNELL
2	21E9	HEAD	1	WOOD (LVL)	EAGLE WINDOW & DOOR
3	A52D	HEAD PAD	2	EPDM	CLIM-A-TECH
4	046W	SCREEN ASSEMBLY (OPT.)	1	ALUMINUM	HOMESHIELD
5	A43G	HEAD WEATHER STRIP	1	URETHANE FOAM	AMESBURY FOAMTITE
6	21YA	FRAME PARTING STOP/HEAD COVER	1	WOOD	EAGLE WINDOW & DOOR
7	212N	VENT INTERIOR HEAD STOP	1	WOOD	EAGLE WINDOW & DOOR
8	A473	HALF SCREEN RETAINER	1	ALUMINUM	BONNELL
9	046X	HALF SCREEN ASSEMBLY (OPT.)	1	ALUMINUM	HOMESHIELD
10	A732	SNUBBER	2	GLASS FILLED NYLON	LCS
11	A74H	SILL WATER DAM	1	VINYL	CLIM-A-TECH
12	A72H	FRAME PLUG	2	NYLON	LCS
13	A571	FRAME SILL COVER	1	ALUMINUM	HYDRO
14	A735	SETTING PAD	2	PVC FOAM	CLIM-A-TECH
15	20F1	THERMAL BLOCK	1	WOOD	EAGLE WINDOW & DOOR
16	20F8	SILL STOP	1	WOOD	EAGLE WINDOW & DOOR
	20FM	SILL STOP - AUX OPTION		WOOD	EAGLE WINDOW & DOOR
17	A00L	3/16" x 1 1/8" STAPLE	AS REQUIRED	GALVANIZED STEEL	ABILITY FASTENERS
18	A514	SIDE FRAME COVER	2	ALUMINUM	HYDRO
19	2134	JAMB	2	WOOD (LVL)	EAGLE WINDOW & DOOR
20	20F6	SIDE INTERIOR STOP	2	WOOD	EAGLE WINDOW & DOOR
21	A28C	5/8" BRAD HEAD FINISH NAIL - 18 GA.	AS REQUIRED	GALVANIZED STEEL	ABILITY FASTENERS
22	20FL	INTERIOR SIDE STOP (MONUMENTAL)	2	WOOD	EAGLE WINDOW & DOOR
23	A71W 01	JAMBLINER	2	VINYL	CLIM-A-TECH
	A71W 02	JAMBLINER (W/ NOTCH) (MONUMENTAL)		VINYL	CLIM-A-TECH
24	A71N	SPRING COVER	2	PVC	CLIM-A-TECH
25	A48Y	PVC SNAP IN UPPER	2	RIGID PVC	CLIM-A-TECH
	A558	WOOD VENEER SNAP IN UPPER (OPT.)		RIGID PVC	CLIM-A-TECH
26	A523	JAMB WEATHERSTRIP UPPER	2	URETHANE FOAM	SCHLEGEL
27	A523	JAMB WEATHERSTRIP LOWER	2	URETHANE FOAM	SCHLEGEL
28	A52F	SASH STOP	2	RIGID PVC	CLIM-A-TECH
29	A522	ALUM. SNAP IN LOWER EXT. (OPT.)	2	ALUMINUM	HOMESHIELD
30	A030	SILICONE SEALANT	AS REQUIRED	SILICONE	DOW CORNING
31	A733	FOAM SILL FILLER	1	CLOSED CELLFOAM	CLIM-A-TECH
32	A43R	LOCK TERMINAL SHOE	2		UNIQUE BALANCE
33	A734	07 CDHV SILL CUSHION	1	CLOSED CELLFOAM	CLIM-A-TECH
34	A54P	INTERLOCK FUZZ PAD	1	FELT ADHESIVE BACK	AMESBURY
35	A72Y	FRAME CLEAT (MONUMENTAL)	1	GLASS FILLED NYLON	LCS
36	A00T	#7 x 7/8" FHWS S.S.	17	STEEL	ABILITY FASTENERS
37	A330	#8 x 1 1/2" FHWS Z&Y	2	STEEL	ABILITY FASTENERS
38	A70K	07 CORNER BLOCK	1		LCS
39	A11K	#6 x 7/16", #8 BODY FHSMS S.S.	7	STAINLESS STEEL	ABILITY FASTENERS
40	A11D	7/16" x 1 3/4" 16 GA. STAPLE	6	GALVANIZED STEEL	ABILITY FASTENERS
41	A100	90 CORNER KEY	2	NYLON	LAKE COUNTRY SALES
42	A08W	MDL CORNER KEY	2	ABS COMPOUND	LAKE COUNTRY SALES
43	A02E	#8 x 1 3/4" FH SMS (Z&Y)	4	STEEL	ABILITY FASTENERS
44	A39W	#7 x 1 1/4" FH SMS (S.S.)	2	STEEL	ABILITY FASTENERS
45	A16K	SASH COVER	4	ALUMINUM	HYDRO
46	20F4	UPPER RAIL	1	WOOD	EAGLE WINDOW & DOOR
47	A40E	1" HARDENED STEEL BRAD (18 GA.)	AS REQUIRED	STEEL	ABILITY FASTENERS
48	A67M	.031 x .625 FOAM TAPE (GLASS STOP TAPE	AS REQUIRED	POLYTHYLENE	ADHESIVE RESEARCH
49	220N	HORZ. COLONIAL GLAZING STOP	4	WOOD	EAGLE WINDOW & DOOR
50	A742	PIVOT PIN (DIE-CAST) "STD. DH"	4	ZAMACK-3	DECO
	A743	PIVOT PIN (S.S.) "MONUMENTAL SH"		STAINLESS STEEL	GIESE
51	20F4	UPPER STILE	2	WOOD	EAGLE WINDOW & DOOR
52	220J	VERT. COLONIAL GLAZING STOP	4	WOOD	EAGLE WINDOW & DOOR
53	A08J	5/8" INSULATED GLASS	1	GLASS	CARDINAL IG
	A32Y	SINGLE PANE GLASS (OPT.)		GLASS	CARDINAL IG
54	221H	GLAZING STOP	1	WOOD	EAGLE WINDOW & DOOR
55	A72N	KEEPER	2	ZAMACK-3	ASHLAND
56	A51H	INSTANT GLAZE II SEALANT	AS REQUIRED	POLYURETHANE	DOW CORNING
57	A00E	NEOPRENE GLASS SETTING BLOCK	AS REQUIRED	NEOPRENE RUBBER	CLIM-A-TECH

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

NO	DESCRIPTION	DFT	DOC	DATE

TITLE: CDHV UNIT ASSEMBLY	
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=1
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 11

NO.	DWG NO.	DESCRIPTION	QUANTITY	MATERIAL	SUPPLIER
58	A08K	GLAZING SHIM .250 x .065 x 4.000	AS REQUIRED	NEOPRENE RUBBER	CLIM-A-TECH
59	A01A	.094 x .265 BUTYL TAPE	AS REQUIRED	BUTYL RUBBER	PTI INC.
60	A627	FOAM END PLUG	2	POLYETHYLENE	CLIM-A-TECH
61	A04T	#8 x 1/2" PH TEKS SCREW	AS REQUIRED	STEEL	ABILITY FASTENERS
62	20F2	UPPER CHECK RAIL	1	WOOD	EAGLE WINDOW & DOOR
63	A72W	CHECK RAIL COVER (UPPER)	1	ALUMINUM	HYDRO
64	A72T	WEATHER STRIP	1	VINYL	CLIM-A-TECH
65	A172	SASH CORNER KEY	4	NYLON	LAKE COUNTRY SALES
66	A01D	TYPE 1 BOND WOOD ADHESIVE	AS REQUIRED	COPOLYMER	NATIONAL STARCH
67	A00R	#7 x 5/8" FHSMS	2	STAINLESS STEEL	ABILITY FASTENERS
68	A72R	SURFACE TILT-LATCH	2	NYLON	HILL DESIGN
69					
70	A19H	#4 x 1/2" FHSMS	8	STAINLESS STEEL	ABILITY FASTENERS
71	A54J	DH HANDLE SCREW HOLE PLUG	2	NYLON	ASHLAND HARDWARE
72	A54L	#8-32 x 7/8" PPHMS, TRI-OBIAL	2	STEEL	ASHLAND HARDWARE
73	A54G	E-TILT DH LOCK HANDLE	2	ZAMACK-3	ASHLAND HARDWARE
74	A54H	E-TILT DH BEZEL PLATE	2	ZAMACK-3	ASHLAND HARDWARE
75	20F5	LOWER CHECK RAIL	1	WOOD	EAGLE WINDOW & DOOR
76	A72X	CHECK RAIL COVER (LOWER)	1	ALUMINUM	HYDRO
77	20F4	LOWER STILE	2	WOOD	EAGLE WINDOW & DOOR
78	A741	LOWER STILE COVER	2	ALUMINUM	HYDRO
79	A63A	FINGER LIFT	AS REQUIRED	ZAMACK-3	ASHLAND HARDWARE
80	A03Y	#6 x 1 FHSMS Z&Y (PAINTED HEAD)	AS REQUIRED	STEEL	ABILITY FASTENERS
81	A71X	LOWER RAIL COVER	1	ALUMINUM	HYDRO
82	20E8	LOWER RAIL	1	WOOD	EAGLE WINDOW & DOOR
83	A72G	LOWER SASH WEATHER STRIP	1		CLIM-A-TECH
84	A737	.031 x 1.125 SEALANT (BUTYL TAPE)	3	BUTYL RUBBER	DEVAN SEALANTS
85	A54N	#6 x 1 1/4" FHWS TEKS POINT S.S.	4	STAINLESS STEEL	ABILITY FASTENERS
86	A131	3/16 x 1 1/2 STAPLE (STD. DH)	6	GALVANIZED STEEL	ABILITY FASTENERS
87	A54F	E-TILT DOUBLE HUNG LOCK	2		ASHLAND HARDWARE
88	A67G	LOWER SASH PAD	2		CLIM-A-TECH
89	A72P	TILT-LATCH ARM	2	PVC	ASHLAND HARDWARE
90	A54D	SPRING WASHER	2	STAINLESS STEEL	ASHLAND HARDWARE
91	A48C	#8 x 2 1/4" COMBO ROUND WASHER HEAD	2	STEEL	ABILITY FASTENERS
92	H-40	5/8" BETWEEN GLASS MUNTIN	AS REQUIRED	ALUMINUM	ALLMETAL
93	P/PD	1" CONTOUR MUNTIN	AS REQUIRED	ALUMINUM	ALLMETAL
94	220H	1 1/2" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
95	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
96	A507	1 1/2" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
97	A67X	1 1/2" MDL ADHESIVE TAPE (EXTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
98	A67L	1 1/2" MDL ADHESIVE TAPE (INTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
99	220H	1 1/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
100	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
101	A507	1 1/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
102	A67W	1 1/8" MDL ADHESIVE TAPE (EXTERIOR TA	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
103	A67R	1 1/8" MDL ADHESIVE TAPE (INTERIOR TAP	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
104	220H	7/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
105	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
106	A507	7/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
107	A67T	7/8" MDL ADHESIVE TAPE (EXTERIOR TAPI	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
108	A67N	7/8" MDL ADHESIVE TAPE (INTERIOR TAPE	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
109	20FA	5/8" INTERIOR COLONIAL MDL BAR	AS REQUIRED	WOOD	EAGLE WINDOW & DOOR
110	H-40	SPACER CHANNEL	AS REQUIRED	ALUMINUM	ALLMETAL
111	A72D	5/8" EXTERIOR MDL BAR	AS REQUIRED	ALUMINUM	HYDRO
112	A75N	5/8" MDL ADHESIVE TAPE (EXTERIOR TAPI	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
113	A75M	5/8" MDL ADHESIVE TAPE (INTERIOR TAPE	AS REQUIRED	POLYETHYLENE	ADHESIVE RESEARCH
114	N/A	ADHESIVE FOAM TAPE	AS REQUIRED	POLYETHYLENE	CARDINAL

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/26/1/07 Tech 16

NO	DESCRIPTION	DFT	DOC	DATE

TITLE: CDHV UNIT ASSEMBLY	
FINISH:	
MATL:	
DFT: KJS	SCALE: 1=1
DCN: 0881	DRWG: 0534
DATE: 3/19/07	C 12

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 .469	SINGLE GLAZED H. MSTR MONO	.680

1

Architectural Testing

Test sample complies with these details. Deviations are noted.

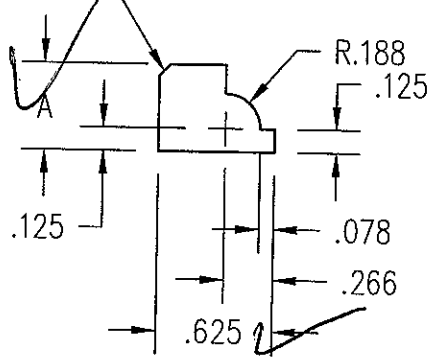
Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

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

.062 x .062 CHAMFER

3



TITLE: COLONIAL GLAZING STOP

FINISH:

MATL: EAGLE STD WOOD OFFERINGS

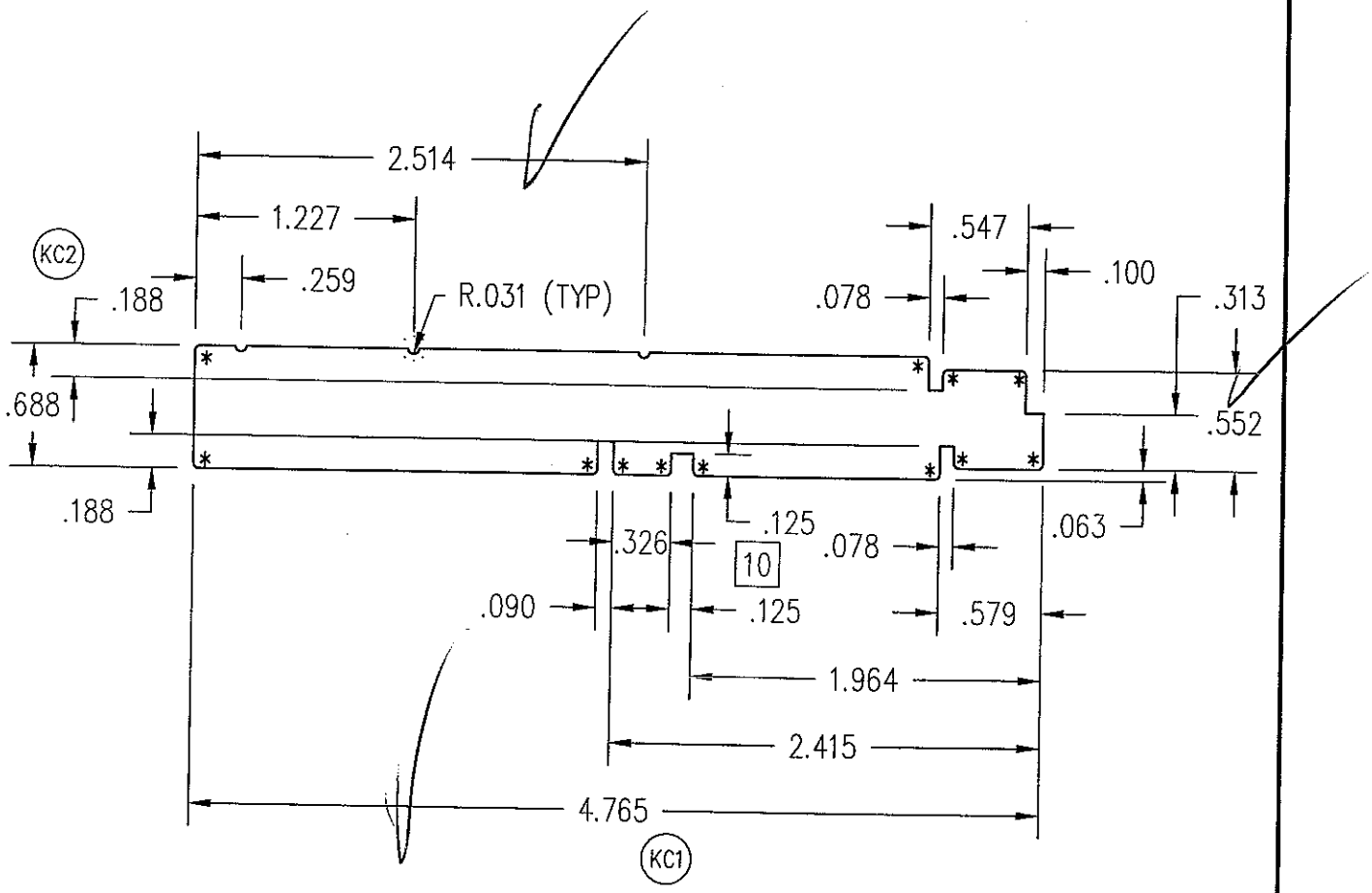
DFT: JMH | SCALE: 1=1

DCN: 0650 | DRWG: 220J

DATE: 5/29/2002 | A 01 OF 03

NO	DESCRIPTION	DFT	DOC	DATE
04	ADDED CDHG PICT TO CHART	KJS	0881	3/6/07
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

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. UNLESS OTHERWISE SPECIFIED ALL RADII = .031. DENOTED BY * (12 PLCS).



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

TITLE: CDHV/CDHVET/CSW – HEAD
CDHF – HEAD/SIDE JAMB

FINISH:

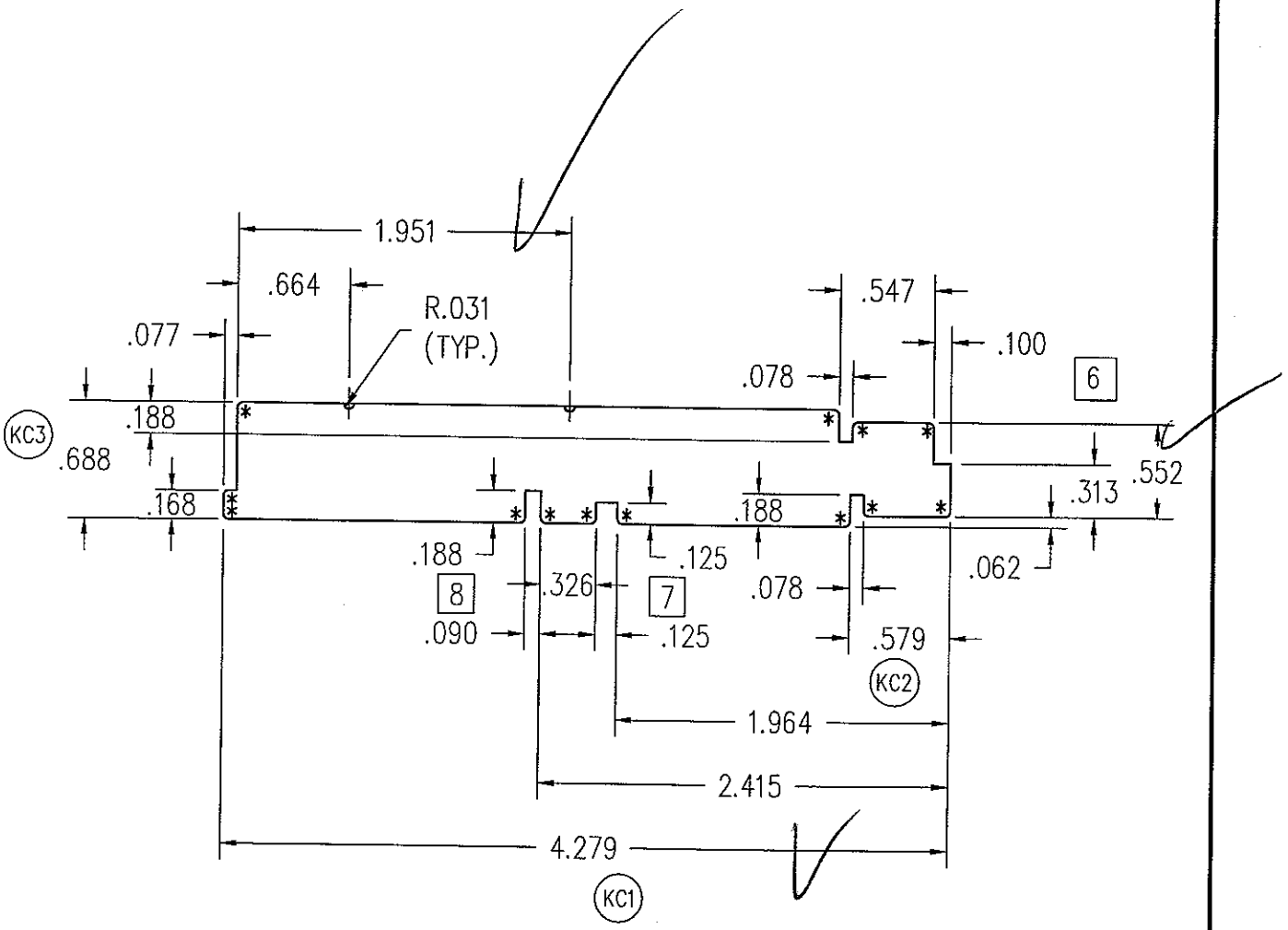
MATL: SEE PAGE 02

NO	DESCRIPTION	DFT	DOC	DATE
10	ADD 2ND KERF TO MATCH #2134	TWN	0768	1/30/03
09	ADDED E-TILT DHG	RJW	0589	6/26/02

DFT: BRL
DCN: 0215
DATE: 9/29/1995

SCALE: 1=1
DRWG: 21E9
A 01 OF 02

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. UNLESS OTHERWISE SPECIFIED ALL RADII = .031. DENOTED BY * (13 PLCS)



Architectural Testing

Test sample complies with these details.
Deviations are noted.

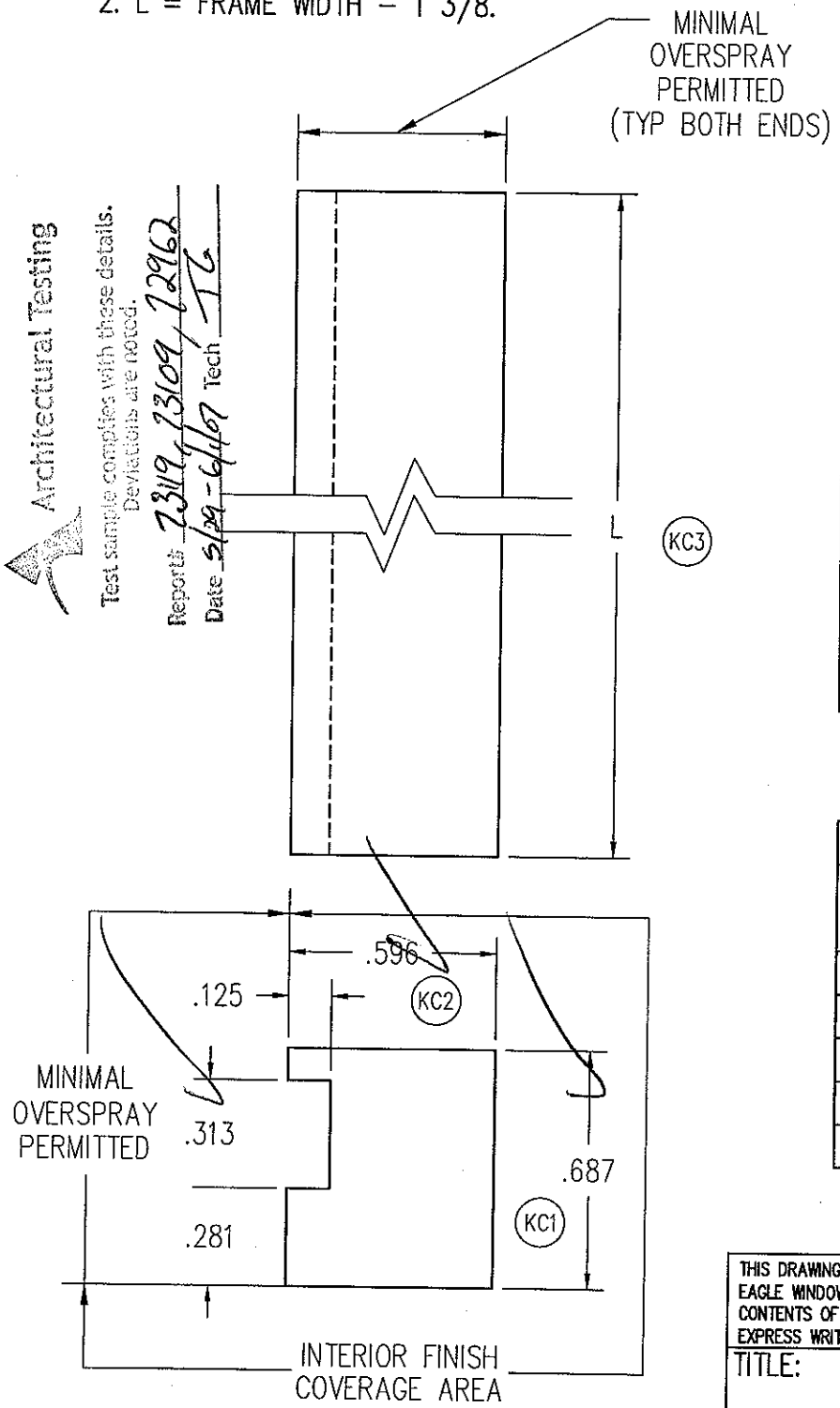
Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

TITLE:	CDHV/CDHVET/CSW SIDE JAMB			
FINISH:				
MATL:	SEE PAGE 02			
DFT:	GDE	SCALE:	1=1	
DCN:	0073	DRWG:	2134	
DATE:	3/2/1993	A	01 OF 02	

NO	DESCRIPTION	DFT	DOC	DATE
08	ADD 2ND KEFT TO MATCH #21E9	TWN	0768	1/30/2003
07	ADDED KERF FOR E-TILT	AWW	0589	6/26/2002
06	CHNG'D PROFILE	AWW	0580	8/3/2001
05	ADD RADIUS TO CORNERS	SCT	0292	5/1/1998
04	CHG'D DESCRIPTION	CEL	0247	5/5/1997

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. L = FRAME WIDTH – 1 3/8.



Architectural Testing
Test sample complies with these details.
Deviations are noted.
Report # 23119, 23109, 12962
Date 5/29-6/4/07 Tech TC

DOUBLE HUNG	
FRAME WIDTH	L
20	18 5/8
24	22 5/8
28	26 5/8
30	28 5/8
32	30 5/8
36	34 5/8
40	38 5/8
44	42 5/8
48	46 5/8
60	58 5/8

CSW / WSW	
FRAME WIDTH	L
36	34 5/8
48	46 5/8
60	58 5/8
72	70 5/8
96	94 5/8

TITLE: CDHV,WDHV,CSW,WSW HEAD INTERIOR STOP

FINISH:

MATL: CLEAR PINE

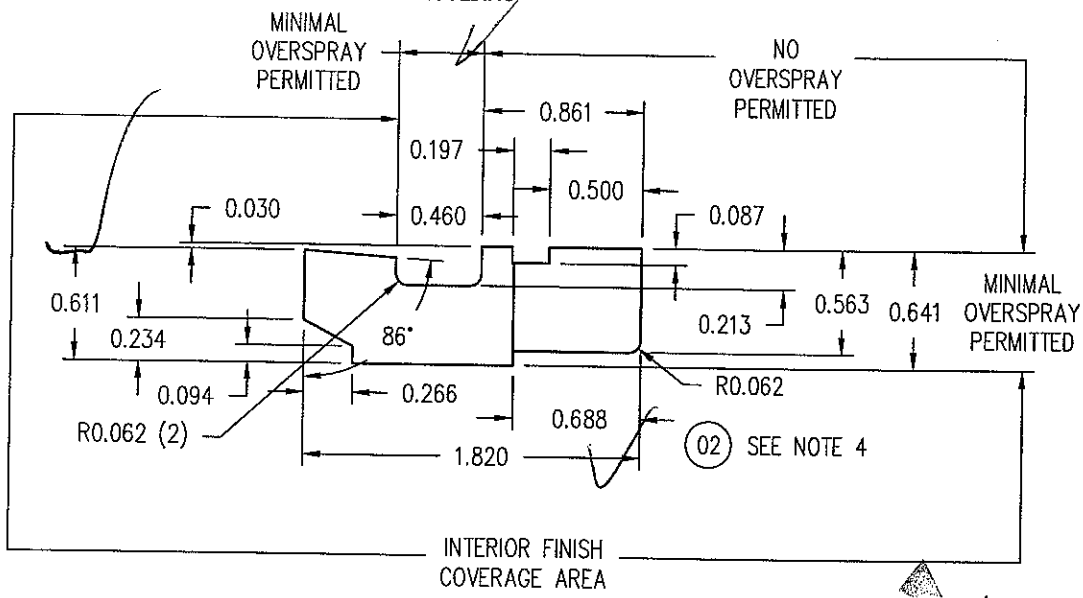
DFT: GDE | SCALE: 2=1

DCN: 0073 | DRWG: 212N

DATE: 3/25/1993 | A 01 OF 01

NO	DESCRIPTION	DFT	DOC	DATE
06	CHG'D PROFILE	JH	0840	8/15/2003

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 L = FRAME HEIGHT – 2 11/16".
3 LEFT & RIGHTS REQUIRED, LEFT HAND SHOWN (AS VIEWED FROM EXT.)
4 HOLD 0.750 AT TENON BEFORE MOULDING

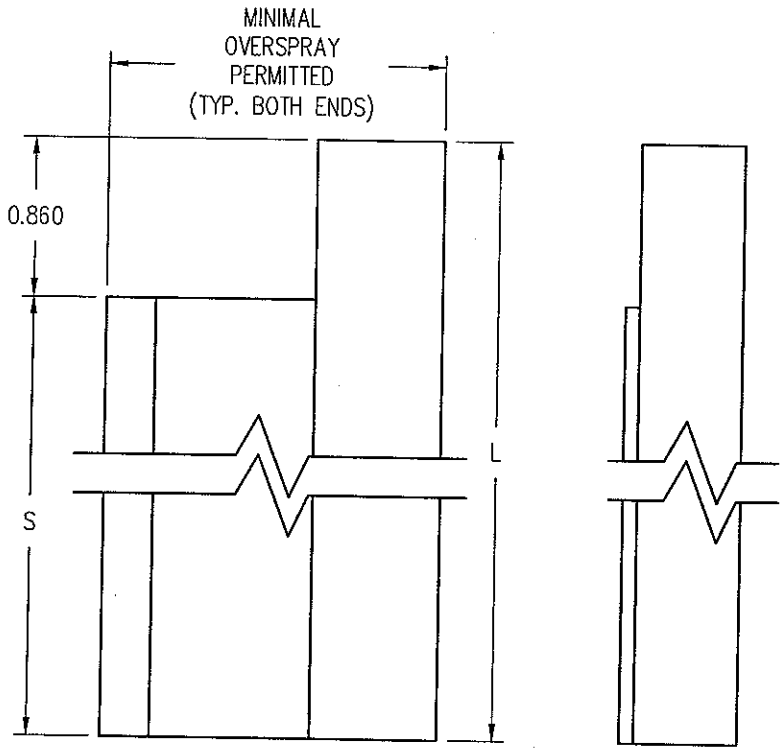


Architectural Testing

Test sample complies with these details. Deviations are noted.

Report# 23119, 23129, 22962

Date 5/22-6/4/02 Tech 16



FRAME HEIGHT	L	S
36	33 5/16	32 7/16
40	37 5/16	36 7/16
48	45 5/16	44 7/16
54	51 5/16	50 7/16
60	57 5/16	56 7/16
66	63 5/16	62 7/16
72	69 5/16	68 7/16
78	75 5/16	74 7/16
84	81 5/16	80 7/16
90	87 5/16	86 7/16

NO	Description of Change	Drafter	DCN#	Date
02	ADDED NOTE #4	JH	0893	06/17/2004
01	ADD FILLET	PJB	0723	10/08/2002

Title: CDHVET/WDHVET SIDE INTERIOR STOP	Finish: INT FINISH SEE A02F	Material CLEAR PINE	
Scale: 1"=1"	Date: 1/18/2002	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: 2
Drafter: AWW	DCN# 0723		21Y9 01 of 01

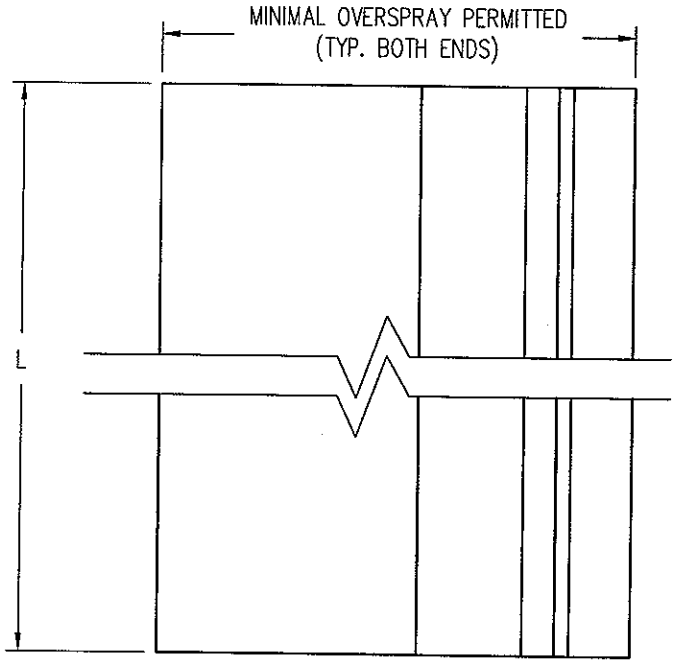
Note: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC.+/- .005, FRACTION +/- 1/64, ANGLES +/- 1/2.
2. L = FRAME WIDTH – 3 21/32".

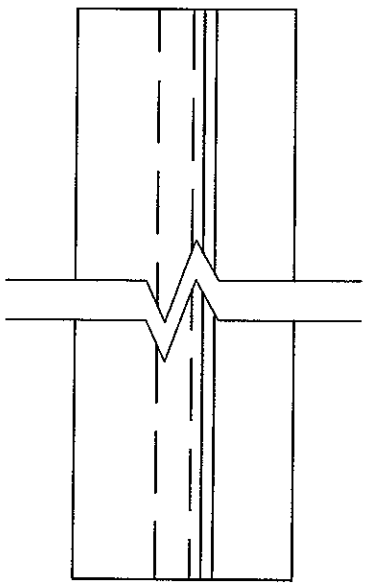
Architectural Testing

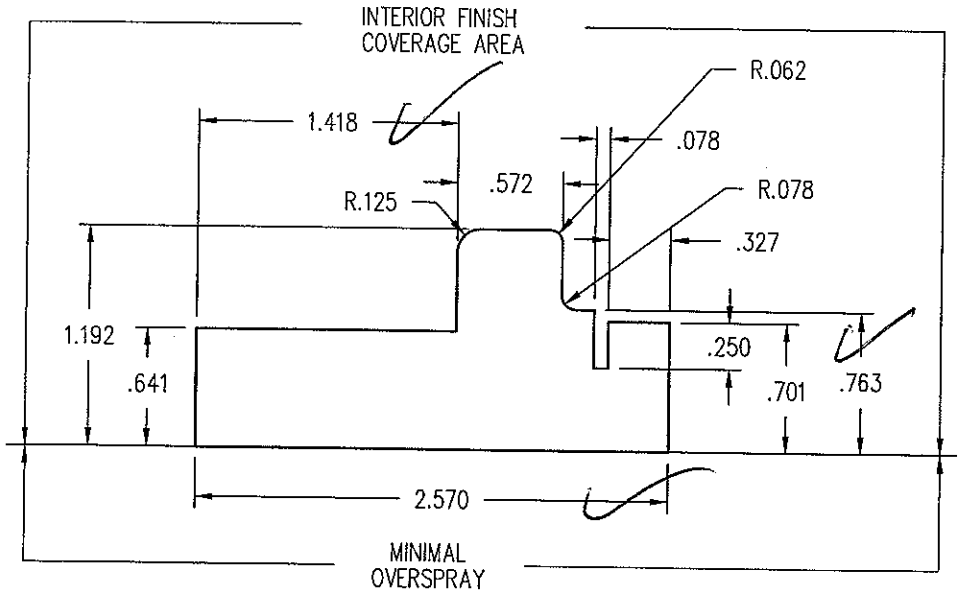
Test sample complies with these details.
Deviations are noted.

Report# 7319, 73109, 72962

Date 5/31-6/1/07 Tech TB







FRAME WIDTH	L
20	16 11/32
24	20 11/32
28	24 11/32
30	26 11/32
32	28 11/32
36	32 11/32
40	36 11/32
44	40 11/32
48	44 11/32
60	56 11/32

NO	Description of Change	Drafter	DCN#	Date
03	CHANGED PROFILE SIZE	TWN	0881	3/30/07
02	CHANGED SCALE	KJS	BOM	05/02/06
01	ADDED FINISH TO TITLE BLOCK	JH	0893	06/17/04

Title: CDHV/WDHV HEAD PARTING STOP	Finish: PRESERVATIVE	Material: CLEAR PINE	
Scale: 1"=1"	Date: 1/18/2002		
Drafter: AWW	DCN# 0589		

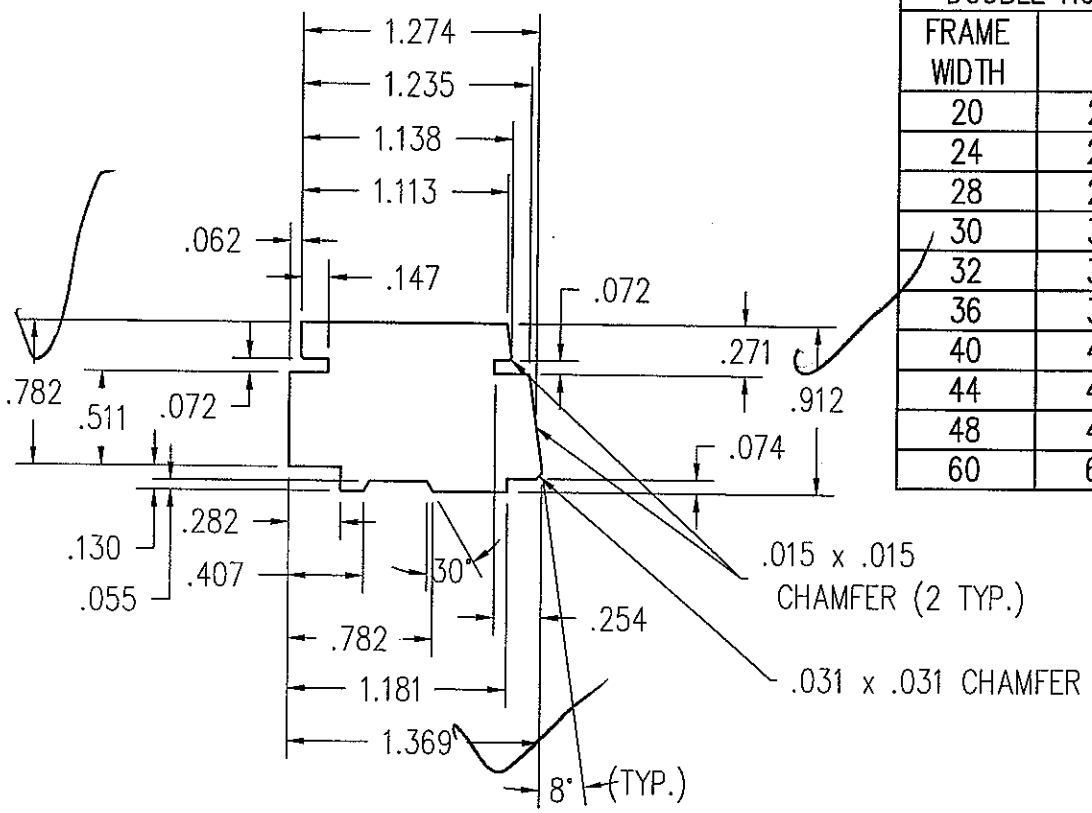
REVISION: 3

21YA

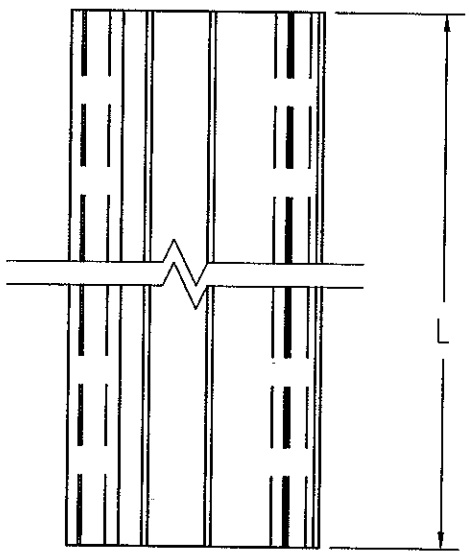
01 of 01

20,54,60

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. L = FRAME WIDTH.



DOUBLE HUNG	
FRAME WIDTH	L
20	20
24	24
28	28
30	30
32	32
36	36
40	40
44	44
48	48
60	60



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/09-6/07 Tech TG

TITLE:	'07 DOUBLE HUNG THERMAL BLOCK
FINISH:	PRESERVATIVE
MATL:	EDGE GLUED AND FINGER JOINTED PINE
DFT: tnies	SCALE: 1=1
DCN: 0881	DRWG: 20F1
DATE: 9/28/2006	A 01 OF 01

NO	DESCRIPTION	DFT	DOC	DATE
01	UPDATED PROFILE	KJS	0881	1/4/07

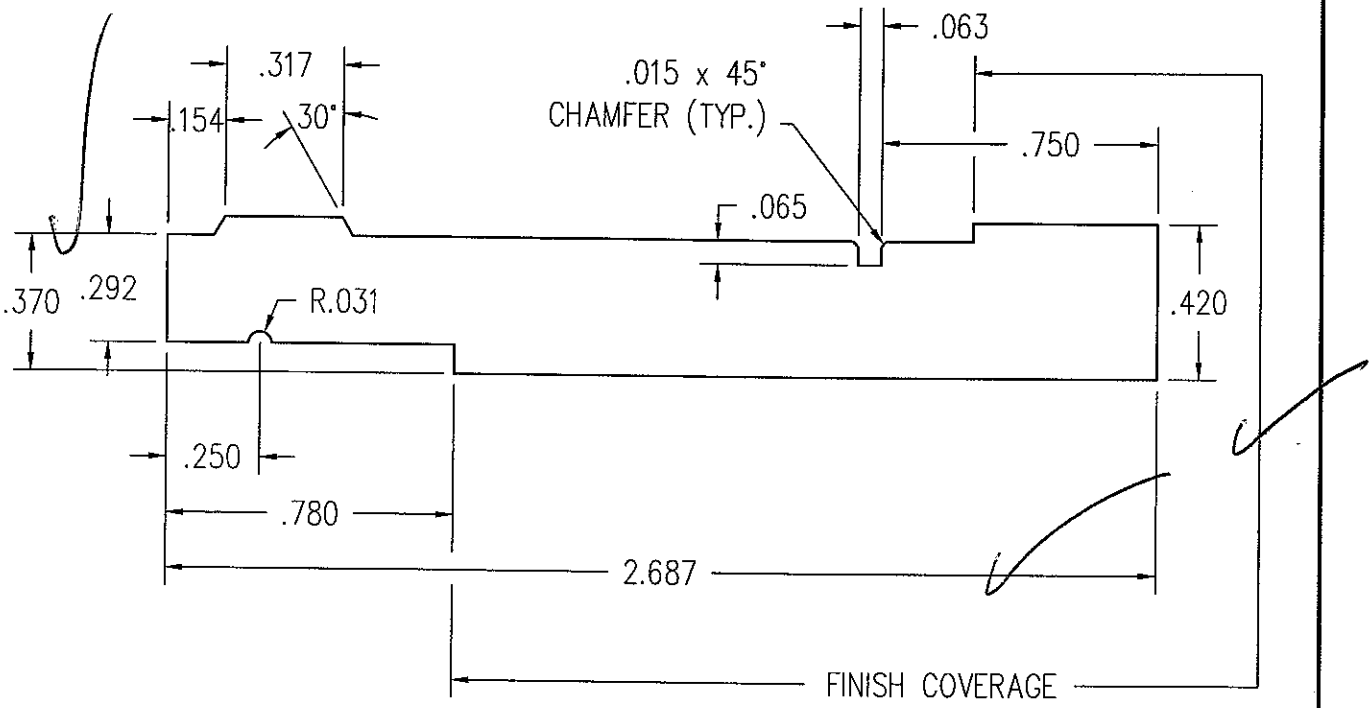
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 7319, 7364, 7896?

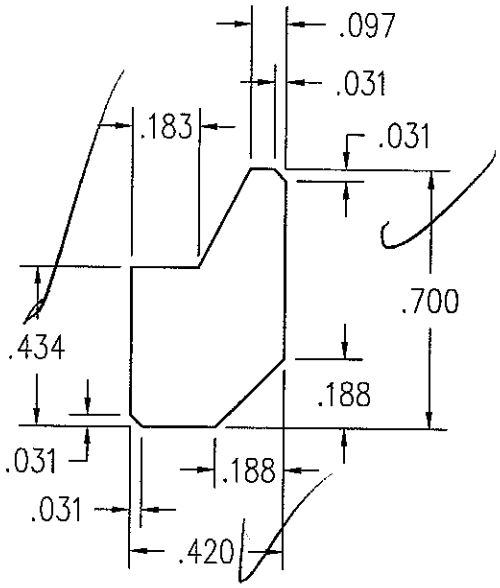
Date _____ Tech _____



TITLE:	'07 SILL STOP
FINISH:	
MATL:	CLEAR PINE
DFT: tnies	SCALE: 2=1
DCN: 0881	DRWG: 20F8
DATE: 12/12/2006	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. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. L = AFH − 4.344.



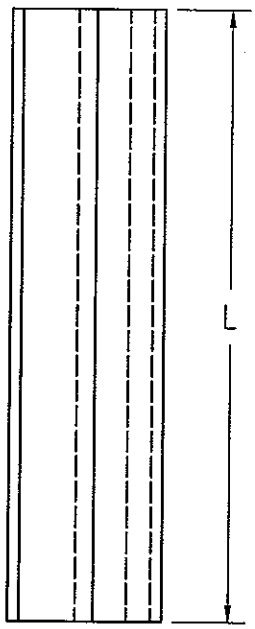
Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TB

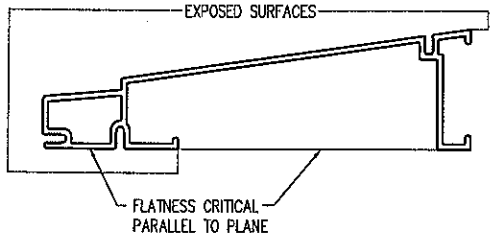
FRAME HEIGHT	L
72	67.656
78	73.656
84	79.656
90	85.656
96	91.656
102	97.656
108	103.656
114	109.656
120	115.656

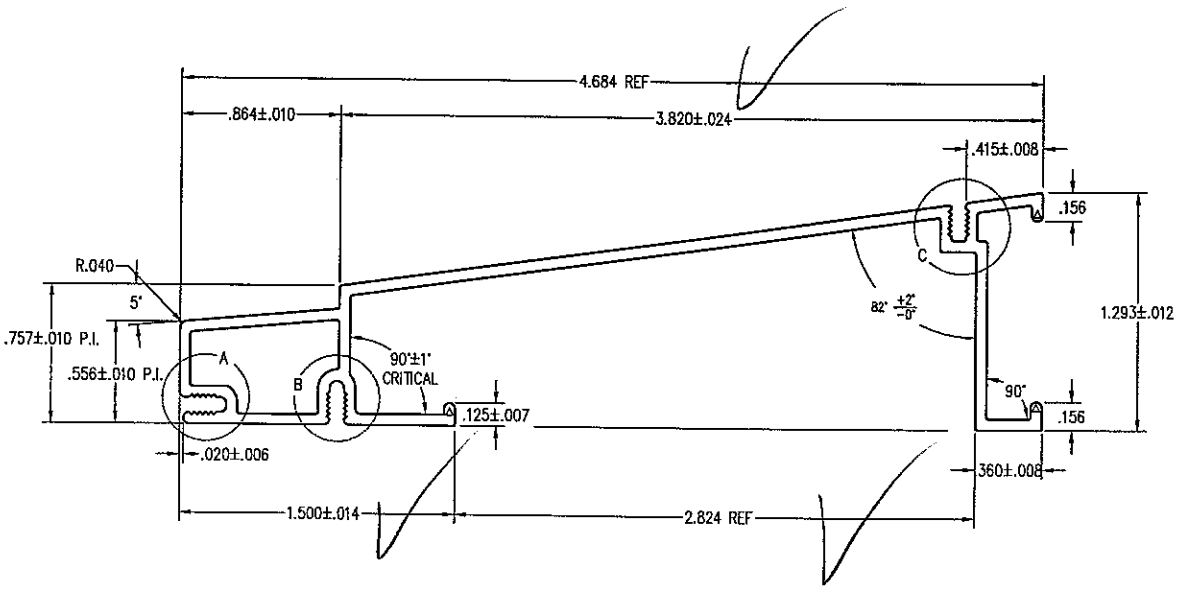


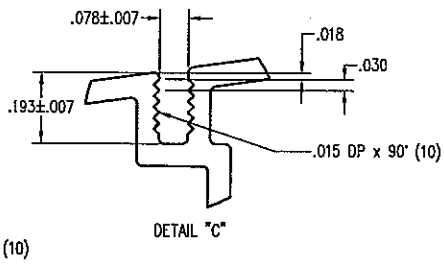
TITLE:	'07 CSHMV – INTERIOR SIDE STOP
FINISH:	
MATL:	CLEAR PINE
DFT: tnies	SCALE: 2=1
DCN: 0881	DRWG: 20FL
DATE: 2/2/2007	A 01 OF 01

NO	DESCRIPTION	DFT	DOC	DATE

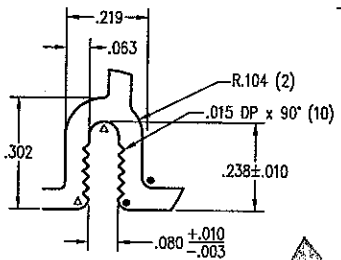
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. UNLESS OTHERWISE SPECIFIED, WALL THICKNESS IS .060.
3. UNLESS OTHERWISE SPECIFIED BREAK ALL CORNERS .015 RADIUS.
4. AREA = .572 SQIN
5. MILL PART NO. = # M5746 ,
6. BON-L # EWD-285





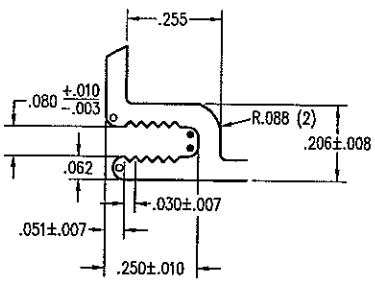


DETAIL "C"



DETAIL "B"

• R .028 (6)
○ R .031 (2)
X R .062 (0)
△ FULL RAD.(4)



DETAIL "A"

Architectural Testing

Test sample complies with these details.
Deviations are noted.

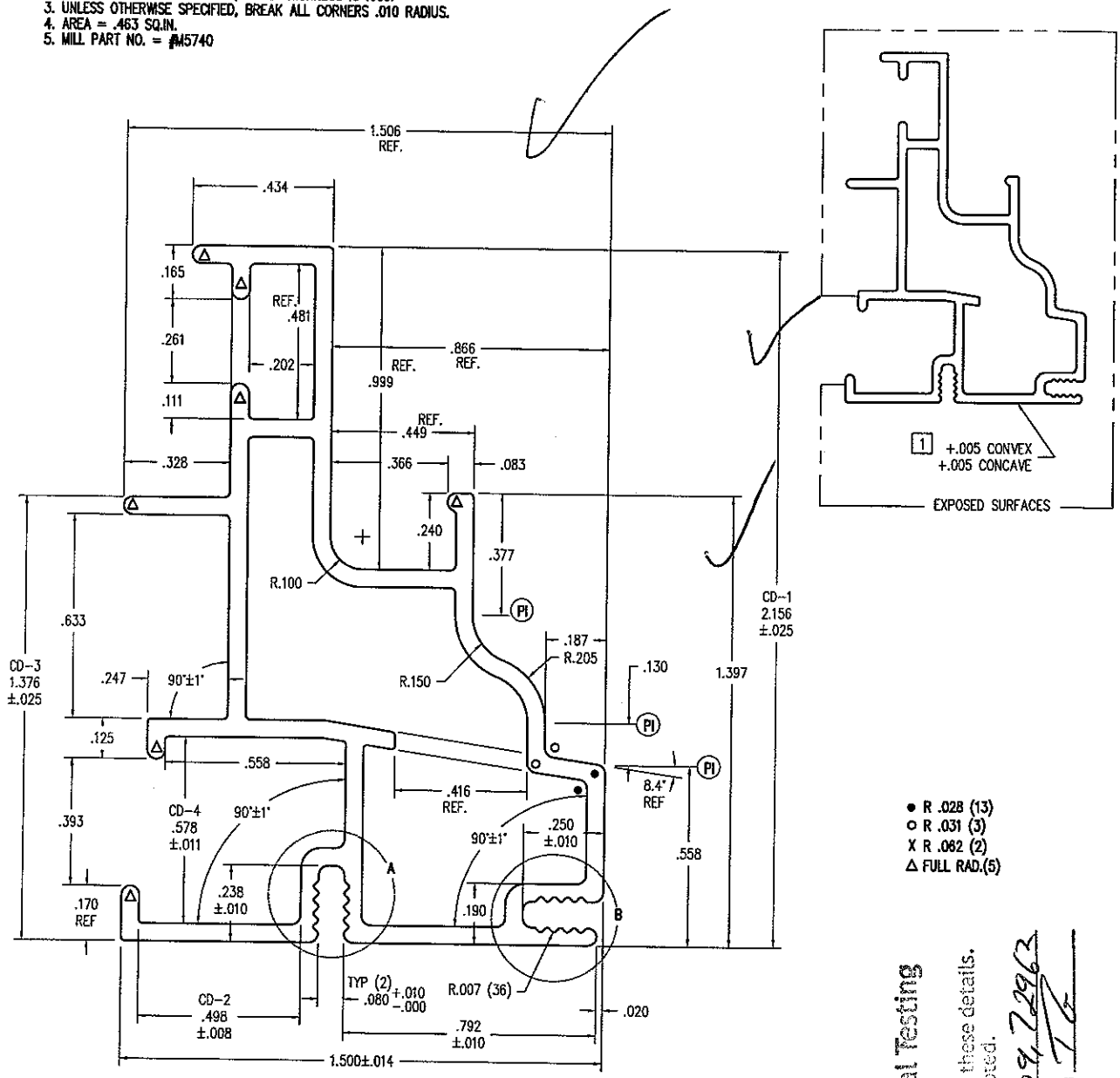
Report# 73119, 73109, 72962

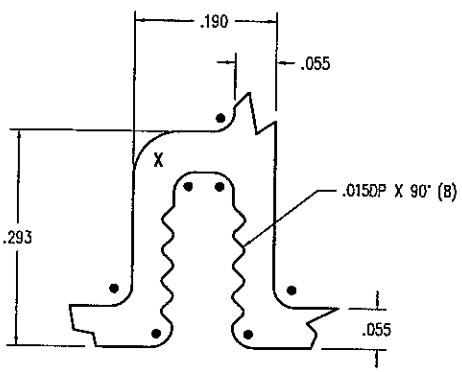
Date 5/29-6/4/07 Tech TG

NO	DESCRIPTION	DFT	DOC	DATE

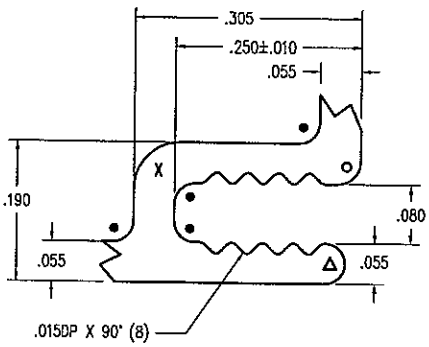
TITLE:	CDHV/CDHF/CSW SILL COVER (HOLLOW NOSE)		
FINISH:	EAGLE'S STD. COLORS		
MATL:	6063 T-6 ALUMINUM		
DFT:	PJB	SCALE:	1=1
DCN:	0734	DRWG:	A571
DATE:	7/23/2002	C	01 OF 02

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. UNLESS OTHERWISE SPECIFIED, WALL THICKNESS IS .055.
3. UNLESS OTHERWISE SPECIFIED, BREAK ALL CORNERS .010 RADIUS.
4. AREA = .463 SQ.IN.
5. MILL PART NO. = #M5740





DETAIL "A"



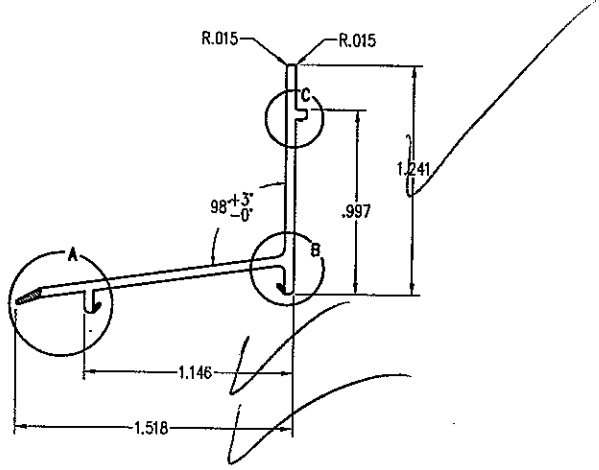
DETAIL "B"

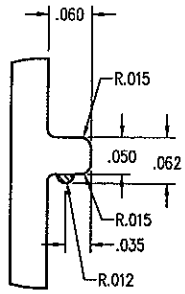
Architectural Testing
Test sample complies with these details.
Deviations are noted.
Report# 73119.23104.22963
Date 5-29-2007 Tech TC

TITLE:	CDHV/CDHF/CSW HEAD / SIDE FRAME COVER
FINISH:	EAGLE'S STD. COLORS
MATL:	6063 T-6 ALUMINUM
DFT: AWW	SCALE: 2=1
DCN: 0667	DRWG: A514
DATE: 11/7/2001	C 01 OF 03

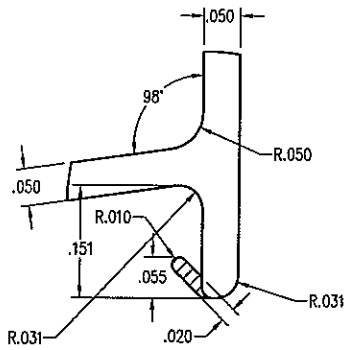
NO	DESCRIPTION	DFT	DOC	DATE
01	ADDED/CHG'D DIM. & TOLERANCE	TWN	0778	4/4/2003

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. TYPICAL RIGID WALL THICKNESS; .050.
3. TYPICAL FLEXIBLE WALL THICKNESS; .020.

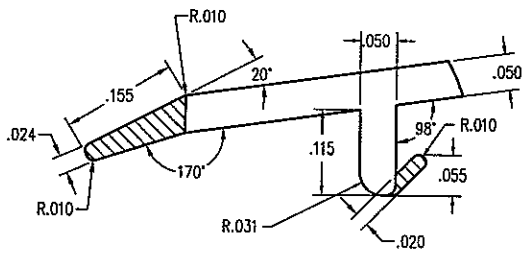




DETAIL C
SCALE X 4



DETAIL B
SCALE X 4



DETAIL A
SCALE X 4

TOLERANCES (UNLESS NOTED)	
.000 – .125	±.010
.125 – .500	±.015
.500 – 2.00	±.020
2.00 – 4.00	±.030
4.00 – 5.00	±.040
WALLS	±.005
ANGLES	±3°

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962

Date 5/29-6/1/07 Tech TG

TITLE: '07 SILL WATER DAM

FINISH:

MATL: BEIGE VINYL

DFT: ksmith SCALE: 1=1

DCN: 0681 DRWG: A74H

DATE: 2/26/2007 C 01 OF 02

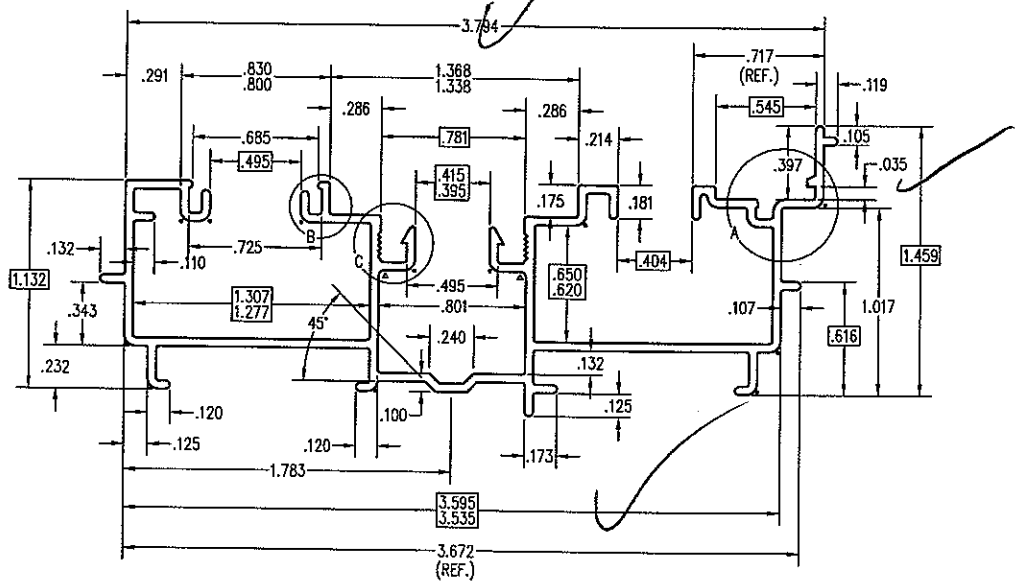
NO	DESCRIPTION	DFT	DOC	DATE

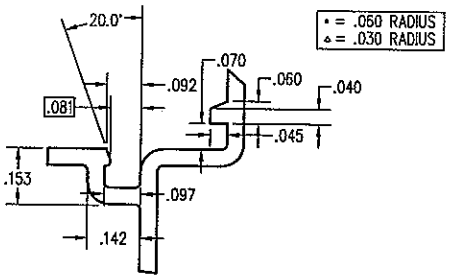
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. WALL THICKNESS = .045
3. AREA = .569 SQ.IN.
4. ALL UNSPECIFIED RADII = .015
5. DIMENSIONS MARKED IN A BOX ARE CRITICAL

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 7296-2
Date 5/29-6/1/07 Tech JG



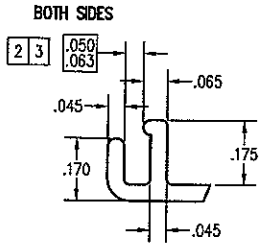


DETAIL "A"

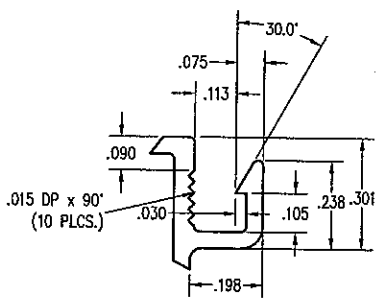
PVC TOLERANCES

.000–.125	±.010
.125–.500	±.015
.500–2.00	±.020
2.00–4.00	±.030
4.00–5.00	±.040
WALLS	±.005
ANGLES	±3°

BOTH SIDES



DETAIL "B"



DETAIL "C"

TITLE:	CDHVET/WDHVET RIGID JAMBLINER
FINISH:	BEIGE, WHITE
MATL:	RIGID PVC
DFT:	AWW
SCALE:	1=1
DCN:	0589
DRWG:	A48X
DATE:	6/21/2001
	C 01 OF 05

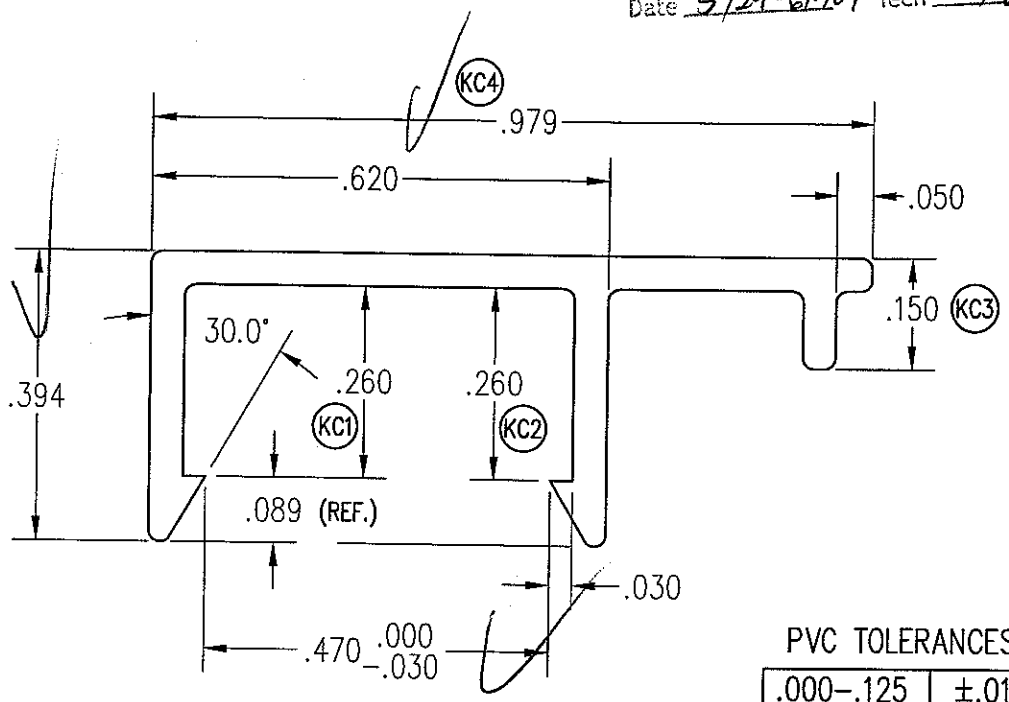
NO	DESCRIPTION	DFT	DOC	DATE
03	CHANGED DIM/TOLERANCE	TWN	0805	7/9/2003
02	ADDED .046 CRITICAL DIM	PJB	0784	5/27/2003
01	ADDED CRITICAL INDICATORS	TWN	0730	2/20/2003

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. WALL THICKNESS = .045.
3. AREA = .0808 SQ. IN.
4. ALL RADII = .015.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, 73109, 72962
Date 5/29-6/1/07 Tech FC



PVC TOLERANCES

.000–.125	±.010
.125–.500	±.015
.500–2.00	±.020
2.00–4.00	±.030
4.00–5.00	±.040
WALLS	±.005
ANGLES	±3°

TITLE: CDHV/WDHV PVC JAMBLINER COVER
FINISH: BEIGE, WHITE
MATL: RIGID PVC

NO	DESCRIPTION	DFT	DOC	DATE
01	ADDED CRITICAL DIM & TOL. BLK.	PJB	PRE	6/4/2002

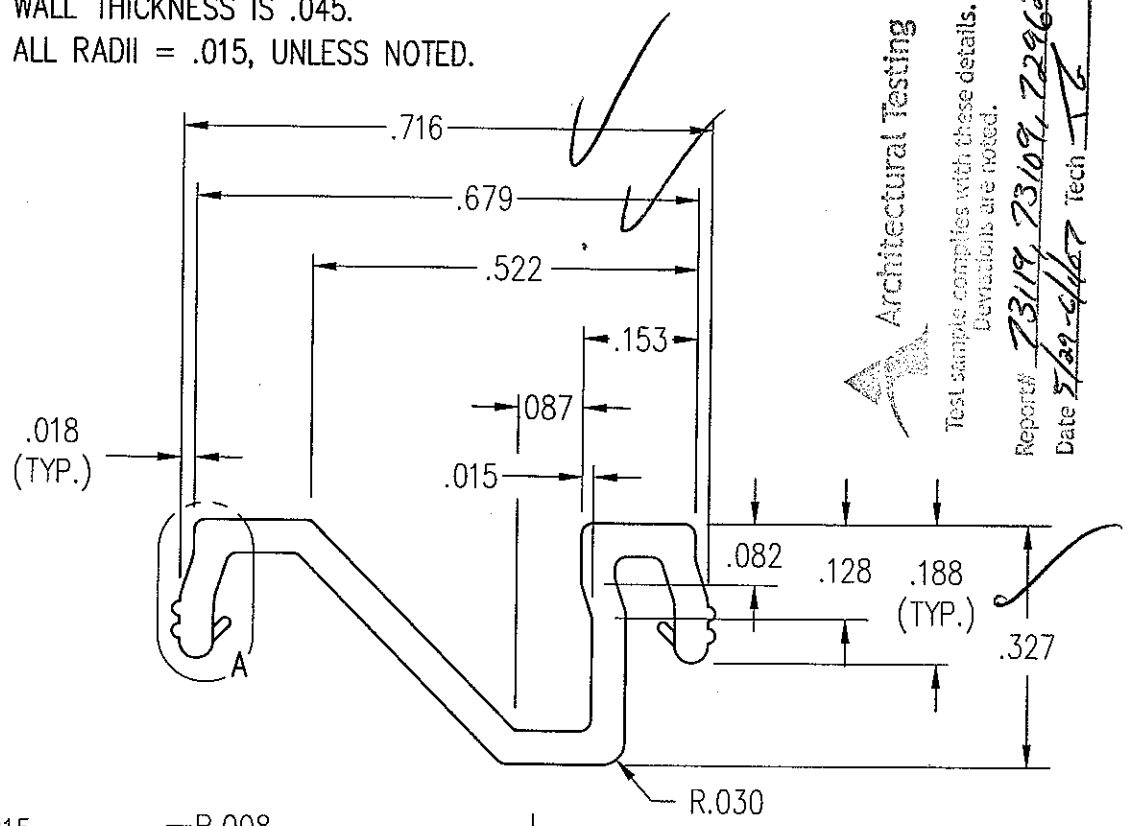
DFT: PJB
DCN: 0589
DATE: 6/21/2001
SCALE: 4=1
DRWG: A48Y
A 01 OF 03

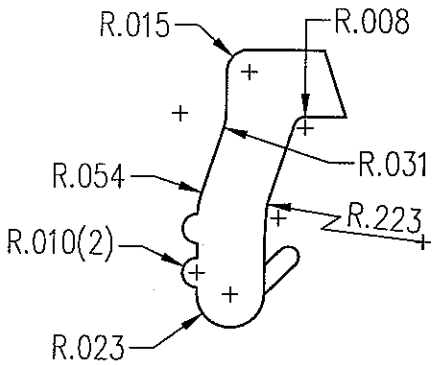
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

2. WALL THICKNESS IS .045.

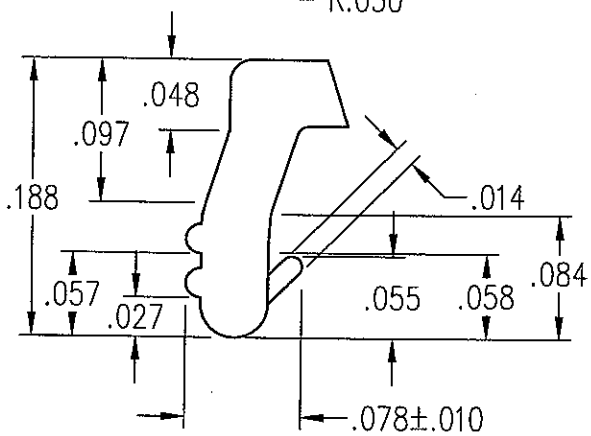
3. ALL RADII = .015, UNLESS NOTED.

Architectural Testing
Test samples complies with these details. Deviations are noted.
Report# 23119.23102.22962
Date 5/30-6/1/07 Tech





DETAIL "A" -- RADII



DETAIL "A"

PVC TOLERANCES

.000–.125	±.010
.125–.500	±.015
.500–2.00	±.020
2.00–4.00	±.030
4.00–5.00	±.040
WALLS	±.005
ANGLES	±3°

TITLE:	'07 CDHV SPRING COVER
FINISH:	BEIGE, WHITE
MATL:	PVC
DFT: ksmith	SCALE: 4=1
DCN: 0881	DRWG: A71N
DATE: 1/29/2007	A 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE

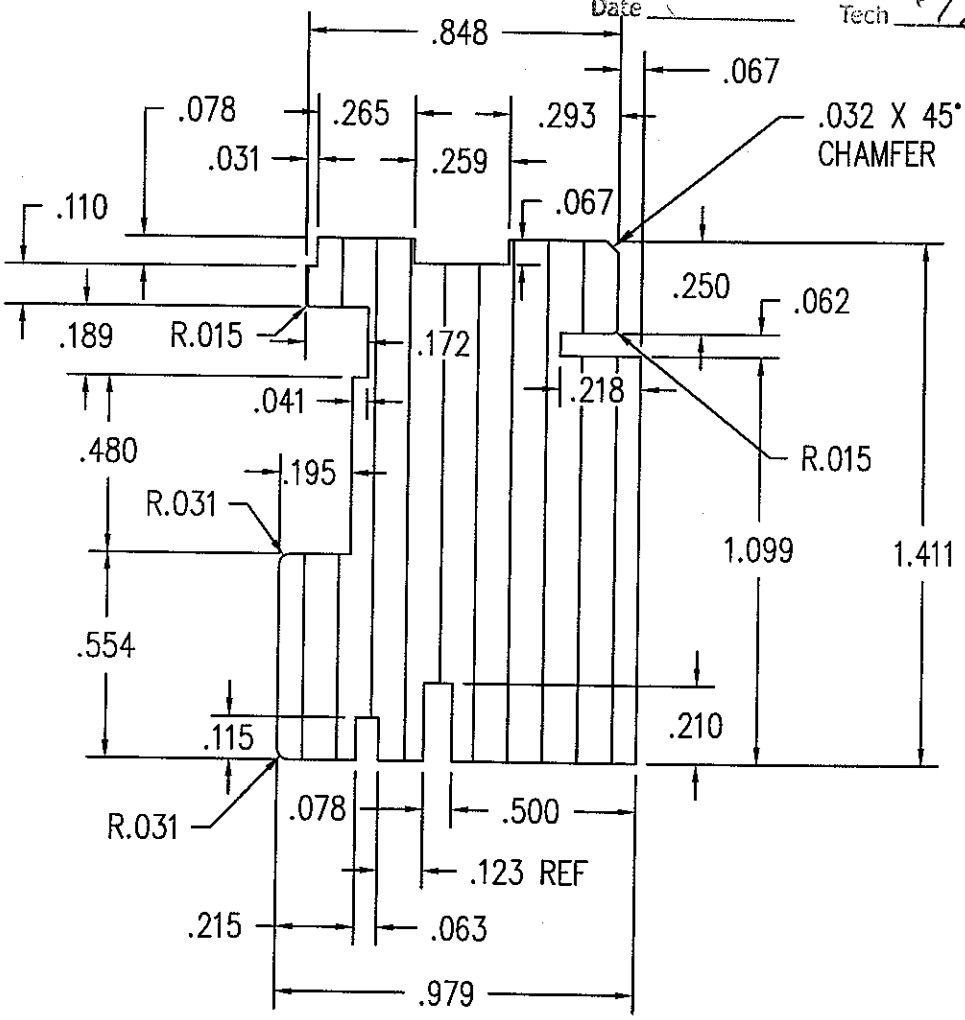
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. DOUGLAS FIR LVL IS REQUIRED.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, ~~73120~~, 73109, 72962

Date _____ Tech TG



TITLE: '07 CLAD DOUBLE HUNG UPPER CHECK RAIL

FINISH:

MATL: SEE NOTE #2

NO	DESCRIPTION	DFT	DOC	DATE
03	CHANGED PROFILE	TWN	PRE	3/20/07
02	REVISED PROFILE	TWN	PRE	1/15/07
01	UPDATED PROFILE	KJS	0881	1/4/07

DFT: tnies SCALE: 2=1
DCN: 0881 DRWG: 20F2
DATE: 9/28/2006 A 01 OF 02

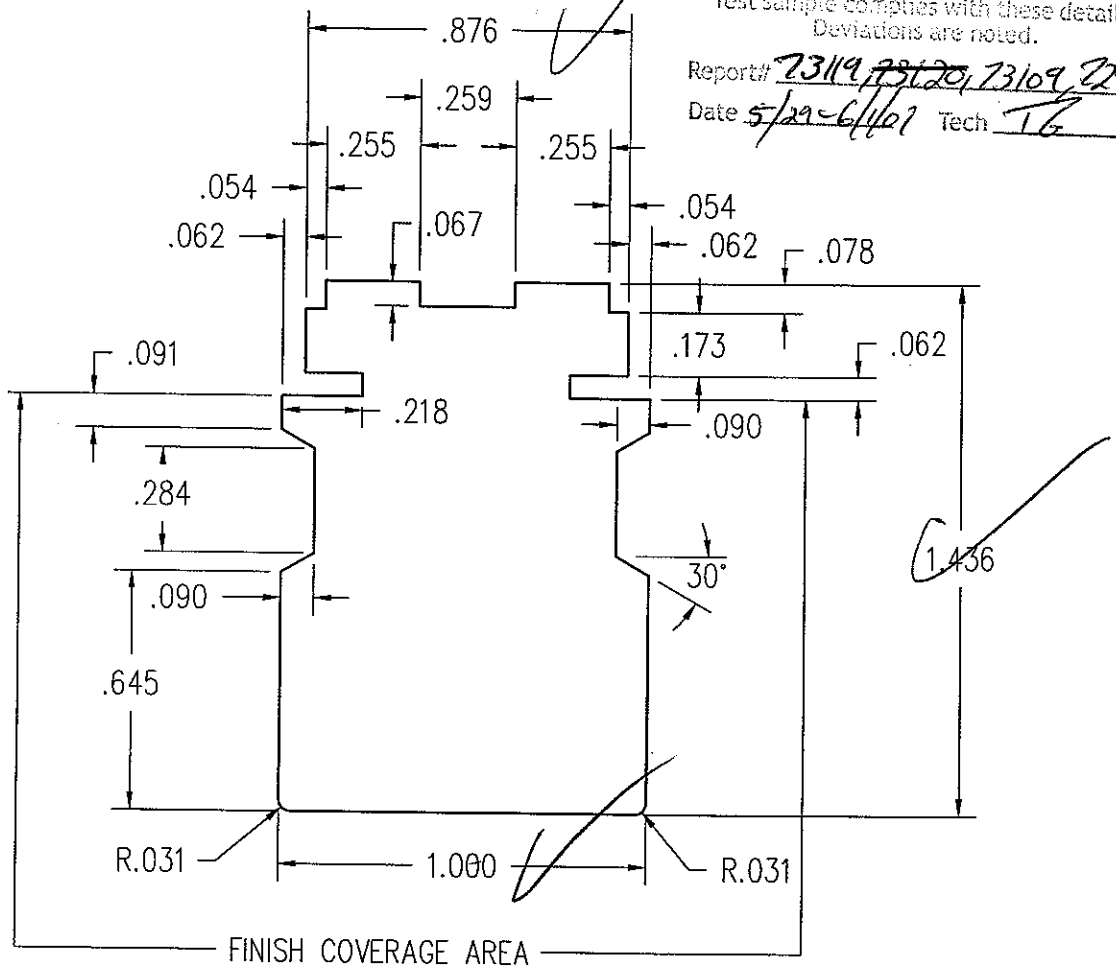
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, ~~73120~~, 73109, 2962

Date 5/29-6/1/07 Tech TG



TITLE: '07 CDHV/CSHV – STILE/RAIL	
FINISH: PRESERVATIVE	
MATL: CLEAR PINE	
DFT: ksmith	SCALE: 2=1
DCN: 0881	DRWG: 20F4
DATE: 1/4/2007	A 01 OF 06

NO	DESCRIPTION	DFT	DOC	DATE

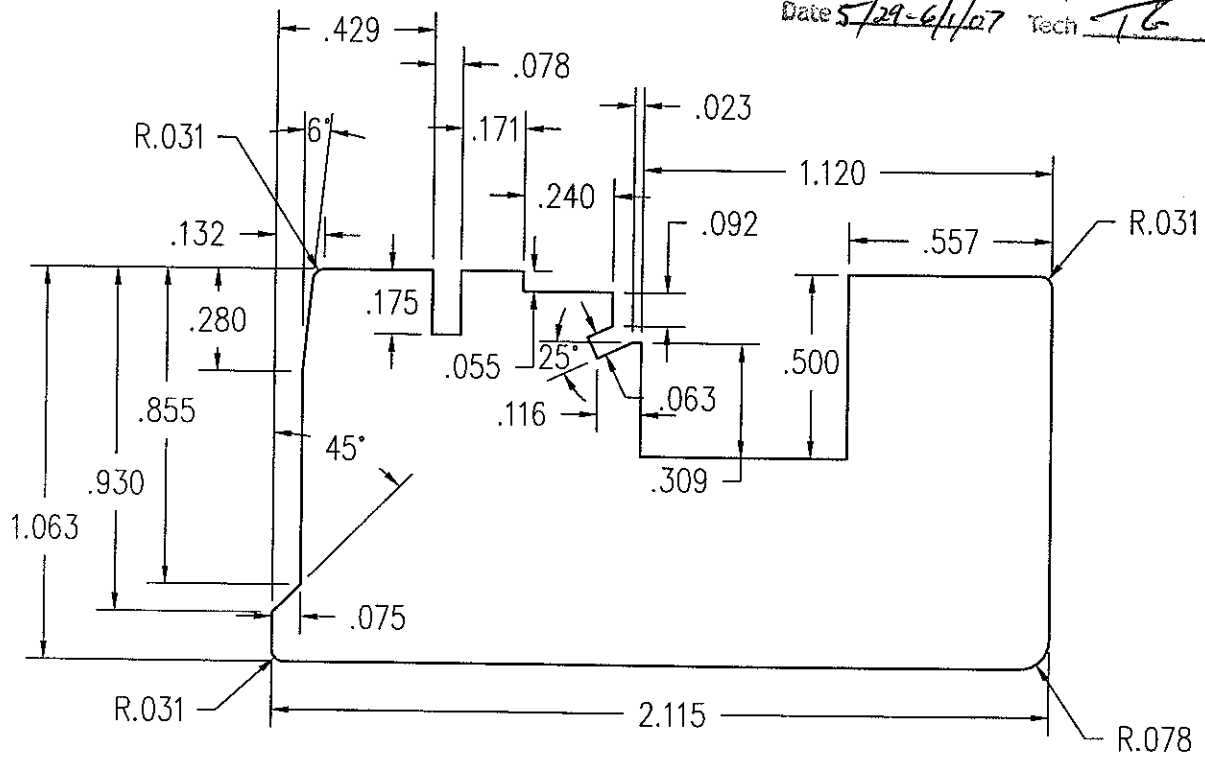
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 23119, ~~23120~~, 23209, 23962

Date 5/29-6/1/07 Tech TG



TITLE: '07 CLAD DOUBLE HUNG LOWER CHECK RAIL				
FINISH:				
MATL: CLEAR PINE				
DFT: tnies			SCALE: 2=1	
DCN: 0881			DRWG: 20F5	
DATE: 9/28/2006			A 01 OF 02	

NO	DESCRIPTION	DFT	DOC	DATE
01	UPDATED PROFILE	KJS	0881	1/4/07

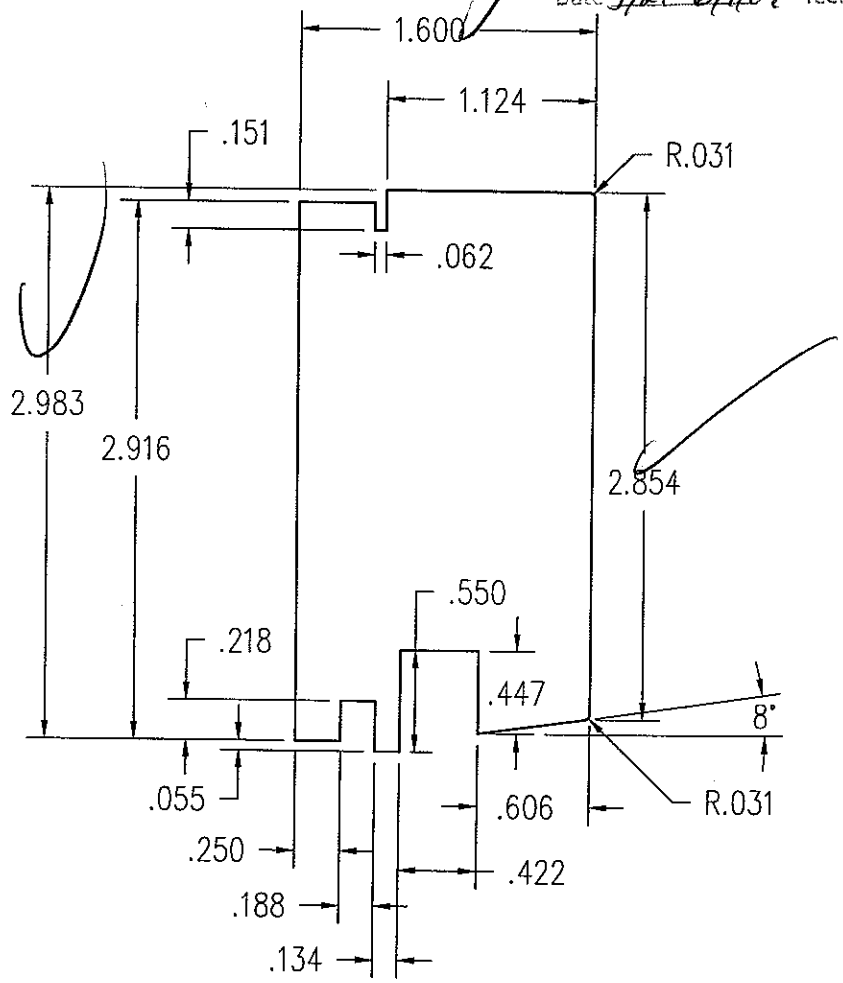
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, ~~73120~~, 73109, 72962

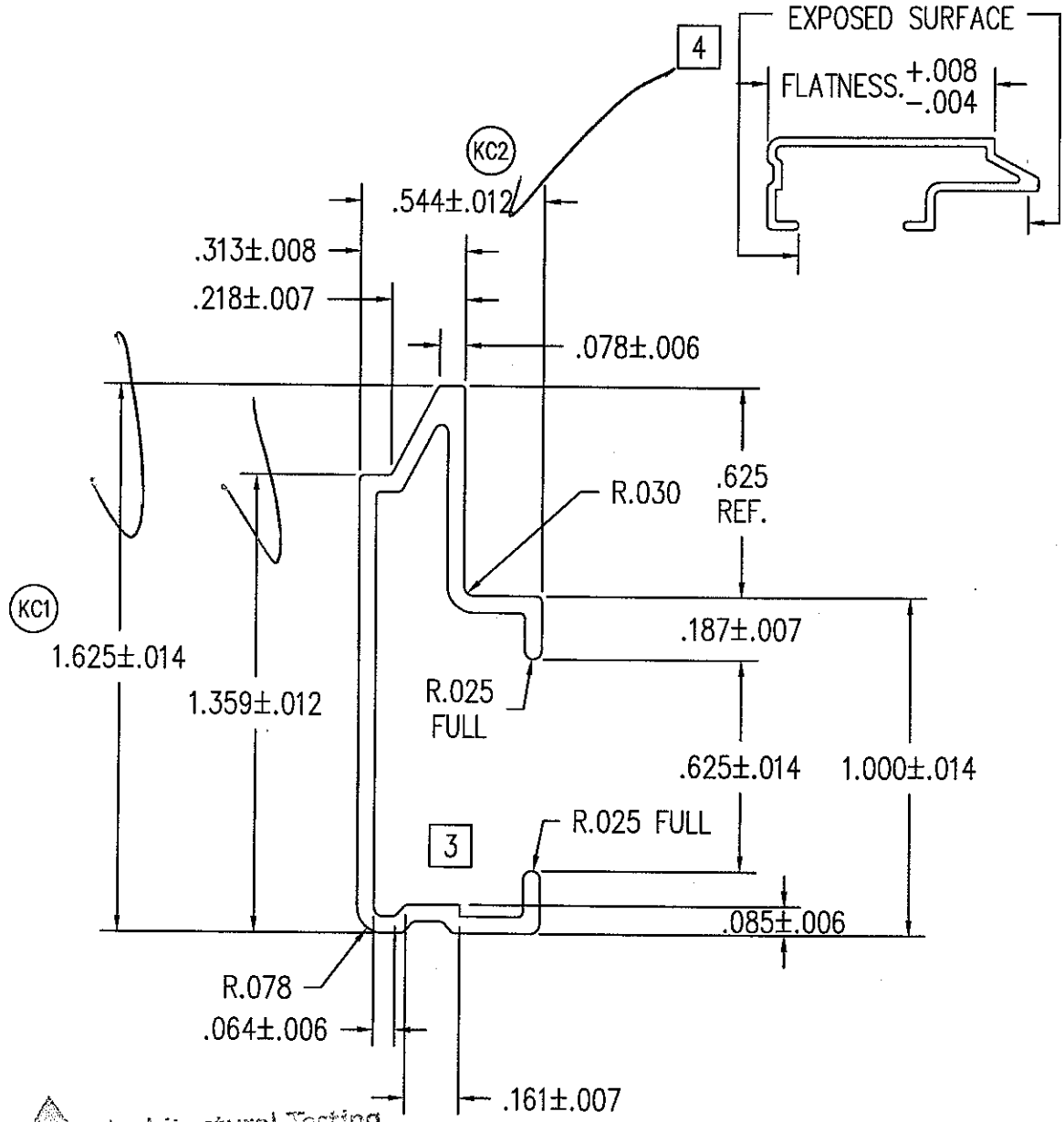
Date 5/29-6/4/07 Tech TG



TITLE:	'07 CDHV, CDHF WIDE RAIL
FINISH:	
MATL:	CLEAR PINE
DFT: tnies	SCALE: 1=1
DCN: 0881	DRWG: 20E8
DATE: 9/29/2006	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. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. TYPICAL WALL THICKNESS .050±.005.
3. UNSPECIFIED RADIUS TO BE .015.



Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, ~~73120~~, 73109, 72962

Date 5/29-6/1/07 Tech JG

NO	DESCRIPTION	DFT	DOC	DATE
05	ADDED E-TILT DHG	RJW	0589	6/26/2002
04	ADDED TOLERANCE SPECS.	TWN	0595	8/31/2001
03	REVISED PROFILE	CEL	0366	10/27/1998
02	CHG'D DESCRIPTION	CEL	0247	4/14/1997
01	PROFILE REDESIGNED	BRL	0215	8/29/1995

TITLE: CDHV,CDHF,CSW,CDHVET SASH COVER

FINISH: EAGLE'S STD. COLORS

MATL: 6063 T-6 ALUMINUM OR EQUIVALENT

DFT: GDE

DCN: 0073

DATE: 3/26/1993

SCALE: 2=1

DRWG: A16K

A 01 OF 02

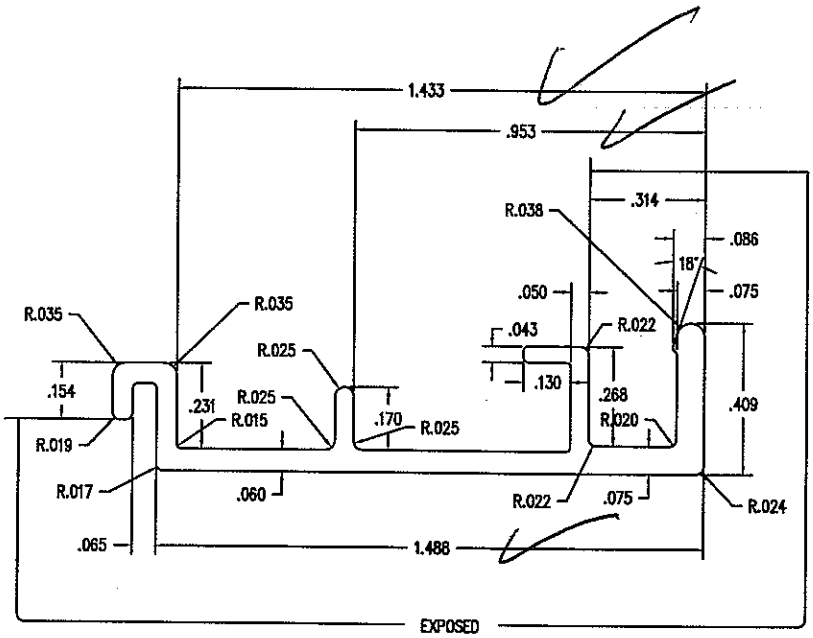
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. TYPICAL WALL THICKNESS .055
3. ALL RADIUS TO BE .010 UNLESS OTHERWISE SPECIFIED.
4. AREA = .171 SQ. IN.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 23119, ~~23120~~, 23109, 2962

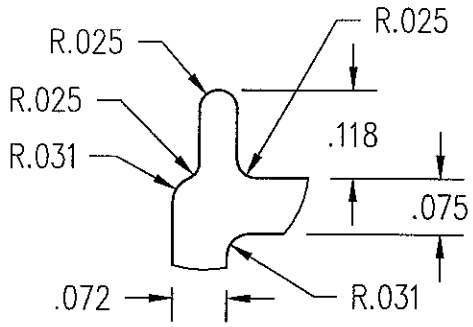
Date 5/31-6/1/07 Tech TG



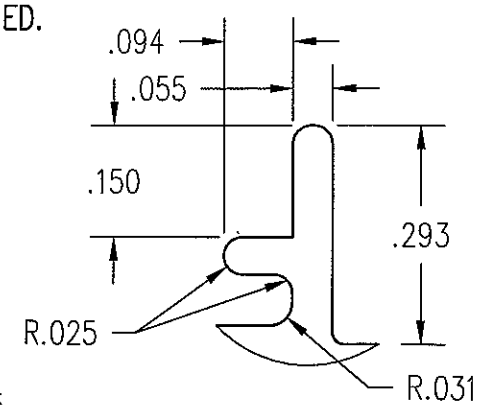
TITLE:	'07 CDHV, CSHV CHECK RAIL
FINISH:	EAGLE'S STD. COLORS
MATL:	6063 – T6 ALUMINUM
DFT: ksmith	SCALE: 2=1
DCN: 0881	DRWG: A72W
DATE: 1/29/2007	C 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE

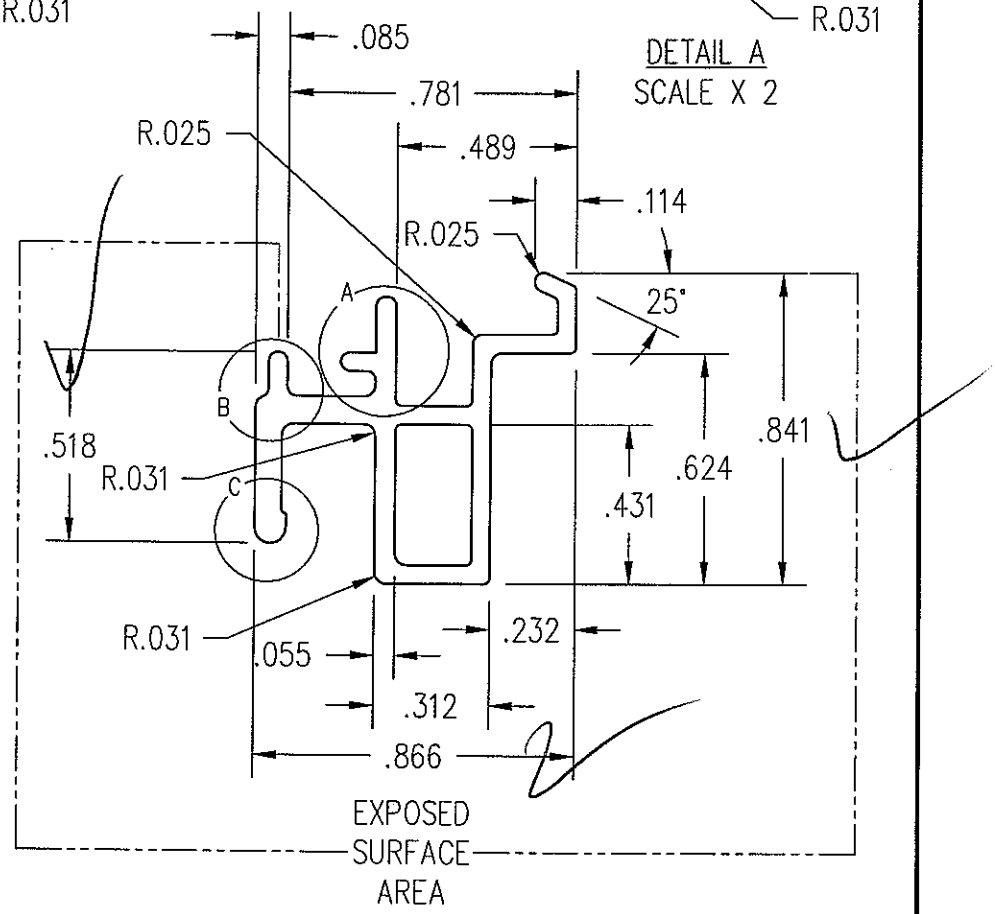
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. WALL THICKNESS TO BE .050 UNLESS OTHERWISE SPECIFIED.
3. RADIUS TO BE .016 UNLESS OTHERWISE SPECIFIED.

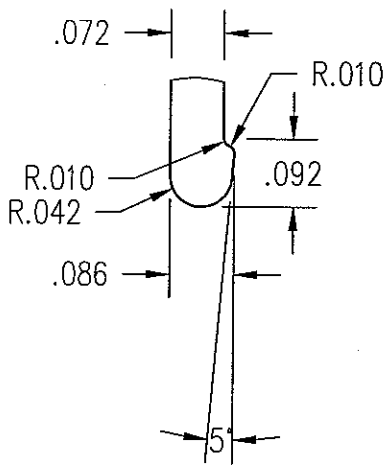


DETAIL B
SCALE X 2



DETAIL A
SCALE X 2





DETAIL C
SCALE X 2

Architectural Testing

Test sample complies with these details.
Deviations are noted.

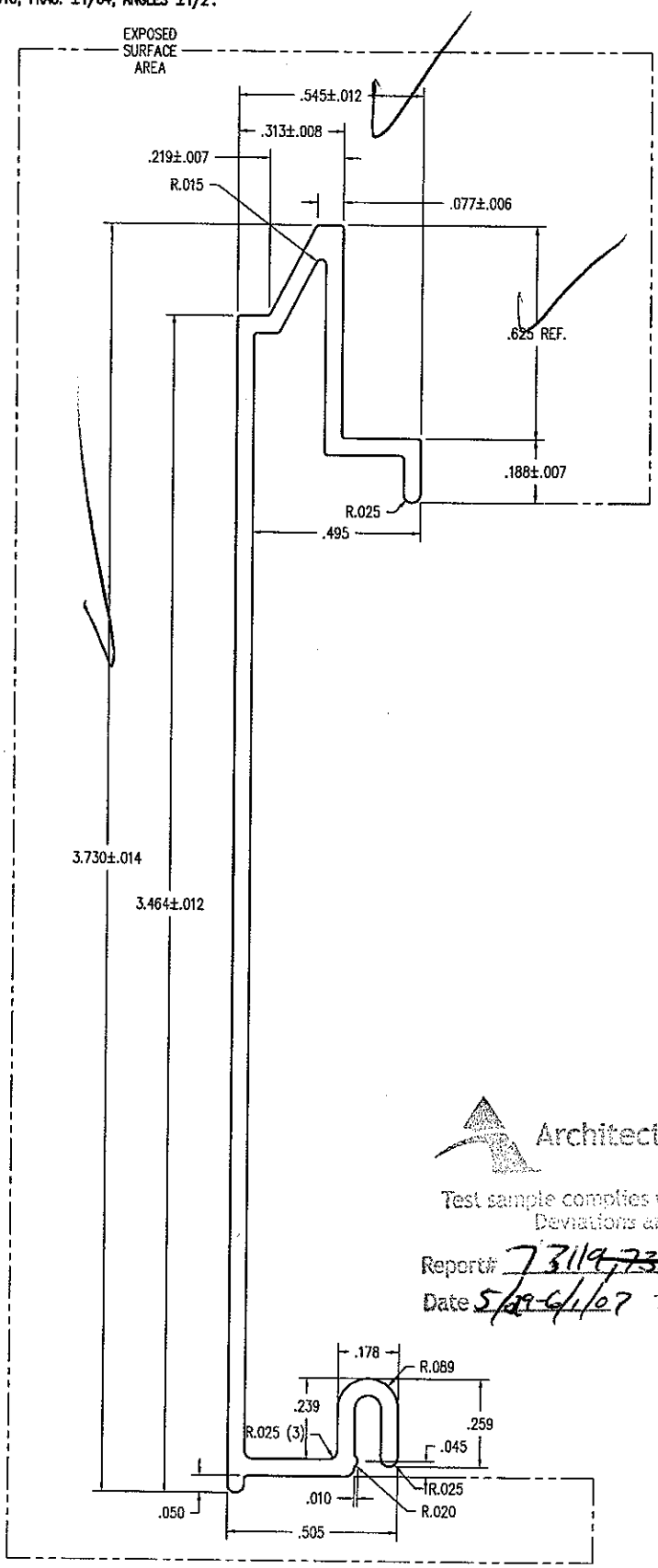
Report# 73119, ~~73120~~, 73109, 72962

Date 5/29-6/4/07 Tech TG

TITLE:	'07 CDHV BOTTOM CHECK RAIL
FINISH:	EAGLE'S STD. COLORS
MATL:	6063 – T6 ALUMINUM
DFT: ksmith	SCALE: 2=1
DCN: 0881	DRWG: A72X
DATE: 1/29/2007	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. ±.010; FRAC. ±1/64; ANGLES ±1/2°.
2. TYPICAL WALL THICKNESS .050.
3. UNSPECIFIED RADIUS TO BE .010.
4. AREA = .287 SQ. IN.



Architectural Testing

Test sample complies with these details.
Deviations are noted.

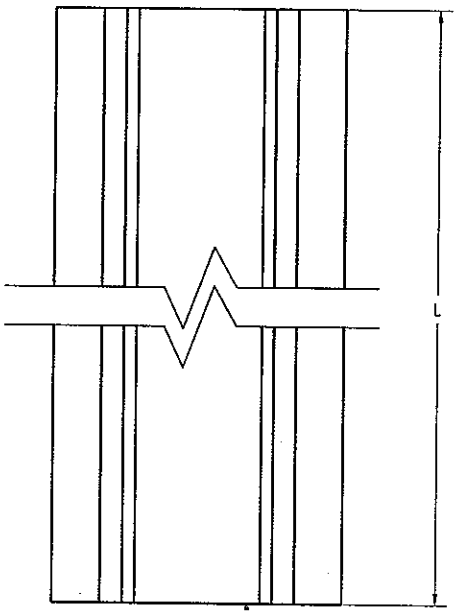
Report# 73119, ~~73120~~ 73109, 72962

Date 5/29-6/1/07 Tech TG

TITLE:	'07 CDHV, CDHF LOWER RAIL COVER
FINISH:	EAGLE'S STD. COLORS
MATL:	6063 T-6 ALUMINUM
DFT: ksmith	SCALE: 2=1
DCN: 0881	DRWG: A71X
DATE: 1/29/2007	C 01 OF 02

NO	DESCRIPTION	DFT	DOC	DATE
01	CHANGED PROFILE	TWN	PRE	12/12/06

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. UNLESS OTHERWISE SPECIFIED, WALL THICKNESS IS .045
3. UNLESS SPECIFIED, BREAK ALL CORNERS .015.
4. PROFILE AREA = .075 SQ. IN.
5. SHG (L) = AFH/2 − 1.188.
SHG COTT. (L) = AFH/2 + 4.812.
SHG REV. COTT. (L) = AFH/2 − 7.188.



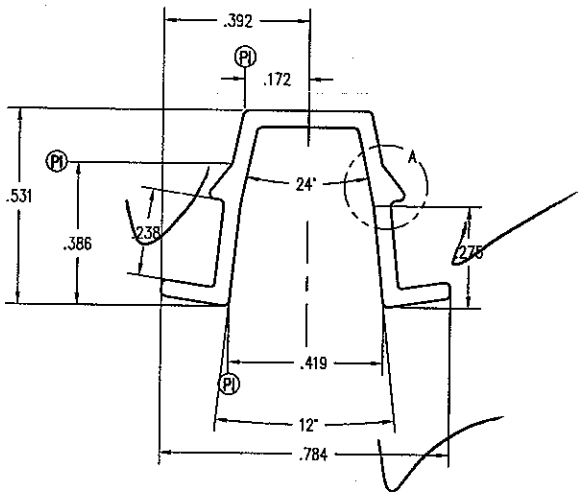
DOUBLE HUNG	
FRAME HEIGHT	L
36	0
40	0
48	0
54	0
60	0
66	12
72	12
78	12
84	12
90	24

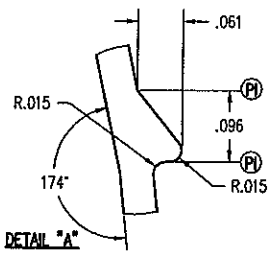
SINGLE HUNG	
FRAME HEIGHT	L
36	16 13/16
40	18 13/16
48	22 13/16
54	25 13/16
60	28 13/16
66	31 13/16
72	34 13/16
78	37 13/16
84	40 13/16
90	43 13/16

DH COTT.	
FRAME HEIGHT	L
36	0
40	0
48	0
54	14
60	14
66	14
72	14
78	14
84	14
90	24

DH REV. COTT.	
FRAME HEIGHT	L
36	0
40	0
48	0
54	0
60	0
66	0
72	12
78	12
84	12
90	12

3





PVC TOLERANCES	
.000–.125	±.010
.125–.500	±.015
.500–2.00	±.020
2.00–4.00	±.030
4.00–5.00	±.040
WALLS	±.005
ANGLES	±3°

Architectural Testing

Test samples complies with these details.
Deviations are noted.

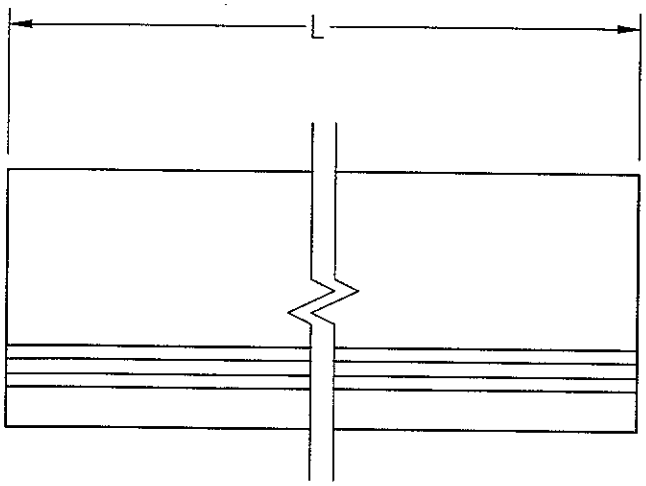
Report# 23119, ~~23120,~~ 73109, 72962

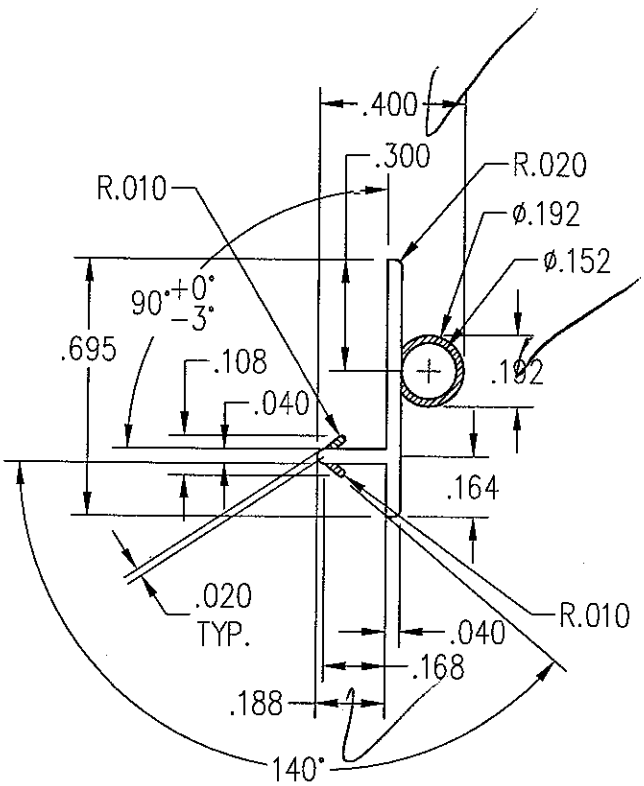
Date 5/29-6/1/07 Tech TG

NO	DESCRIPTION	DFT	DOC	DATE
03	CHG'D LENGTHS TO 14"	TWN	TRKR	10/20/05
02	CORRECT 78" SHG (L)	AWW	0844	1/22/04
01	FLARED LEGS APART	PJB	0805	7/9/03

TITLE:	CDHV/WDHV SASH STOP
FINISH:	BEIGE, WHITE
MATL:	RIGID PVC
DFT: AWW	SCALE: 2=1
DCN: 0589	DRWG: A52F
DATE: 2/4/2002	C 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. ALL NON LABELED RADIUS ARE .020.
3. L = AFW – 3 13/16".





Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 73119, ~~73120~~, 73109, 72962
Date 5/29-6/1/07 Tech TG

TITLE:	'07 CDHV CR WEATHERSTRIP					
FINISH:	BEIGE					
MATL:	DUAL DURAMETER / VINYL					
DFT:	ksmith				SCALE:	2=1
DCN:	0881				DRWG:	A72T
DATE:	1/29/2007				A	01 OF 01

NO	DESCRIPTION	DFT	DOC	DATE
01	CHANGED BULB SIZE	TWN	PRE	3/20/07

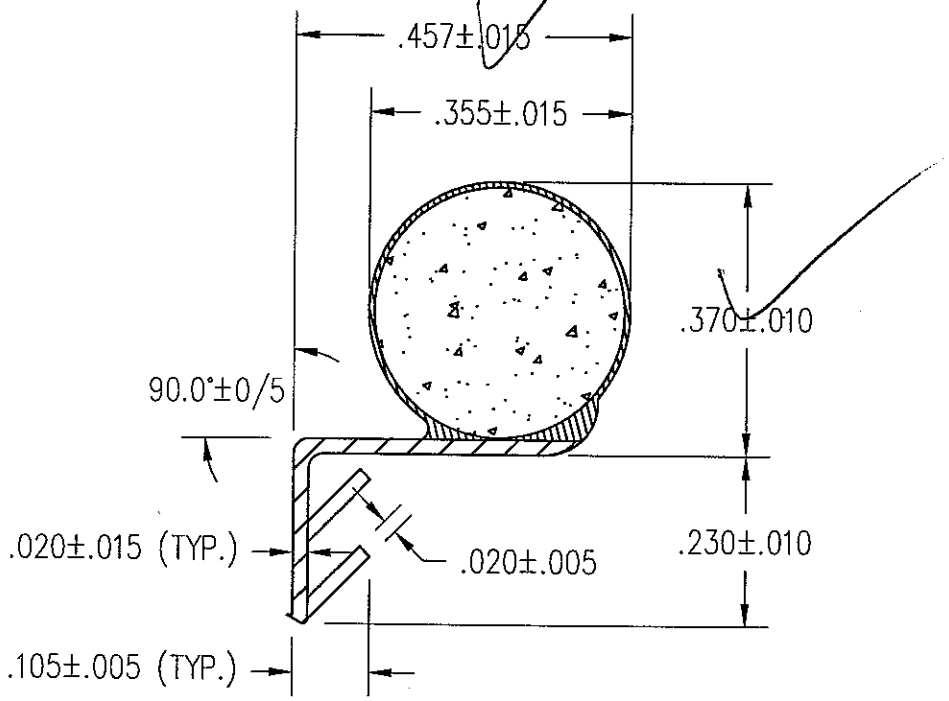
NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.

Architectural Testing

Test sample complies with these details.
Deviations are noted.

Report# 23119, ~~23120~~, 23109, 22962

Date ~~5/29/6/1/07~~ Tech 16

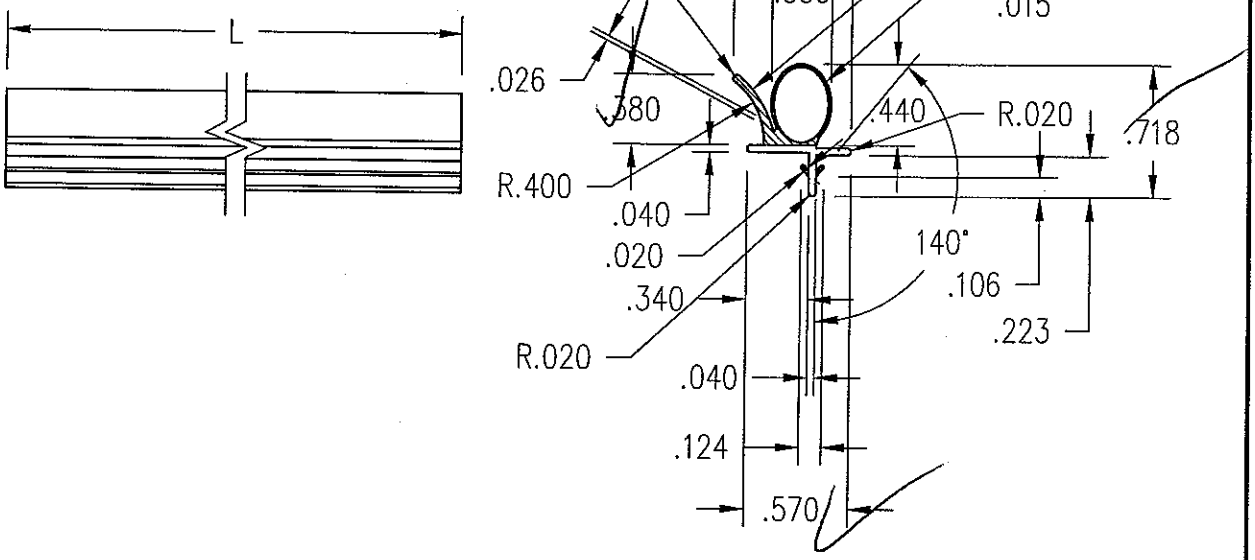


TITLE: DH HEAD WEATHERSTRIP			
FINISH:			
MATL:			
DFT: RJW		SCALE: 4=1	
DCN: 0498		DRWG: A43G	
DATE: 9/28/00		A 01 OF 02	

NO	DESCRIPTION	DFT	DOC	DATE

NOTE: 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS SHOWN ARE IN INCHES AND ALL TOLERANCES ARE TO BE: DEC. ±.005; FRAC. ±1/64; ANGLES ±1/2°.
2. L = AFW – 3.800.

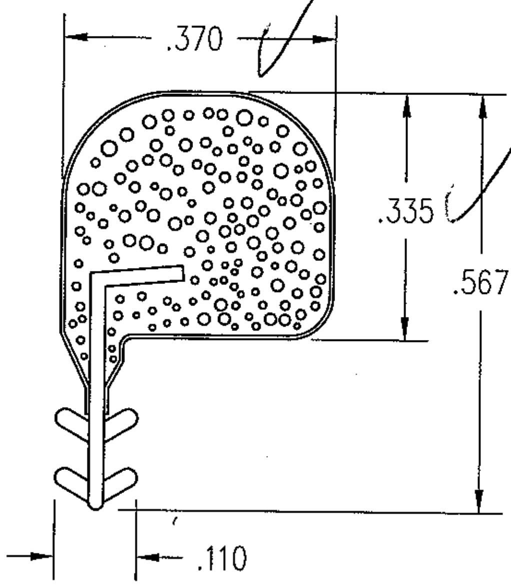
Architectural Testing
Test sample complies with these details.
Deviations are noted.
Report# 73119~~73120~~, 7309, 7296
Date 5/29-6/1/07 Tech TG



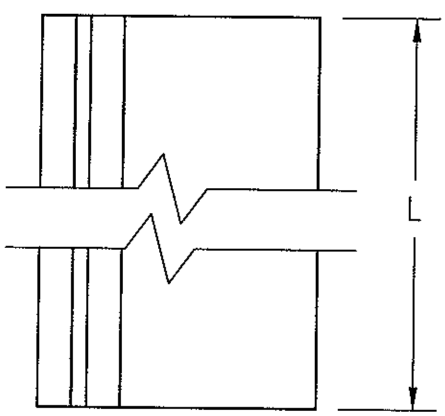
TITLE: '07 CDHV BULB W–STRIP						
FINISH:						
MATL:						
01	CHANGED PROFILE	TWN	PRE	3/20/07	DFT: ksmith	SCALE: 1=1
NO	DESCRIPTION	DFT	DOC	DATE	DCN: 0881	DRWG: A72G
					DATE: 1/29/2007	A 01 OF 01

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. (4) PCS./UNIT REQ'D. -- (2) TOP (EXT.), (2) BOTTOM (INT.).
3. UPPER SASH: DH L = AFH/2 - 2".
LOWER SASH: DH L = AFH/2 + 11/32".
4. CSD USES BEIGE, (L) = AFH - 1 7/8"
5. COMPRESSION SPECIFICATION
A) 4.5 LBS ±1 LB @ 25% COMPRESSION (.084")
B) .2 LBS PRE-LOAD
C) 4.000" PIECE ±.020"

DOUBLE HUNG		
FRAME HEIGHT	UPPER SASH L	LOWER SASH L
36	16	18 11/32
40	18	20 11/32
48	22	24 11/32
54	25	27 11/32
60	28	30 11/32
66	31	33 11/32
72	34	36 11/32
78	37	39 11/32
84	40	42 11/32
90	43	45 11/32
96	46	48 11/32
102	49	51 11/32
108	52	54 11/32
114	55	57 11/32
120	58	60 11/32



CSD (INTERLOCK)	
FRAME HEIGHT	L
80	78 1/8
82	80 1/8
96	94 1/8
120	118 1/8



Architectural Testing
Test sample complies with these details. Deviations are noted.
Report# 73119, ~~73120~~, 73109, 72962
Date 5/30-6/1/07 Tech TG

TITLE: DHG JAMB WEATHER STRIP SCHLEGEL (LAMINATED LINER)

FINISH:

MATL: CORE: HR URETHANE FOAM
SKIN: PE LINER M5

NO	DESCRIPTION	DFT	DOC	DATE
03	UPDATED DHG CHART & NOTE #3	KJS	0881	1/5/07
02	ADD COMPRESSION SPEC	PJB	0873	4/6/2004
01	ADD CSD CHART	AWW	0743	2/17/2003

DFT: AWW	SCALE: 4=1
DCN: 0589	DRWG: A523
DATE: 8/23/2001	A 01 OF 01