2395 Speakman Dr.
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EVALUATION OF
WINDOW WALL MOCK-UP – "500 RS SERIES THERMALLY BROKEN ALUMINUM WINDOWS"

For ZENITH ALUMINUM SYSTEMS LTD.

IN ACCORDANCE WITH:
ASTM E283, E331, E547, & E330/330M

Report to:	Zenith Aluminum Systems Ltd. 66 Rivalda Road Toronto, Ontario M9M 2M3
Attention:	Isaac Walter
Email: Cc:	iwalter@zenithaluminum.com kira@proactivefenestration.com
Revised Report No.: Original Report No.:	23-06-B0008-2B 23-06-B0008-2A 6 Pages, 1 Appendix
Proposal No.:	22-006-362729
Revised Report Date: Original Report Date:	September 27, 2023 September 21, 2023

1.0 INTRODUCTION

At the request of Zenith Aluminum Systems Ltd., Element Materials Technology Inc. was retained to evaluate the Air Leakage Rate, Water Penetration Resistance, and Uniform Load performance of a Window Wall system, "500 RS Series Thermally Broken Aluminum Windows", as outlined in proposal No.: 22-006-382151.

Note: This report is re-issued in the name of Zenith Aluminum Systems Ltd., through written authorization from Falbo Aluminum Systems Ltd., to whom the original report was released. Element Original Report No.: 23-06-B0008-2A (Dated: September 21, 2023).

2.0 SAMPLE DESCRIPTION

Sample No:	23-06-B0008-2
Series/Model Name:	500 RS Series Thermally Broken Aluminum Windows
Product Type:	Window Wall Mock-up, 1765 mm x 5345 mm (69.49" x 210.43"), two louvre type spandrels over two spandrels over bypass over spandrel by awning over fixed unit
Fixed Unit:	One, extruded aluminum, 900 mm x 1040 mm x 124 mm (35.43" x 40.94" x 4.88")
Awning Window	One, extruded aluminum frame and sash members, 900 mm x 1000 mm x 76 mm (35.43" x 39.37" x 2.99"), operator at sill center, two single single point locks one per jamb/stile
Spandrels:	Extruded Aluminum, insulated with steel backpan Two, louvre type, 900 mm x 800 mm 124 mm (35.43" x 31.50" x 4.88") Two, 900 mm x 2080 mm x 124 mm (35.43" x 81.89" x 4.88), 6 mm tempered glass front face One, 890 mm x 2080 mm x 124 mm (35.04" x 81.89" x 4.88"), aluminum 3 mm (0.12") thick aluminum front face Two, 890 mm x 178 mm x 124 mm (35.04" x 7.01" x 4.88"), aluminum 3 mm (0.12") thick aluminum front face
Bypass:	Extruded Aluminum, 1830 mm x 178 mm x 124 mm (42.53" x 7.01" x 4.88")
Installation:	
Test Buck:	Aluminum buck
Simulated Floor:	Wood construction, 200 mm (7.87") high, positioned behind bypass
Clips:	Sample fastened to aluminium buck with 75 mm (2.95") aluminium clips, one clip every 300 mm (11.81") each clip snaps into sample frame and fastened to aluminium buck with one #12x1" self-tapping pan head screw.
Sealant:	Interior and exterior perimeter sealed with flexible sealant
Glazing Type:	Dual glazed, tempered, glass thickness, 6 mm (0.24"), overall thickness 25.4 mm (1.00"), gap thickness, 13.4 mm (0.52"), argon gas fill
Glazing Method:	Laid in, dry glazed
Glazing Stop:	PVC, interior perimeter
Heel Bead:	Flexible sealant, interior perimeter full perimeter
Setting Block:	Plastic, eight, 100 mm x 25 mm x 6 mm (3.94" x 0.98" x 0.24"), two per glazing cavity, 200 mm (7.87") from the ends
Tape:	Butyl tape, exterior perimeter
Reinforcement:	None
Thermal Break:	Extruded PVC, one per aluminum frame and sash member

Photo 1: Window Wall Mock-Up

3.0 TEST METHODS

Test performed in accordance to the following standard test method, specific test criteria taken as reference from AAMA/WDMA/CSA 101/1.S.2/A440-17 as directed by the client

ASTM E283-04(2012)	*"Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Window Walls, and Doors Under Specified Pressure Differences Across the Specimen"*
ASTM E331-00(2016)	*"Standard Test Method for Water Penetration of Exterior Windows, Window Walls, and Doors by Uniform Static Air Pressure Difference"*
ASTM E547-00(2016)	*"Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Window Walls by Cyclic Static Air Pressure Difference"*
ASTM E330/E330M-14*	*"Standard Test Method for Structural Performance of Exterior Windows, Doors, Skylights and Window Walls by Uniform Static Air Pressure Difference"*

**For Uniform Load testing the sample was broken into an upper and lower portion to better simulate a rigid slab between floors. The Upper portion included the bypass*

4.0 TEST RESULTS

Table 1 – Window Wall Mock-Up
Element Specimen No.: 23-06-B0008-2
Test Specimen Size: 1765 mm x 5345 mm (69.49" x 210.43")

<table>
<tr><th>Test</th><th colspan="2">Client Requirements</th><th colspan="2">Results</th></tr>
<tr><td rowspan="4">Air Leakage Resistance
ASTM E283
Test Date:
January 30, 2023</td><td colspan="2">Allowable rate of air leakage shall be less than or equal to the following, L/s.m² (cfm/ft²), at the subsequent test pressure:</td><td colspan="2">Test area, m² (ft²): 9.4 (101.55)</td></tr>
<tr><td>Test Pressure, Pa (psf):</td><td>300 (6.27)</td><td colspan="2">Measured Air Leakage Rate, L/s.m² (cfm/ft²):</td></tr>
<tr><td rowspan="2">Canadian A3 Level:</td><td rowspan="2">0.5 (0.10)</td><td>Infiltration:</td><td>0.2 (0.04)</td></tr>
<tr><td>Exfiltration:</td><td>0.2 (0.05)</td></tr>
<tr><td rowspan="2">Static Water Penetration Resistance
ASTM E331
Test Date:
January 30, 2023</td><td colspan="2" rowspan="2">No water leakage shall be observed at the following specified static pressure differential, Pa (psf):</td><td colspan="2">No water leakage was observed at the following specified pressure differential, Pa (psf):</td></tr>
<tr><td>Test Pressure</td><td>720 (15.04)</td></tr>
<tr><td rowspan="2">Cyclic Water Penetration Resistance
ASTM E547
Test Date:
January 30, 2023</td><td colspan="2" rowspan="2">No water leakage shall be observed at the following specified cyclic static pressure differential, Pa (psf):</td><td colspan="2">No water leakage was observed at the following specified pressure differential, Pa (psf):</td></tr>
<tr><td>Test Pressure</td><td>720 (15.04)</td></tr>
</table>

Table 2 – Window Wall Mock-Up – Lower Portion Element Specimen No.: 23-06-B0008-2L Test Specimen Size: 1765 mm x 2245 mm (69.49" x 88.39")				
Test	**Test Criteria**			**Result**
Uniform Load Deflection *Per ASTM E330* **Test Date:** February 9, 2023	The deflection of the longest unsupported span must be measured and reported at the following specified test pressure, Pa(psf):	Measured net deflection of vertical mullion, mm (in):		**PASS**
	Allowable deflection, mm (in): Report Only	Span: 2245 (88.39)		
	Test Pressure: ±2880 (60.15)	Positive:	7.1 (0.28)	
		Negative:	-7.1 (-0.28)	
Uniform Load Structural (Clause 9.3.4.3) *Per ASTM E330* **Test Date:** February 9, 2023	There shall be no permanent damage to the window components after the following specified test pressures, Pa (psf). No member shall have permanent deflect more that 0.4% of span.	Measured net deflection of vertical mullion, mm (in):		**PASS**
	Allowable permanent deflection, mm (in): 9.0 (0.35)	Span: 2245 (88.39)		
	Test pressure: ±4320 (90.23)	Positive:	3.8 (0.15)	
		Negative:	-8.8 (-0.35)	

Table 3 – Window Wall Mock-Up – Upper Portion Element Specimen No.: 23-06-B0008-2U Test Specimen Size: 1765 mm x 3100 mm (69.49" x 122.05")				
Test	**Test Criteria**			**Result**
Uniform Load Deflection *Per ASTM E330* **Test Date:** February 9, 2023	The deflection of the longest unsupported span must be measured and reported at the following specified test pressure, Pa(psf):	Measured net deflection of vertical mullion, mm (in):		**PASS**
	Allowable deflection, mm (in): Report Only	Span: 3100 (122.05)		
	Test Pressure: ±1920 (40.10)	Positive:	15.8 (0.62)	
		Negative:	-16.1 (-0.64)	
Uniform Load Structural *Per ASTM E330* **Test Date:** February 9, 2023	There shall be no permanent damage to the window components after the following specified test pressures, Pa (psf). No member shall have permanent deflect more that 0.4% of span.	Measured permanent deflection of vertical mullion, mm (in):		**PASS**
	Allowable permanent deflection, mm (in): 12.4 (0.49)	Span: 3100 (122.05)		
	Test pressure: ±2880 (60.15)	Positive:	0.1 (0.04)	
		Negative:	-0.1 (-0.04)	

5.0 CONCLUSION

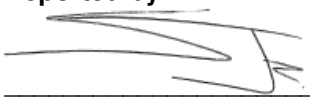
Element has conducted Air Leakage Rate, Water Penetration Resistance, and Uniform Load testing of a Window Wall system, "500 RS Series Thermally Broken Aluminum Windows", in reference to the listed standards and results are contained herein.

Note: This report is re-issued in the name of Zenith Aluminum Systems Ltd., through written authorization from Falbo Aluminum Systems Ltd., to whom the original report was released. Element Original Report No.: 23-06-B0008-2A (Dated: September 21, 2023).

6.0 REPORT REVISION SUMMARY

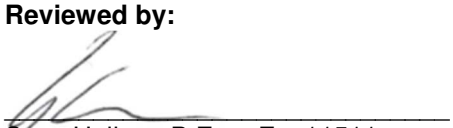
Revision No:	**Date:**	**Description of Revisions:**
23-06-B0008-2A	September 21, 2023	Original Document
23-06-B0008-2B	September 27, 2023	Report reissued to: **Zenith Aluminum Systems Ltd.**

Reported by:



Emmanuel Siapno, Ext. 10292
Testing Technician, Building Systems
Building Science Division

Reviewed by:



Scott Hallam, B.Eng. Ext 11511
Building Systems Specialist, Building Systems
Building Science Division

Appendix A

Manufacturers Detail Drawings

31 Pages

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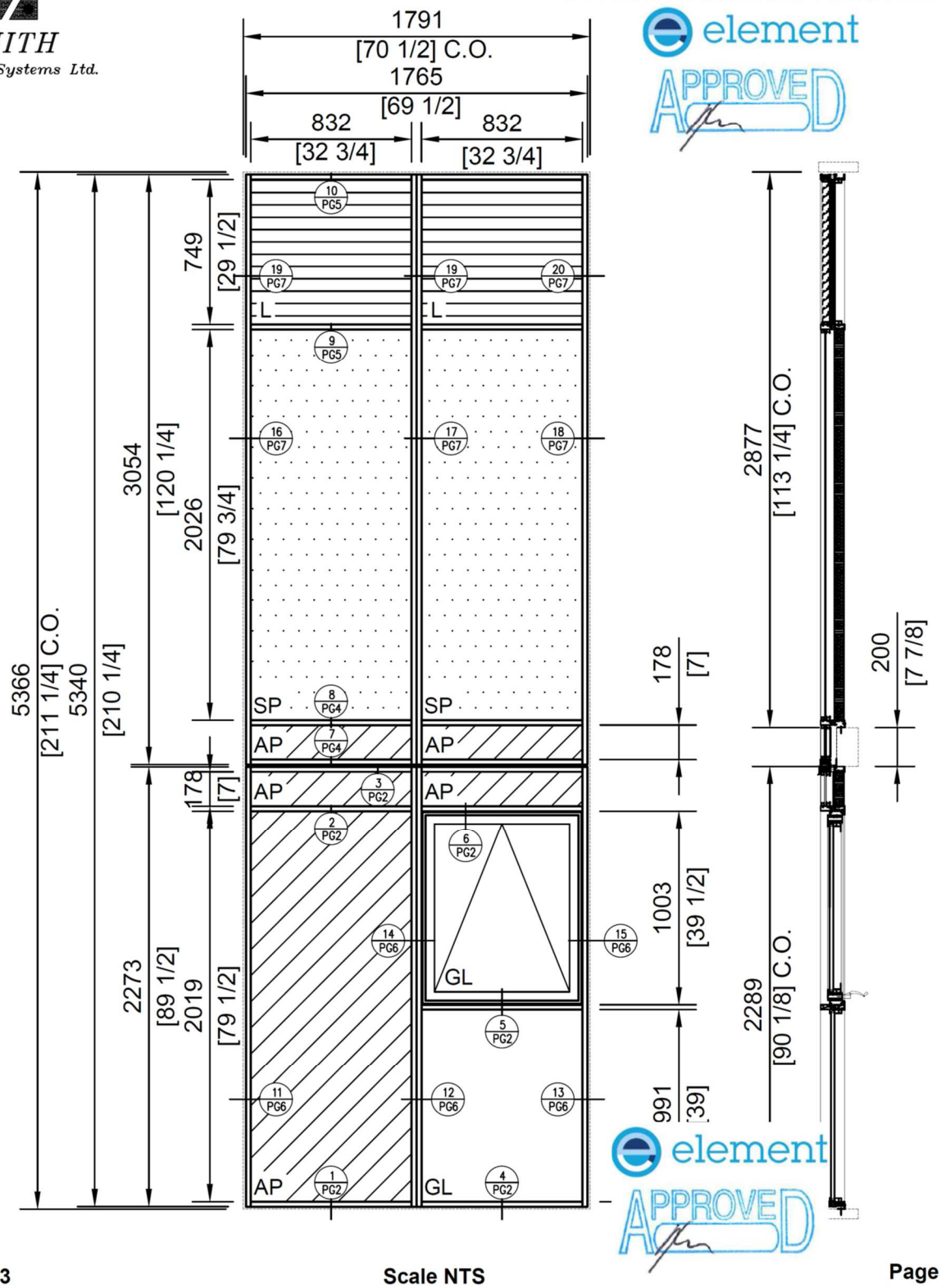
WINDOW WALL / SLAB BYPASS

500 RS Series, Thermally Broken Aluminum Windows



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WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows

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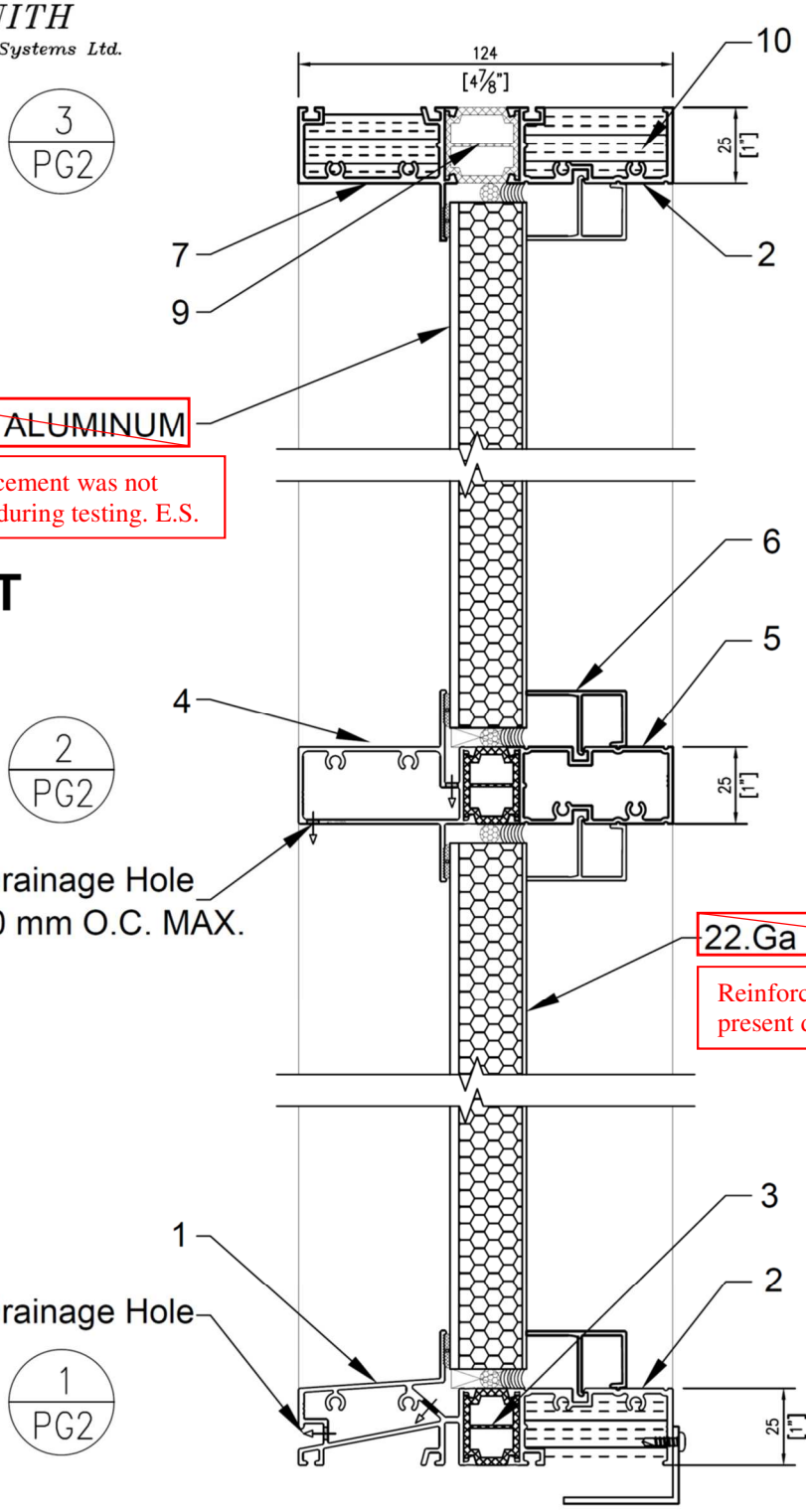
Aluminum Systems Ltd.



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July, 2023 Scale NTS Page 2

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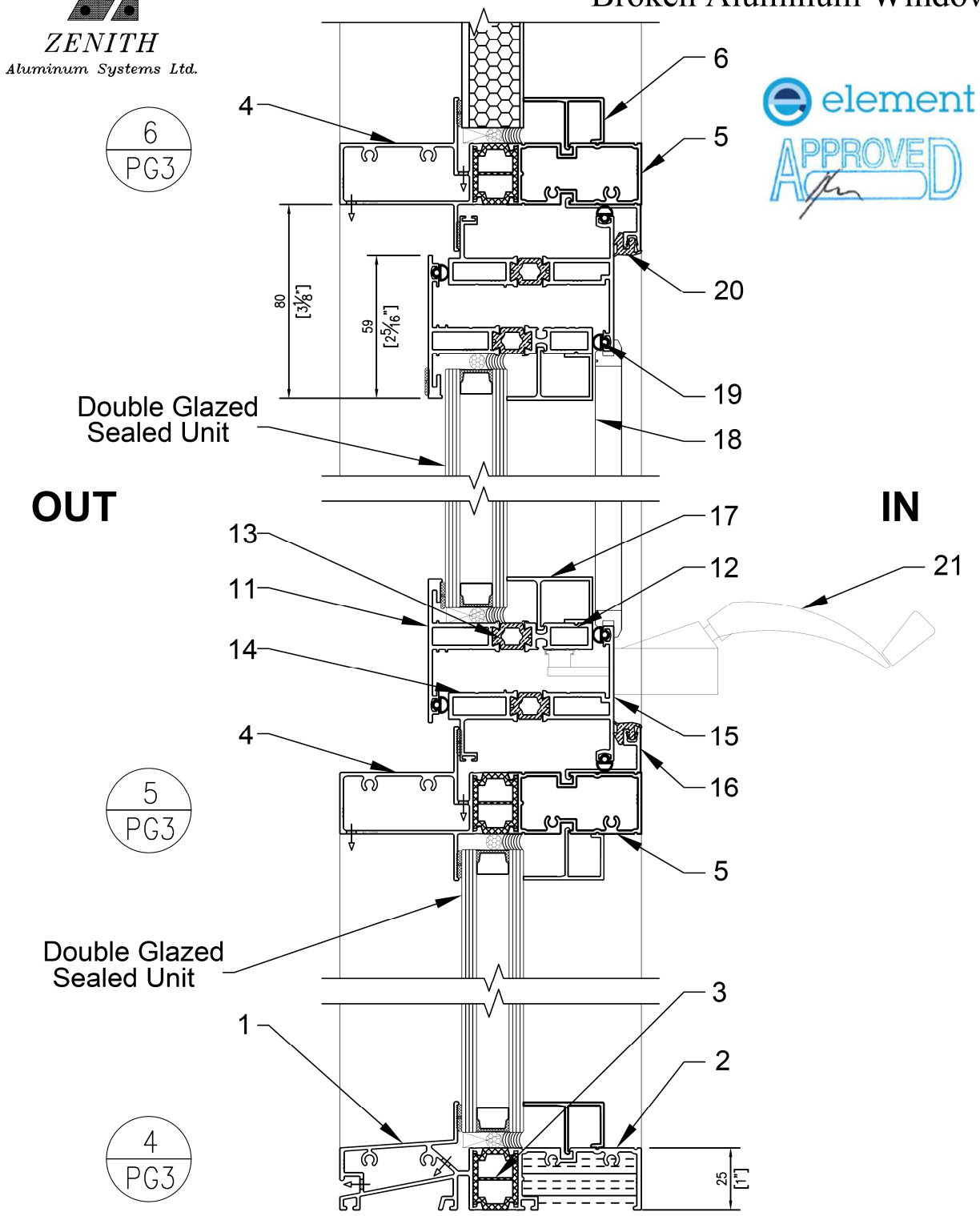
WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows



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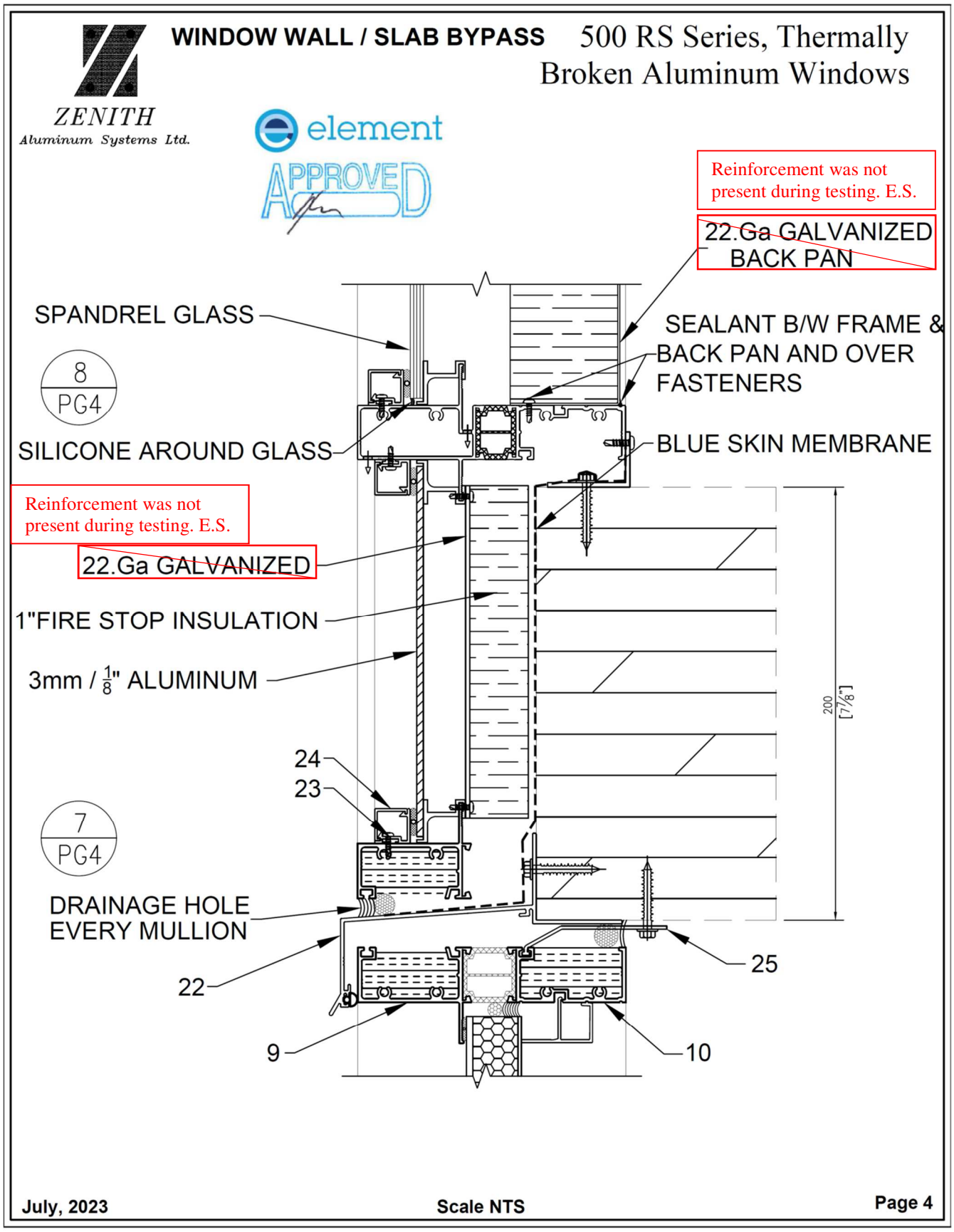
July, 2023 **Scale NTS** **Page 3**


WINDOW WALL / SLAB BYPASS
500 RS Series, Thermally Broken Aluminum Windows
ZENITH
Aluminum Systems Ltd.
element
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Reinforcement was not present during testing. E.S.
22.Ga GALVANIZED BACK PAN
SPANDREL GLASS
SEALANT B/W FRAME & BACK PAN AND OVER FASTENERS
8
PG4
SILICONE AROUND GLASS
BLUE SKIN MEMBRANE
Reinforcement was not present during testing. E.S.
22.Ga GALVANIZED
1"FIRE STOP INSULATION
3mm / 1/8" ALUMINUM
200 [7⅞"]
24
23
7
PG4
DRAINAGE HOLE EVERY MULLION
22
25
9
10
July, 2023
Scale NTS
Page 4

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WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows

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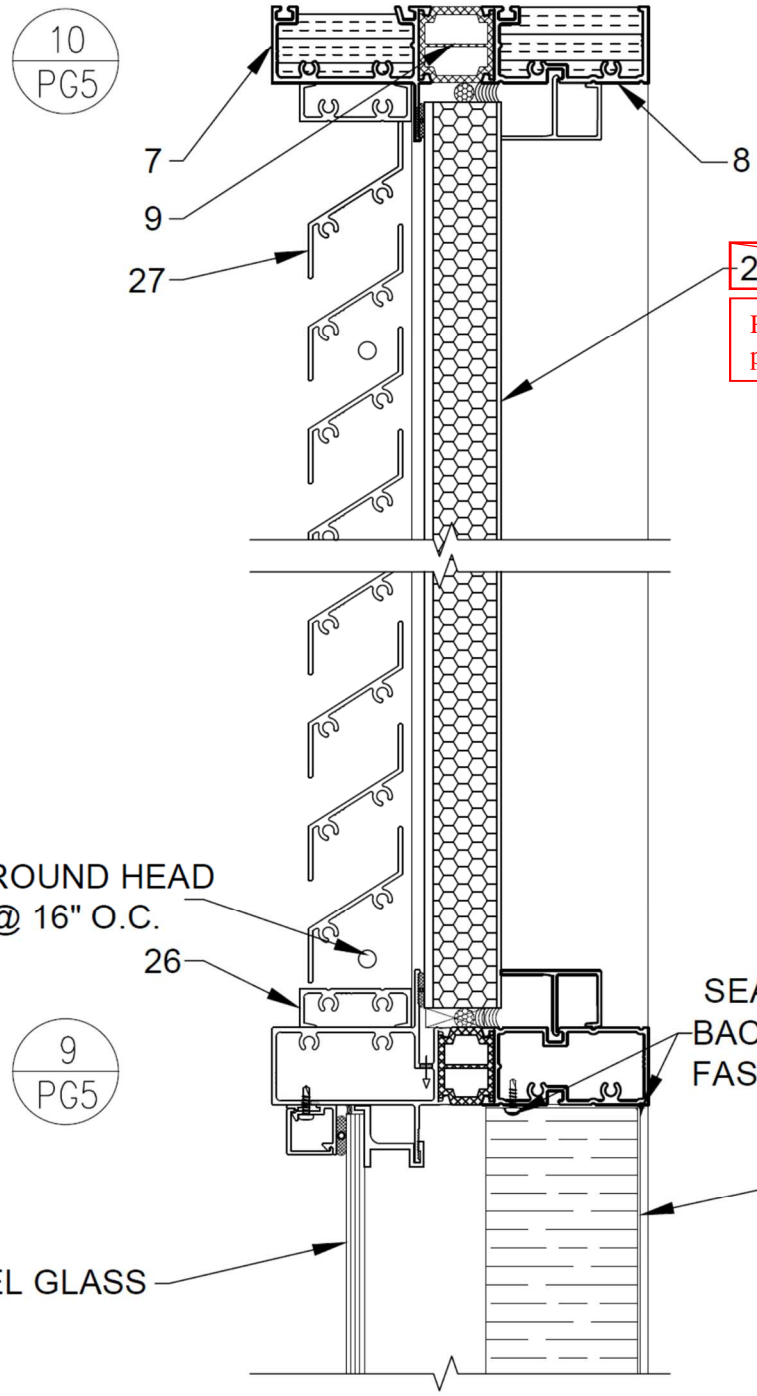

July, 2023 Scale NTS Page 5

WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows

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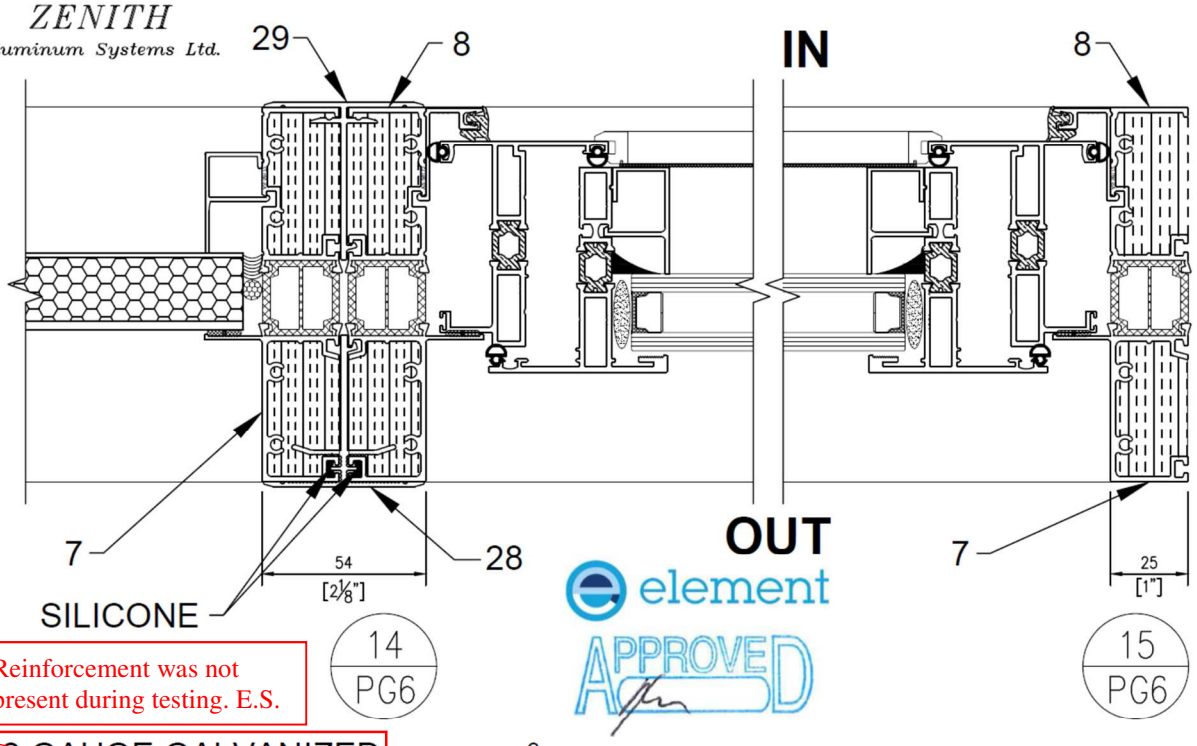

element
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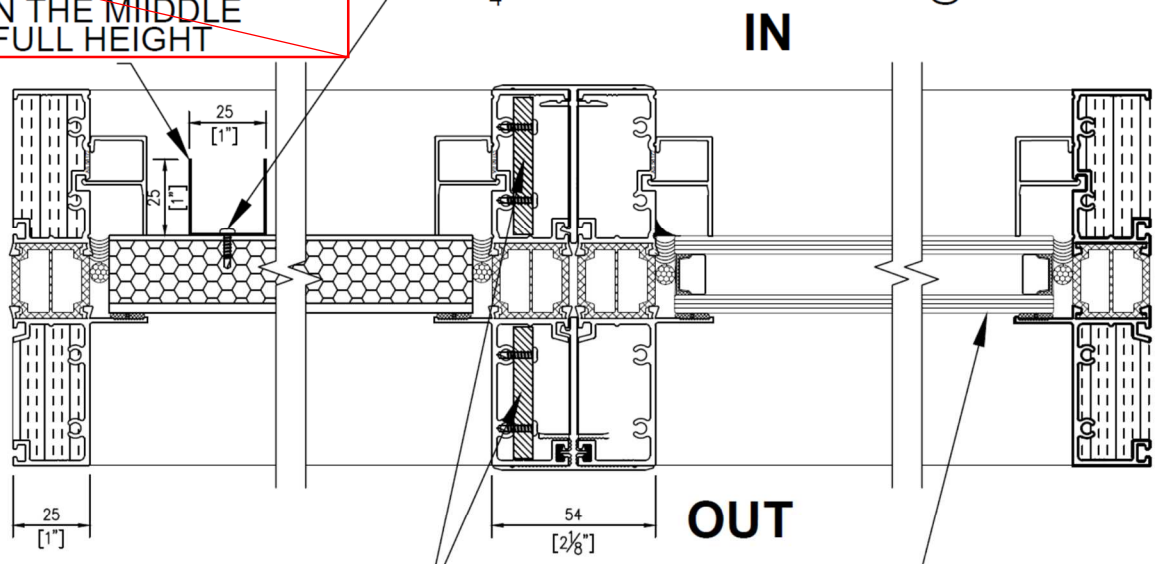
Reinforcement was not present during testing. E.S.

22 GAUGE GALVANIZED IN THE MIDDLE FULL HEIGHT

#8 x ¾" SELF TAPPING SCREW @12" O.C.



¼" STEEL REINFORCEMENT

Double Glazed Sealed Unit

11 PG6

Reinforcement was not present during testing. E.S.

12 PG6

13 PG6

July, 2023 Scale NTS Page 6

WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows

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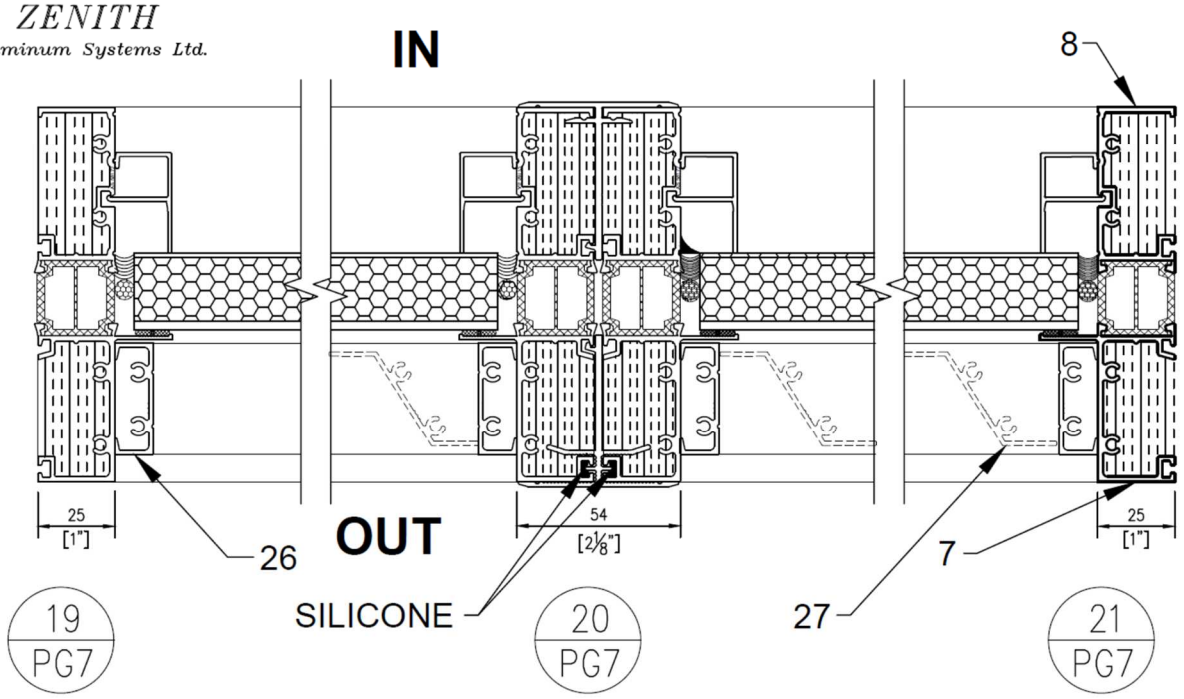

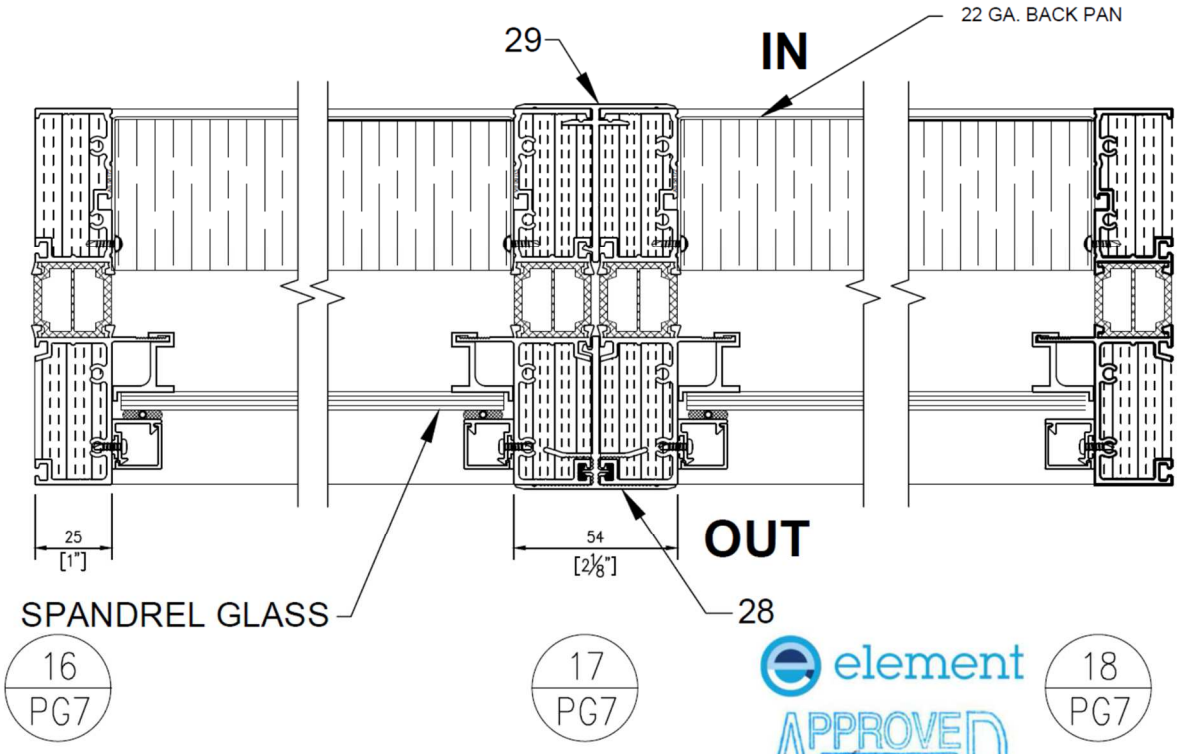

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July, 2023 **Scale NTS** **Page 7**

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WINDOW WALL / SLAB BYPASS 500 RS Series, Thermally Broken Aluminum Windows

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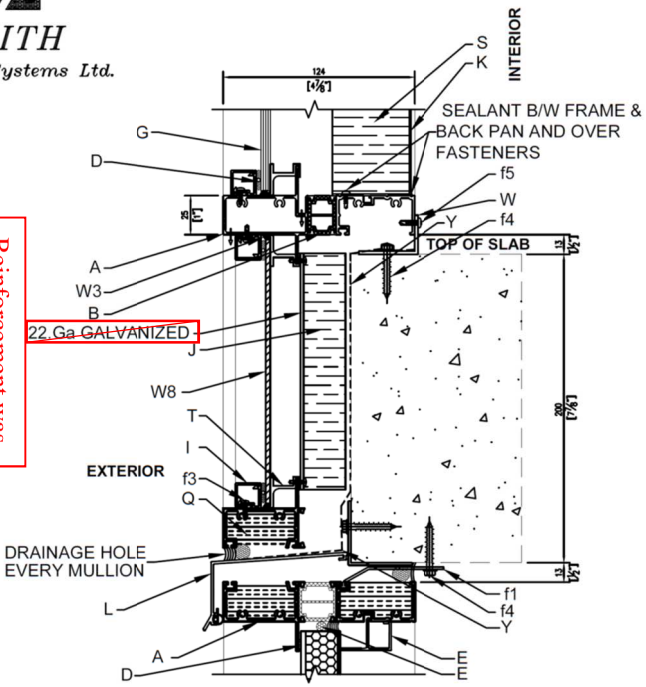
No.	Die No.	Description	Supplier
8	AS58174	Fixed Exterior Male Frame	Hydro Extrusion
2	AS58172	Fixed Interior Male Frame	Hydro Extrusion
4	AH70355	Exterior Mullion with Drainage	Hydro Extrusion
5	AH58170	Interior Mullion	Hydro Extrusion
1	AH70354	Exterior Base Drainage	Hydro Extrusion
6	V630	PVC Glass Stop -for Fixed	Hydro Extrusion
14	AH65002	Awning Exterior Frame	Hydro Extrusion
15	AH64950	Awning Interior Frame	Hydro Extrusion
11	AH65093	Awning Exterior Sash	Hydro Extrusion
12	AH64957	Awning Interior Sash	Hydro Extrusion
16	AH65747	Awning Interior Closure	Hydro Extrusion
	AS65136	Awning Corner Key	Hydro Extrusion
18		Awning Screen	Nap
17	V-731	PVC Glass Stop -for Awning	Rollaway
21		Awning Roto Operator	Nap
		Awning Hinges	Nap
9	V-706	Perimeter Thermal Break	Vinyl Profiles
3	V-707	Mullion thermal Break	Vinyl Profiles
13	V-708	Awnings Thermal Break	Vinyl Profiles
20	V-701	Awning Interior Gasket	Vinyl Profiles
19	V-44	Awning Bulb	Vinyl Profiles
24	AS 5647	Exterior 2-Parts Stop	Hydro Extrusion
23	AS 5646	Interior 2-Parts stop Base	Hydro Extrusion
27	AS 57050	Ext Louver Fin.	Hydro Extrusion
26	AS 56978	Ext Louver Main Frame.	Hydro Extrusion
28	AS 61066	Exterior H - Bar	Hydro Extrusion
29	AS 61077	Interior H -Bar	Hydro Extrusion
21	AS 68201	Head Sill	Hydro Extrusion

ZENITH
Aluminum Systems Ltd.

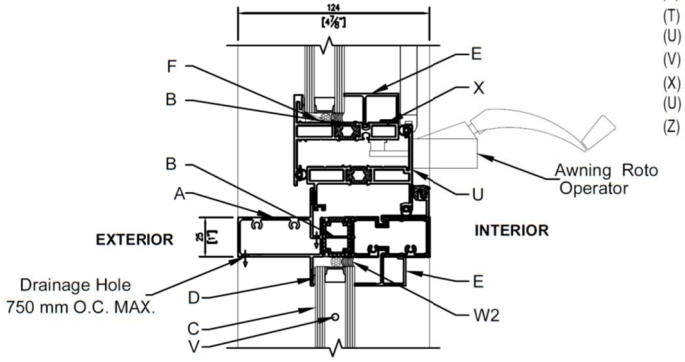
WINDOW WALL / SLAB BYPASS

500 RS Series, Thermally Broken Aluminum Windows

Reinforcement was not present during testing. E.S.



VERTICAL CROSS SECTION



VERTICAL CROSS SECTION

GENERAL NOTES:–

(A) WINDOWS:– Zenith 500 SERIES Thermally Broken Alum. Section Size: 124 x 25 (4 7/8" x 1")
MATERIAL: Extruded Alum. Shapes 6063–T6 Architectural Manufacturer's Association

(B) THERMAL BREAK: Rigid Extruded PVC.

(C) INSULATING GLASS:–
Double Glazed Thermo Pane Sealed Insulating Units (25mm) conforms to CAN/CGSB–12.8–M90
Primary Seal – TRUSEAL JS780
Secondary Seal – Silicone Sealant
Exterior Glazing:– 6mm Clear
Interior Glazing:– 6mm Clear
Note: glass below 1070 mm tempered on inside
Spacer:– Warm Edge Spacer Tubular Frame c/w Seals – 17mm Argon Space and Spacer

(D) GLAZING TAPE: 1/16" Type A440 Tape (Tremco)

(E) GLASS STOP: Extruded Vinyl – Snap On type (Colour to match Frame)

(F) SETTING BLOCKS: Tremco 80 EPDM Hardness: 80 Shore"A"

(G) SPANDREL GLASS:– 6mm Temperd

(H) GLAZING TAPE: 1/16" Type A440 Tape (Tremco)

(I) Spandrel Glass Stop:– Ext. Alum. Stop Base mill finish

(J) Fire Stopping Roxul RockBoard 35 1–1/2" thick

(K) BACKPAN: 22 ga. Galv. Steel c/w Sealant

(L) FLASHING: 1.5mm Extruded Alum.

(M) H–BAR: 1.5mm Extruded Alum.

(N) CAULKING: Tremco Tremsill 600

(O) CAULKING: Temco Dymeric

(P) SEALANT: Tremco 830

(Q) INSULATION: Styrofoam Insulation

(R) INSULATION: Foam Insulation

(S) INSULATION: Roxul RockBoard 2" thick

(T) SPANDREL GLASS SPACER: EXTRUDED PVC

(U) Alum. Closure

(V) HOLES: 6 mm Dia. VENT HOLES in Vertical Frame

(X) Awning Sash

(U) Awning Frame

(Z) HOLES:

(W) Alum. Angle – 1" x 1 1/2" x 1/8"

(w1) Alum. Angle – 6mm Dia. Drain Holes in Vertical Mullion

(W2) Heel Bead Backer Rod for Sealant to clear of Hole

(W3) Sealant Silicone at perimeter of spandrel glass

(W4) Spacer Extruded PVC perimeter of spandrel glass

(W5) Backpan 22 ga. Galv. Steel

(W6) Weep hole 25 mm x 6mm Weep Holes at @ of Vertical Mumion

(W7) Alum. Angle – 2" x 3" x 1/4" WINDOW SUPPORT

(W8) Alum. Panel – 3mm (1/8") thick finish

(W9) Silicone – Perimeter of aluminum panel and window frame

(Y) AIR/VAPOUR BARRIER Membrane – Blue Skin c/w Primer & Mastic Sealant Fit over Flashing, Edge & Top of Slab & over back of Window Frame & at Jambs & Sills

FASTENERS: (All Screws to be Corrosion Resistant) zinc or climaseal coating

(f1) Deflection Strap @ Head:– 1/16' x 3" x 3"Extruded Alum. 18" ctrs. max. (Min. 2 per Frame) (4 per 48 " Frame)

(f2) #8 RH Self Drill Screws x 3/4" butter with silicone

(f3) #8 RH Self Drill Screws x 3/4" butter

(f4) 1/4" Dia. x 2" Hex Head Stitch Tapcon Screw @ 12" o/c

(f5) #12 HH Self Drill Screws x 1" @ 12" o/c min. bite 1/4" between Alum. Angle. "w" and base of windows frame

Reinforcement was not present during testing. E.S.

General Specifications of Windows & Window Wall:–

Performance Evaluation Performed in Accordance with: AAMA/WDMA/CSA101/I.S.2/A440–110 & CSA 440S1–11
Overall Performance Rating Class CW – PG70

(i) Ontario Building Code (2012)
(ii) CAN/CSA–A440–05 for Windows
(iii) CAN/CSA–S157–05/S157.1–05 for Aluminum
(iv) CAN/CGSB–12.8–97 for Glass
(v) CAN/CGSB–12.9–M91 for Spandrel Glass
(vi) Window Ratings:– A3, B7, C5
(vii) Forced Entry Resistance – F20
(viii) Temperature Index Rating – I = 65.2

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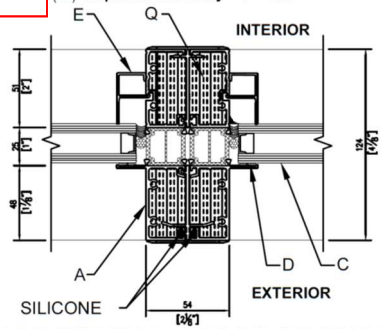
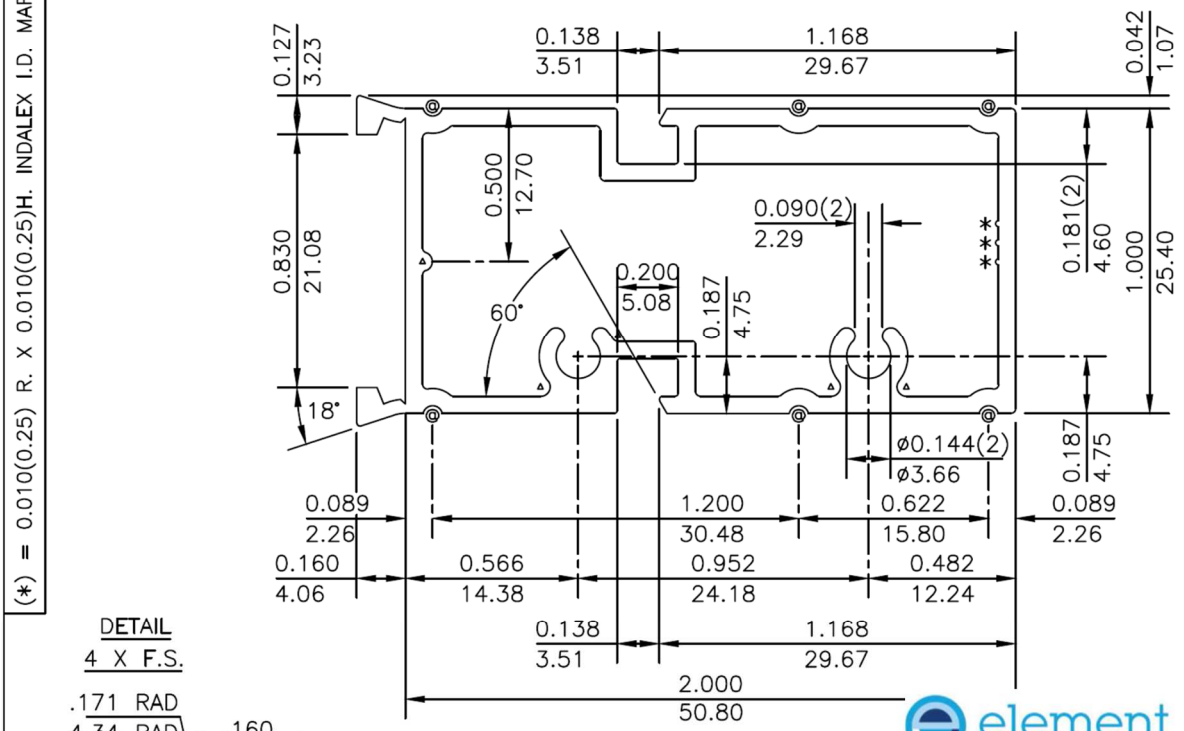


HORIZONTAL CROSS SECTION

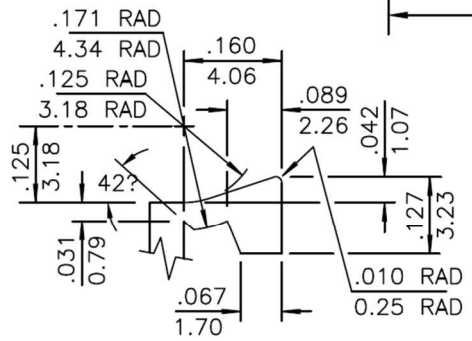
element

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO	–	AH–58170	1
DESCRIPTION: –	TARRIF# 7604.21.00.00	PROPOSAL# 14092–9	
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		

(*) = 0.010(0.25) R. X 0.010(0.25)H. INDALEX I.D. MARKS



DETAIL
4 X F.S.



(@) = 0.032(0.80) X 0.025(0.64) R. (6)
(^) = 0.031(0.79) R. (4)
UNMARKED RADII = RADIUS TO SUIT

element

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ACTUAL SIZE

EXPOSED SURFACE

INDALEX ALUMINUM SOLUTIONS

UNSPECIFIED WALL THICKNESS ±.008 ±0.20 0.056(1.42)

EST. AREA 0.459 IN² 296 MM²		OUT PER. 7.947 IN 202 MM	
EST. WT. 0.550 LBS/FT. 0.819 KG/M		FACTOR 28	
EST. PER. 15.327 IN 389 MM		C.C.D. 2.399 IN 61 MM	
DWN BY	ALLOY 6063–T5	SCALE 2:1	DATE 07/05/03

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

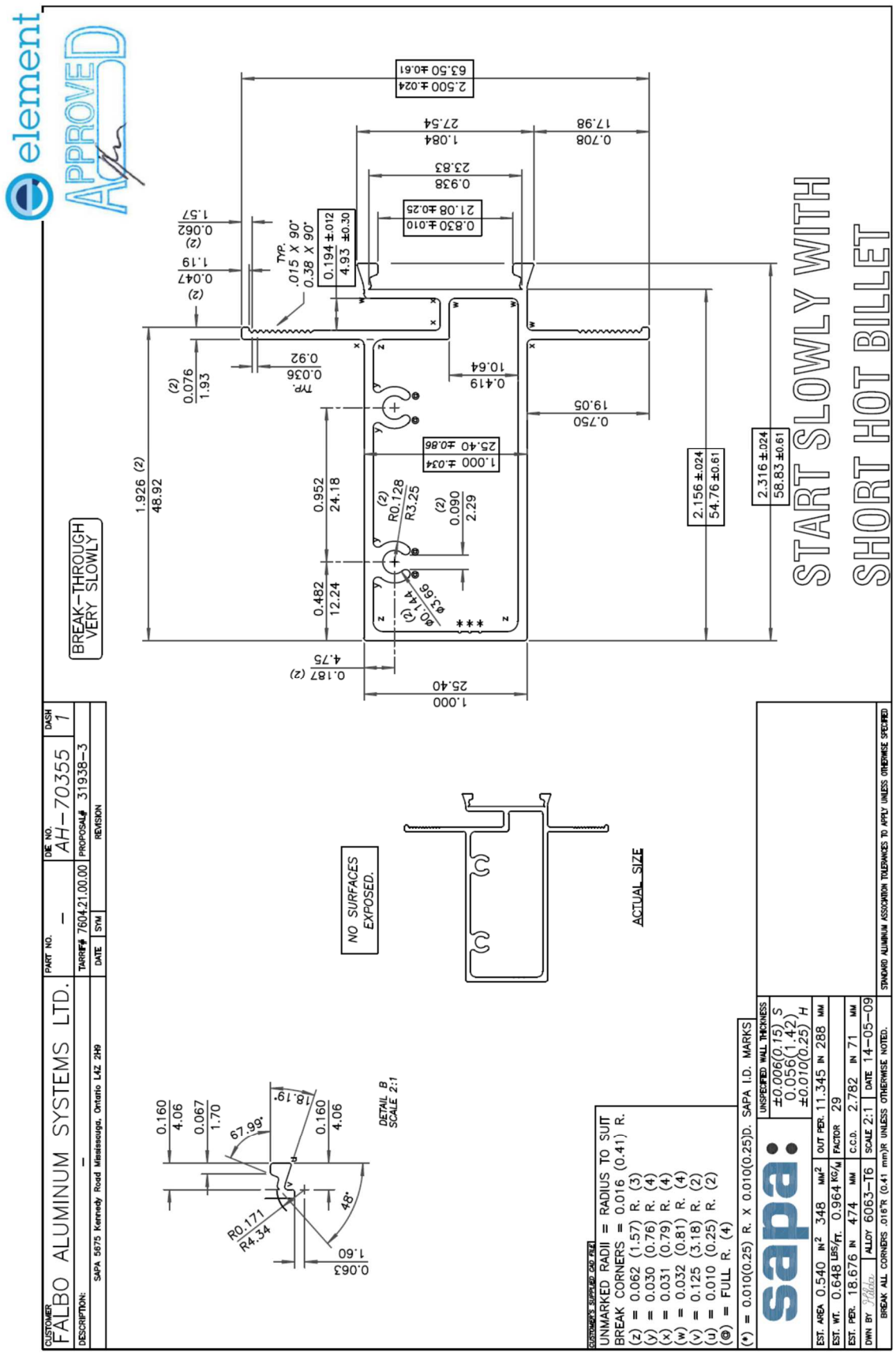
SAMPLE APPROVAL

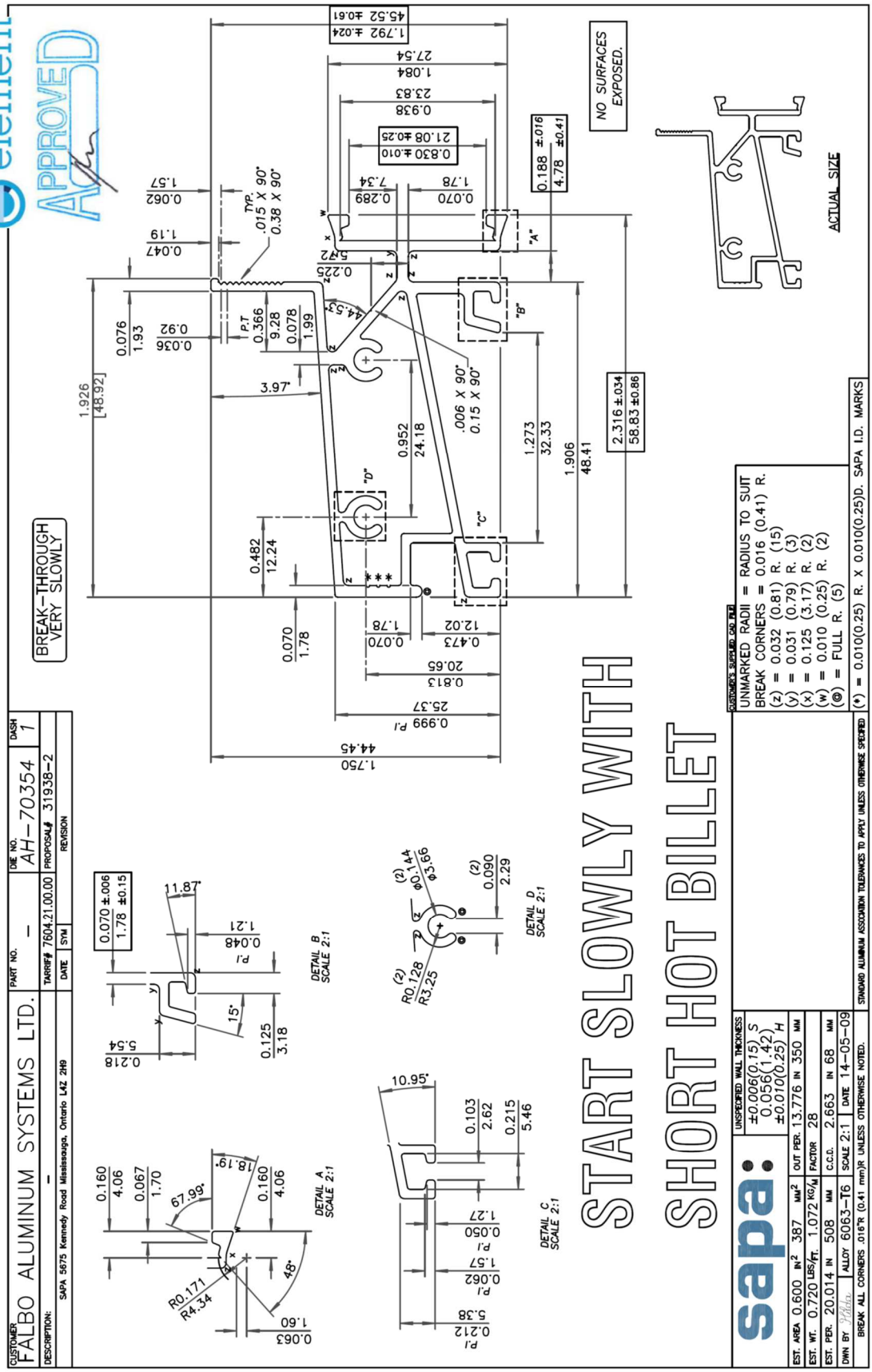
THIS SAMPLE IS APPROVED
AND INDALEX LIMITED
MAY PROCEED WITH PRODUCTION

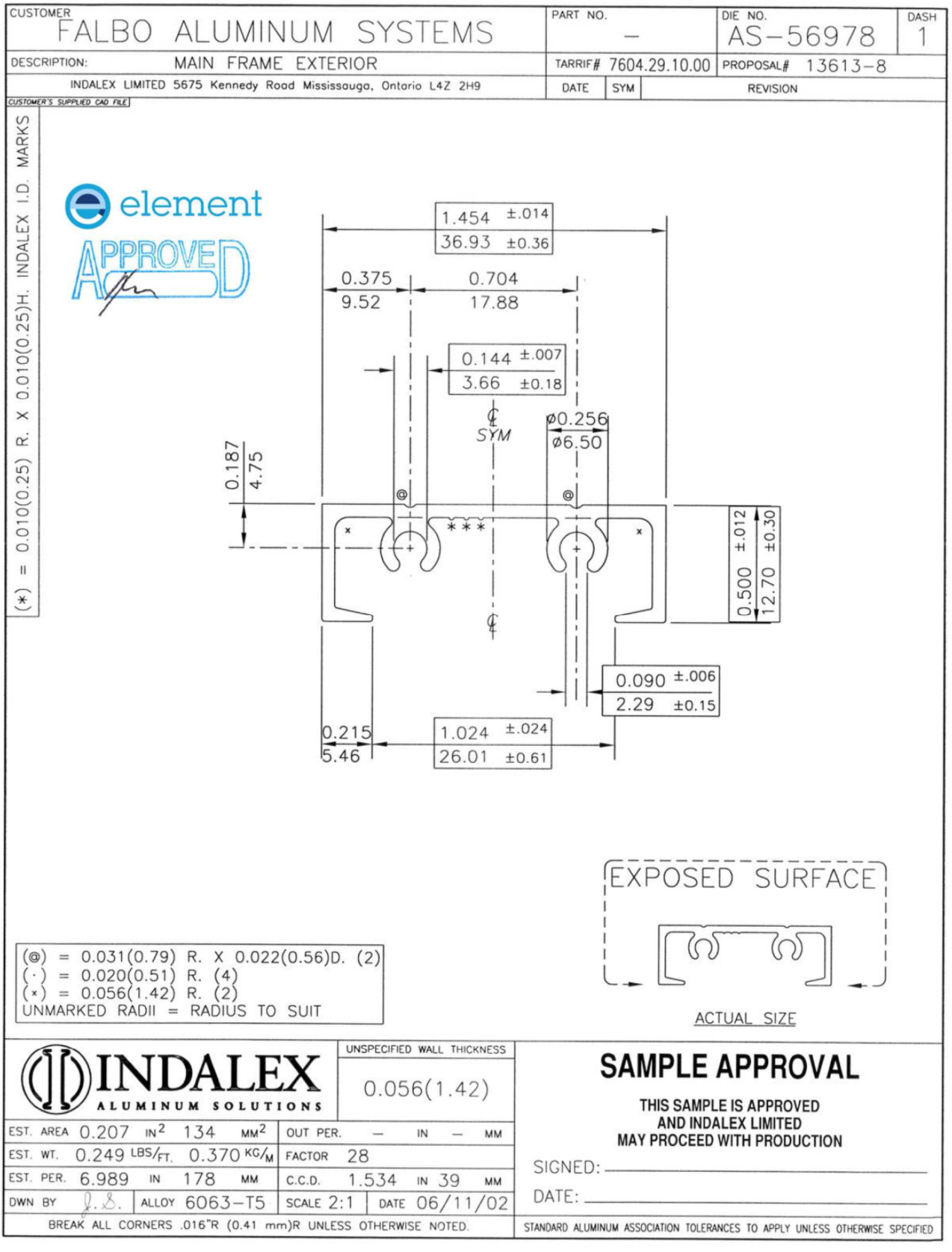
SIGNED: _____

DATE: _____

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED


element
APPROVED
CUSTOMER: FALBO ALUMINUM SYSTEMS LTD.
PART NO. –
DIE NO. AH–70355
DASH 1
DESCRIPTION: –
TARIFF# 7604.21.00.00
PROPOSAL# 31938–3
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE
SYM
REVISION
BREAK–THROUGH VERY SLOWLY
START SLOWLY WITH SHORT HOT BILLET
NO SURFACES EXPOSED.
ACTUAL SIZE
DETAIL B SCALE 2:1
UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.016 (0.41) R.
(z) = 0.062 (1.57) R. (3)
(y) = 0.030 (0.76) R. (4)
(x) = 0.031 (0.79) R. (4)
(w) = 0.032 (0.81) R. (4)
(v) = 0.125 (3.18) R. (2)
(u) = 0.010 (0.25) R. (2)
(e) = FULL R. (4)
(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA I.D. MARKS
UNSPECIFIED WALL THICKNESS
±0.006(0.15) S
0.056(1.42)
±0.010(0.25) H
sapa:
EST. AREA 0.540 IN² 348 MM² OUT PER. 11.345 IN 288 MM
EST. WT. 0.648 LBS/FT. 0.964 KG/M FACTOR 29
EST. PER. 18.676 IN 474 MM C.C.D. 2.782 IN 71 MM
DWN BY Mike ALLOY 6063–T6 SCALE 2:1 DATE 14–05–09
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED


element
APPROVED
CUSTOMER FALBO ALUMINUM SYSTEMS LTD.
PART NO. –
DIE NO. AH–70354
DASH 1
DESCRIPTION: –
TARRIF# 7604.21.00.00
PROPOSAL# 31938–2
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE
SYM
REVISION
BREAK–THROUGH VERY SLOWLY
START SLOWLY WITH
SHORT HOT BILLET
NO SURFACES EXPOSED.
ACTUAL SIZE
UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.016 (0.41) R.
(z) = 0.032 (0.81) R. (15)
(y) = 0.031 (0.79) R. (3)
(x) = 0.125 (3.17) R. (2)
(w) = 0.010 (0.25) R. (2)
(●) = FULL R. (5)
(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA I.D. MARKS
sapa
UNSPECIFIED WALL THICKNESS
±0.006(0.15) S
0.056(1.42)
±0.010(0.25) H
EST. AREA 0.600 IN² 387 MM² OUT PER. 13.776 IN 350 MM
EST. WT. 0.720 LBS/FT. 1.072 KG/M FACTOR 28
EST. PER. 20.014 IN 508 MM C.C.D. 2.663 IN 68 MM
DWN BY Falbo ALLOY 6063–T6 SCALE 2:1 DATE 14–05–09
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED
DETAIL A SCALE 2:1
DETAIL B SCALE 2:1
DETAIL C SCALE 2:1
DETAIL D SCALE 2:1

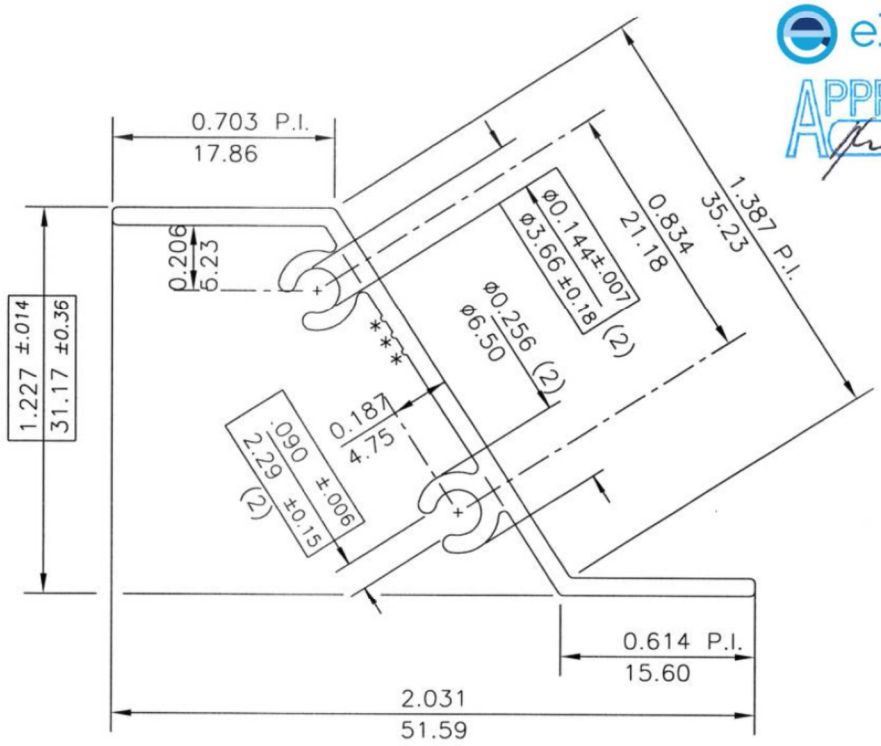

CUSTOMER
FALBO ALUMINUM SYSTEMS
PART NO. –
DIE NO. AS–56978
DASH 1
DESCRIPTION: MAIN FRAME EXTERIOR
TARRIF# 7604.29.10.00
PROPOSAL# 13613–8
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE SYM REVISION
CUSTOMER'S SUPPLIED CAD FILE
(*) = 0.010(0.25) R. X 0.010(0.25)H. INDALEX I.D. MARKS
element
APPROVED
1.454 ±.014
36.93 ±0.36
0.375
9.52
0.704
17.88
0.144 ±.007
3.66 ±0.18
℄ SYM
ø0.256
ø6.50
0.187
4.75
0.500 ±.012
12.70 ±0.30
0.090 ±.006
2.29 ±0.15
0.215
5.46
1.024 ±.024
26.01 ±0.61
(@) = 0.031(0.79) R. X 0.022(0.56)D. (2)
(·) = 0.020(0.51) R. (4)
(×) = 0.056(1.42) R. (2)
UNMARKED RADII = RADIUS TO SUIT
EXPOSED SURFACE
ACTUAL SIZE
INDALEX
ALUMINUM SOLUTIONS
UNSPECIFIED WALL THICKNESS
0.056(1.42)
EST. AREA 0.207 IN² 134 MM² OUT PER. – IN – MM
EST. WT. 0.249 LBS/FT. 0.370 KG/M FACTOR 28
EST. PER. 6.989 IN 178 MM C.C.D. 1.534 IN 39 MM
DWN BY J.S. ALLOY 6063–T5 SCALE 2:1 DATE 06/11/02
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.
SAMPLE APPROVAL
THIS SAMPLE IS APPROVED
AND INDALEX LIMITED
MAY PROCEED WITH PRODUCTION
SIGNED:
DATE:
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

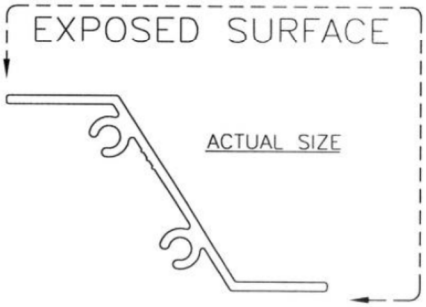
CUSTOMER	PART NO.	DIE NO.	DASH
FALBO ALUMINUM SYSTEMS	–	AS–57050	1
DESCRIPTION: Z–BAR	TARRIF# 7604.29.10.00	PROPOSAL# 13613–5A	
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		

CUSTOMER'S SUPPLIED CAD FILE

(*) = 0.010(0.25) R. X 0.010(0.25)H. INDALEX I.D. MARKS

element APPROVED





(·) = 0.020(0.51) R. (4)
UNMARKED RADII = RADIUS TO SUIT

INDALEX ALUMINUM SOLUTIONS

UNSPECIFIED WALL THICKNESS: 0.056(1.42)

EST. AREA 0.211 IN² 136 MM²	OUT PER. – IN – MM		
EST. WT. 0.253 LBS/FT. 0.376 KG/M	FACTOR 28		
EST. PER. 7.116 IN 181 MM	C.C.D. 2.360 IN 60 MM		
DWN BY J.S.	ALLOY 6063–T5	SCALE 2:1	DATE 06/11/02

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO	–	AS–58172	1
DESCRIPTION: –	TARRIF# 7604.29.10.00	PROPOSAL# 14092–11	
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		

(*) = 0.010(0.25) R. X 0.010(0.25)H. INDALEX I.D. MARKS

1.548 ±.026
39.32 ±0.66

0.327 8.31 | 0.103 2.62 | 0.112 2.84 | 0.125 3.18 | 0.070 1.78 | 0.042 1.07
0.127 3.23 | 0.218 5.54 | 0.500 12.70 | 0.830 21.08 | 0.070 1.78 | 0.090(2) 2.29 | 102° | 0.062 P.I. 1.57 | 1.000 25.40
60° | 0.200 5.08 | 0.187 4.75 | *** | 18° | 0.070 1.78 | ø0.144(2) ø3.66 | 0.187 4.75
0.089 2.26 | 1.200 30.48 | 0.622 15.80 | 0.089 2.26
0.160 4.06 | 0.566 14.38 | 0.952 24.18 | 0.482 12.24
0.138 3.51 | 1.168 29.67
2.000 50.80

DETAIL
4 X F.S.

.171 RAD 4.34 RAD | .160 4.06 | .089 2.26 | .042 1.07
.125 RAD 3.18 RAD | .125 3.18 | 42° | .127 3.23
.031 0.79 | .067 1.70 | .010 RAD 0.25 RAD

ACTUAL SIZE

EXPOSED SURFACE

(@) = 0.032(0.80) X 0.025(0.64) R. (3)
(▵) = 0.031(0.79) R. (4)
UNMARKED RADII = RADIUS TO SUIT

element APPROVED

INDALEX ALUMINUM SOLUTIONS

UNSPECIFIED WALL THICKNESS 0.056(1.42)

EST. AREA 0.402 IN² 259 MM²	OUT PER. – IN – MM		
EST. WT. 0.482 LBS/FT. 0.717 KG/M	FACTOR 24		
EST. PER. 11.800 IN 300 MM	C.C.D. 2.421 IN 61 MM		
DWN BY J.S.	ALLOY 6063–T5	SCALE 2:1	DATE 07/05/03

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

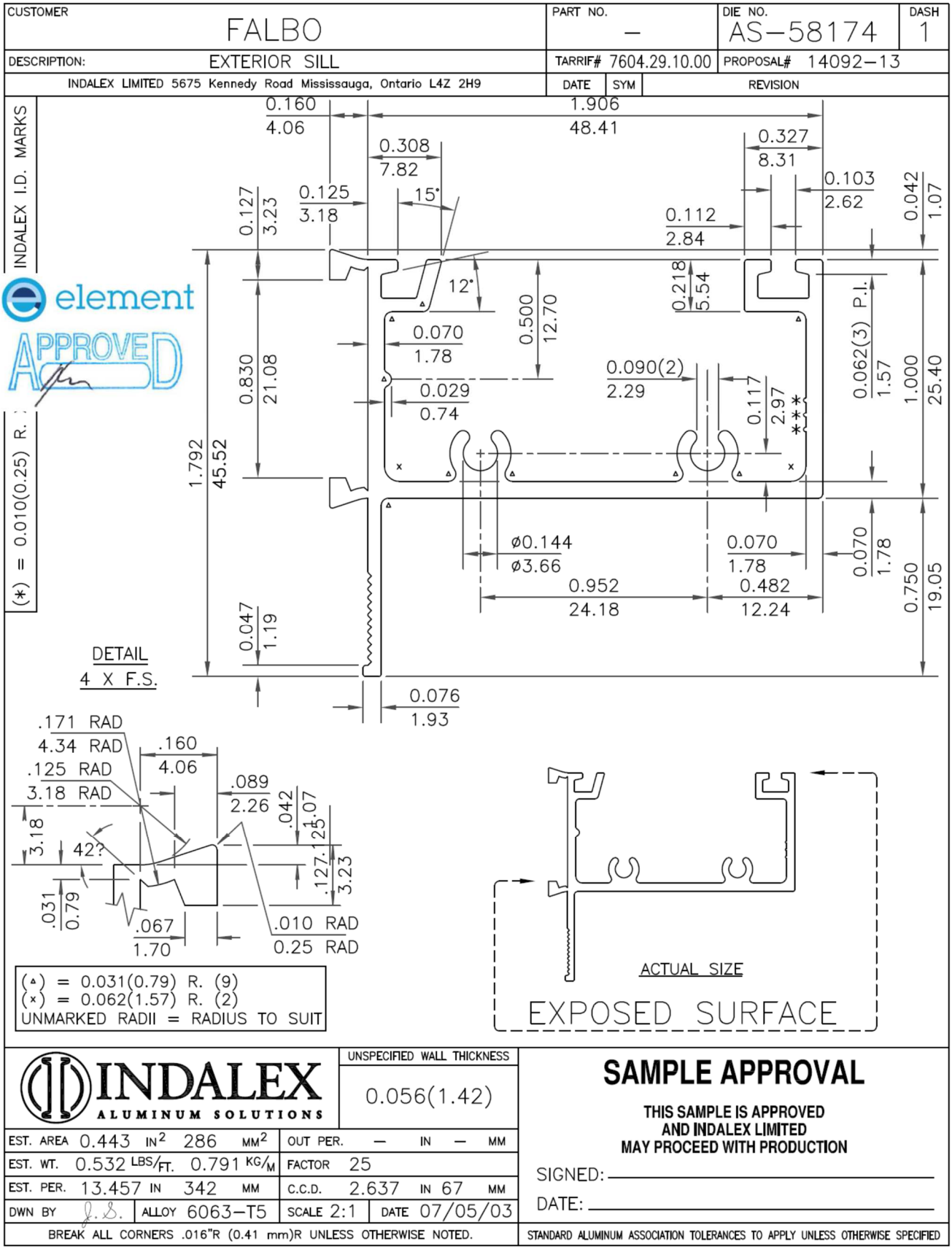
SAMPLE APPROVAL

THIS SAMPLE IS APPROVED
AND INDALEX LIMITED
MAY PROCEED WITH PRODUCTION

SIGNED: _____

DATE: _____

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED


CUSTOMER
FALBO
PART NO.
–
DIE NO.
AS–58174
DASH
1
DESCRIPTION:
EXTERIOR SILL
TARRIF# 7604.29.10.00
PROPOSAL# 14092–13
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE
SYM
REVISION
INDALEX I.D. MARKS
(*) = 0.010(0.25) R.
element
APPROVED
0.160
4.06
1.906
48.41
0.308
7.82
0.125
3.18
15°
0.127
3.23
0.327
8.31
0.103
2.62
0.042
1.07
0.112
2.84
0.218
5.54
12°
0.500
12.70
0.070
1.78
0.830
21.08
0.029
0.74
0.090(2)
2.29
0.117
2.97
***
0.062(3) P.I.
1.57
1.000
25.40
1.792
45.52
ø0.144
ø3.66
0.070
1.78
0.952
24.18
0.482
12.24
0.070
1.78
0.750
19.05
0.047
1.19
0.076
1.93
DETAIL
4 X F.S.
.171 RAD
4.34 RAD
.125 RAD
3.18 RAD
.160
4.06
.089
2.26
.042
1.07
.125
3.18
3.18
42°
.127
3.23
.031
0.79
.067
1.70
.010 RAD
0.25 RAD
(▵) = 0.031(0.79) R. (9)
(×) = 0.062(1.57) R. (2)
UNMARKED RADII = RADIUS TO SUIT
ACTUAL SIZE
EXPOSED SURFACE
INDALEX
ALUMINUM SOLUTIONS
UNSPECIFIED WALL THICKNESS
0.056(1.42)
EST. AREA 0.443 IN² 286 MM²
OUT PER. – IN – MM
EST. WT. 0.532 LBS/FT. 0.791 KG/M
FACTOR 25
EST. PER. 13.457 IN 342 MM
C.C.D. 2.637 IN 67 MM
DWN BY J.S.
ALLOY 6063–T5
SCALE 2:1
DATE 07/05/03
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.
SAMPLE APPROVAL
THIS SAMPLE IS APPROVED
AND INDALEX LIMITED
MAY PROCEED WITH PRODUCTION
SIGNED:
DATE:
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO ALUMINUM SYSTEMS	–	AS–61066	
DESCRIPTION: EXTERIOR H–BAR	TARRIF# 7604.29.10.00	PROPOSAL# 14823–4A	
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9			

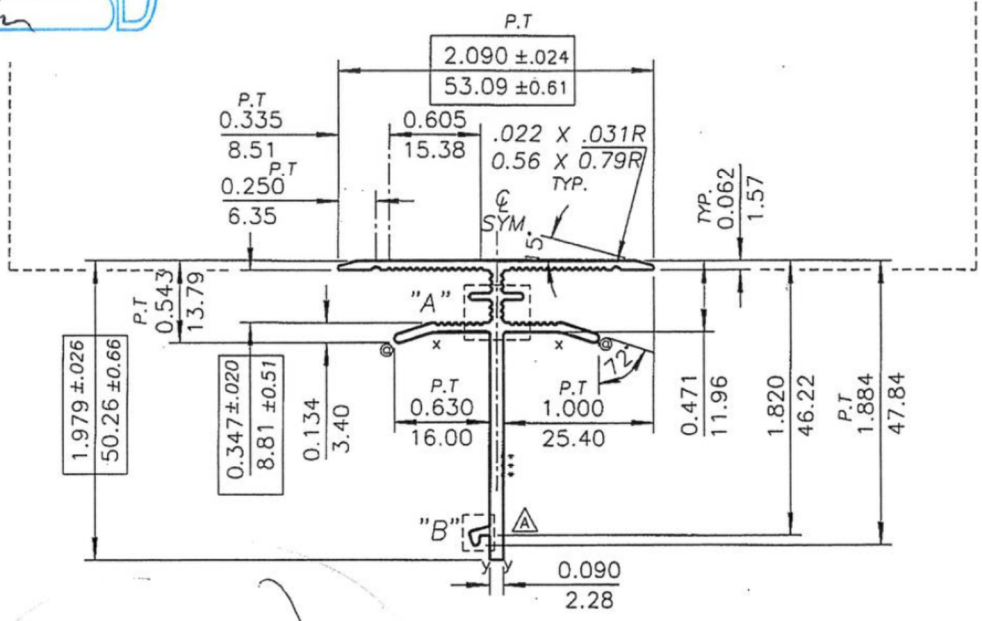
DATE	SYM	REVISION	BY
15–01–06	A	REMOVED LOWER RIGHT SIDE LEG	Angela

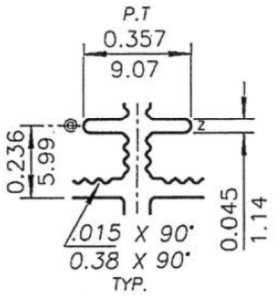
$711

element

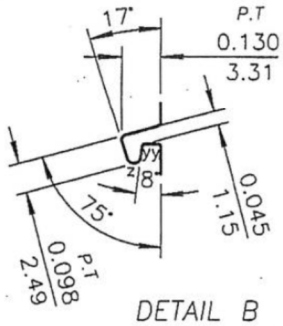
APPROVED

EXPOSED SURFACE





DETAIL A
SCALE 2:1



DETAIL B
SCALE 2:1

CUSTOMER'S SUPPLIED CAD FILE

UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.016 (0.41) R.
(z) = 0.023 (0.57) R. (2)
(y) = 0.010 (0.25) R. (4)
(x) = 0.250 (6.35) R. (2)
(℄) = FULL R. (3)

(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA I.D. MARKS

sapa:

UNSPECIFIED WALL THICKNESS: A/S

NOTE
CHECK OR INDICATE EXPOSED SURFACES, CIRCLE CRITICAL DIMENSIONS
INDICATE LOCATION FOR SAPA IDENTIFICATION MARK

AREA 0.376 IN² 242 MM²		OUT PER. – IN – MM	
EST. WT. 0.451 LBS/FT. 0.671 KG/M		FACTOR 26	
EST. PER. 11.950 IN 304 MM		C.C.D. 2.501 IN 64 MM	
DWN BY S.B	ALLOY 6063–T5	SCALE 1:1	DATE 08–02–15

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

SHAPE DRAWING APPROVAL

PLEASE SIGNIFY BELOW THAT THE SHAPE AND DIMENSIONS CONFORM TO YOUR REQUIREMENTS AND THAT YOU AGREE TO ACCEPT ALL LEGAL RESPONSIBILITIES FOR PATENTS, TRADE MARK, COPYRIGHT, INDUSTRIAL DESIGN OR ANY OTHER INFRINGEMENT RELATING TO THIS SHAPE AND TO INDEMNIFY AND SAVE HARMLESS SAPA FROM ANY CLAIMS, SUITS, ACTIONS OR DEMANDS ARISING THEREFROM.

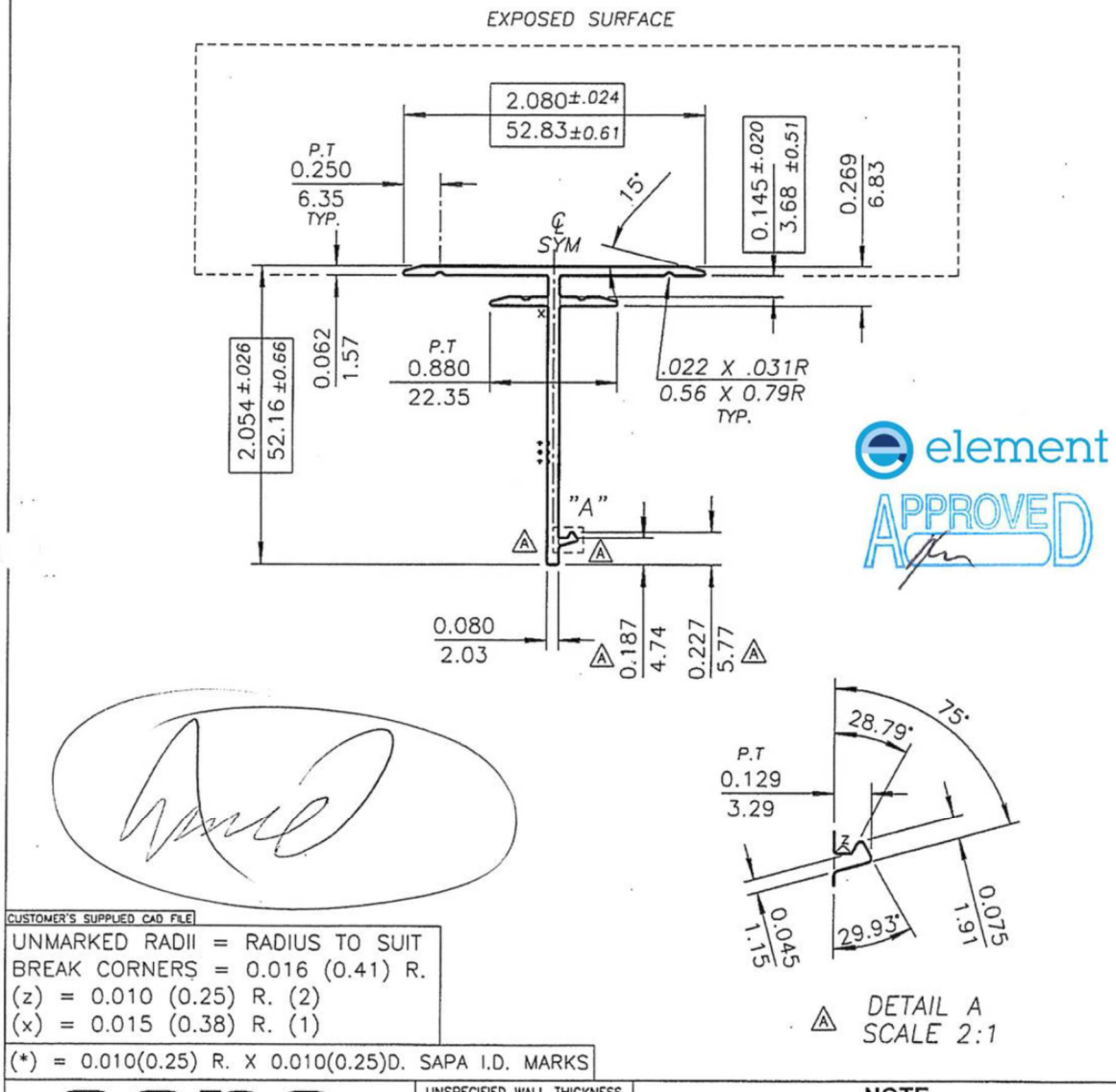
SIGNED BY: DATE:

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO ALUMINUM SYSTEMS	–	AS–61067	
DESCRIPTION: –	TARRIF# 7604.29.10.00	PROPOSAL# 14823–5A	
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9			

DATE	SYM	REVISION	BY
15-01-06	A	REMOVED ONE LEG,CHANGED SHAPE OF DETAIL A .227 WAS .245, .187 WAS .167	Angela

$604



element APPROVED

CUSTOMER'S SUPPLIED CAD FILE

UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.016 (0.41) R.
(z) = 0.010 (0.25) R. (2)
(x) = 0.015 (0.38) R. (1)

(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA I.D. MARKS

sapa:

UNSPECIFIED WALL THICKNESS: A/S

AREA 0.332 IN² 214 MM²		OUT PER. – IN – MM	
EST. WT. 0.398 LBS/FT. 0.593 KG/M		FACTOR 25	
EST. PER. 10.004 IN 254 MM		C.C.D. 2.550 IN 65 MM	
DWN BY S.B	ALLOY 6063–T5	SCALE 1:1	DATE 07–04–24

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

NOTE
CHECK OR INDICATE EXPOSED SURFACES, CIRCLE CRITICAL DIMENSIONS
INDICATE LOCATION FOR SAPA IDENTIFICATION MARK

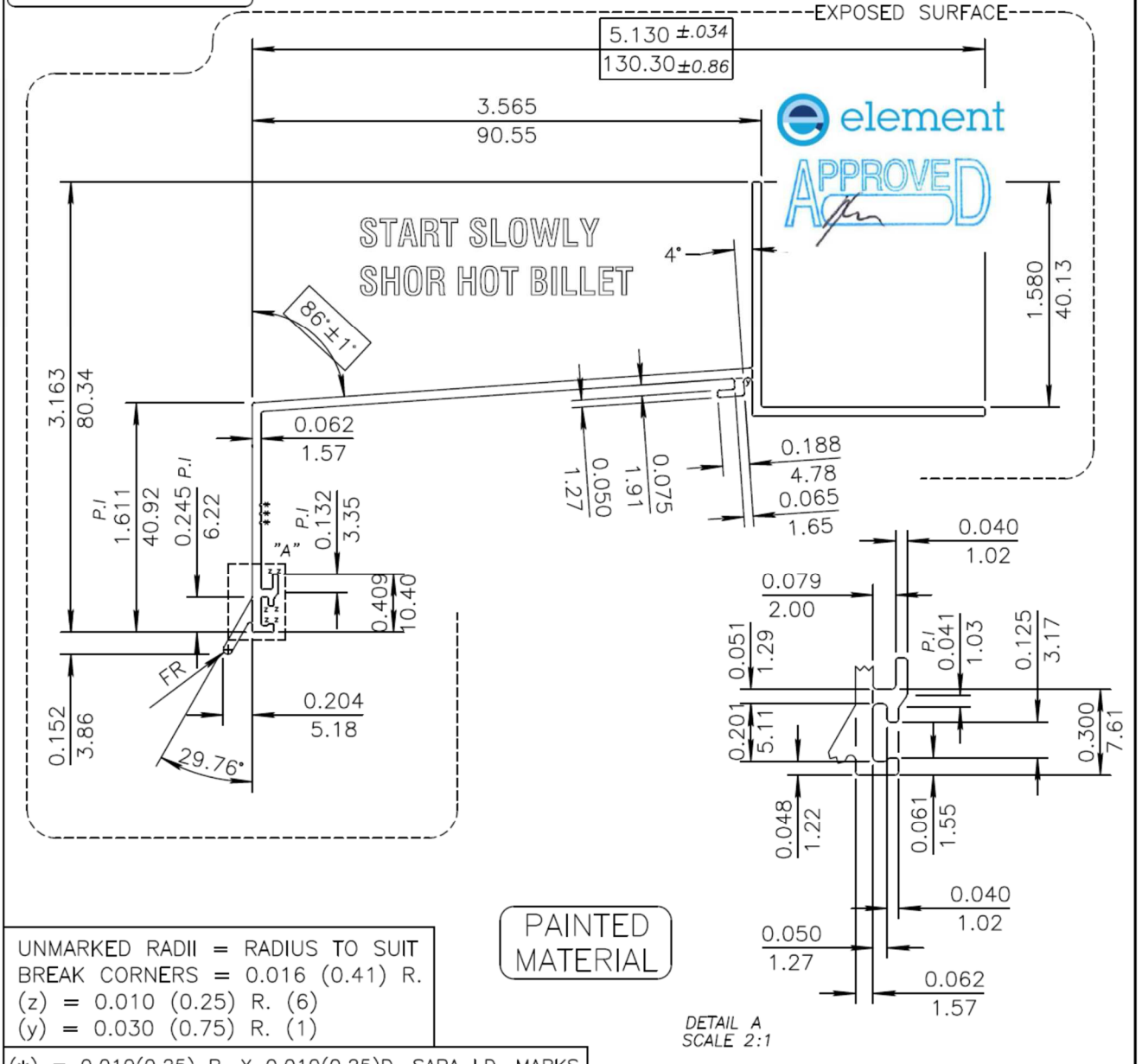
SHAPE DRAWING APPROVAL

PLEASE SIGNIFY BELOW THAT THE SHAPE AND DIMENSIONS CONFORM TO YOUR REQUIREMENTS AND THAT YOU AGREE TO ACCEPT ALL LEGAL RESPONSIBILITIES FOR PATENTS, TRADE MARK, COPYRIGHT, INDUSTRIAL DESIGN OR ANY OTHER INFRINGEMENT RELATING TO THIS SHAPE AND TO INDEMNIFY AND SAVE HARMLESS SAPA FROM ANY CLAIMS, SUITS, ACTIONS OR DEMANDS ARISING THEREFROM.

SIGNED BY: DATE:

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO	–	AS–68201	1
DESCRIPTION: HEAD SILL 40 mm insulation	TARRIF#	PROPOSAL# 18159–1B	
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		



UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.016 (0.41) R.
(z) = 0.010 (0.25) R. (6)
(y) = 0.030 (0.75) R. (1)

(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA I.D. MARKS

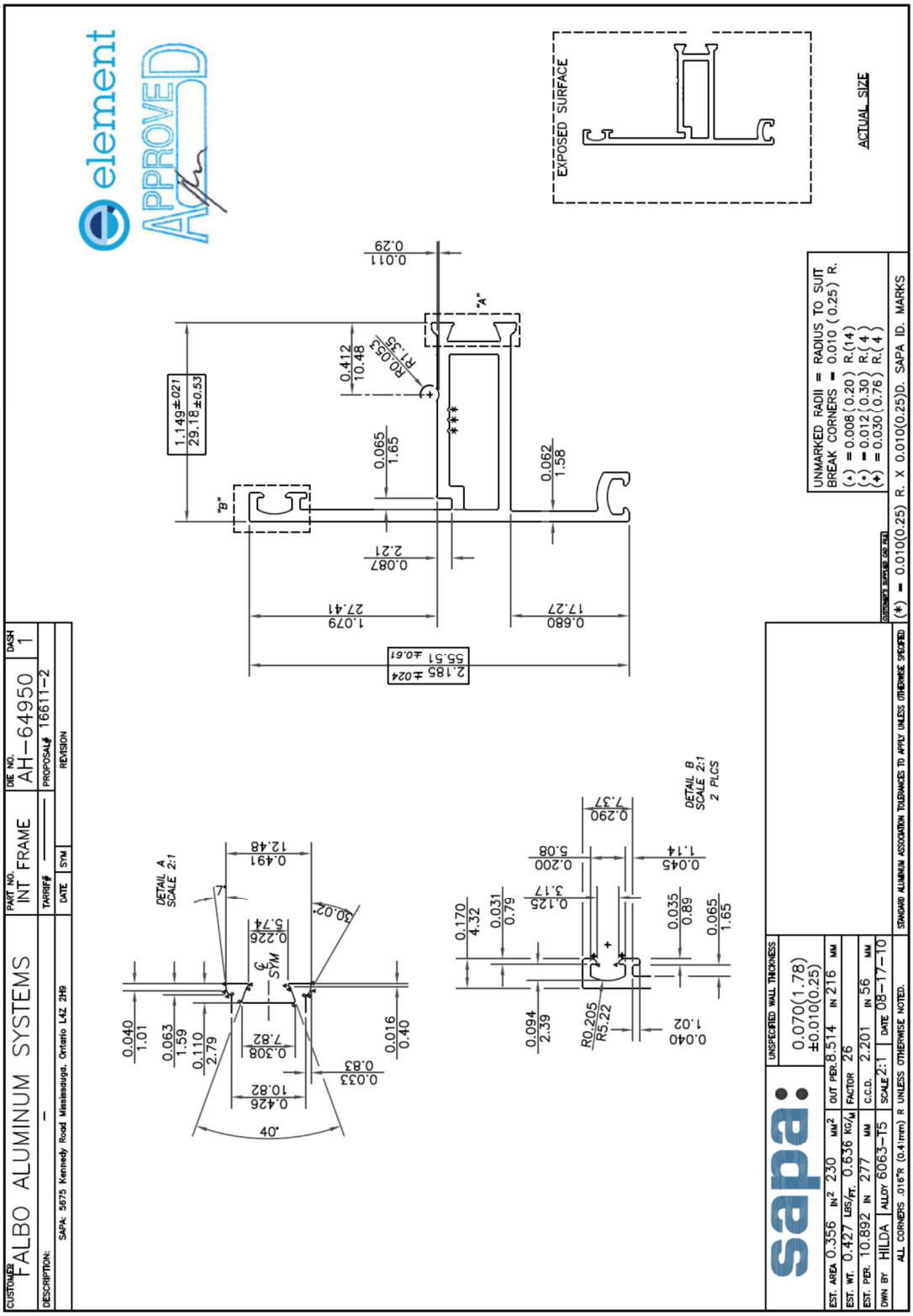
sapa:

UNSPECIFIED WALL THICKNESS
0.065(1.65)
±0.006(0.15)

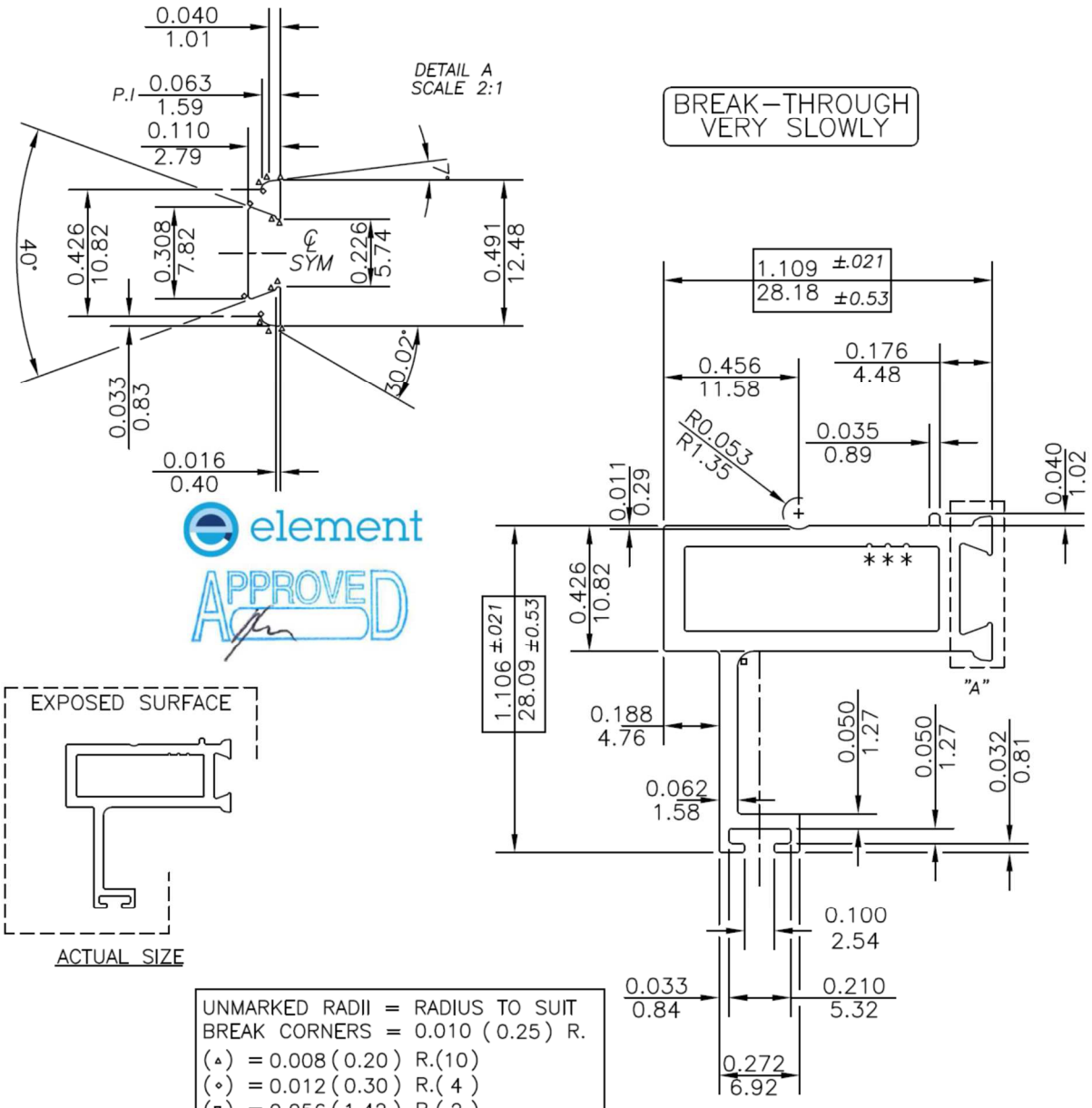
EST. AREA 0.589 IN^2 380 MM^2		OUT PER. – IN – MM	
EST. WT. 0.707 LBS/FT. 1.052 KG/M		FACTOR 26	
EST. PER. 18.346 IN 466 MM		C.C.D. 5.596 IN 142 MM	
DWN BY TEDDY	ALLOY 6063–T5	SCALE 1:1	DATE 12–09–02

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED


element
APPROVED
EXPOSED SURFACE
ACTUAL SIZE
UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.010 (0.25) R.
(•) = 0.008 (0.20) R.(14)
(•) = 0.012 (0.30) R.(4)
(•) = 0.030 (0.76) R.(4)
(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA ID. MARKS
CUSTOMER FALBO ALUMINUM SYSTEMS
PART NO. INT FRAME
DIE NO. AH-64950
DASH 1
DESCRIPTION: -
TARRIF# —
PROPOSAL# 16611-2
SAPA: 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE
SYM
REVISION
sapa
UNSPECIFIED WALL THICKNESS
0.070(1.78) ±0.010(0.25)
EST. AREA 0.356 IN² 230 MM²
EST. WT. 0.427 LBS/FT. 0.636 KG/M
EST. PER. 10.892 IN 277 MM
DWN BY HILDA
ALLOY 6063-T5
OUT PER 8.514 IN 216 MM
FACTOR 26
C.C.D. 2.201 IN 56 MM
SCALE 2:1
DATE 08-17-10
ALL CORNERS .016"R (0.41mm) R UNLESS OTHERWISE NOTED.
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED
DETAIL A SCALE 2:1
DETAIL B SCALE 2:1 2 PLCS
WAS
40°

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO ALUMINUM SYSTEMS	EXT FRAME	AH–65002	1
DESCRIPTION: –	TARRIF# 7604.21.00.00	PROPOSAL# 16611–1A	
SAPA: 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		



element APPROVED

UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.010 (0.25) R.
(▵) = 0.008 (0.20) R.(10)
(◦) = 0.012 (0.30) R.(4)
(▫) = 0.056 (1.42) R.(2)

CUSTOMER'S SUPPLIED CAD FILE

(*) = 0.010(0.25) R. X 0.010(0.25)D. SAPA ID. MARKS

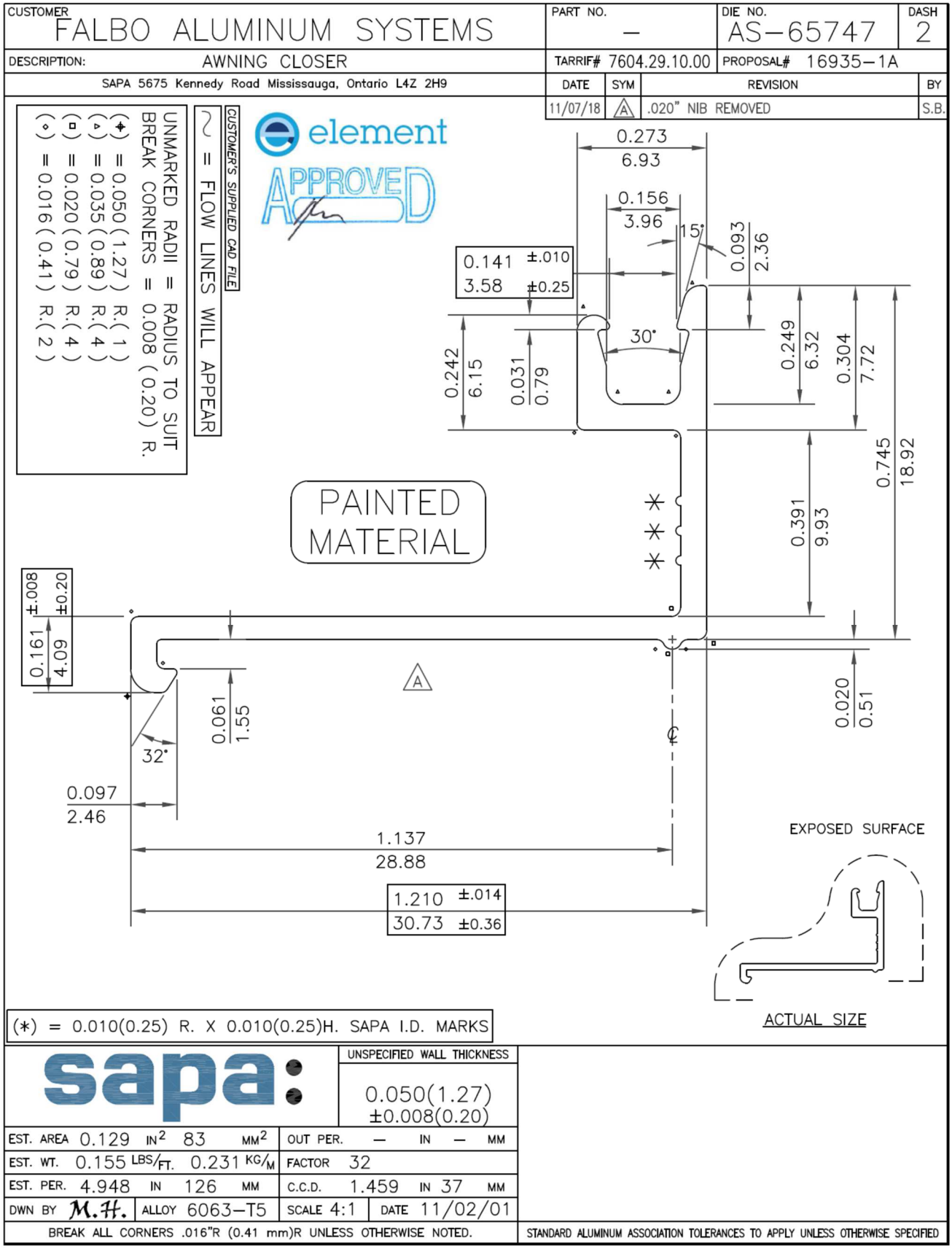
sapa:

UNSPECIFIED WALL THICKNESS
0.070(1.78)
±0.010(0.25)

EST. AREA 0.258 IN² 166 MM²		OUT PER. 5.612 IN 143 MM	
EST. WT. 0.309 LBS/FT. 0.460 KG/M		FACTOR 26	
EST. PER. 7.920 IN 201 MM		C.C.D. 1.529 IN 39 MM	
DWN BY HILDA	ALLOY 6063–T6	SCALE 2:1	DATE 10/09/10

BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

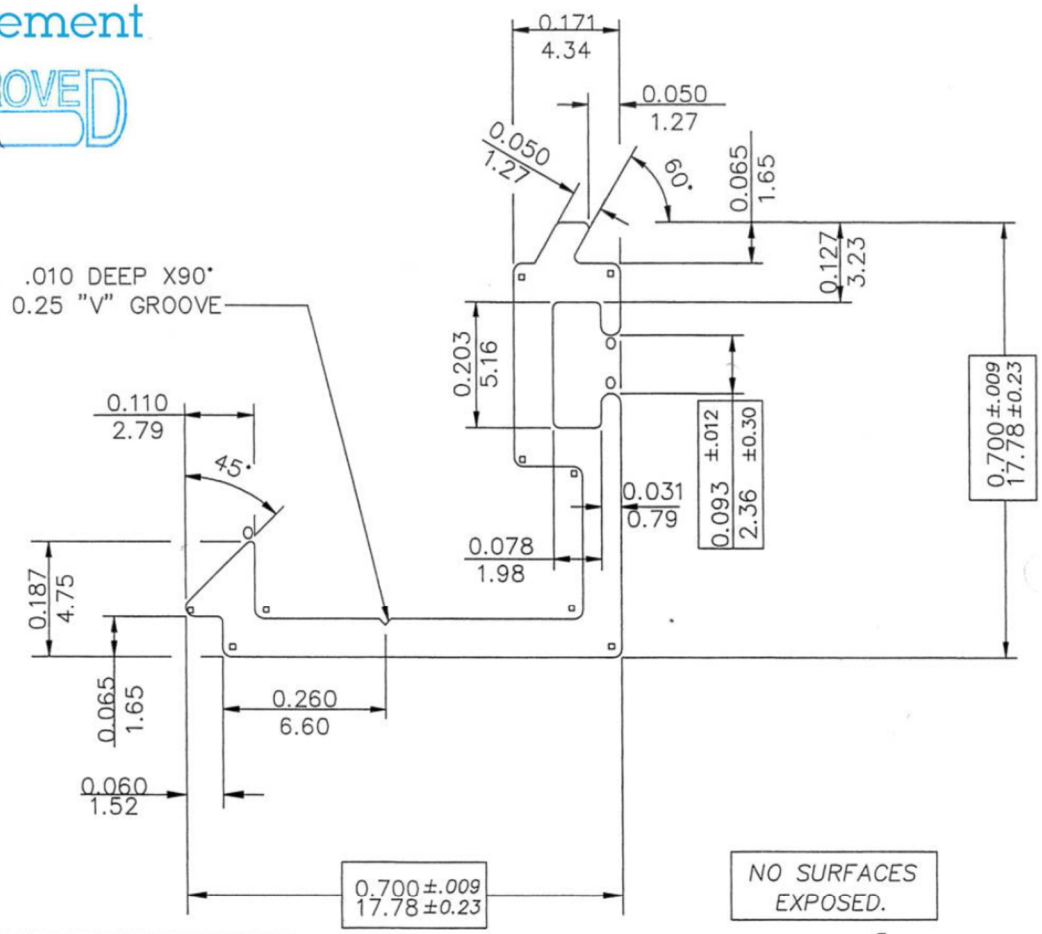

CUSTOMER
FALBO ALUMINUM SYSTEMS
PART NO. –
DIE NO. AS–65747
DASH 2
DESCRIPTION: AWNING CLOSER
TARRIF# 7604.29.10.00
PROPOSAL# 16935–1A
SAPA 5675 Kennedy Road Mississauga, Ontario L4Z 2H9
DATE SYM REVISION BY
11/07/18 A .020" NIB REMOVED S.B.
element
APPROVED
CUSTOMER'S SUPPLIED CAD FILE
~ = FLOW LINES WILL APPEAR
UNMARKED RADII = RADIUS TO SUIT BREAK CORNERS = 0.008 (0.20) R.
(+) = 0.050 (1.27) R.(1)
(▵) = 0.035 (0.89) R.(4)
(□) = 0.020 (0.79) R.(4)
(◇) = 0.016 (0.41) R.(2)
0.273
6.93
0.156
3.96
15°
0.093
2.36
0.141 ±.010
3.58 ±0.25
30°
0.242
6.15
0.031
0.79
0.249
6.32
0.304
7.72
0.745
18.92
0.391
9.93
PAINTED MATERIAL
0.161 ±.008
4.09 ±0.20
0.091
1.55
32°
0.097
2.46
0.020
0.51
1.137
28.88
1.210 ±.014
30.73 ±0.36
EXPOSED SURFACE
ACTUAL SIZE
(*) = 0.010(0.25) R. X 0.010(0.25)H. SAPA I.D. MARKS
sapa:
UNSPECIFIED WALL THICKNESS
0.050(1.27)
±0.008(0.20)
EST. AREA 0.129 IN² 83 MM²
OUT PER. – IN – MM
EST. WT. 0.155 LBS/FT. 0.231 KG/M
FACTOR 32
EST. PER. 4.948 IN 126 MM
C.C.D. 1.459 IN 37 MM
DWN BY M.H. ALLOY 6063–T5
SCALE 4:1 DATE 11/02/01
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.
STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

\\MIS01-MS001\MIS$\TEAMS\MIS_DIEDWGS\5000\A5646.DWG

CUSTOMER	PART NO.	DIE NO.	DASH
INDALEX	–	AS–5646	1
DESCRIPTION: 2PC STOP – INTERIOR	TARRIF#	PROPOSAL# –	
INDALEX LIMITED 5675 Kennedy Road Mississauga, Ontario L4Z 2H9	DATE / SYM / REVISION		
NEVER PAINT	07/12/20 / A / TOLERANCE ADDED		S.B.

element

APPROVED



NO SURFACES EXPOSED.

ACTUAL SIZE

NOTE:
TO SNAP–FIT WITH AS–5647

UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.010(0.25) R.
(o) = FULL . R.(3)
(▫) = .015(0.38) R.(9)

INDALEX ALUMINUM SOLUTIONS

UNSPECIFIED WALL THICKNESS
0.062(1.57)
±0.006(0.15)

AREA 0.104 IN² 67 MM²	OUT PER. – IN – MM		
WT. 0.125 LBS/FT. 0.186 KG/M	FACTOR 29		
EST. PER. 3.571 IN 91 MM	C.C.D. 0.938 IN 24 MM		
DWN BY S.B.	ALLOY 6063–T5	SCALE 4:1	DATE 07/11/7

BREAK ALL CORNERS .016"R (0.41mm) R UNLESS OTHERWISE NOTED.

SAMPLE APPROVAL

THIS SAMPLE IS APPROVED
AND INDALEX LIMITED
MAY PROCEED WITH PRODUCTION

SIGNED: _____

DATE: 5/5/16

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED

1 of

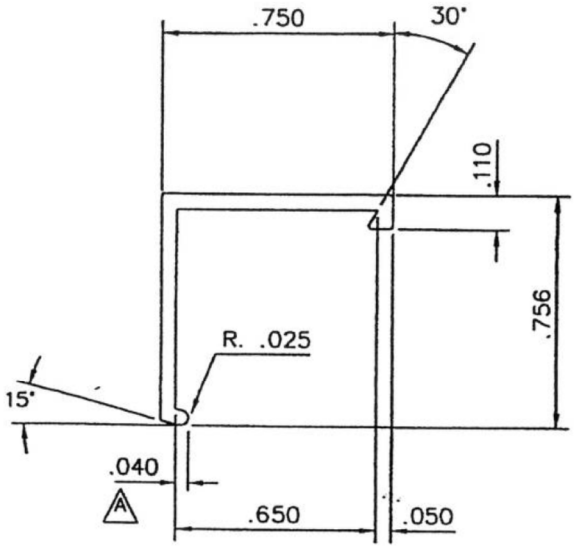
\\2KMISSFNP\DIEDWGS37\5000\A

CUSTOMER	INDALEX	PART NO.	DIE NO. AS-5647	DAS
DESCRIPTION:	2 PART STOPS	TARRIF# 7604.29.10.00	PROPOSAL# D5647	

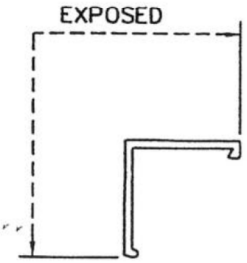
DATE	SYM	REVISION
82/10/04		WT. RECALC. PA
90/02/13	A	.040 WAS .015 OUTSIDE

element

APPROVED



SNAP FIT WITH AS-5646



ACTUAL SIZE

Caradon Indalex
TORONTO – MONTREAL – VANCOUVER CALGARY

UNSPECIFIED WALL THICKNESS 0.050

EST. AREA 0.078 IN² 50 MM²		OUT PER. IN MM	
EST. WT. 0.092 LBS/FT. 0.136 KG/M		FACTOR 35	
EST. PER. 3.185 IN 81 MM		C.C.D. 1.049 IN 27 MM	
DWN BY S.S	ALLOY 6063-T5	SCALE 2:1	DATE 70/07/25

BREAK ALL CORNERS .010"R (0.25R) UNLESS OTHERWISE NOTED

186"

.64328ea.

CUSTOMER	PART NO.	DIE NO.	DASH
FALBO ALUMINUM SYSTEMS	CONER KEY	AS–65136	2

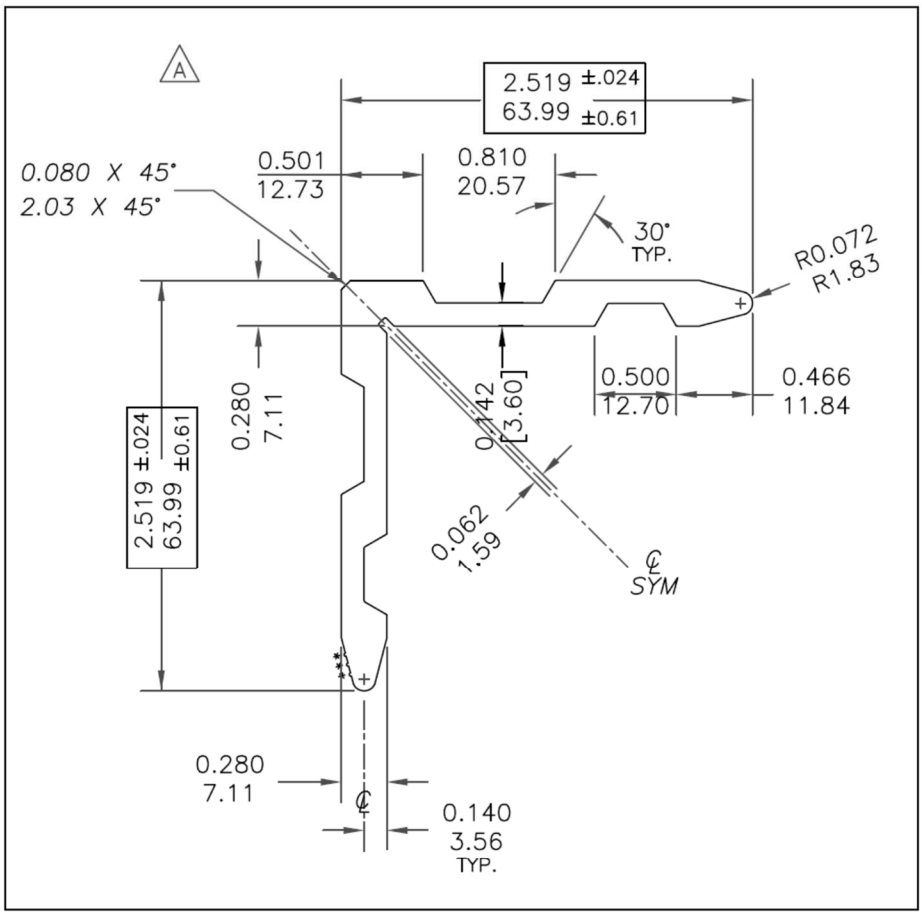
DESCRIPTION:	TARRIF# 7604.29.10.00	PROPOSAL# 16716–1
SAPA: 5675 Kennedy Road Mississauga, Ontario L4Z 2H9		

DATE	SYM	REVISION	BY
11/03/21	A	ENTIRE PROFILE CHANGE AS PER CUST. REQUEST	M.H.

CUSTOMER'S SUPPLIED CAD FILE

element

APPROVED



UNMARKED RADII = RADIUS TO SUIT
BREAK CORNERS = 0.010 (0.25) R.

(*) = 0.010(0.25) R. X 0.010(0.25)H. SAPA I.D. MARKS

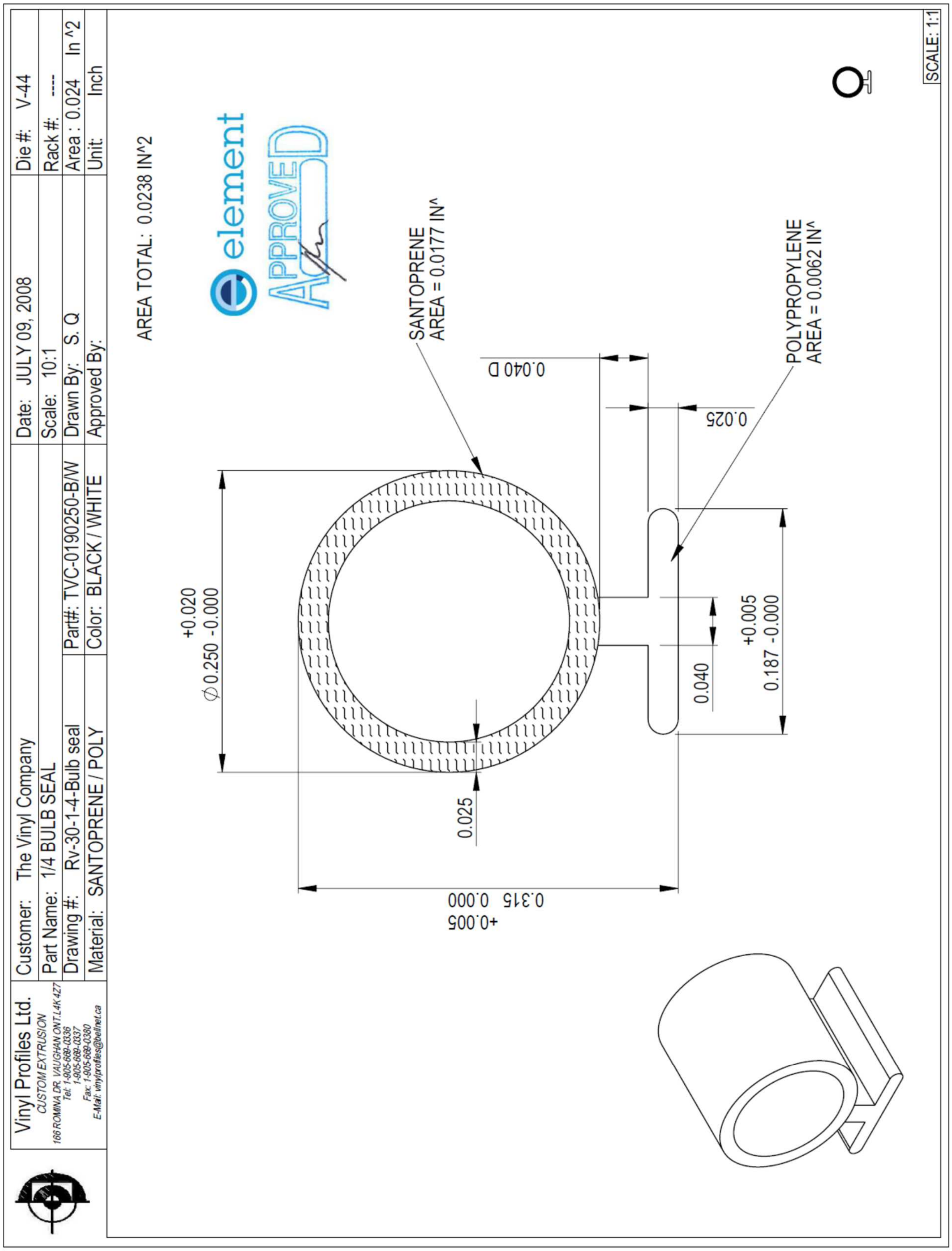
sapa:

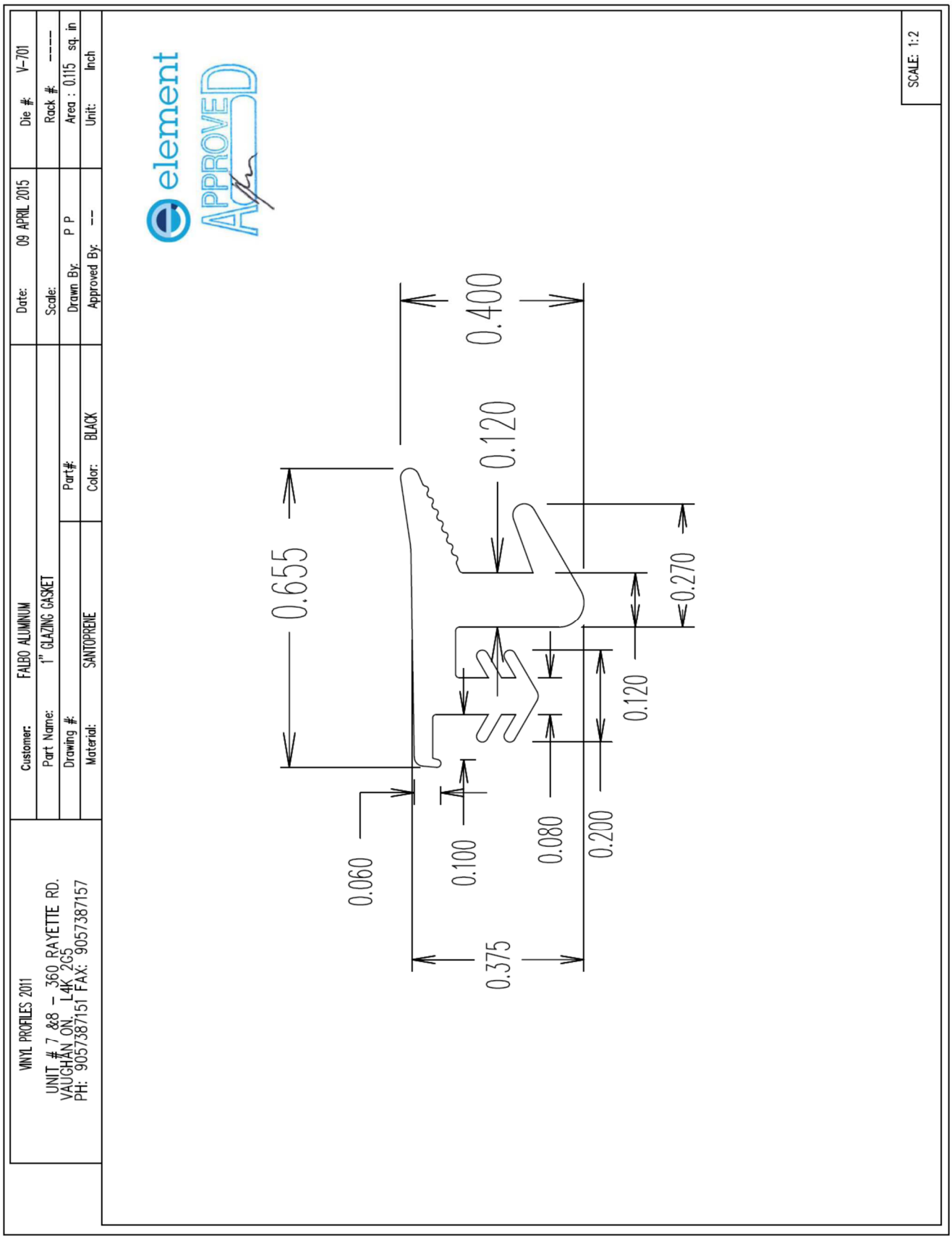
UNSPECIFIED WALL THICKNESS: see above

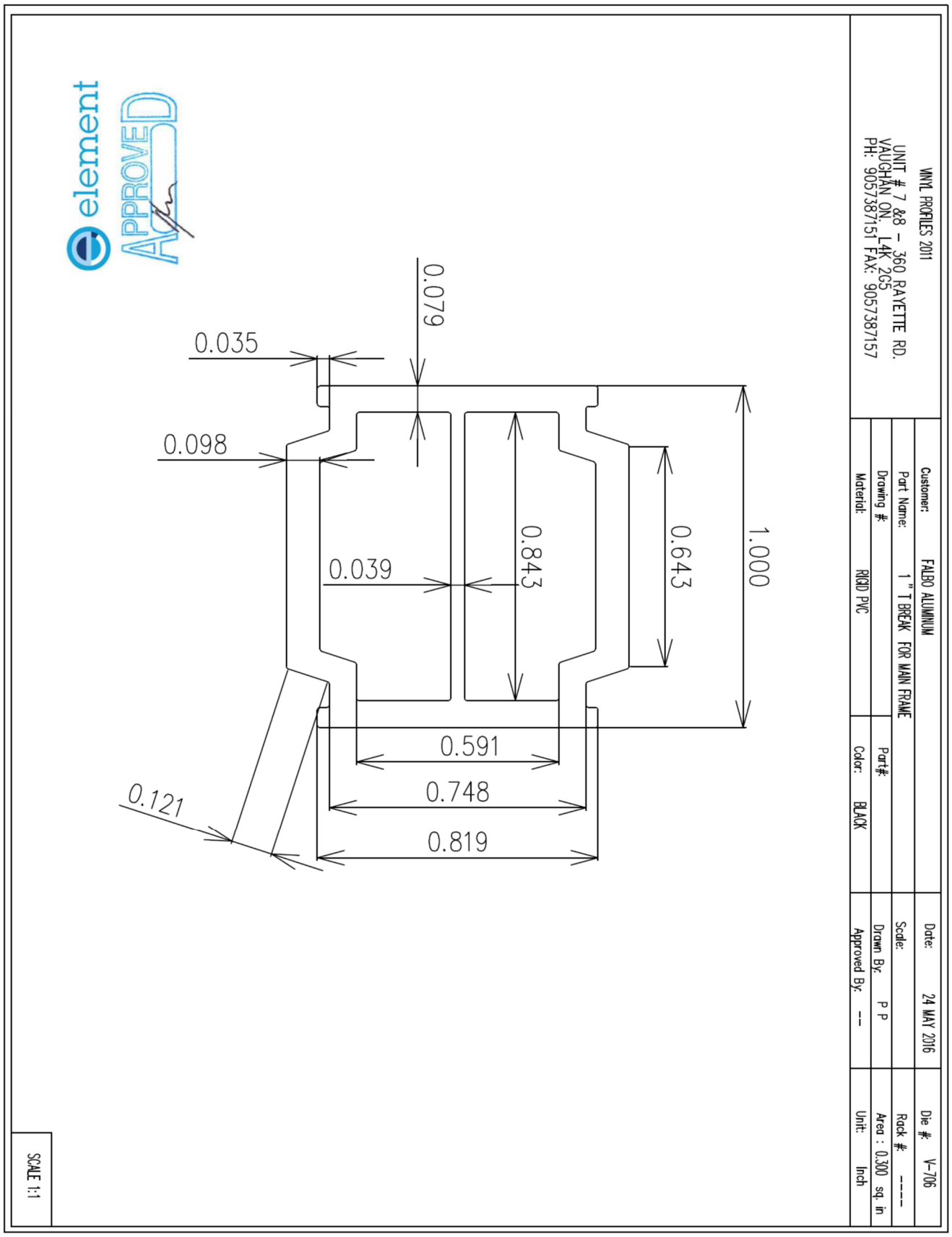
EST. AREA 0.959 IN² 619 MM²		OUT PER. — IN — MM	
EST. WT. 1.151 LBS/FT. 1.713 KG/M		FACTOR 9	
EST. PER. 10.470 IN 266 MM		C.C.D. 3.488 IN 89 MM	
DWN BY HILDA	ALLOY	SCALE 1:1	DATE 10–10–8

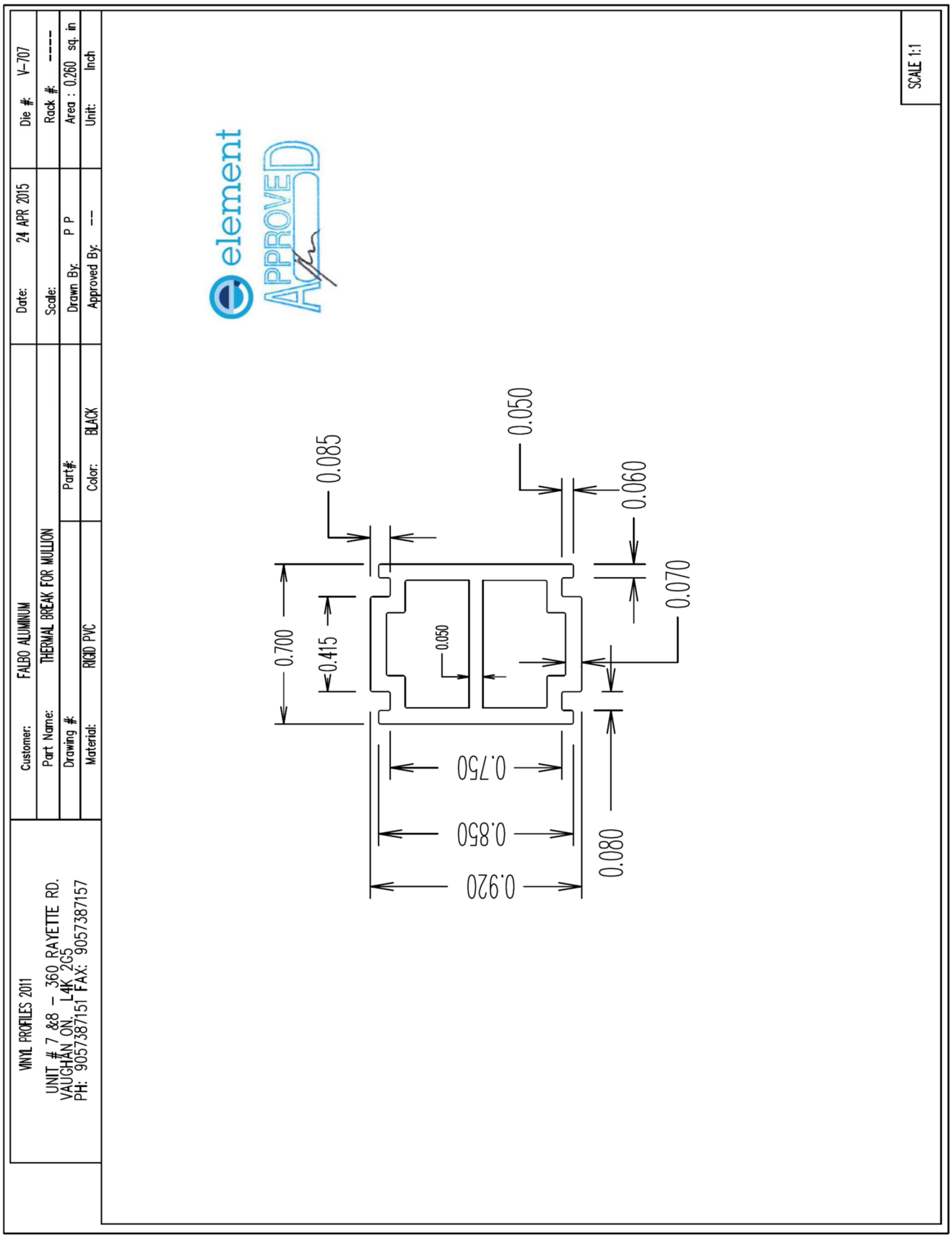
BREAK ALL CORNERS .016"R (0.41 mm)R UNLESS OTHERWISE NOTED.

STANDARD ALUMINUM ASSOCIATION TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED


Vinyl Profiles Ltd.
CUSTOM EXTRUSION
166 ROMINA DR. VAUGHAN ONT. L4K 4Z7
Tel: 1-905-669-0336
1-905-669-0337
Fax: 1-905-669-0380
E-Mail: vinylprofiles@bellnet.ca
Customer: The Vinyl Company
Part Name: 1/4 BULB SEAL
Drawing #: Rv-30-1-4-Bulb seal
Material: SANTOPRENE / POLY
Part#: TVC-0190250-B/W
Color: BLACK / WHITE
Date: JULY 09, 2008
Scale: 10:1
Drawn By: S. Q
Approved By:
Die #: V-44
Rack #: ----
Area : 0.024 In ^2
Unit: Inch
AREA TOTAL: 0.0238 IN^2
element
APPROVED
SANTOPRENE
AREA = 0.0177 IN^
POLYPROPYLENE
AREA = 0.0062 IN^
0.040 D
0.025
+0.020
Ø 0.250 -0.000
0.040
+0.005
0.187 -0.000
0.025
+0.005
0.315 0.000
SCALE: 1:1


VINYL PROFILES 2011
UNIT # 7 &8 – 360 RAYETTE RD.
VAUGHAN ON. L4K 2G5
PH: 9057387151 FAX: 9057387157
Customer: FALBO ALUMINUM
Part Name: 1" GLAZING GASKET
Drawing #:
Material: SANTOPRENE
Part#:
Color: BLACK
Date: 09 APRIL 2015
Scale:
Drawn By: P P
Approved By: --
Die # V-701
Rack # ----
Area : 0.115 sq. in
Unit: Inch
element
APPROVED
SCALE: 1:2
0.655
0.400
0.120
0.270
0.120
0.060
0.100
0.080
0.200
0.375


VINYL PROFILES 2011
UNIT # 7 &8 – 360 RAYETTE RD.
VAUGHAN ON. L4K 2G5
PH: 9057387151 FAX: 9057387157
Customer: FALDO ALUMINUM
Part Name: 1" T BREAK FOR MAIN FRAME
Drawing #:
Material: RIGID PVC
Part#:
Color: BLACK
Date: 24 MAY 2016
Scale:
Drawn By: P P
Approved By: --
Die #: V-706
Rack #: ----
Area : 0.300 sq. in
Unit: Inch
element
APPROVED
0.079
0.035
0.098
0.039
0.843
0.643
1.000
0.591
0.748
0.819
0.121
SCALE 1:1


VINYL PROFILES 2011
UNIT # 7 &8 – 360 RAYETTE RD.
VAUGHAN ON. L4K 2G5
PH: 9057387151 FAX: 9057387157
Customer: FALBO ALUMINUM
Part Name: THERMAL BREAK FOR MULLION
Drawing #:
Part#:
Material: RIGID PVC
Color: BLACK
Date: 24 APR 2015
Scale:
Drawn By: P P
Approved By: --
Die #: V-707
Rack #: ----
Area : 0.260 sq. in
Unit: Inch
element
APPROVED
SCALE 1:1
0.085
0.050
0.060
0.700
0.415
0.050
0.070
0.750
0.850
0.920
0.080

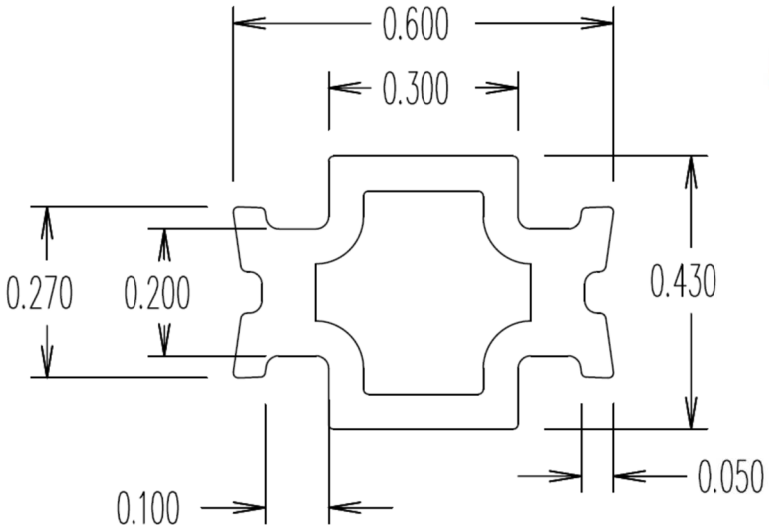
VINYL PROFILES 2011

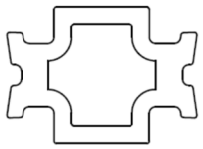
UNIT # 7 &8 – 360 RAYETTE RD.
VAUGHAN ON. L4K 2G5
PH: 9057387151 FAX: 9057387157

Customer: FALBO		Date: 30 JULY 2015	Die #: V-708
Part Name: AWNING THERMAL BREAK		Scale:	Rack #: -----
Drawing #:	Part#:	Drawn By: P P	Area : 0.120 sq. in
Material: RIGID PVC	Color: BLACK	Approved By: --	Unit: Inch

Wall thinkness: OUT SIDE 0.055"

element APPROVED





SCALE 1:1

SCALE: 1:2

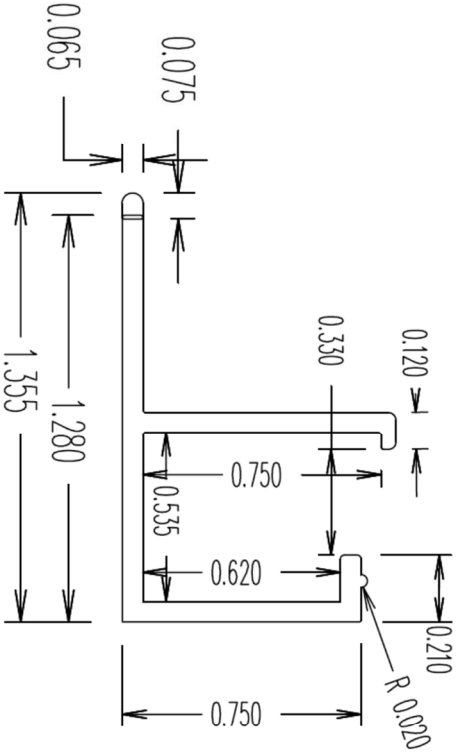
element

element

VINYL PROFILES 2011

UNIT # 7 &8 – 360 RAYETTE RD.
VAUGHAN ON. L4K 2G5
PH: 9057387151 FAX: 9057387157

Customer: FALBO ALUMINUM		Date: 27 JULY 2015	Die #: V-630
Part Name: 1" GLAZING STOP		Scale:	Rack #: ----
Drawing #:	Part#:	Drawn By: P P	Area : 0.200 sq. in
Material: DUAL PVC	Color: WHITE AND BLACK	Approved By: --	Unit: Inch



Wall thinkness:0.065 "

element APPROVED

SCALE: 1:1