

Fenestration Testing Laboratory, Inc.

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Report No. : T10-095
Date : September 30, 2010
Page : 1 of 3

TESTED FOR

INTERNATIONAL WINDOW CORP.

5625 East Firestone Boulevard
South Gate, CA 90280

1.0 PURPOSE

The purpose of this report is to present the testing methods employed and the test results obtained during the performance testing of one (1) **PVC Horizontal Sliding Window** described in paragraph 4.0 of this report.

2.0 TEST REFERENCES

2.1 NAFS – North American Fenestration Standard/specification for windows, doors, and skylights
AAMA/WDMA/CSA 101/I.S.2/A440-08

Class LC – PG25: Size Tested 2432 x 1515 mm (96 x 60 in) Type HS

2.2 CAWM 301 – 90 Forced Entry Resistance Tests for Windows.

2.3 ASTM F 588-07 Standard Test Method for Measuring the Forced Entry Resistance of Windows

3.0 SUMMARY

The test results in paragraphs 5.0 and 6.0 indicate that the tested sample described in paragraph 4.0 of this report complied with the performance requirements of the above referenced specifications.

4.0 SAMPLE SUBMITTED

SERIES: 5321 HS

CONFIGURATION: XOX

FRAME SIZE: 2432 mm x 1515 mm (95.75" x 59.65")

ACTIVE SASH: 591 mm x 1461 mm (23.27" x 57.52")

FIXED LITE: 1143 mm x 1441 mm (45.00" x 56.73") Daylight Opening

GLASS: Each lite consisted of 0.75" overall wide insulated glass. The active sashes each contained DS annealed glass on both sides and a 0.5" spacer. The fixed lite contained 3/16" annealed glass on both sides and a 3/8" spacer.

SPACER: Each spacer was "U" shaped metal and single sealed.

GLAZING: The active sashes were outside wet glazed and the fixed sash was outside tape glazed with 0.5" x 0.06" double sided adhesive foam tape. Each lite sat on 1/8" x 0.8" x 4" rubber setting block at quarter points at the bottom end. PVC snap-in glazing bead was applied full perimeter on the exterior of each lite.

WEEPAGE:

The sill was weeped as follows:

- 1) The sill outside face contained a 1.75" x 0.22" weep hole at each end. A snap-in gated weep cover was inserted in each hole.
- 2) The sill active channel contained a 0.5" diameter vertical weep at each end which drained down into the hollow. The PVC snap-in roller track was cut so as to leave a 0.25" gap at each end to allow water to drain down to the bottom of the active channel.
- 3) The fixed channel contained a 0.25" diameter vertical weep at 3" and 22" from each end.

The active sash bottom rail contained a 0.25" diameter vertical weep at each end which ran straight through from the top web to the bottom.

WEATHERING:

The active sash contained a strip of 0.220" overall high polypile with center fin full perimeter facing out.

HARDWARE:

Each active sash lock stile contained the following at mid-span:

- 1) A two part metal spring loaded latch lock. The base of the lock was fastened with three #6 x 0.75" PFH screws to the lock stile. The spring loaded latch portion sat over the base and was fastened to it with a pair of #6 x 0.75" PFH screws. When locked, the latch engaged a metal keeper fastened to the fixed interlock with a pair of #6 x 0.75" PFH screws.
- 2) Each active sash bottom rail contained a tandem nylon roller in PVC housing which snap fit into a slot at each end.

The head active channel contained a PVC anti-lift at mid-span of each active sash.

CONSTRUCTION:

The frame and sash corners were mitered and fusion welded.

The fixed interlocks were mechanically joined to the frame with a pair of #8 x 2.5" PFH screws respectively.

The lock stiles and fixed interlocks were each reinforced with rolled steel.

CAULKING:

The heads of the screws that fastened the fixed interlock to the frame were sealed.

ANCHORING:

The frame was fastened to a 2" x 6" wooden rough opening with #8 x 1.5" screws every 16" through the nail-on fins at head and jambs.

5.0 TEST PROCEDURES AND RESULTS

5.1 All testing procedures were performed in accordance with the performance requirements of the test specifications referenced in paragraph 2.0 of this report.

5.2 TEST RESULTS

<u>PARAGRAPH</u>	<u>TEST DESCRIPTION</u>	<u>MEASURED</u>	<u>ALLOWED</u>
5.3.1.1	Operating Force (ASTM E 2068)		
	Breakaway Force	56 N (12.6 lbf)	Report only
	Operating Force	30 N (6.7 lbf)	115 N (25 lbf)
5.3.1.1.3	Latching Device		
	Open and Close Latch Device	18 N (4.0 lbf)	100 N (22.5 lbf)
5.3.2.1	Air Infiltration (ASTM E 283)		
	75 Pa	1.0 L/s*m ²	1.5 L/s*m ²
	(1.6 PSF)	0.2 CFM/ft ²	0.3 CFM/ft ²
The tested specimen exceeds the performance requirements specified in AAMA/WDMA/CSA 101 / I.S.2 / A440 for air leakage resistance.			

5.2 **TEST RESULTS (Continued)**

<u>PARAGRAPH</u>	<u>TEST DESCRIPTION</u>	<u>MEASURED</u>	<u>ALLOWED</u>
5.3.3.2	Water Penetration (ASTM E 547) 180 Pa (3.8 PSF) With and without screen	No Leakage	No Leakage
5.3.4.2	Uniform Load Deflection (ASTM E 330) 1200 Pa (25.0 PSF) POS 1200 Pa (25.0 PSF) NEG	21.50 mm (0.85") 19.50 mm (0.77")	Report Only Report Only
5.3.4.3	Uniform Load Structural (ASTM E 330) 1800 Pa (37.5 PSF) POS 1800 Pa (37.5 PSF) NEG	0.00 mm (0.00") 0.00 mm (0.00")	5.75 mm (0.23") 5.75 mm (0.23")
5.3.6.2	Thermoplastic Corner Welded Test Frame Vent	Pass Pass	Break Shall Not Extend along Entire Weld
5.3.6.3	Deglazing (ASTM E 987) 320 N (70 lbf) Stiles 230 N (50 lbf) Rails	11% 6%	Less than 90% Less than 90%

6.0 5.3.5 **ASTM F 588 Forced Entry Resistance Test Results for Windows**
CAWM 301 - 90 FORCED ENTRY RESISTANCE TEST RESULTS

For the gateway test results refer to FTL report T10-092.

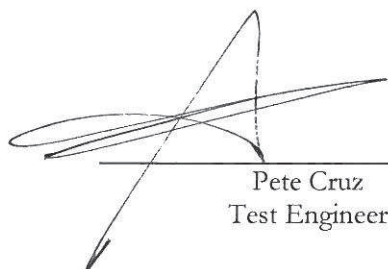
For a complete description of the tested sample refer to the attached thirteen (13) pages consisting of the bill of materials, cross section drawings, and individual part drawings.

Cross section drawings and die drawings of frame members are on file and have been compared to the sample submitted. Test sample sections, drawings and a copy of this report will be retained at the test laboratory for four years.

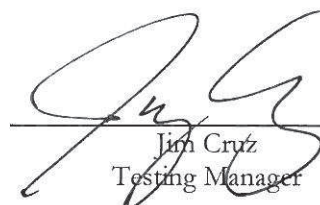
This test report may not be modified in any way without the written consent of Fenestration Testing Laboratory.

The preceding test results relate only to the tested specimen and were obtained by using the applicable ASTM, CAWM and AAMA test methods. This report does not constitute certification of this product. Certification can only be granted by an approved administrator and/or validator.

Testing Completed: September 29, 2010
Report Completed: September 30, 2010



Pete Cruz
Test Engineer



Jim Cruz
Testing Manager

5320/5321/5360/5280 Horizontal Sliding Window XO

9/19/2007

"G"

Item #	Part Number	Description	Comments	Vendor	Vendor Part Number	Qty
F1	RS1521	Head, 1 3/8" offset frame w/stucco key	5320/5380 only	Royal	154-D82	1
	RS1461	Head, 1" offset frame w/stucco key	5321 only	Royal	154-D79	
	RS1041	Head, flush fin frame	5560 only	Royal	154-D44	
F2	RS1521	Sill, 1 3/8" offset frame w/stucco key	5320/5380 only	Royal	154-D82	1
	RS1461	Sill, 1" offset frame w/stucco key	5321 only	Royal	154-D79	
	RS1041	Sill, flush fin frame	5560 only	Royal	154-D44	
F3	RS1521	Jamb, 1 3/8" offset frame w/stucco key	5320/5380 only	Royal	154-D82	2
	RS1461	Jamb, 1" offset frame w/stucco key	5321 only	Royal	154-D79	
	RS1041	Jamb, flush fin frame	5560 only	Royal	154-D44	
F4	RS1037	Vertical Mullion		Royal	154-D50	1
F5	FT5311	Vertical Mullion Reinforcement		North Star	NS-1123	1
F6	RS1008	Vent Track		Royal	154-D8A	1
F7	RS1061	Glass Stop		Royal	154-D49	4
S1	RS1079	Vent Top & Bottom Rail		Royal	154-D3A	2
S2	RS1079	Vent Stile		Royal	154-D3A	1
S3	RS1036	Vent Interlock		Royal	154-D4B	1
S4	FT5310	Interlock Reinforcement		North Star	NS-1122	1
S5	RS1061	Glass Stop		Royal	154-D49	4
SC1	SCRN5300	Screen				1
SC2						
SC3						
SC4						
Screens						
SP1	RS1062	Anti-Lift (5" Long)	CM	Royal	154-D29	1
SP2	SP3305	Clam Latch Assembly & Keeper	CM			1
SP3	SP3302	Nylon Roller Assembly	Nylon	Acer		2
SP4	SP5521	Weep Cover	CM	Croan		2
SP5	RS1027	Vent Stop	CM			1
Small Parts						

FENESTRATION TESTING LAB

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9/30/16