

**TEST REPORT**

**Report No.:** A7901.01-701-44

**Rendered to:**

PRL ALUMINUM ARCHTECTURAL PRODUCTS  
City of Industry, California

**PRODUCT TYPE:** Aluminum Sliding Glass Door  
**SERIES/MODEL:** PRL Max Top Rolling Sliding Door "CABO"

**SPECIFICATION:** AAMA/WDMA/CSA 101/I.S.2/A440-08, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

<b>Title</b>	<b>Summary of Results</b>
Primary Product Designator	Class R-PG15-SD 2210 x 2134 (87x 84)
Design Pressure	±720 Pa (±15.04 psf)
Air Infiltration	1.5 L/s/m <sup>2</sup> (0.28 cfm/ft <sup>2</sup> )
Water Penetration Resistance Test Pressure	180 Pa (2.92 psf)

**Test Completion Date:** 5/3/2011

**This report contains in its entirety:**

**Cover Page:** 1 page  
**Report Body:** 8 pages  
**Alteration Addendum:** 1 page  
**Drawings:** 19 pages

Reference must be made to Report No. A7901.01-701-44 dated 07/28/11 for complete test specimen description and detailed test results.

**1.0 Report Issued To:** PRL Aluminum Architectural Products  
14760 Don Julian Road  
City of Industry, California 91746

**2.0 Test Laboratory:** Architectural Testing, Inc.  
4 Rancho Circle  
Lake Forest, CA 92630  
949.460.9600

**3.0 Project Summary:**

**3.1 Product Type:** Aluminum Sliding Glass Door

**3.2 Series/Model:** PRL Max Top Rolling Sliding Door "CABO"

**3.3 Compliance Statement:** Results obtained are tested values and were secured by using the designated test method(s). The specimen tested successfully met the performance requirements for a **Class R-PG15-SD 2210 x 2134 (87x 84)** rating.

**3.4 Test Dates:** 2/17/2011 - 5/3/2011

**3.5 Test Location:** Architectural Testing's test facility in Lake Forest, California.

**3.6 Test Sample Source:** The test specimen was provided by the client. Representative samples of the test specimen will be retained by Architectural Testing for a minimum of four years from the test completion date.

**3.7 Drawing Reference:** The test specimen drawings have been reviewed by Architectural Testing and are representative of the test specimen reported herein. Test specimen construction was verified by Architectural Testing per the drawings located in Appendix B. Any deviations are documented herein or on the drawings.

**3.8 List of Official Observers:**

<u>Name</u>	<u>Company</u>
Frank Fisher	PRL Aluminum
John Mayfield	Architectural Testing, Inc.

#### 4.0 Test Specification(s):

AAMA/WDMA/CSA 101/I.S.2/A440-08, *NAFS - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

#### 5.0 Test Specimen Description:

##### 5.1 Product Sizes:

Overall Area: 4.7 m <sup>2</sup> (50.4 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	2210	87	2121	83-1/2
Rough Opening	2216	87-1/4	2127	83-3/4
Active Panel Size	1118	44	2045	80-1/2

##### 5.2 Frame Construction:

Frame Member	Material	Description
Head	Aluminum	Custom shaped extruded aluminum
Interior trim plate	Aluminum	Snapped into the accessory groove of the head and fully sealed along the exterior joint
Exterior trim plate	Aluminum	Snapped into the accessory groove of the head and fully sealed along the exterior joint
Top fixed panel shoe	Aluminum	Snapped in and fully sealed into the exterior pocket of the head and secured using one #10 x 2" sheet metal screw located 4" on center from the ends and 12" on center thereafter
Bottom fixed panel shoe	Aluminum	Bedded in sealant below the bottom rail of the fixed panel and secured to the test buck using one #8 x 1" sheet metal screw located 4" on center from the ends and 12" on center thereafter.
Sill/Track guide	Aluminum	Bedded in sealant full length and fully sealed to each jamb member; secured to the test buck using one #8 x 1" sheet metal screw located 10" on center from the ends and at the midpoint.
Jamb	Aluminum	Custom shaped extruded aluminum member with 2 pockets
Exterior jamb pocket cover	Aluminum	Snapped into the exterior jamb pocket of the strike jamb
Interior jamb pocket cover	Aluminum	Snapped into the interior jamb pocket of the fixed panel



**5.0 Test Specimen Description: (Continued)**

	<b>Joinery Type</b>	<b>Detail</b>
Head/Jamb	Butted and sealed	Corners were butted and sealed full perimeter using sealant
Threshold/jamb	Butted and sealed	Corners were butted and sealed full perimeter using sealant

**5.3 Panel Construction:**

<b>Fixed Panel Member</b>	<b>Material</b>	<b>Description</b>
Rails	Aluminum	Custom shaped extruded aluminum
Stiles	Aluminum	Custom shaped extruded aluminum

<b>Active Panel Member</b>	<b>Material</b>	<b>Description</b>
Rails	Aluminum	Custom shaped extruded aluminum
Stiles	Aluminum	Custom shaped extruded aluminum

	<b>Joinery Type</b>	<b>Detail</b>
Rail/Stile	Butted	Members are butted and secured using a custom-shaped aluminum L-shaped bracket that is secured through the glazing pocket of the rail member using two #10 x1" sheet metal screws and secured to the stile using a #10 x 3/4" socket head cap bolt with a #10 lock nut.

## 5.0 Test Specimen Description: (Continued)

### 5.4 Weatherstripping:

Description	Quantity	Location
0.320" x 0.270 pile w/fin	1 Row	Interior face of the interior trim plate
0.320" x 0.270 pile w/fin	1 Row	Interior face of the exterior trim plate
0.320" x 0.270 pile w/fin	2 Rows	Jamb face of the lock stile
0.290" x 0.270 pile w/fin	1 Row	Interior leg of the interior jamb pocket
0.290" x 0.270 pile w/fin	1 Row	Exterior leg of the interior jamb pocket
0.320" x 0.270 pile w/fin	2 Rows	Jamb face of the fixed stile
0.290" x 0.270 pile w/fin	1 Row	Exterior leg of the exterior jamb pocket
0.290" x 0.270 pile w/fin	1 Row	Interior leg of the exterior jamb pocket
0.320" x 0.270 pile w/fin	2 Rows	Interior face of the fixed interlock stile
3" x 2" x 1" open cell foam	1 Plug	Fully sealed into the top hollow of the fixed interlock extrusion
2" x 2" x 1" open cell foam	1 Plug	Fully sealed into the bottom hollow of the fixed interlock extrusion
0.290" x 0.270 pile w/fin	2 Rows	Exterior face of the interlocking stile of the active panel

### 5.5 Glazing:

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
1-1/4" IG	Aluminum box	1/4" Tempered	1/4" Tempered	Marine glazed into a rubber glazing gasket

Location	Quantity	Daylight Opening		Glass Bite
		millimeters	inches	
Fixed panel	1	965 x 1778	38 x 70	0.625"
Active panel	1	965 x 1778	38 x 70	0.625"

## 5.0 Test Specimen Description: (Continued)

### 5.6 Drainage:

Drainage Method	Size	Quantity	Location
Weep hole	1/2" wide x 1/2" high	6	4" on center from the ends and 16" on center thereafter through the exterior leg of the track guide
Weep hole with open cell foam baffle	1" wide by 1/4" high	2	3" on center from the ends of the fixed panel jambs through the interior and exterior leg of the shoe assembly

### 5.7 Hardware:

Description	Quantity	Location
Bottom mounting bar	2	Installed into the top rail of the active panel at each end using four 1/4" x 3-1/2" flat head machine screws that are secured through the top of the roller housing into an aluminum screw boss spacers, which are inserted into the top rail hollow
Top mounting bar	2	Inserted into the bottom mounting bar and secured using a #10 x 1" socket head cap screw stop and using a #8 x 1/2" grub screw
Top roller assembly	2	Attached to the top mounting bar at the midpoint
Track bar	2	Installed 4" on center from each of the head using two #8 x 3/4" flat head machine screws
Pemco weatherstripping assembly	1	Inserted into the bottom rail of the active panel and secured using one #8 x 1" pan head machine screw
Adams-Rite lock set	1	Located at the midpoint of the stile.

## 5.0 Test Specimen Description: (Continued)

**5.8 Reinforcement:** No reinforcement was utilized.

**5.9 Screen Construction:** No screen was utilized.

## 6.0 Installation:

The specimen was installed into a 2x6 aluminum test frame, which was secured into a 2x10 fir test buck using 3/4" wood stops located at the interior and exterior. The exterior perimeter of the door was sealed with sealant.

<b>Location</b>	<b>Anchor Description</b>	<b>Anchor Location</b>
Jambs	#10 x 2" Phillips flat head sheet metal screw	3" on center from the head and sill and 16" on center thereafter
Head	#10 x 1" Phillips flat head sheet metal screw	3" on center from the ends and 12" on center thereafter
Bottom fixed panel shoe	#10 x 1" Phillips flat head sheet metal screw	4" on center from the ends and 12" on center thereafter.
Track guide	#10 x 1" Phillips flat head sheet metal screw	10" on center from the ends and at the midpoint.

**7.0 Test Results:** The temperature during testing was 25°C (77°F). The results are tabulated as follows:

Title of Test	Results	Allowed	Note
<b>Operating Force,</b> per ASTM E 2068	Initiate motion: 62.3 N (14 lbf) Maintain motion: 31.1 N (7 lbf) Lock: 17.8 N (4 lbf)	135.0 N (30 lbf) max.  90.0 N (20 lbf) max.  100.0 N (22.5 lbf) max.	
<b>Air Leakage,</b> Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	1.4 L/s/m <sup>2</sup> (0.28 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1
<b>Water Penetration,</b> per ASTM E 547 at 180 Pa (2.92 psf)	Pass	No leakage	2
<b>Uniform Load Deflection,</b> per ASTM E 330 taken on the fixed interlock stile +720 Pa (+15.04 psf) -720 Pa (-15.04 psf)	3.0 mm (0.12") 3.3 mm (0.13")	Report Only Report Only	4, 5, 6
<b>Uniform Load Structural,</b> per ASTM E 330 taken on the fixed interlock stile +1080 Pa (+22.56 psf) -1080 Pa (-22.56 psf)	0.2 mm (0.01") 0.2 mm (0.01")	7.8 mm (0.31") max. 7.8 mm (0.31") max.	5, 6
<b>Forced Entry Resistance,</b> per ASTM F 842, Type: A - Grade: 10	Pass	No entry	
<b>Deglazing,</b> per ASTM E 987 Operating direction, 320 N (70 lbf)	Pass	Meets as stated	
Remaining direction, 230 N (50 lbf)	Pass	Meets as stated	



*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: Without insect screen.*

*Note 3: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.*

*Note 4: The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation. The deflection data is recorded in this report for special code compliance and information only.*

*Note 5: Loads were held for 10 seconds.*

*Note 6: Tape and film were not used to seal against air leakage during structural testing.*

The service life of this report will expire on the stated Test Record Retention End Date, at which time such materials as drawings, data sheets, samples of test specimens, copies of this report, and any other pertinent project documentation, shall be discarded without notice.

If test specimen contains glazing, no conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) 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 specimen(s) tested. This report may not be reproduced, except in full, without the written approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, Inc.

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John S. Mayfield  
Project Manager

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Shawn G. Collins, P.E.  
Laboratory Support Engineer

JM:cmd/bu

Attachments (pages): This report is complete only when all attachments listed are included.

Appendix-A: Alteration Addendum (1)

Appendix-B: Drawings (19)

## Appendix A

### Alteration Addendum

**Alteration #1:** Date - 4/27/11  
Cause for alteration – Water infiltration over the interior sill leg  
Remedial action taken – Cut additional weep holes into the sill member  
and inserted open cell foam baffles



Architectural Testing

Test Report No.: A7901.01-701-44

Report Date: 07/28/11

Test Record Retention End Date: 05/03/15

## **Appendix B**

### **Drawings**

**PRL Max sliding door "CABO"**

Bill of Material

key number	PRL part number	manufacturer	description	qty required	size
1	2239	PRL proprietary	top frame rail	2	W
2	2238	PRL proprietary	top rail trim plates	2	W
3	2236	PRL proprietary	top and bottom fixed panel shoe	2	(W/2)+3/4"
4	2205	PRL proprietary	top and bottom sash rails	4	(W/2)- 5 1/16"
5	BS_F01	PRL proprietary	sill track/guide	2	W
6	2195	PRL proprietary	frame jamb	4	H- 1.6"
7	2201	PRL proprietary	sash lock/jamb stile	2	H-2 1/8"
8	2237	PRL proprietary	sash interlock stiles	2	H-2 1/8"
9	2197	PRL proprietary	frame jamb closer	2	H-1.6"
10	32027045BKQB	PRL proprietary	fin seal 0.320 x 0.270 base (typ horizontally)	2	W
11	29027045BKQB	Amesbury	fin seal 0.290 x 0.270 base (typ horizontally)	12	H
12	BL-4288	bandlock	glazing channel	2	(4*H)+(2*W)
20	<b>Roller Assembly comprises:</b>			2 per leaf	
A		PRL proprietary	roller wheel	1	
B	2329	PRL proprietary	top mounting bar	1	10"
C	2329-B	PRL proprietary	bottom mounting bar	1	12"
D	4766	Sierra aluminum	spacers	4	1"
E	commodity	commodity	1.28"x 0.6" track bar	1	7 1/2"
F		PRL proprietary	4" x 1.5" x 1/4" angle corner cleat	1	1 1/4"
1A		commodity	#8 x 1/2" grub screw	1	
2A		commodity	1/4" x 3 1/2" flat head screw	4	
3A		commodity	#10x 1" socket head cap screw (mounting bar stop)	1	
4A		commodity	#10 x 3/4" flat head screw	2	
5A		commodity	#10 x 3/4" socket head cap screw (stile to rail secure)	1	
6A		commodity	#10 nylock nut	1	
7A		commodity	#10 x 1" sheet metal screw (stile to rail secure)	1	
8A		commodity	1/4" x 3/4" flat head screw	2	
22	CRL-434	Pemco	operating sash bottom rail weather-strip	1	(W/2) - 4 7/8"
23	generic		open cell foam	6	1"
			insulated glass width	2	(W/2)- 3 3/4"
			insulated glass height	2	H- 10 15/16"
			Adams Rite 4189 lock set with 4195 interior handle	1	



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

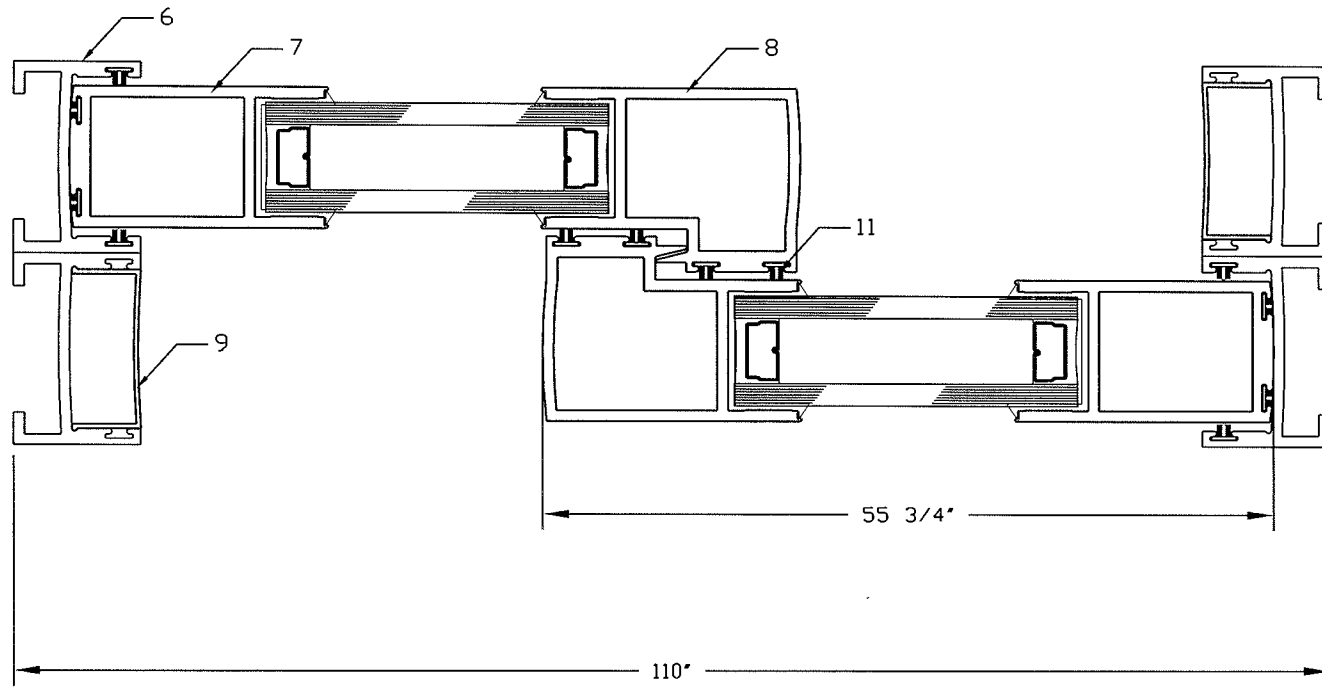
Report# 17901.01  
Date 7/5/11 Tech [Signature]

# max sliding door "CABO"



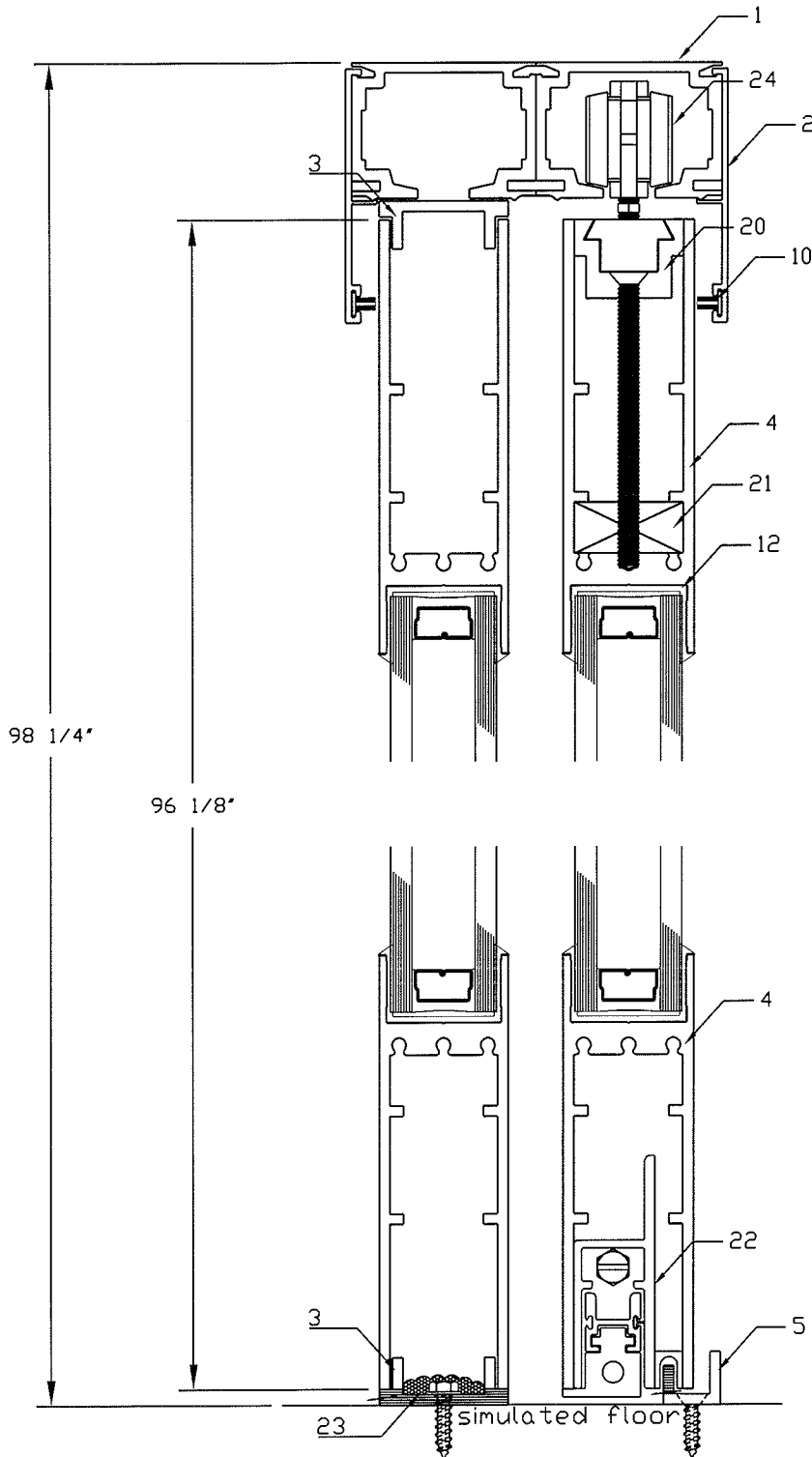
Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 7/5/11 Tech \_\_\_\_\_



**PRL**   
ALUMINUM INC.

# max sliding door "CABO"



**Architectural Testing**

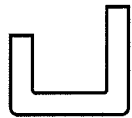
Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 7/5/11 Tech \_\_\_\_\_

part #3 & 5  
have 3 weep  
holes per light  
1/2" wide.

**PRL**   
ALUMINUM INC.

DIE NO. ~~SS-701~~ SS-701



full size

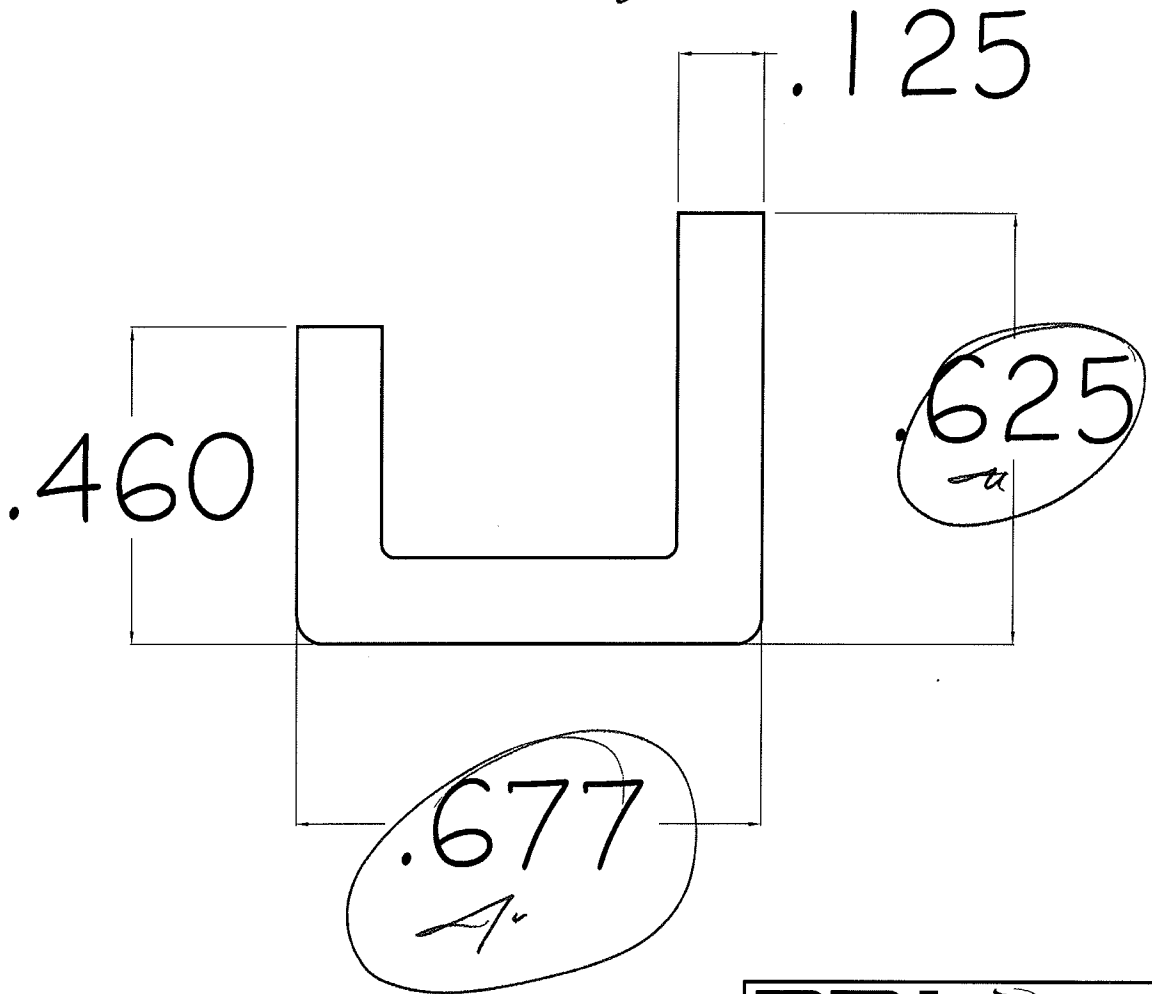


### Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report# A7901.01

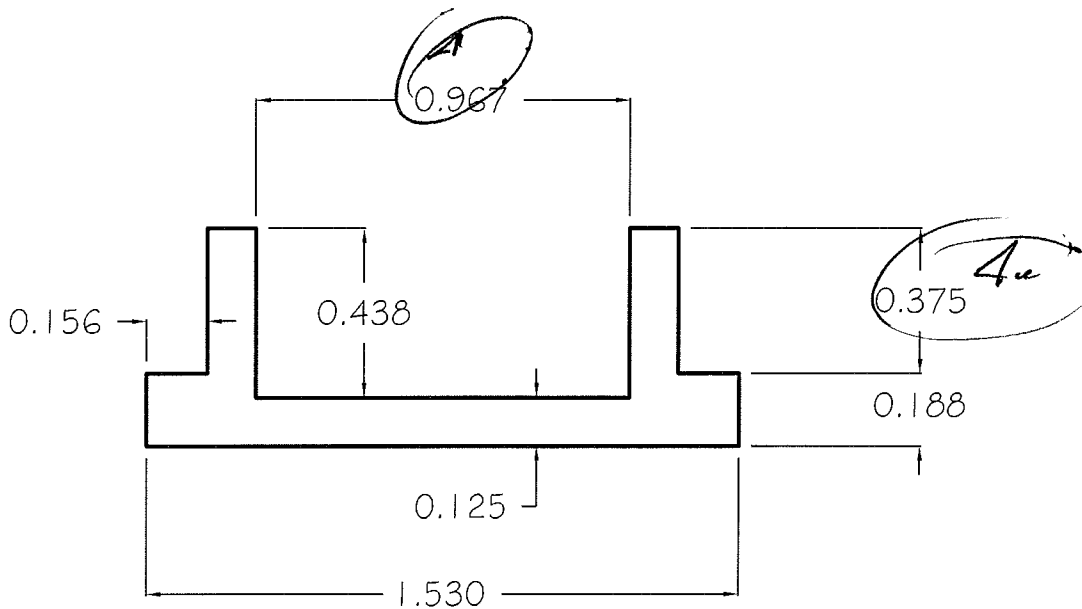
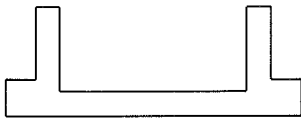
Date 2/6/11 Tech [Signature]



**PRL**  
**ALUMINUM INC.**  
14760 DON JULIAN RD.  
INDUSTRY CA. 91746  
TEL. (877) 775-2586  
PRL-ALUM  
FAX (877) 274-8800  
PART NAME: Sill guide  
PART #

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2236



Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 7/5/11 Tech AJ

UNLESS OTHER WISE NOTED .125 TYP. WALL

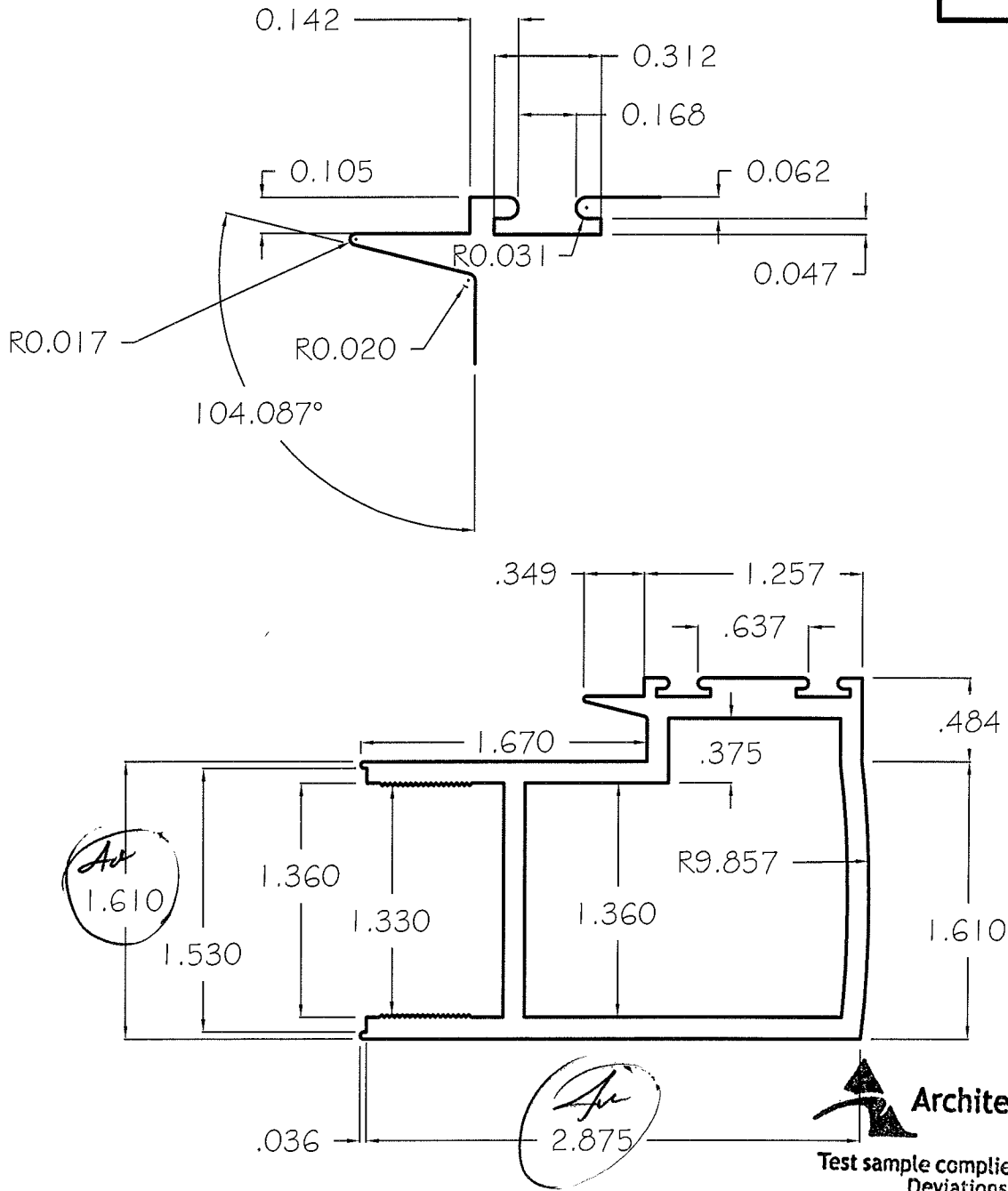
UNMARKED CORNERS .010 R.

REVISION	CUSTOMER: PRL ALUMINUM INC			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
MAT.'L	6063-T5	HOLES	* CRITICAL DIM.	PART NAME: Setting track
AREA	0.321	BACKER	⊗ SPECIAL TOOL	
WT. / FT	0.384	BOLSTER		
PERI.	5.06	W/P	DRAWN: AJ	
FACTOR	13.17	EXT. RATIO	DATE: 4/07/10	
C.C.D.	CLASS Solid	SCALE	1 : 2	
PART #				



UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2237



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 2/5/11 Tech A

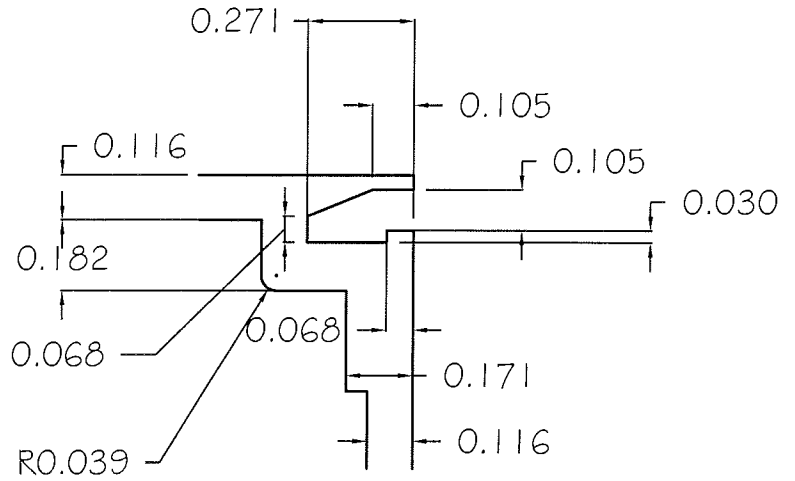
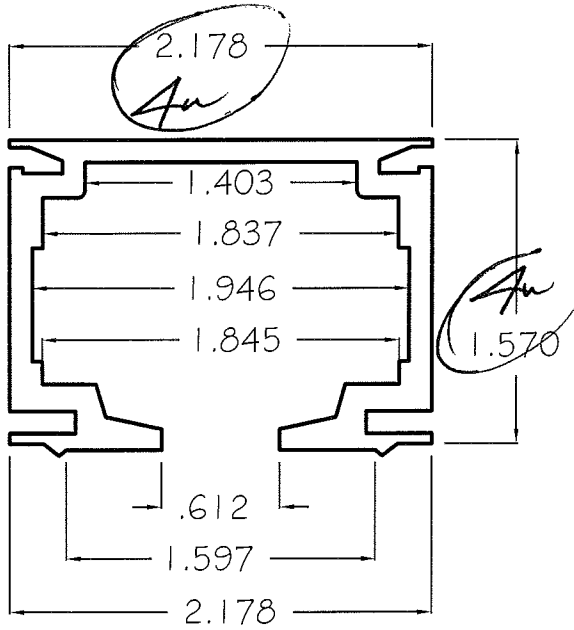
UNLESS OTHER WISE NOTED .125 TYP. WALL

UNMARKED CORNERS .010 R.

REVISION	CUSTOMER: PRL ALUMINUM INC			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
	MAT'L	6063-T5	HOLES	
	AREA	1.277	BACKER	⊗ SPECIAL TOOL
	WT./ FT	1.534	BOLSTER	
	PERI.	20.77	W/P	DRAWN: AJ
	FACTOR	13.54	EXT. RATIO	DATE: 4/07/10
	C.C.D.		CLASS Hollow	SCALE 1 : 1
				PART NAME: Int Lock Stile
				PART #

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2239



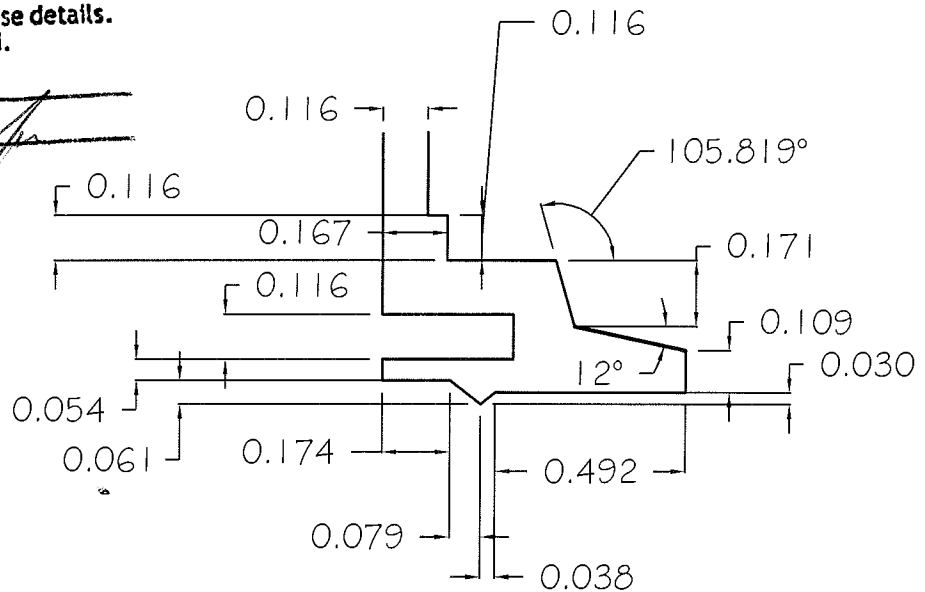
**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A1001.01

Date 7/5/11

Tech [Signature]



UNLESS OTHER WISE NOTED TYP. WALL

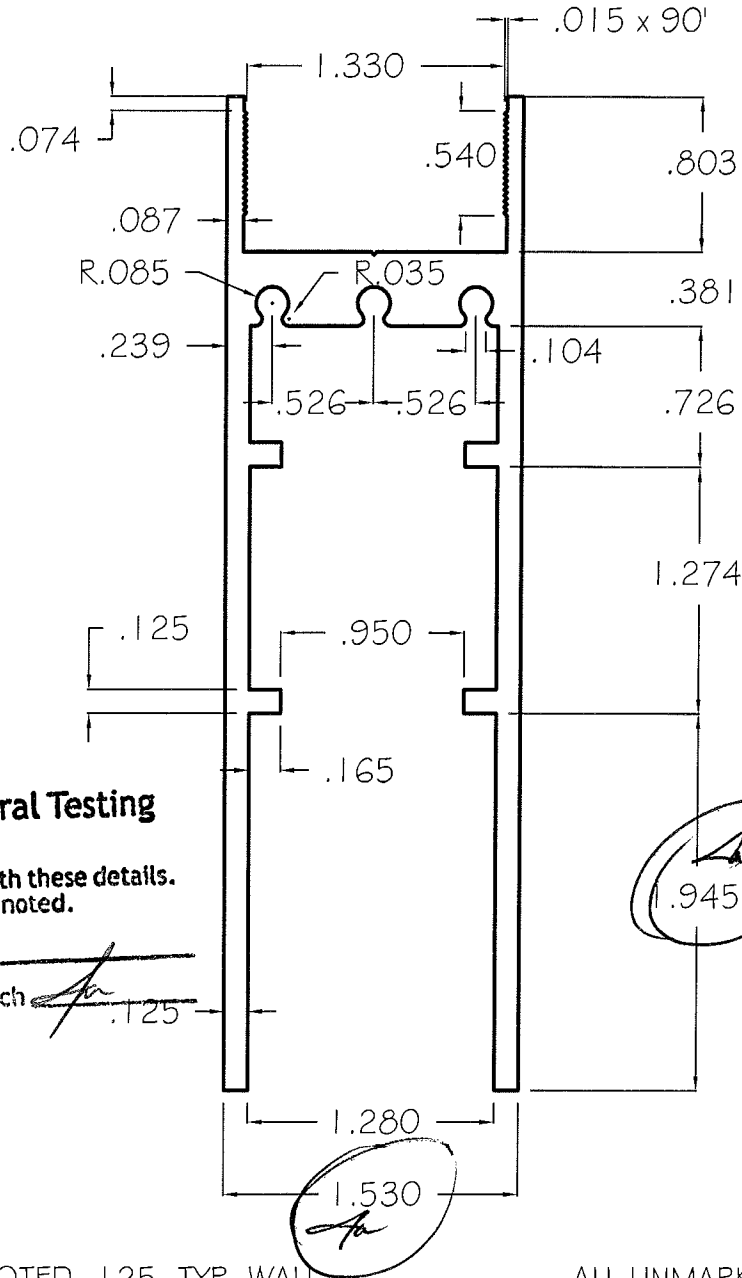
UNMARKED CORNERS .010 R.

REVISION	CUSTOMER: PRL ALUMINUM INC		
MAT'L	G063-T5	HOLES	* CRITICAL DIM.
AREA	.905	BACKER	⊗ SPECIAL TOOL
WT. / FT	1.086	BOLSTER	DRAWN: AJ
PERI.	15.50	W/P	DATE: 4/07/10
FACTOR	14.27	EXT. RATIO	PART NAME: Top track
C.C.D.	CLASS Solid	SCALE 1 : 1	PART #

**PRL**  
ALUMINUM INC.  
14760 DON JULIAN RD.  
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PRL-ALUM  
FAX (877) 274-8800

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2205



Test sample complies with these details.  
Deviations are noted.

Report# A 7901.01  
Date: 7/5/11 Tech [Signature]

[Signature]  
1.945

[Signature]  
1.530

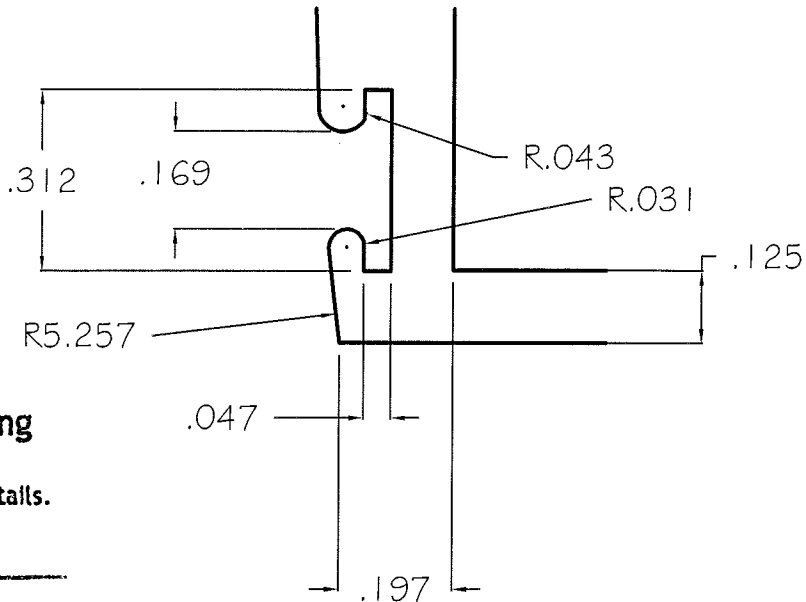
UNLESS OTHER WISE NOTED .125 TYP. WALL

ALL UNMARK CORNER ARE 0.010

REVISION	CUSTOMER:			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
	Revised as of 2/11/10			
MAT.'L	G063-T5	HOLES	* CRITICAL DIM.	PART NAME:
AREA	1.72	BACKER	⊗ SPECIAL TOOL	
WT. / FT	2.06	BOLSTER	DRAWN: AJ	PART #
PERI.	25.73	W/P	DATE: 12/8/09	
FACTOR	12.50	EXT. RATIO	SCALE 1:1	
C.C.D.	CLASS	Solid		

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

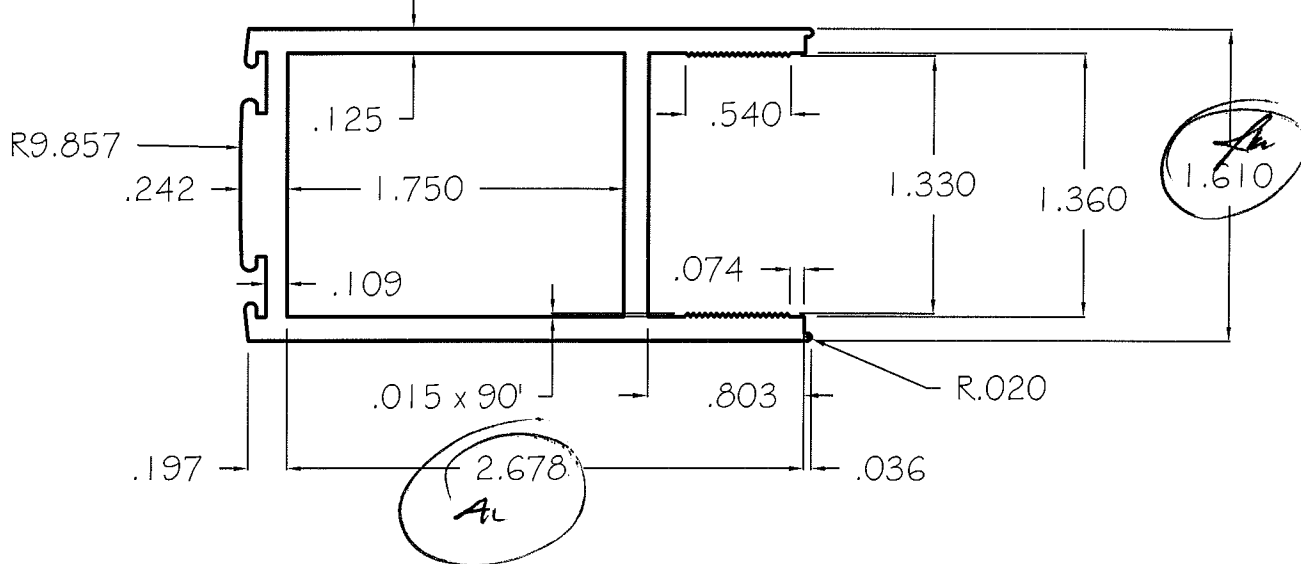
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**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

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Date 7/5/11 Tech [Signature]



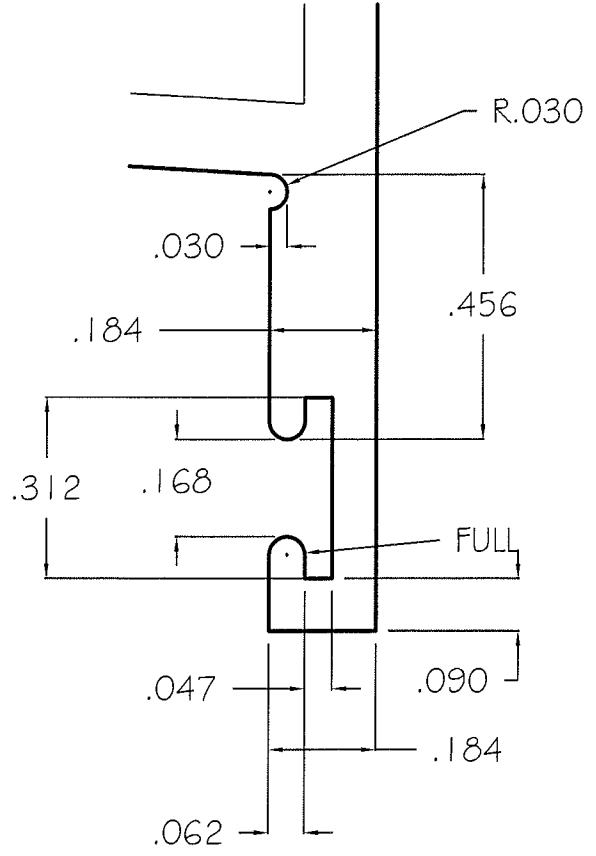
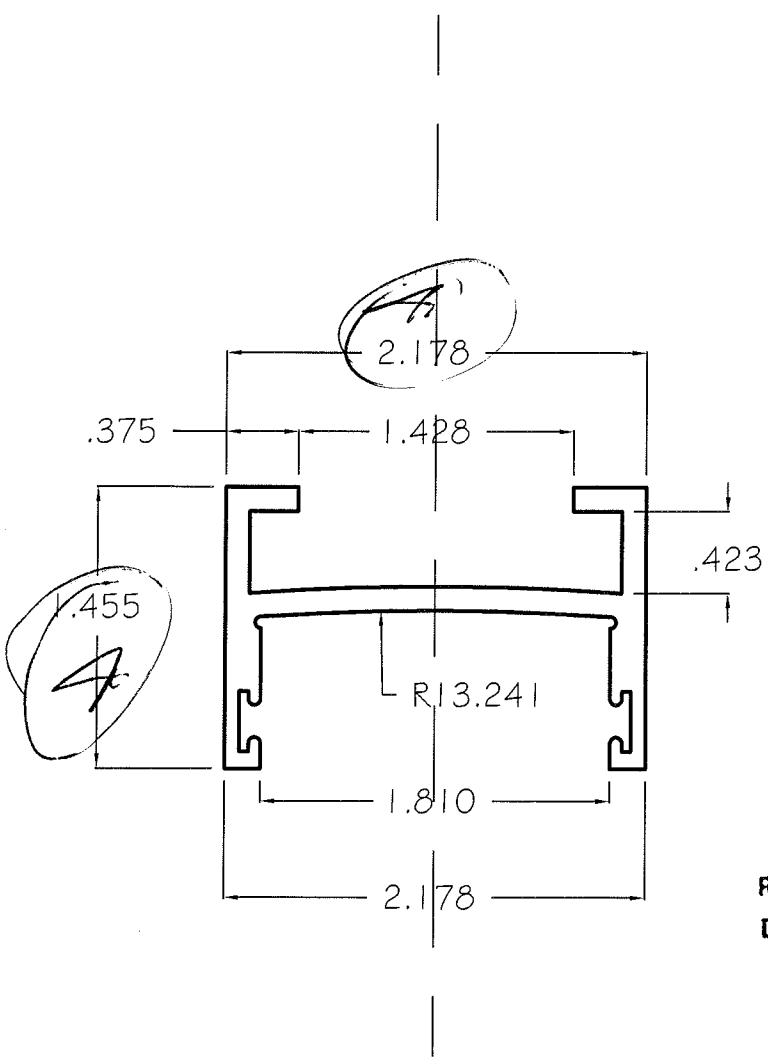
UNLESS OTHER WISE NOTED .125 TYP. WALL

ALL UNMARK CORNER ARE 0.010

REVISION	CUSTOMER:			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
		Revised as of 2/11/10		
	MAT.'L 6063-T5	HOLES	* CRITICAL DIM.	
	AREA 1.164	BACKER	⊗ SPECIAL TOOL	
	WT./ FT 1.40	BOLSTER		
	PERI. 18.28	W/P	DRAWN: AJ	
	FACTOR 13.06	EXT. RATIO	DATE: 12/8/09	
	C.C.D.	CLASS Hollow	SCALE 1 : 1	
			PART NAME:	
			PART #	

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2195



**Architectural Testing**  
 Test sample complies with these details.  
 Deviations are noted.  
 Report# A7901.01  
 Date 7/5/11 Tech AJ

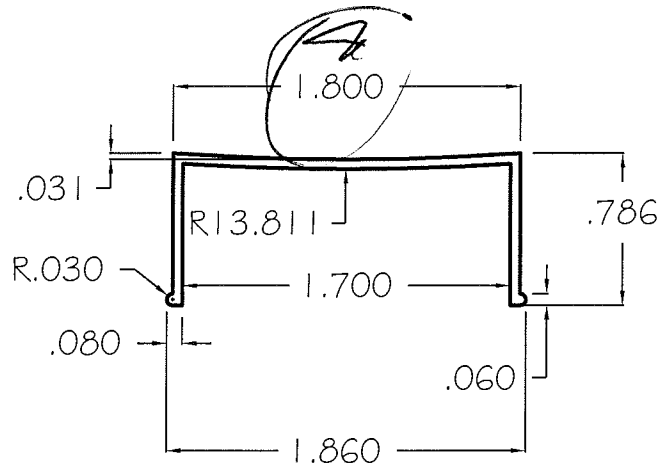
UNLESS OTHER WISE NOTED .125 TYP. WALL

ALL UNMARK CORNER ARE 0.010

REVISION	CUSTOMER:			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
	MAT'L 6063-T5	HOLES	* CRITICAL DIM.	PART NAME: PART #
	AREA .706	BACKER	⊗ SPECIAL TOOL	
	WT. / FT .85	BOLSTER	DRAWN: AJ	
	PERI. 11.91	W/P	DATE: 12/8/09	
	FACTOR 13.65	EXT. RATIO	SCALE 1 : 1	
	C.C.D.	CLASS Solid		

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2197



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A 7901.01  
Date 7/5/11 Tech [Signature]

UNLESS OTHER WISE NOTED .050 TYP. WALL

ALL UNMARK CORNER ARE 0.010

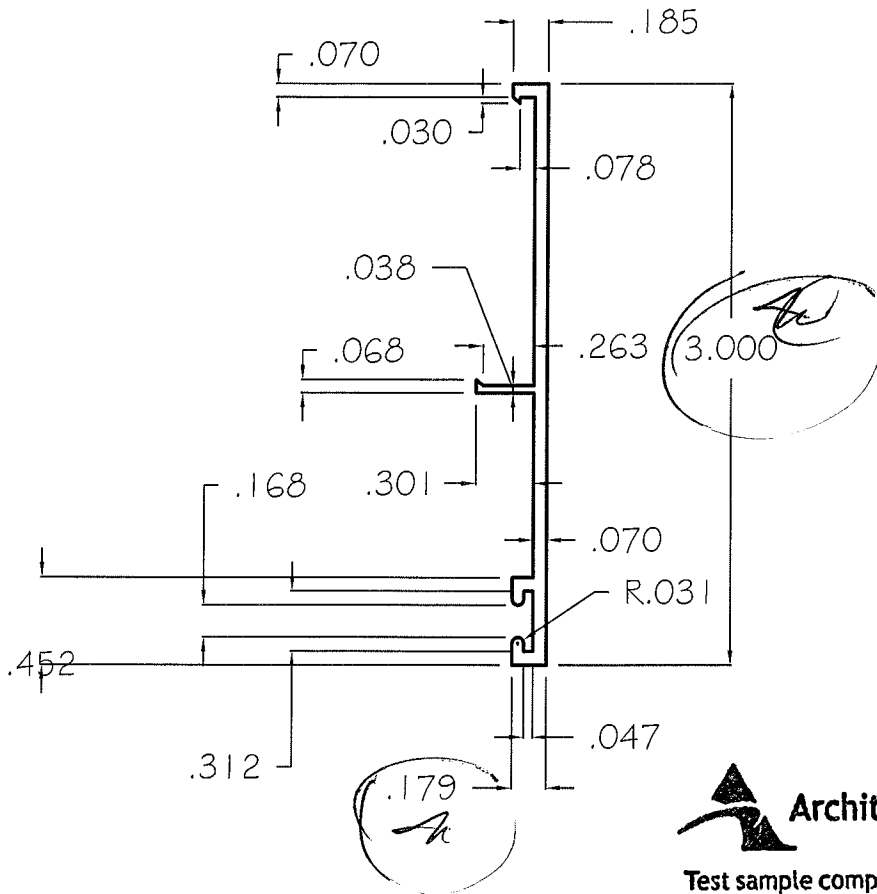
REVISION	CUSTOMER:		
MAT.'L	6063-T5	HOLES	* CRITICAL DIM.
AREA	.167	BACKER	⊗ SPECIAL TOOL
WT. / FT	.20	BOLSTER	DRAWN: AJ
PERI.	6.70	W/P	DATE: 12/8/09
FACTOR	33.50	EXT. RATIO	SCALE 1 : 1
C.C.D.	CLASS Solid		

**PRL**   
**ALUMINUM INC.**  
 14760 DON JULIAN RD.  
 INDUSTRY CA. 91746  
 TEL. (877) 775-2586  
 PRL-ALUM  
 FAX (877) 274-8800

PART NAME:  
PART #

UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

DIE NO. 2238



Test sample complies with these details. Deviations are noted.

Report# A7901.01  
 Date 7/5/11 Tech [Signature]

UNLESS OTHER WISE NOTED .070 TYP. WALL

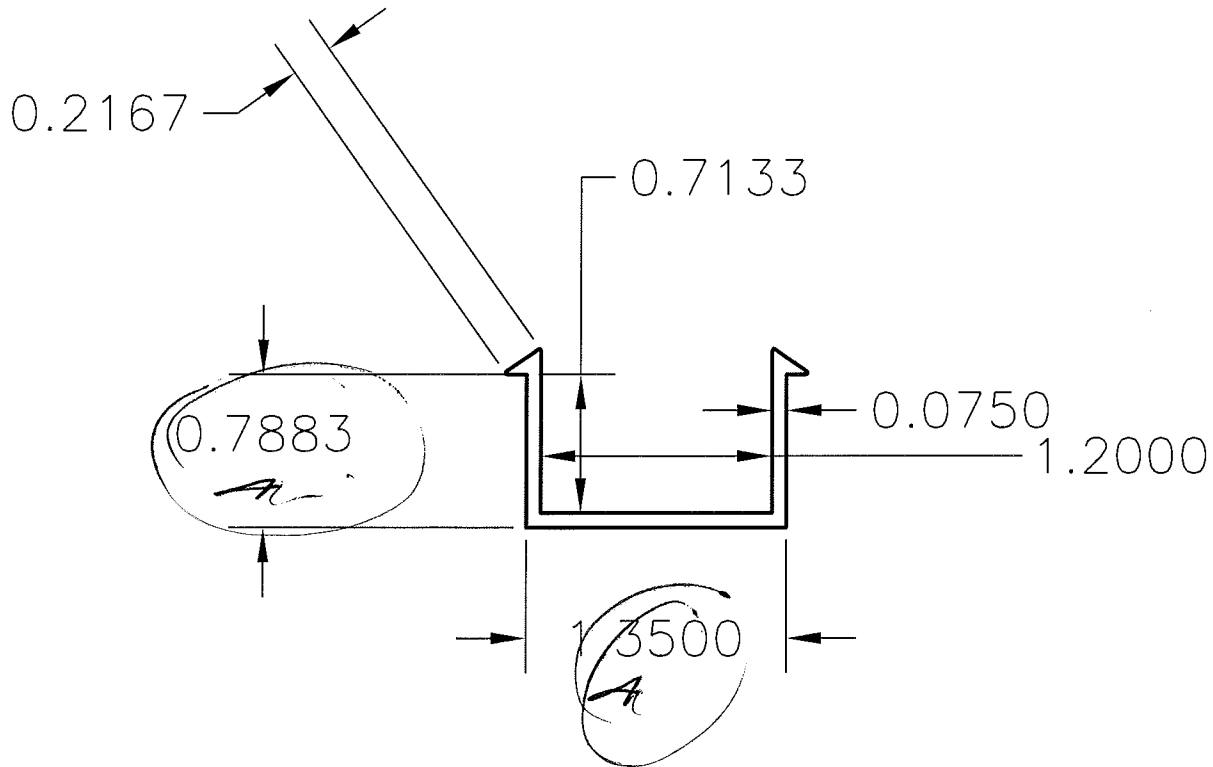
UNMARKED CORNERS .010 R.

REVISION	CUSTOMER: PRL ALUMINUM INC		
	MAT.'L	6063-T5	HOLES
	AREA	0.254	BACKER
	WT. / FT	0.305	BOLSTER
PERI.	7.724	W/P	DRAWN: AJ
FACTOR	25.32	EXT. RATIO	DATE: 4/07/10
C.C.D.		CLASS Solid	SCALE 1 : 1

**PRL**   
**ALUMINUM INC.**  
 14760 DON JULIAN RD.  
 INDUSTRY CA. 91746  
 TEL. (877) 775-2586  
 PRL-ALUM  
 FAX (877) 274-8800

PART NAME: Side Cover  
 PART #

DIE NO. BL-4288



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 7/5/11 Tech A

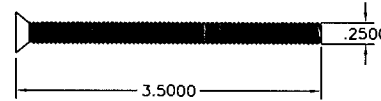
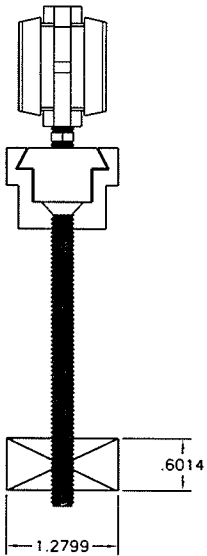
REVISION	CUSTOMER:		
	MAT.'L XX	HOLES	* CRITICAL DIM.
	AREA XX	BACKER	⊗ SPECIAL TOOL
	WT. / FXX	BOLSTER	DRAWN: AJ
PERI. XX	W/P	DATE: xx	
FACTOR XX	EXT. RATIO	SCALE 1 : 1	
C.C.D.	CLASS Solid		

**PRL**

**ALUMINUM INC.**  
 14760 DON JULIAN RD.  
 INDUSTRY CA. 91746  
 TEL. ( 877 ) 775-2586  
 PRL-ALUM  
 FAX ( 877 ) 274-8800

PART NAME:  
PART #



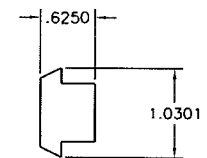
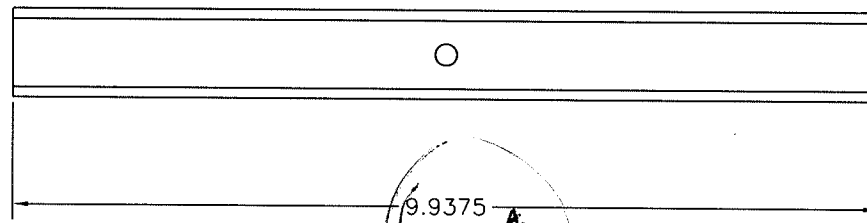
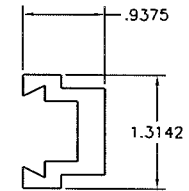
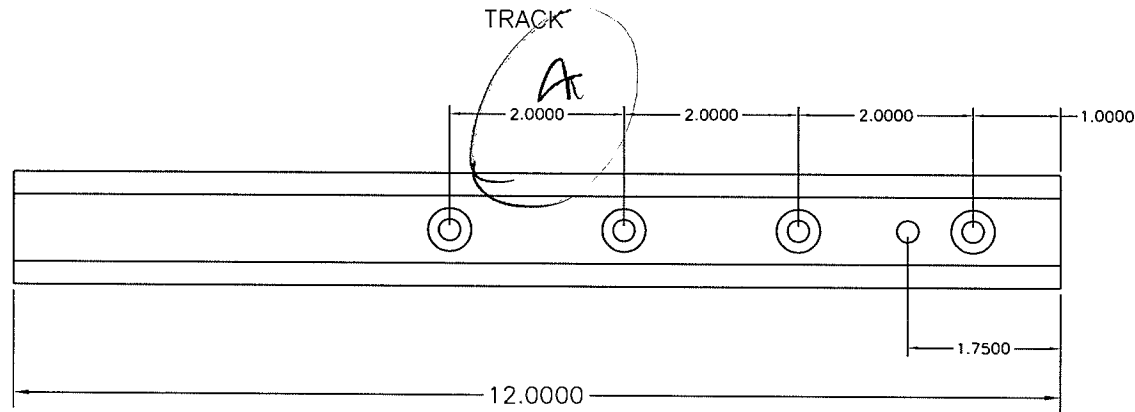


Test sample complies with these details.  
Deviations are noted.

Report# A7901.01

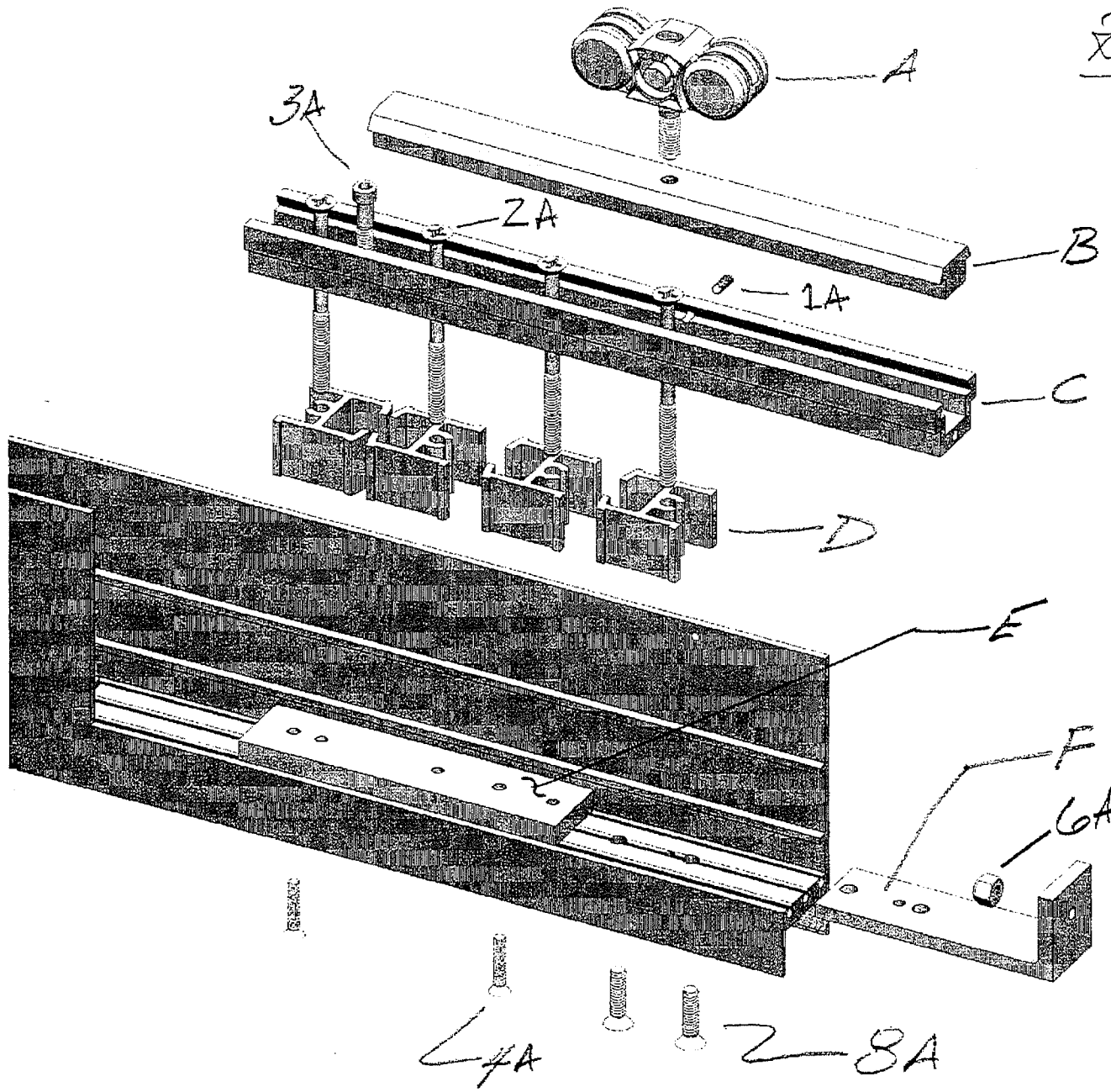
Date 7/5/11


Tech [Signature]

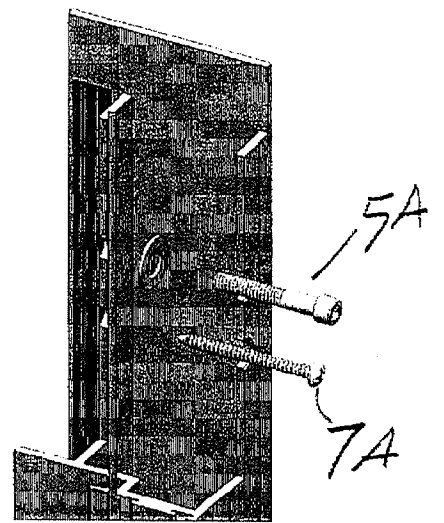


**PRL**   
ALUMINUM INC.

# ROLLER ASSEMBLY

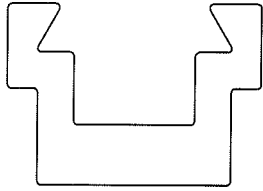


 **Architectural Testing**  
Test sample complies with these details.  
Deviations are noted.  
Report# A7901-01  
Date 7/5/11 Tech [Signature]



UNLESS OTHERWISE SPECIFIED STANDAR ALUMINUM ASSOCIATION TOLERANCES APPLY

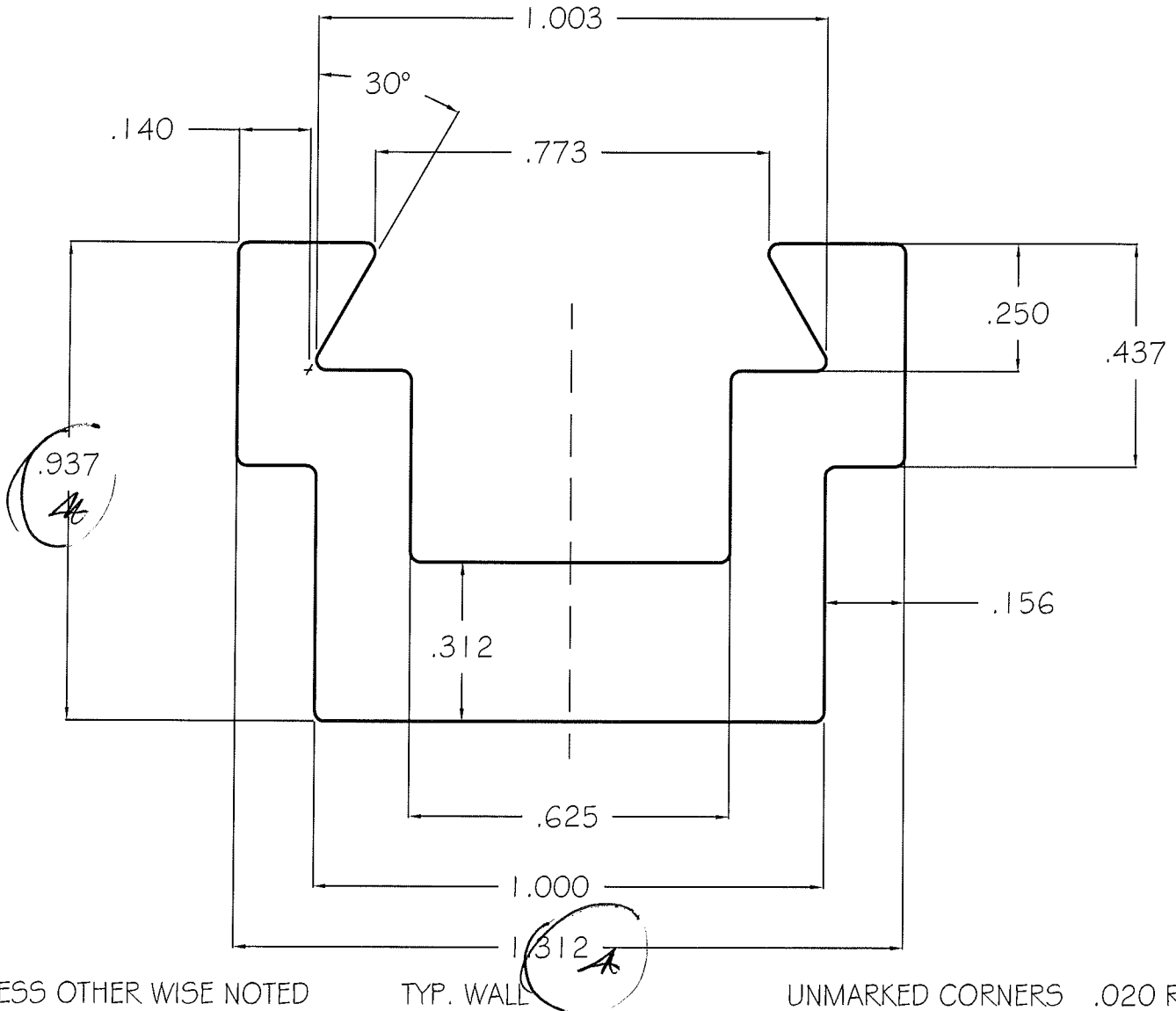
DIE NO. 2329



Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report# A-1901.01  
Date 7/15/11 Tech [Signature]



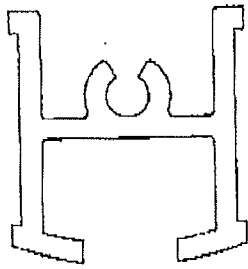
UNLESS OTHER WISE NOTED

TYP. WALL

UNMARKED CORNERS .020 R.

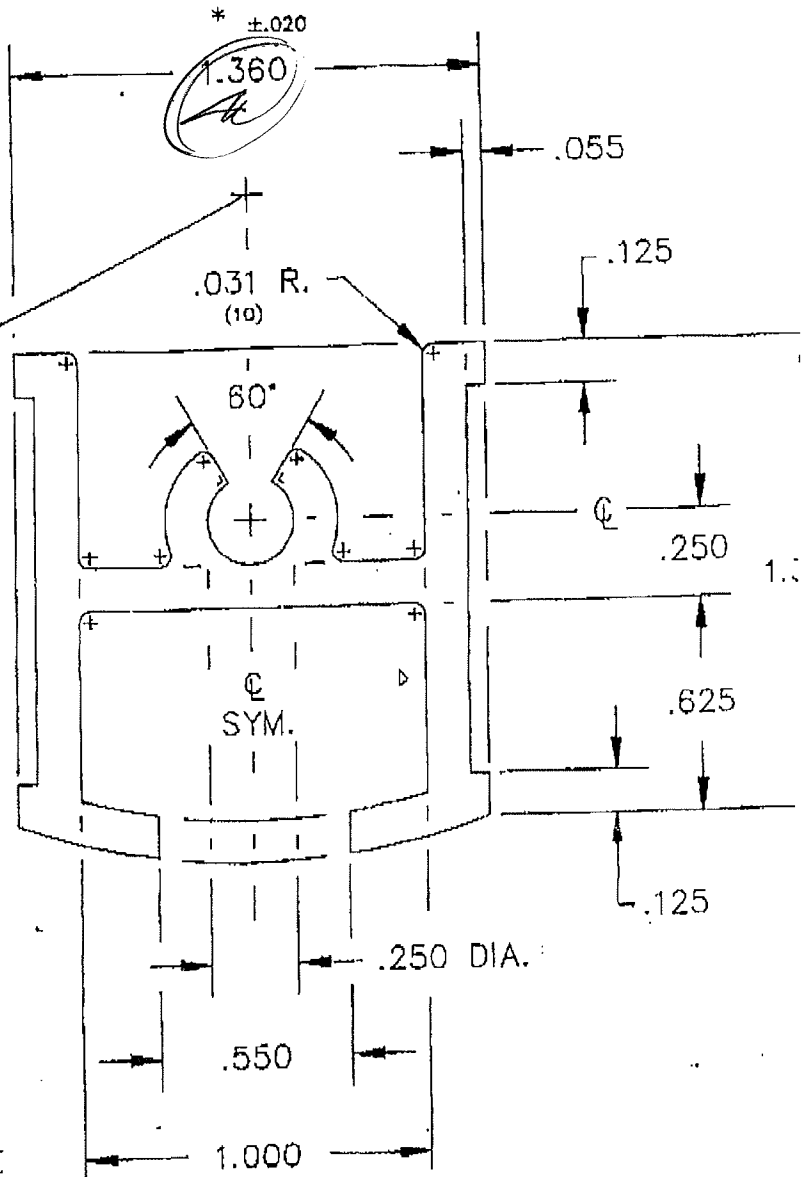
REVISION	CUSTOMER: - <b>PRL</b>			<b>PRL</b> <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
	MAT'L	6063-T5	HOLES	
	AREA	0.617	BACKER	* SPECIAL TOOL
	WT./FT	0.740	BOLSTER	
	PERI.	5.90	W/P	DRAWN: AJ
	FACTOR	7.97	EXT. RATIO	DATE: 3/15/11
	C.C.D.		CLASS Solid	SCALE FULL
				PART NAME:
				PART #

NO EXPOSED SURFACE



ACTUAL SIZE

1.950 R.



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A7901.01  
Date 7/6/90 Tech [Signature]

\* CRITICAL TOLERANCE

L = SHARP CORNERS

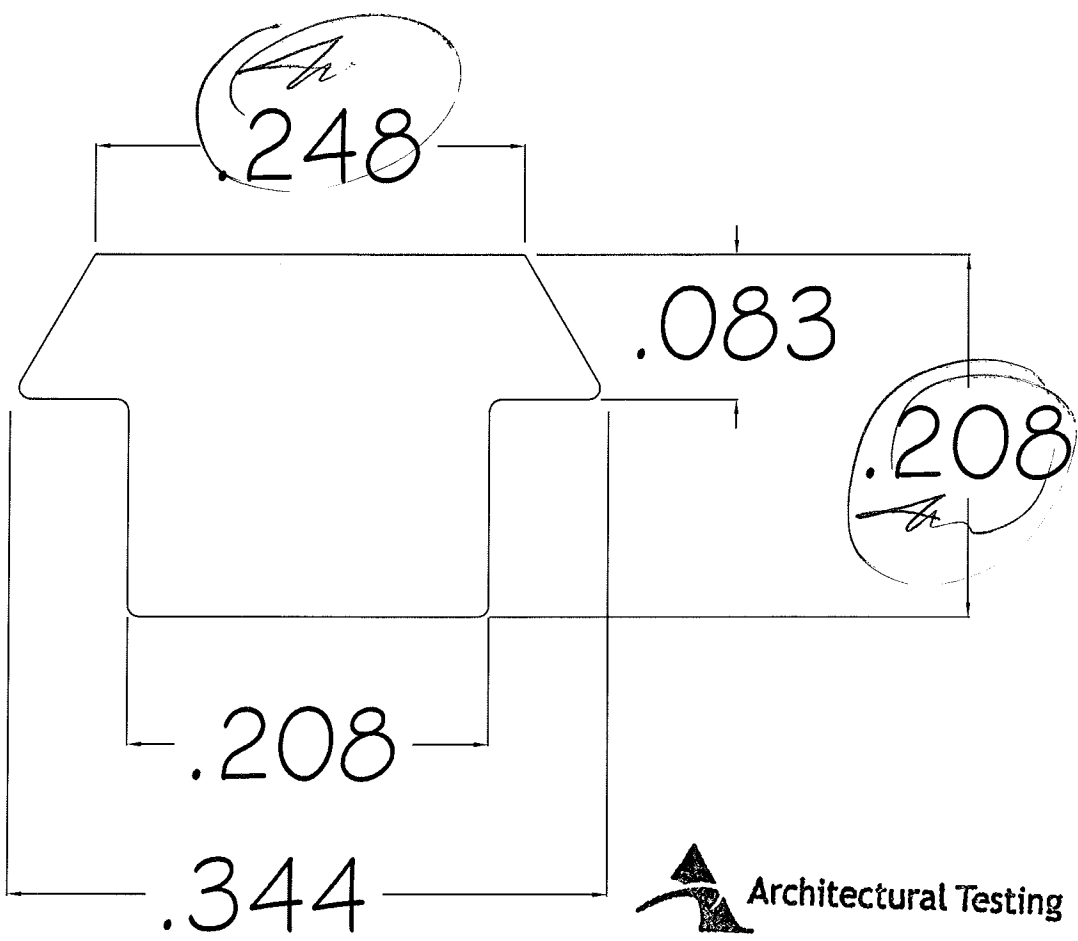
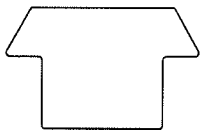
▷ .010 R. X .010 HIGH I.D. MARK

NOTE: .125 TYP. WALL EXCEPT AS NOTED  
UNMARKED CORNERS .010 R.

AREA	650	PORTS	2	BKR	4766			
WT/FT	780	W/P		BOLSTER	2-7			
PERI	10.313	PRI	1847	DIE SIZE	9 X 1			
OWN BY	HILDA	DATE	7/05/90	MAT'L.	6063-T5	R	REDRAWN (COMP. DWG.)	H 7-05
CHKD BY		DATE		STANDARD TOLERANCES UNLESS OTHERWISE NOTED		LET	REVISION	BY D
Sierra Aluminum Company 2345 Fleetwood Drive Riverside, California 92509 (714) 781-7800				CUSTOMER P. R. L. GLASS		SCALE 2:1		PART NO. 4766
				PART NAME				DIE NO

FOR split endcaps.

DIE NO. 2329-B




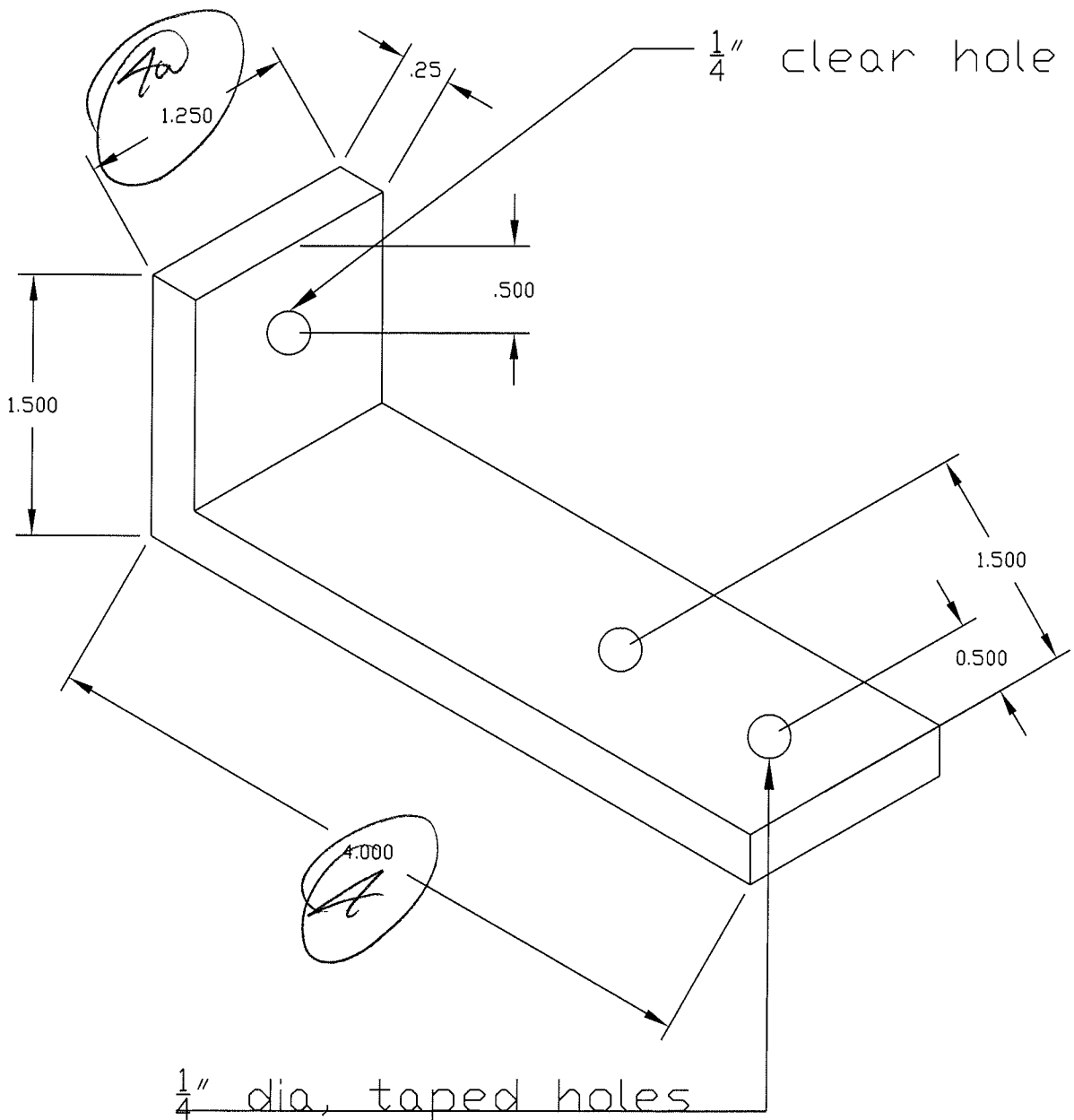
 Architectural Testing

Test sample complies with these details.  
Deviations are noted.

Report# A190101  
Date 9/5/11 Tech [Signature]

UNLESS OTHER WISE NOTED      TYP. WALL      UNMARKED CORNERS .020 R.

REVISION	CUSTOMER: - <b>PRL</b>			<b>PRL</b>  <b>ALUMINUM INC.</b> 14760 DON JULIAN RD. INDUSTRY CA. 91746 TEL. (877) 775-2586 PRL-ALUM FAX (877) 274-8800
MAT'L	6063-T5	HOLES	* CRITICAL DIM.	
AREA	.455	BACKER	<del>*</del> SPECIAL TOOL	
WT. / FT	.546	BOLSTER		
PERI.	3.013	W/P	DRAWN:	
FACTOR		EXT. RATIO	DATE:	
C.C.D.		CLASS Solid	SCALE FULL	
			PART NAME:	
			PART #	



**Architectural Testing**

Test sample complies with these details.  
Deviations are noted.

Report# A790101  
Date 7/5/11 Tech [Signature]

**PRL**  
**ALUMINUM INC.**  
14760 DON JULIAN RD.  
INDUSTRY CA. 91746

TEL. ( 877 ) 775-2586  
FAX ( 877 ) 274-8800

max slider corner angles