



AAMA/NWWDA 101/I.S.2-97
TEST REPORT SUMMARY

Rendered to:

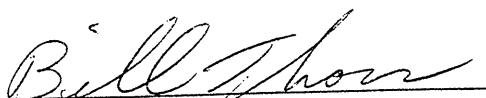
GORELL ENTERPRISES, INC.

SERIES/MODEL: P6002
TYPE: Vinyl Sliding Patio Door
RATING: SGD-R25 71 x 80

Title of Test	Results
Overall Design Pressure	25 psf
Operating Force	10 lb max.
Air Infiltration	0.23 cfm/ft ²
Water Resistance	3.75 psf
Structural Test Pressure	+37.5 psf
Deglazing	Passed
Forced Entry Resistance	Grade 10

Reference should be made to Report No. 01-39044.01 for complete test specimen description and data.

For ARCHITECTURAL TESTING, INC.


Bill Thorr, Technician

BT:baw



Architectural Testing

AAMA/NWWDA 101/I.S.2-97 TEST REPORT

Rendered to:

GORELL ENTERPRISES, INC.
1380 Wayne Avenue
Indiana, Pennsylvania 15701

Report No: 01-39044.01
Test Date: 03/13/01
Report Date: 04/17/01
Expiration Date: 03/13/05

Project Summary: Architectural Testing, Inc. (ATI) was contracted to perform tests on a Series/Model P6002, vinyl sliding patio door. The sample tested successfully met the performance requirements for a SGD-R25 71 x 80 rating. Test specimen description and results are reported herein.

Test Specification: The test specimen was evaluated in accordance with AAMA/NWWDA 101/I.S.2-97, *Voluntary Specifications for Aluminum, Vinyl (PVC) and Wood Windows and Glass Doors*.

Test Specimen Description:

Series/Model: P6002

Type: Vinyl Sliding Patio Door (XO)

Overall Size: 5' 10-5/8" wide by 6' 7-1/2" high

Panel Size: 2' 11-5/8" wide by 6' 5" high

Fixed Daylight Opening Size: 2' 7-1/4" wide by 6' 0-5/8" high

Screen Size: 2' 11-1/2" wide by 6' 4-1/2" high

Finish: All vinyl was white.

Glazing Details: Both panels utilized 7/8" thick sealed insulating glass fabricated from two sheets of 1/8" tempered transparent glass. Both lites were exterior glazed onto dual-sided adhesive foam tape, and secured with snap-in vinyl glazing beads.

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Test Specimen Description: (Continued)

Weatherstripping:

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
0.230" high by 0.187" backed polypile with center fin	1 Row	Perimeter of interior frame pocket, fixed meeting stile, active panel rails and stiles
0.130" high by 0.187" backed polypile	1 Row	Screen rails and jamb stile
0.500" high by 0.187" backed polypile	1 Row	Screen meeting stile

Frame Construction: The frame was constructed of extruded vinyl members with mitered and welded corners. The interior sill pocket utilized an extruded vinyl snap-in threshold. The exterior pocket was covered by an extruded vinyl snap-in threshold cap.

Panel Construction: The active and fixed panels were constructed of extruded vinyl members with mitered and welded corners.

Screen Construction: The screen was constructed of vinyl members with mitered and welded corners. The fiberglass mesh was secured with a flexible spline.

Hardware:

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
Lock handle assembly	2	Midspan of active panel jamb stile and screen jamb stile
Roller assembly	2	One on each end of active panel bottom rail
Plastic screen hanger	2	One on each end of screen top rail
Secondary lock handle assembly with rod	1	Midspan of active panel meeting stile



Test Specimen Description: (Continued)

Drainage:

<u>Description</u>	<u>Quantity</u>	<u>Location</u>
3/8" diameter weephole	4	Ends of bottom rails, draining the panel hollows
3/8" diameter weephole	4	Each end and 33" from each end on interior sill leg draining the interior sill track.
3/8" diameter weephole	4	Each end and 33" from each end of exterior sill leg draining the sill hollow.
1-1/2" wide by 3/8" high weepslot	4	Each end and 33" from each end of the screen track leg draining the screen track.

Reinforcement: A "U" shaped aluminum channel with 0.060" thick walls was utilized in the screen stiles. A custom shaped aluminum reinforcement with 0.080" thick walls was utilized in the fixed meeting stile. A custom shaped aluminum reinforcement with 0.060" thick walls was utilized in the active panel stiles. A custom shaped aluminum reinforcement with 0.045" thick walls was utilized in the screen stiles.

Installation: The test specimen was installed into the 2" x 8" Spruce-Pine-Fir test buck using 1" x 1" interior and exterior blind stops fastened to the test buck 10" on center. Silicone was used on the interior and exterior perimeter as a sealant.

Test Results:

The results are tabulated as follows:

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
2.2.19.5.1	Operating Force Breakaway Force Force To Keep in Motion	10 lbs 4 lbs	30 lbs max. 20 lbs max.
2.1.2	Air Infiltration per ASTM E 283 (See Note #1) @ 1.57 psf (25 mph)	0.23 cfm/ft ²	0.30 cfm/ft ² max.

Note #1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/NWWDA 101/I.S. 2-97 for air infiltration.



Test Results: (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
2.1.3	Water Resistance per ASTM E 547 (with and without screen) WTP = 3.00 psf	No leakage	No leakage
2.1.4.2	Uniform Load Structural per ASTM E 330 (Measurements reported were taken on the fixed meeting stile) @ 22.5 psf (exterior) @ 22.5 psf (interior)	0.02" 0.02"	0.31" max. 0.31" max.
2.2.19.5.2	Deglazing Test per ASTM E 987 In operating direction at 70 lbs Lock stile Meeting stile In remaining direction at 50 lbs Top rail Bottom rail	 0.06"/12% 0.06"/12% 0.03"/6% 0.03"/6%	 0.50"/100% 0.50"/100% 0.50"/100% 0.50"/100%
2.1.7	Welded Corner Test	Meets as stated	Meets as stated
2.1.8	Forced Entry Resistance per ASTM F 842-97 Type: A Grade: 10 Lock Manipulation Test Test A1 thru A6 Lock Manipulation Test	 No entry No entry No entry	 No entry No entry No entry



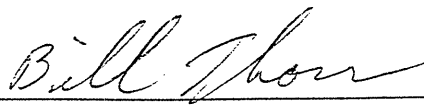
Test Results: (Continued)

<u>Paragraph</u>	<u>Title of Test - Test Method</u>	<u>Results</u>	<u>Allowed</u>
<u>Optional Performance</u>			
4.3	Water Resistance per ASTM E 547 (with and without screen) WTP = 3.75 psf	No leakage	No leakage
4.4.2	Uniform Load Structural per ASTM E 330 (Measurements reported were taken on the fixed meeting stile) @ 37.5 psf (exterior) @ 37.5 psf (interior)	0.03" 0.04"	0.31" max. 0.31" max.
	Structural Loads for North Carolina Building Code (Measurements reported were taken on the fixed meeting stile)		
	@ 35.0 psf (positive)	36 seconds	Deflection 1.79"
	@ 35.0 psf (negative)	36 seconds	1.86"
	@ 43.5 psf (positive)	10 seconds	Permanent Set 0.06"
	@ 43.5 psf (negative)	10 seconds	0.16"

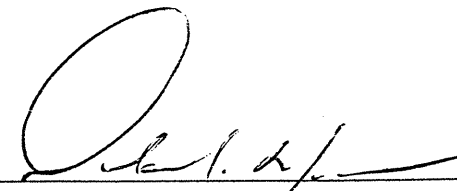
Meets the performance requirements for a 90 mph mean roof height 25 foot rating.

Detailed drawings, representative samples of the test specimen, and a copy of this report will be retained by ATI for a period of four years. The above results were secured by using the designated test methods and they indicate compliance with the performance requirements of the above referenced specification. This report does not constitute certification of this product which may only be granted by the certification program administrator.

For ARCHITECTURAL TESTING, INC:



Bill Thorr
Technician



David G. Moyer, Vice President
Director of Testing Services



DOCUMENT CONTROL ADDENDUM #01-39044.00

Current Issue Date: 04/17/01

Report No.: 01-39044.01

Requested by: Rich Gibson, Gorell Enterprises, Inc.

Purpose: AAMA/NWWDA 101/I.S.2-97 testing of Series/Model P6002, vinyl sliding patio door.

Issued Date: 04/17/01

Comments: Certification copy to John Smith at Associated Laboratories.