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ALUMIL SA
TEST REPORT

SCOPE OF WORK
AAMA/WDMA/CSA 101/I.S.2/A440 AND CSA A440S1 TESTING ON S77, CASEMENT WINDOW

REPORT NUMBER
J3813.01-109-44

TEST DATE(S)
07/10/19 - 07/29/19

ISSUE DATE
08/26/19

RECORD RETENTION END DATE
07/29/23

PAGES
27

DOCUMENT CONTROL NUMBER
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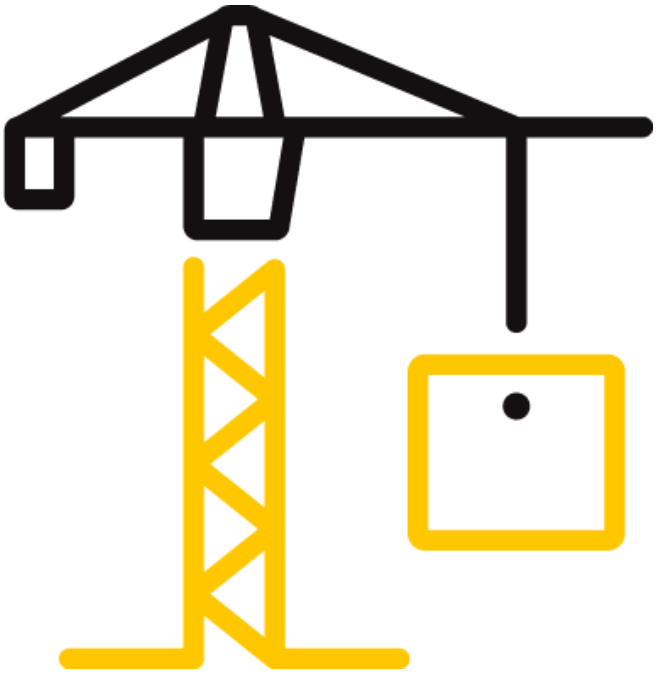

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TEST REPORT FOR ALUMIL SA
Report No.: J3813.01-109-44
Date: 08/26/19

REPORT ISSUED TO

ALUMIL SA
Iatrou Gogousi 8
Thessaloniki, GR 56429
GREECE

SECTION 1

SCOPE

Intertek Building & Construction (B&C) was contracted by Alumil SA to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 and CSA A440S1 on their S77, Casement Window. Results obtained are tested values and were secured by using the designated test method(s). Testing was conducted at Intertek B&C test facility in York, Pennsylvania. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory.

SECTION 2

SUMMARY OF TEST RESULTS

TITLE	RESULTS
Primary Product Designator	Class AW – PG90 – 914 x 1524 (36 x 60) - C
Design Pressure	±4320 Pa (±90.23 psf)
Air Infiltration (6.27 psf)	0.4 L/s/m^2 (0.07 cfm/ft^2)
Air Exfiltration (6.27 psf)	0.4 L/s/m^2 (0.07 cfm/ft^2)
Canadian Air Infiltration/Exfiltration Level	A3
Water Penetration Resistance Test Pressure	720 Pa (15.04 psf)

Reference Intertek B&C Report No. J3813.01-109-44, dated 08/26/19 for complete test specimen description and test results.

For INTERTEK B&C:

COMPLETED BY:	Richard E. Hartman III	**REVIEWED BY:**	Timothy J. McGill
TITLE:	Technician – Product Testing	**TITLE:**	Manager – Product Testing
SIGNATURE:	Digitally Signed by: Richard Hartman III	**SIGNATURE:**	Digitally Signed by: Timothy J. McGill
DATE:	08/26/19	**DATE:**	08/26/19

REH:wnl

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SECTION 3
TEST METHOD(S)

The specimen was evaluated in accordance with the following:

AAMA/WDMA/CSA 101/I.S.2/A440-17, - *North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

AAMA 910-16, *Voluntary "Life Cycle" Specifications and Test Methods for AW Class Architectural Windows and Doors*

AAMA/WDMA/CSA 101/I.S.2/A440-11, *NAFS 2011 - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

CSA A440S1-17, Canadian Supplement to **AAMA/WDMA/CSA 101/I.S.2/A440**, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

ASTM E283-04(2012), *Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*

ASTM E330/E330M-14, *Standard Test Method for Structural Performance of Exterior Windows, Doors, Skylights and Curtain Walls by Uniform Static Air Pressure Difference*

ASTM E331-00(2016), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference*

ASTM E547-00(2016), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Cyclic Static Air Pressure Difference*

ASTM E2068-00(2016), *Standard Test Method for Determination of Operating Force of Sliding Windows and Doors1*

ASTM F588-14, *Standard Test Methods for Measuring the Forced Entry Resistance of Window Assemblies, Excluding Glazing Impact*

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SECTION 4
MATERIAL SOURCE/INSTALLATION

Test specimen(s) was provided by the client. Representative samples of the test specimen(s) will be retained by Intertek B&C for a minimum of four years from the test completion date.

The specimen was installed into a 1-1/2" LVL buck. The rough opening allowed for a 1/2" shim space. The exterior perimeter of the window was sealed with sealant. Installation of the tested product was performed by the client.

LOCATION	ANCHOR DESCRIPTION	ANCHOR LOCATION
Head, sill, and jambs	#12 x 2-1/2" flat head screw through the buck and into the frame	2-1/2" from each corner and spaced 8" on center

SECTION 5
EQUIPMENT

Tape Measure Verification: 63788
Force Gauge: 63156, INT00155
Control Panel: 005644
Weather Station: 63316
Spray Rack: 003956-B, 003956-A
Spring Scale: INT00009, 63395
Thermal Tenney: INT00000
Linear Transducers: INT00147, 65989, INT00151, INT00148

SECTION 6
LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Athanasiadis Thanasis	Alumil SA
Tsokakis Constantine	Alumil SA
John A. Shanabrook	Intertek B&C
Timothy J. McGill	Intertek B&C
Richard E. Hartman III	Intertek B&C

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SECTION 7
TEST SPECIMEN DESCRIPTION

Product Type: Casement Window
Series/Model: S77

Product Size(s):

OVERALL AREA:	**WIDTH**		**HEIGHT**	
1.4 m^2 (15.0 ft^2)	**millimeters**	**inches**	**millimeters**	**inches**
Overall size	914	36	1524	60
Vent size	854	33-5/8	1464	57-5/8

Frame Construction:

FRAME MEMBER	**MATERIAL**	**DESCRIPTION**
Head, sill, and jambs	Aluminum	Extruded, thermally broken, dual strutted

	JOINERY TYPE	**DETAIL**
All corners	Mitered	Sealed, keyed at the interior and exterior hollows and lanced twice per member end

Vent Construction:

VENT MEMBER	**MATERIAL**	**DESCRIPTION**
Rails and stiles	Aluminum	Extruded, thermally broken, dual strutted

	JOINERY TYPE	**DETAIL**
All corners	Mitered	Sealed, keyed at the interior and exterior hollows and lanced twice per member end

Reinforcement: No reinforcement was utilized.

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Weatherstripping:

DESCRIPTION	QUANTITY	LOCATION
0.187" backed by 0.205" high vinyl fin seal	1 Row	Frame perimeter
Co-extruded custom central gasket	1 Row	Frame perimeter
0.187" backed by 0.290" diameter foam bulb seal	1 Row	Vent perimeter

Glazing: *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

GLASS TYPE	SPACER TYPE	INTERIOR LITE	EXTERIOR LITE	GLAZING METHOD
1-9/16" IG	Desiccant-filled aluminum box spacer	5/16" tempered	1/4" tempered	The glazing was set from the interior onto a vinyl glazing strip against the frame. Sealant was used around the entire perimeter of the glazing channel. The glazing was secured using extruded aluminum snap-in glazing beads with a vinyl glazing strip. The glazing beads at the top rail and bottom rail also utilized two #10 x 3/4" pan head screws per glazing bead.

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Vent daylight opening	1	654 x 1270	25-3/4 x 50	5/8"

Drainage:

DRAINAGE METHOD	SIZE	QUANTITY	LOCATION
Weepslot	5/8" wide by 7/32" high	2	Bottom Rail, 9" from member ends
Weepslot	1-3/8" wide by 5/16" high	2	Sill, 6" from member ends

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Hardware:

DESCRIPTION	QUANTITY	LOCATION
Handle and multipoint lock assembly	1 Set	Handle located at the midspan of the latch stile
Receivers	9	Head, 9-5/8" from the latch jamb
		Sill, 10-1/4" and 18-1/2" from the latch jamb
		Hinge jamb, 14-1/4" and 37-1/2" from the sill
		Latch jamb, 2-1/2", 18-1/2", 38-1/2", and 53" from the sill
Barrel hinges	2	Hinge jamb, head and sill corners

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SECTION 8
TEST RESULTS

The temperature during testing was 26 - 31°C (78 - 88°F). The results are tabulated as follows:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
LIFE CYCLE per AAMA 910			
Operating Force, per ASTM E2068	Initiate Motion: 4 N (1 lbf) Maintain Motion: 9 N (2 lbf) Latch: 62 N (14 lbf)	155 N (34.85 lbf) max 135 N (30.35 lbf) max 100 N (22.48 lbf) max	
Air Leakage, Infiltration per ASTM E283 at 300 Pa (6.27 psf)	0.3 L/s/m^2 (0.06cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 2
Air Leakage, Exfiltration per ASTM E283 at 75 Pa (1.57 psf)	<0.1 L/s/m^2 (<0.01 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 2
Air Leakage, Exfiltration per ASTM E283 at 300 Pa (6.27 psf)	0.2 L/s/m^2 (0.03 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 2
Canadian Air Infiltration/Exfiltration Level	A3	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	
Water Penetration, per ASTM E547 and ASTM E331 at 720 Pa (15.04 psf)	Pass	No leakage	3
VENTING			
Vent Cycling, (First half) per AAMA 910 2000 cycles	Vent: Pass	No damage	4, 5
Locking Hardware Cycling, (First half) per AAMA 910 2000 cycles	Latch: Pass	No damage	4, 5

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TITLE OF TEST	RESULTS	ALLOWED	NOTE
MISUSE TESTING per AAMA 910			
Ventilator Vertical Load Test, at 667 N (150 lbf)	Pass	No damage	
VENTING			
Vent Cycling, (Second half) per AAMA 910 2000 cycles	Vent: Pass	No damage	4, 5
Locking Hardware Cycling, (Second half) per AAMA 910 2000 cycles	Latch: Pass	No damage	4, 5, 6
Operating Force, per ASTM E2068	Initiate Motion: 9 N (2 lbf) Maintain Motion: 13 N (3 lbf) Latch: 89 N (20 lbf)	155 N (34.85 lbf) max 135 N (30.35 lbf) max 100 N (22.48 lbf) max	
Air Leakage, (Optional) Infiltration per ASTM E283 at 300 Pa (6.27 psf)	0.3 L/s/m^2 (0.05 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 7
Air Leakage, (Optional) Infiltration per ASTM E283 at 75 Pa (1.57 psf)	0.1 L/s/m^2 (0.02 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 7
Air Leakage, (Optional) Exfiltration per ASTM E283 at 300 Pa (6.27 psf)	0.3 L/s/m^2 (0.05 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	1, 7
Canadian Air Infiltration/Exfiltration Level	A3	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	
Water Penetration, (Optional) per ASTM E547 and ASTM E331 at 720 Pa (15.04 psf)	Pass	No leakage	3
Thermal Cycling, per AAMA 501.5 six cycles from 0°F to 180°F	See Chart 1 for Thermal Cycle		

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TITLE OF TEST	RESULTS	ALLOWED	NOTE
Uniform Load Deflection, per ASTM E330 Deflections taken between lock points			
+4320 Pa (+90.23 psf)	0.5 mm (0.02")	3.3 mm (0.13") max.	
-4320 Pa (-90.23 psf)	0.8 mm (0.03")	3.3 mm (0.13"") max.	8, 9, 10
Air Leakage, Infiltration per ASTM E283 at 300 Pa (6.27 psf)	0.4 L/s/m^2 (0.07 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	11
Air Leakage, Exfiltration per ASTM E283 at 75 Pa (1.57 psf)	0.1 L/s/m^2 (0.02 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	11
Air Leakage, Exfiltration per ASTM E283 at 300 Pa (6.27 psf)	0.4 L/s/m^2 (0.07 cfm/ft^2)	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	11
Canadian Air Infiltration/Exfiltration Level	A3	0.5 L/s/m^2 (0.10 cfm/ft^2) max.	
Water Penetration, per ASTM E547 and ASTM E331 at 720 Pa (15.04 psf)	Pass	No leakage	3
Uniform Load Structural, per ASTM E330 Permanent set taken between lock points			
+6480 Pa (+135.34 psf)	0.3 mm (0.01")	1.3 mm (0.05") max.	
-6480 Pa (-135.34 psf)	0.3 mm (0.01")	1.3 mm (0.05") max.	9, 10
Forced Entry Resistance, per ASTM F588, Type: B- Grade: 10	Pass	No entry	
Sash/Leaf Torsion 90 N (20 lbf)	12.2 mm (0.48")	65.0 mm (2.56") max.	
Sash Vertical Deflection 270 N (60 lbf)	1.3 mm (0.05")	1.8 mm (0.07") max.	

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Note 1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440 for air leakage resistance.

Note 2: Test Date 07/16/19 / Time: 11:50 AM

Note 3: Without insect screen.

Note 4: Lubrication and hardware adjustments were performed every 500 cycles per manufacturer's preventative maintenance manual.

Note 5: Minor cosmetic wear and metal shavings consistent with normal wear and tear.

Note 6: The handle developed a loud clicking action at 1850 operating cycles.

Note 7: Test Date 07/18/19 / Time: 1:10 PM

Note 8: The deflections reported are limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation.

Note 9: Loads were held for 10 seconds.

Note 10: Tape and film were not used to seal against air leakage during structural testing.

Note 11: Test Date 07/23/19 / Time: 8:00 AM

General Note: *The window was tested in accordance with the venting use classification.*

SECTION 9
ALTERATIONS

Alteration #1: Date – 7/10/19
Cause for alteration – Specimen failed air infiltration test
Remedial action taken – Central gasket sealed, and hardware was adjusted

Alteration #2: Date – 7/11/19
Cause for alteration – Specimen failed air infiltration test
Remedial action taken – Vent removed, and hardware was adjusted

Alteration #3: Date – 7/13/19
Cause for alteration – Specimen failed life cycle test
Remedial action taken – Client provided a preventative maintenance manual, repaired vent, limit device was removed, and restarted testing

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Alteration #4: Date – 7/15/19
Cause for alteration – Client not satisfied with air infiltration results
Remedial action taken – Vent removed, and hardware was adjusted

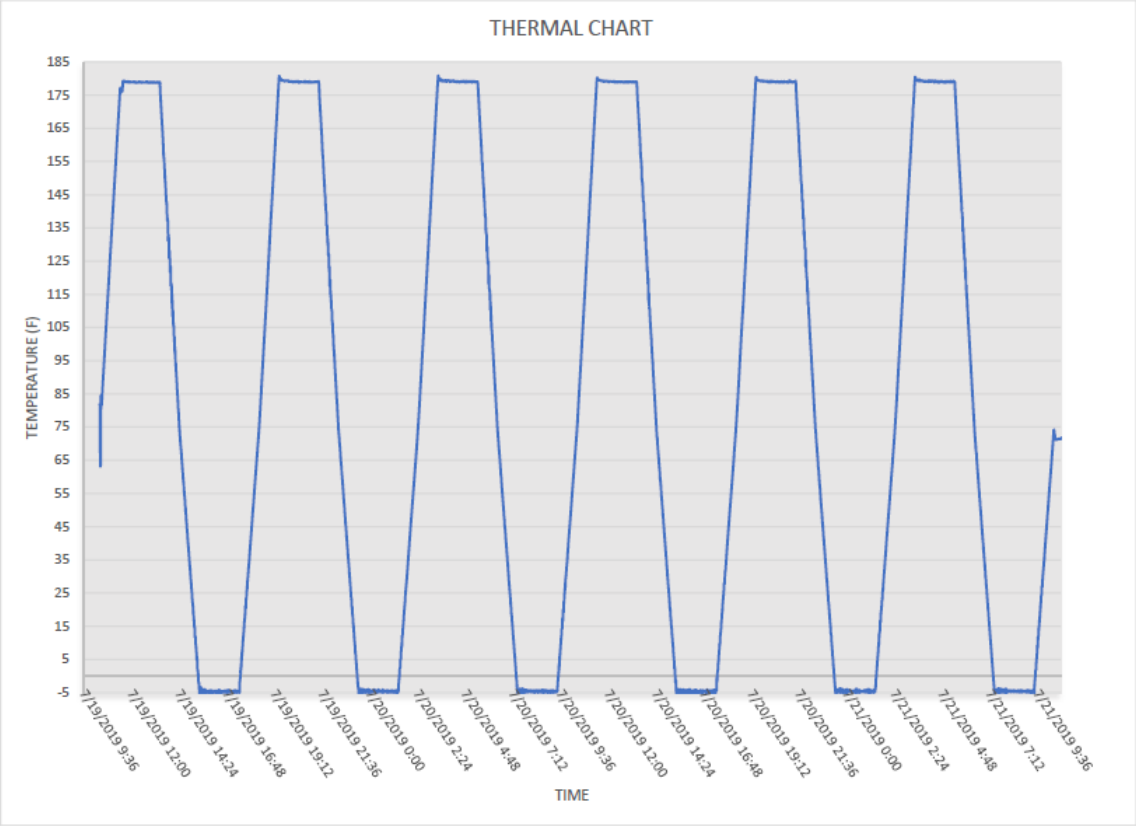
Alteration #5: Date – 7/17/19
Cause for alteration – Specimen failed water penetration test
Remedial action taken – Sill corners sealed

SECTION 10
CONCLUSION

The specimen tested successfully met the performance requirements for a **Class AW – PG90 – 914 x 1524 (36 x 60) - C** rating.

Reference Intertek B&C Report No. J3813.01-109-44, dated 08/26/19 for complete test specimen description and test results.

SECTION 11
CHART(S)



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SECTION 12
MAINTENANCE MANUAL

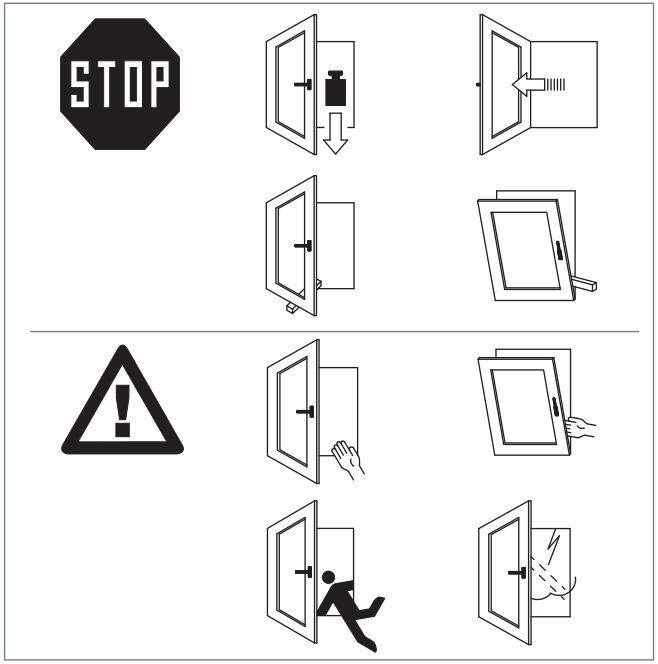
Information regarding dangers, omissions and operation

In order to avoid damage to your window, please take note of the following advice:

- Do not put any additional load on the sash
- Do not turn the sash against the wall beyond the point of resistance
- Do not jam the sash by placing an object between sash and frame

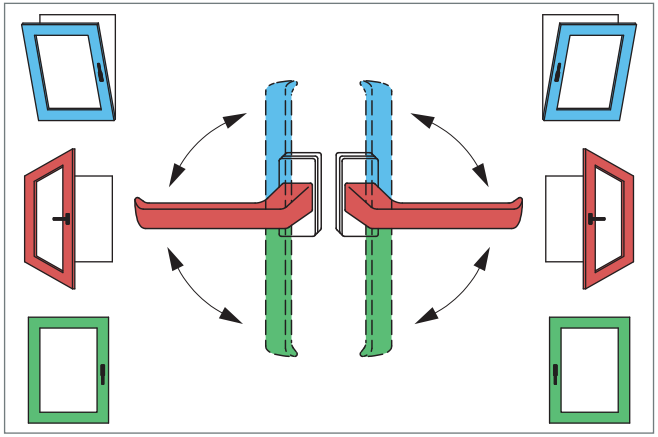
In order to prevent accidents be aware of the following hazards:

- Risk of getting crushed between frame and sash
- Risk of falling out of the open window
- Risk of injury by sash swinging open through a gust of wind



How to operate a Tilt&Turn window (Meaning of symbols)

green: sash closed
blue: sash in tilt position for ventilation
red: sash in Turn-Only position for cleaning or inrush airing



Attention:

In order to prevent hazards it is necessary that sashes in Turn-Only position be held or secured.

Maintain your window's warranty!

In order to maintain the warranty on the window hardware it is imperative that the advice on maintenance, care and hazard prevention be observed.

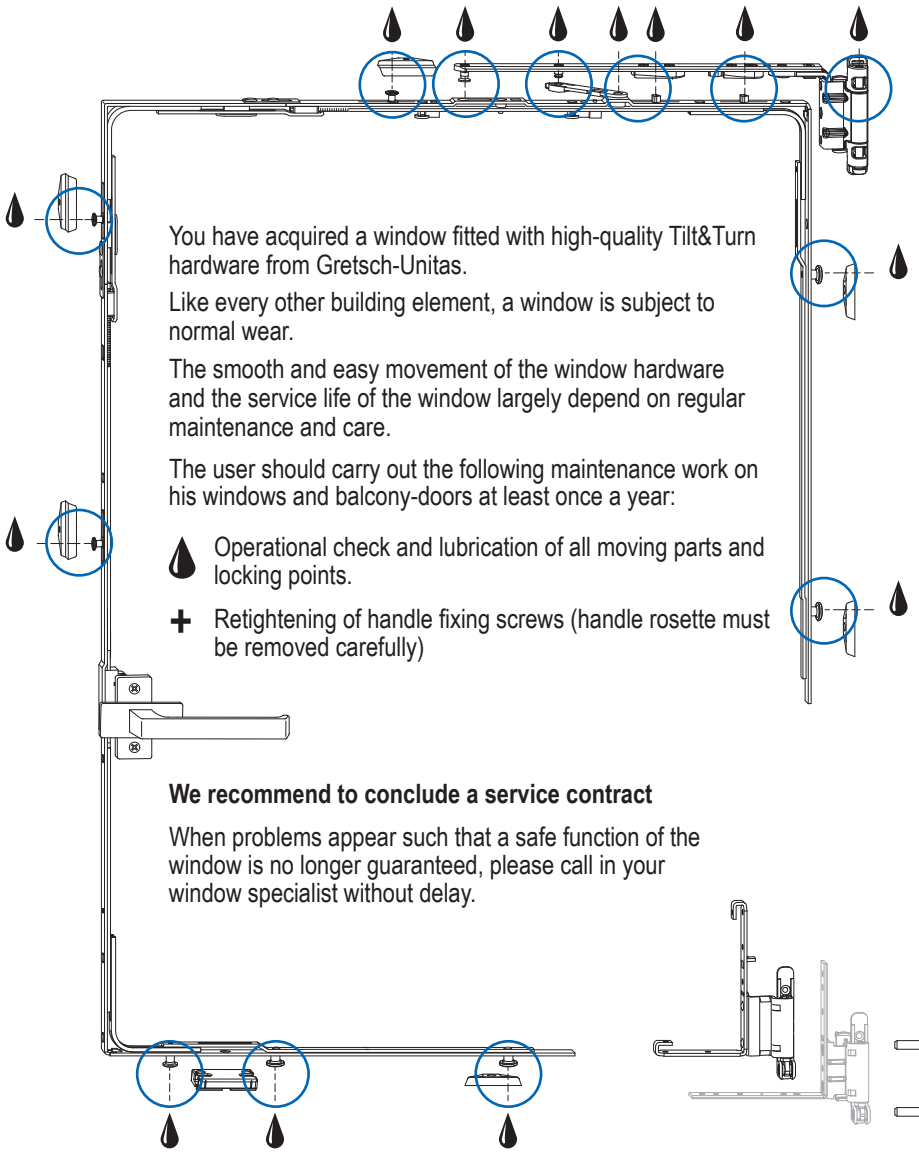
Adhesive label with operating symbols available on request.

0-45981-DD-0-EN | 02 | 06.2016 | G31173 | Designed in Germany

Operation, maintenance and care
UNI-JET
Tilt&Turn hardware

Appropriate operation, maintenance and care of windows

Address / Your Window Service



You have acquired a window fitted with high-quality Tilt&Turn hardware from Gretsch-Unitas.

Like every other building element, a window is subject to normal wear.

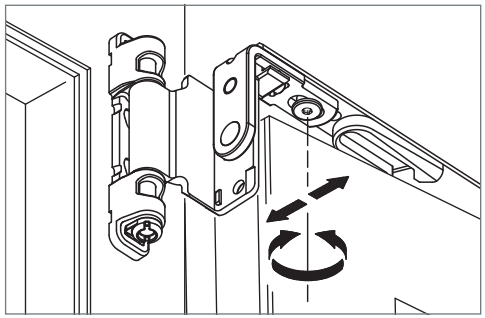
The smooth and easy movement of the window hardware and the service life of the window largely depend on regular maintenance and care.

The user should carry out the following maintenance work on his windows and balcony-doors at least once a year:

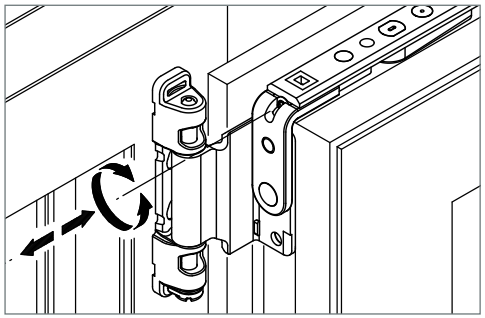
- Operational check and lubrication of all moving parts and locking points.
- \+ Retightening of handle fixing screws (handle rosette must be removed carefully)

We recommend to conclude a service contract

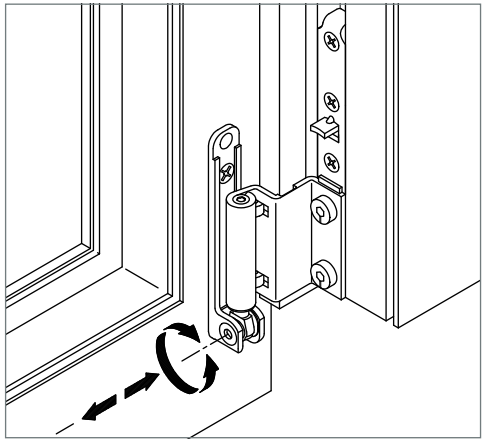
When problems appear such that a safe function of the window is no longer guaranteed, please call in your window specialist without delay.



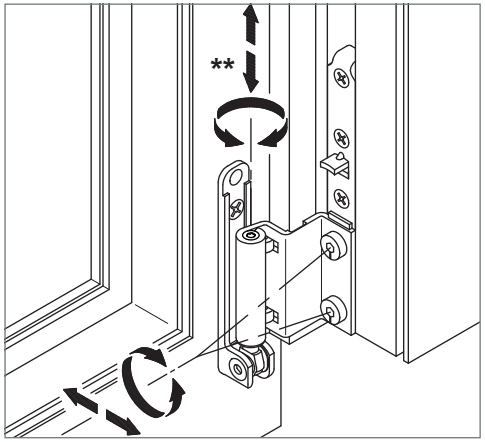
Adjusting the gasket pressure on the stay-arm



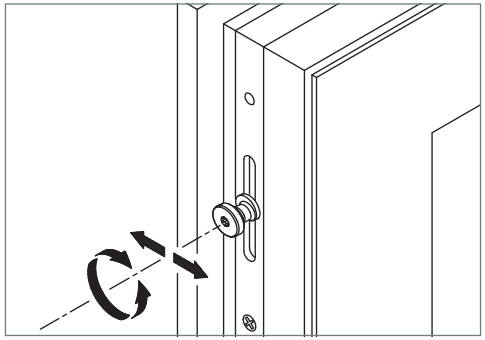
Horizontal sash adjustment on the stay-arm



Horizontal sash adjustment on the pivot-rest



Lifting the sash, adjusting the gasket pressure



Adjusting the gasket pressure on the locking cam

We recommend that the window finish and glazing be regularly checked over and damage made good.

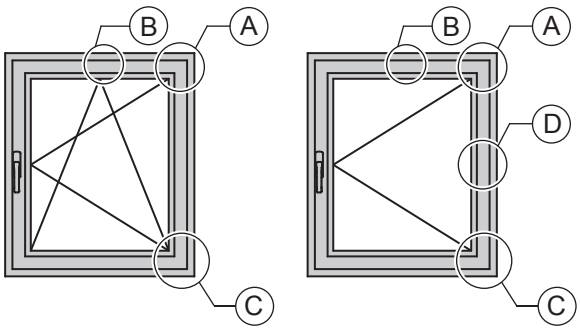
The gasket must not be painted over or cleaned with aggressive agents.

Ask your window fabricator to undertake the adjustments, if required. *

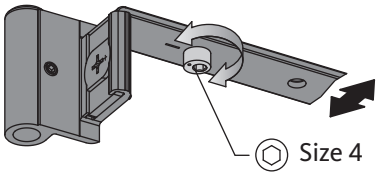
(*) Adjustment tool = Torx 15 screwdriver
or Allen key size 4 (**)

ALU-JET 610 adjustment options

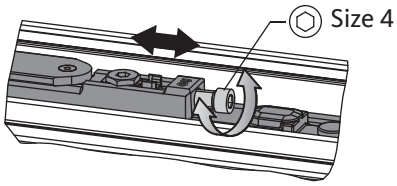
Surface-mounted hinge-sides



Ⓐ Gasket pressure adjustment
±1 mm



Ⓑ Horizontal adjustment
±3 mm



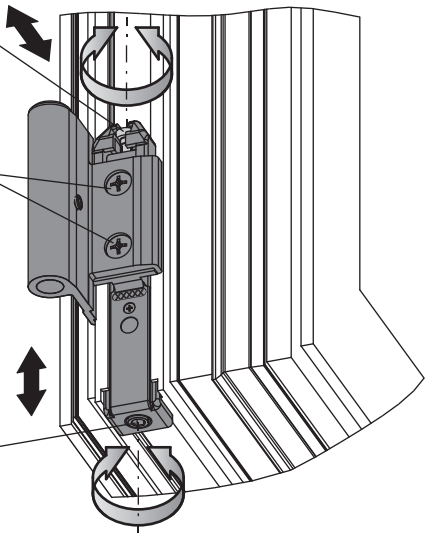
Ⓒ

Size 2.5
Horizontal adjustment ±1 mm

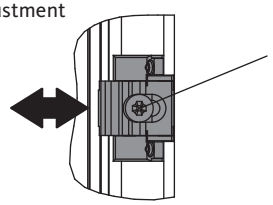
Fully relieve corner hinge before adjustment. Undo screws by turning them through 2 revolutions. Retighten screws following adjustment.

PH2
3.5 Nm

Size 4
Vertical adjustment
+2.5 mm
-1 mm



Ⓓ Gasket pressure adjustment
+2 mm
-1 mm



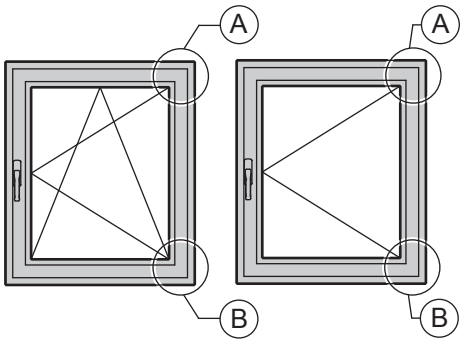
Undo screw to adjust.
Retighten screw following adjustment.

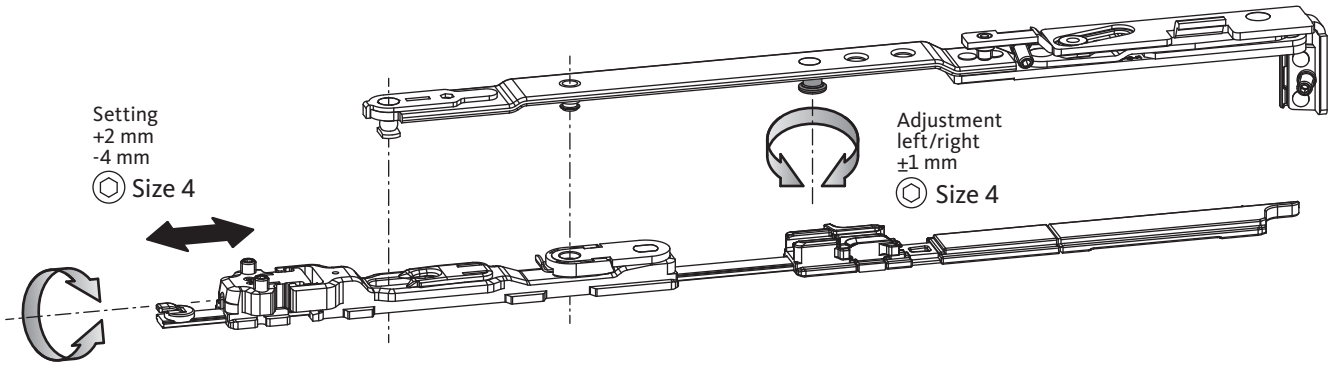
PH2
2 Nm

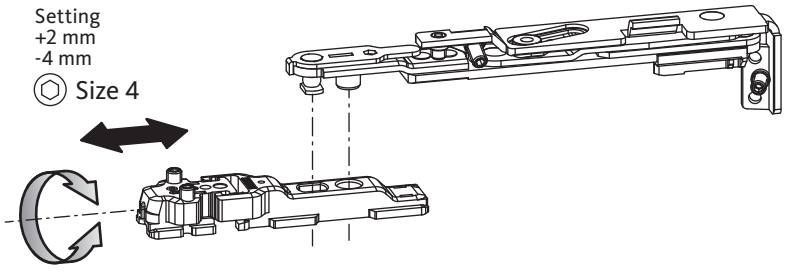
ALU-JET CC610 adjustment options

Concealed hinge-sides

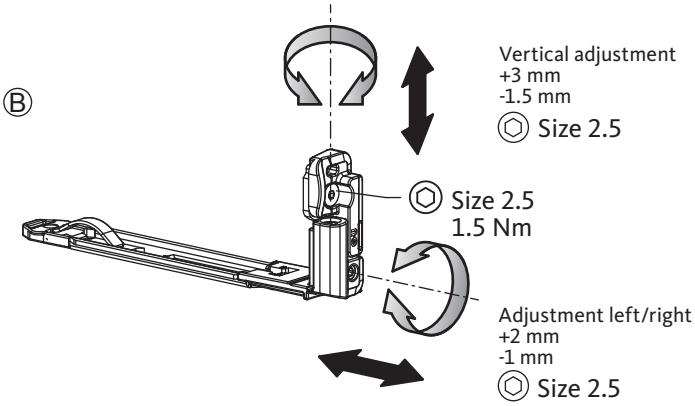
Ⓐ

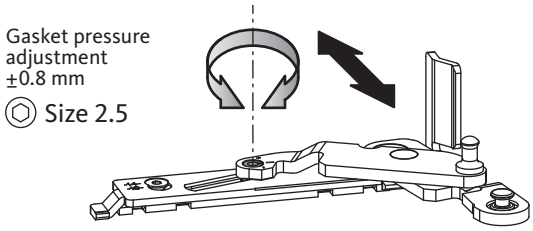




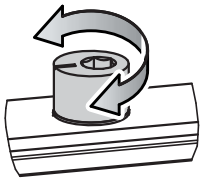


Ⓑ





11. Adjustments



Gasket pressure adjustment ± 1 mm
Size 4
at corner-drive, tilter and locking cam

NOTE **Grease the locking points and sliding points with an acid-free lubricant which is not prone to gumming.**

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SECTION 13
PHOTOGRAPH

Photo No. 1
View of Tested Specimen

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SECTION 14
DRAWINGS

The test specimen drawings have been reviewed by Intertek B&C and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek B&C per the drawings included in this report. Any deviations are documented herein or on the drawings.

intertek
Total Quality. Assured.

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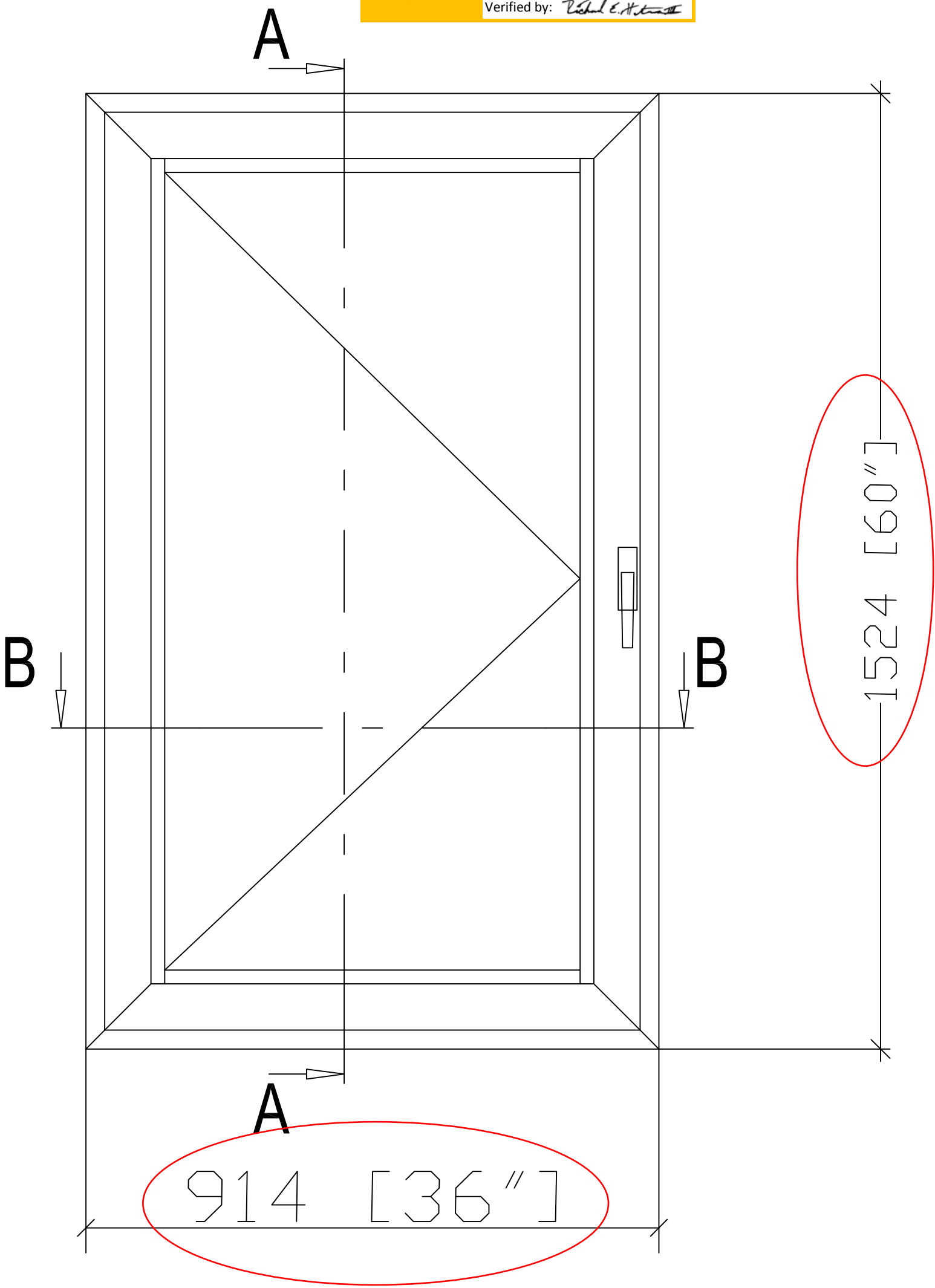
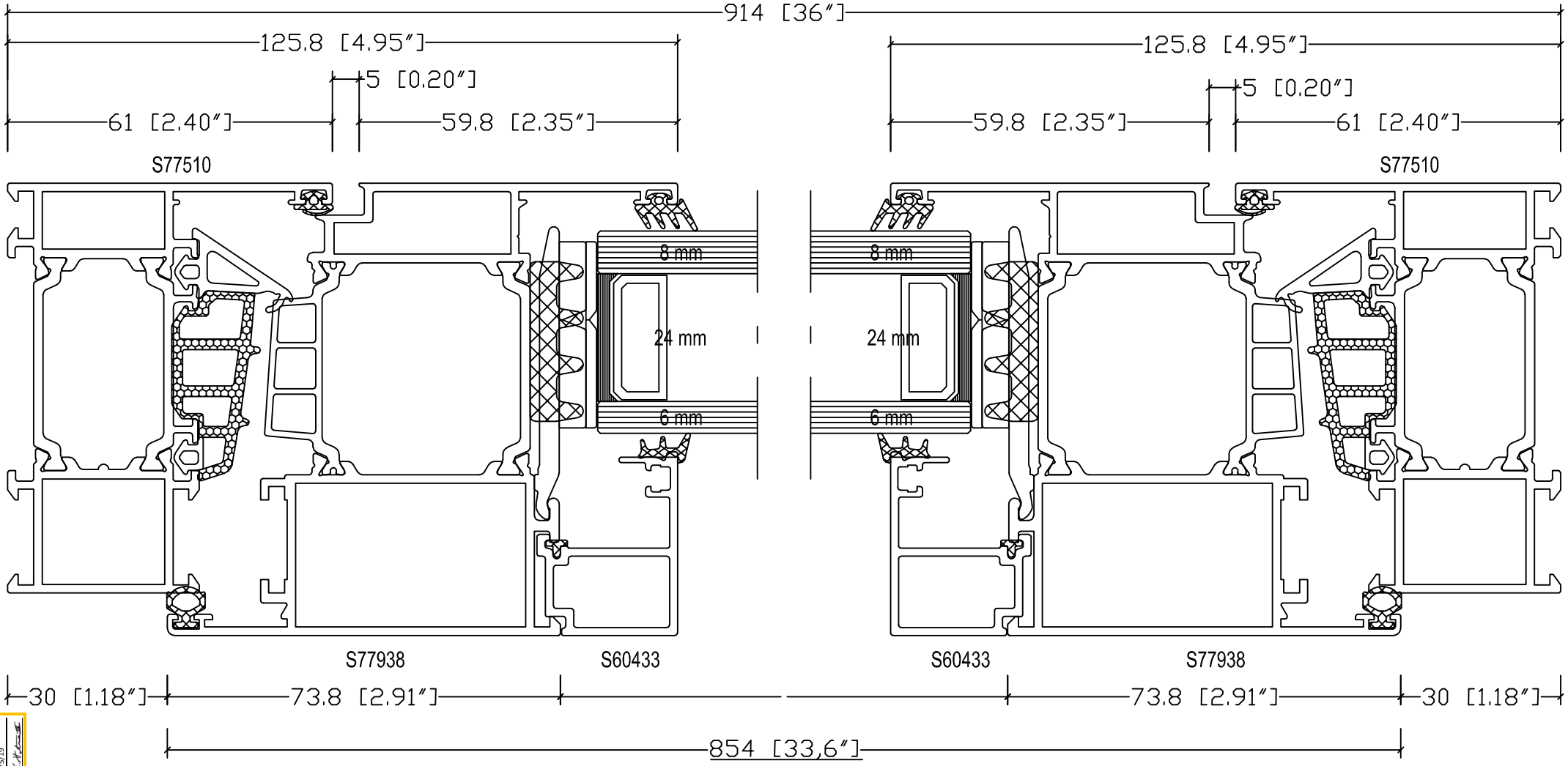
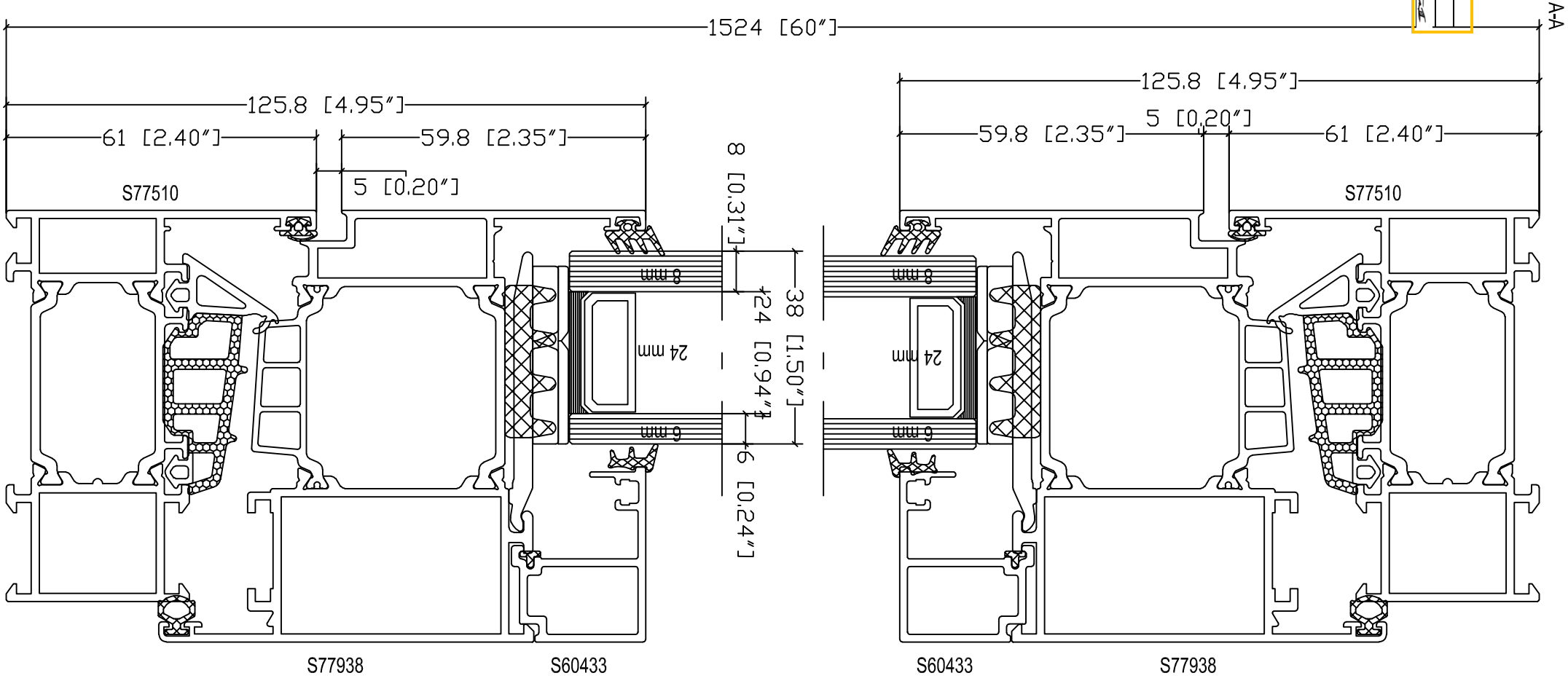


B-B





intertek
Total Quality Assured.

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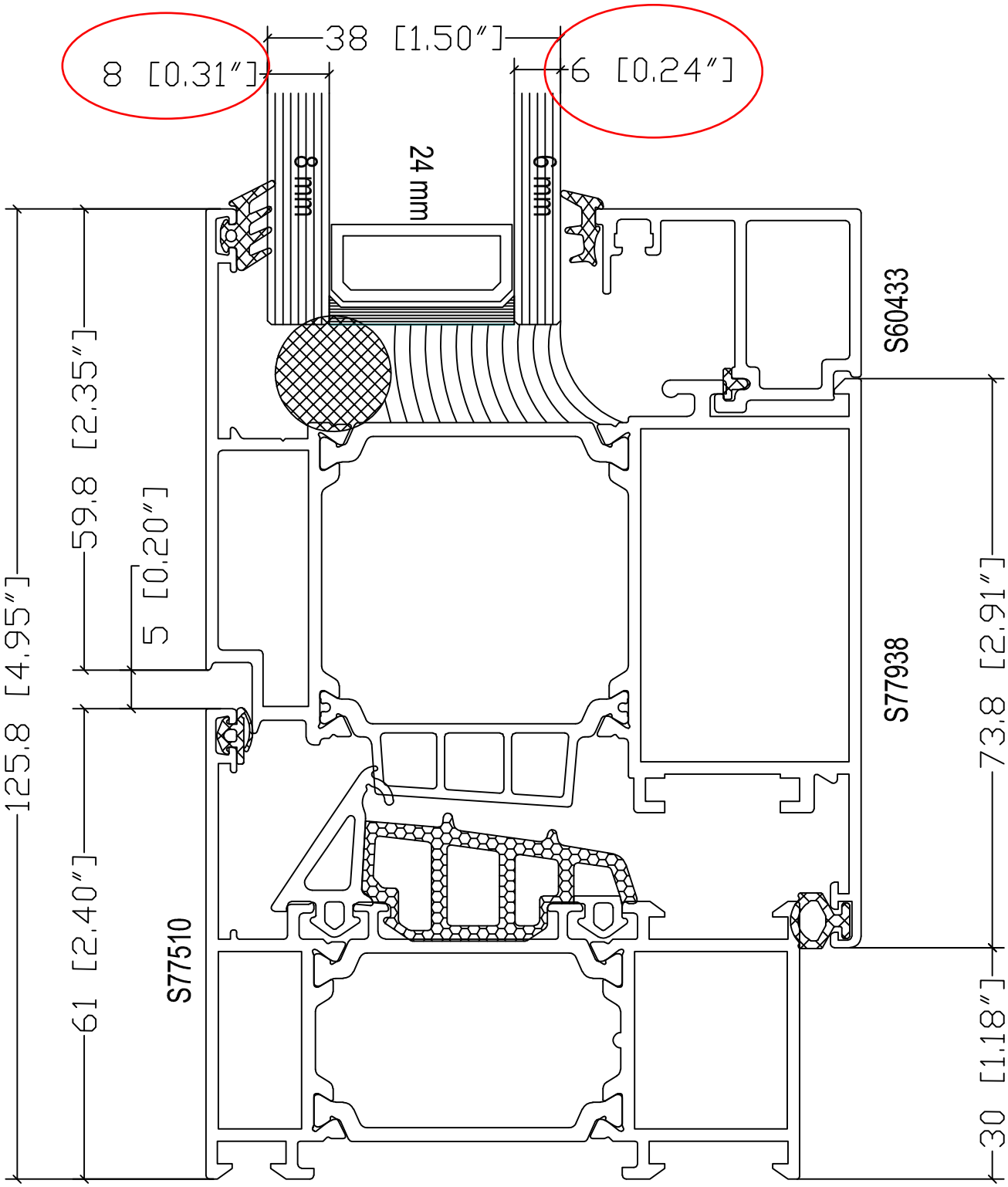
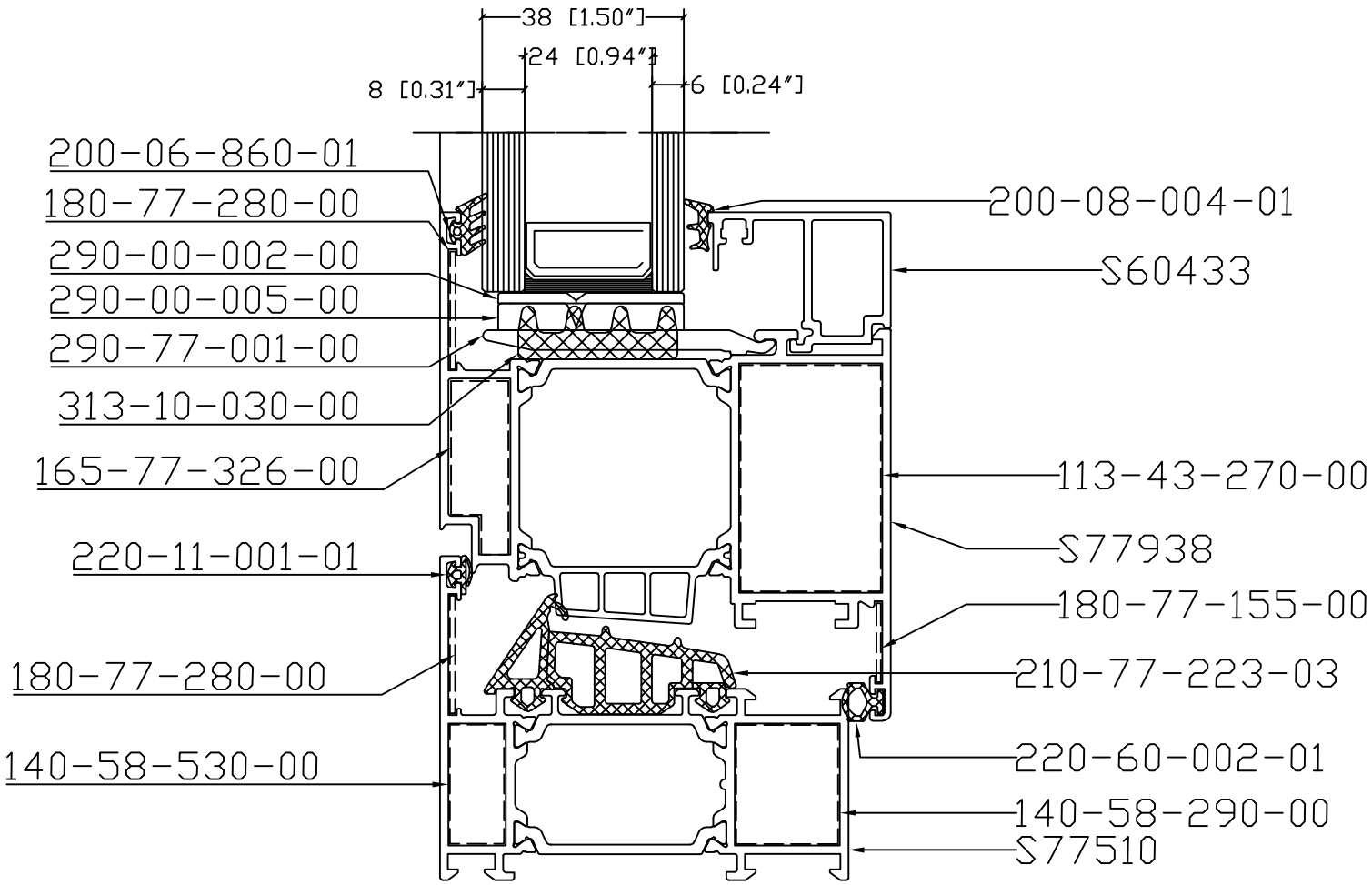
Date: 8/5/19
Verified by:


38 [1.50"]
8 [0.31"]
6 [0.24"]
8 mm
24 mm
6 mm
S60433
S77938
S77510
125.8 [4.95"]
59.8 [2.35"]
5 [0.20"]
61 [2.40"]
73.8 [2.91"]
30 [1.18"]


38 [1.50"]
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200-06-860-01
180-77-280-00
290-00-002-00
290-00-005-00
290-77-001-00
313-10-030-00
165-77-326-00
220-11-001-01
180-77-280-00
140-58-530-00
200-08-004-01
S60433
113-43-270-00
S77938
180-77-155-00
210-77-223-03
220-60-002-01
140-58-290-00
S77510

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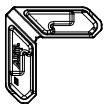
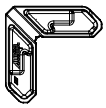
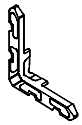
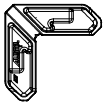
S77510 Frame width	2 pieces
S77510 Frame height	2 pieces
S77938 Sash width	2 pieces
S77938 Sash height	2 pieces
S60433 Glazing bead width	2 pieces
S60433 Glazing bead height	2 pieces

210-77-223-03		Central gasket
255-77-223-03		Vulcanized corner
220-60-002-01		Sash gasket
220-11-001-01		Frame gasket
200-06-860-01		External glazing gasket
200-08-004-01		Internal glazing gasket
220-11-449-12		Gasket for glazing bead
290-00-005-00		5mm Shim
290-00-002-00		2mm Shim
290-77-001-00		Glazing bridge
313-10-030-00		Glazing foam 30x10 mm
180-77-011-00		Alignment corner
180-77-280-00		Alignment corner
140-58-530-00		Die cast corner cleat
140-58-290-00		Die cast corner cleat
165-77-116-00		Cast spring cleat
140-58-310-00		Die cast corner cleat

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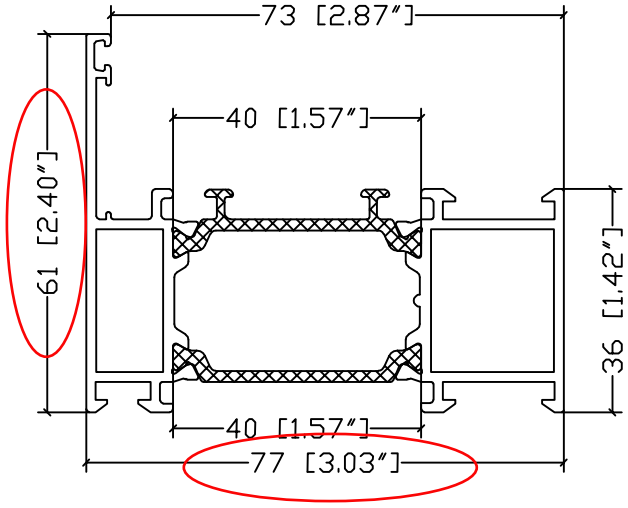
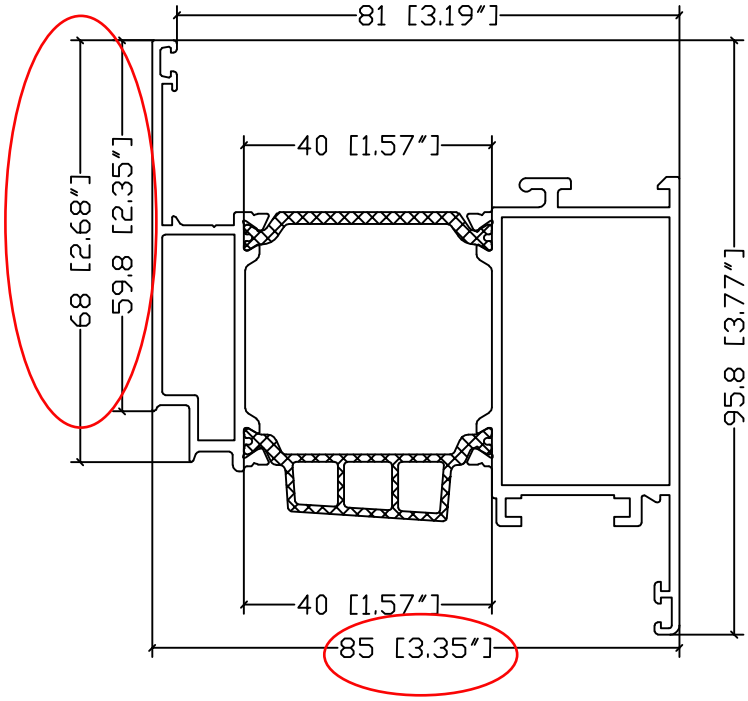
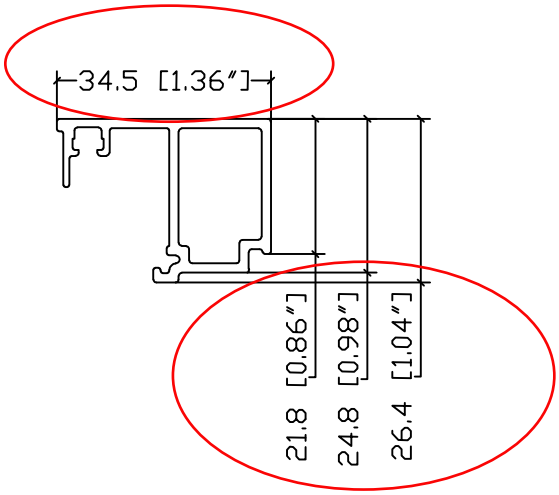
S77510



S77938



S60433



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Report No.: J3813.01-109-44
Date: 08/26/19

SECTION 15
REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	08/26/19	N/A	Original Report Issue