

RAM INDUSTRIES TEST REPORT

SCOPE OF WORK

AAMA/WDMA/CSA 101/I.S.2/A440 TESTING ON SERIES S800 HEAVY PICTURE WINDOW
MULLED TO S900 OUTSWING CASEMENT WINDOW

REPORT NUMBER

J8690.01-801-44-R0

TEST DATE(S)

07/09/19

ISSUE DATE

05/12/20

RECORD RETENTION END DATE

03/18/23

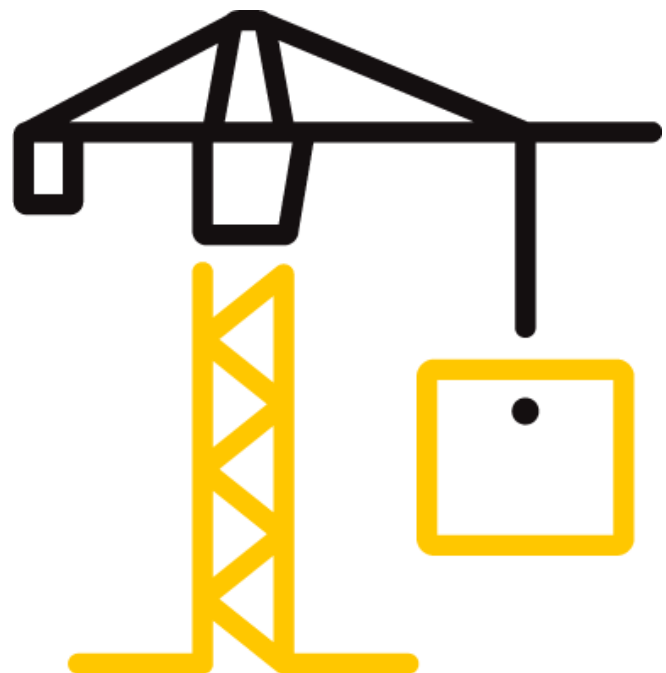
PAGES

23

DOCUMENT CONTROL NUMBER

RT-R-AMER-Test-2804 (04/17/18)

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TEST REPORT FOR RAM INDUSTRIES

Report No.: J8690.01-801-44-r0

Date: 05/12/20

REPORT ISSUED TO

RAM INDUSTRIES

8600 Commerce Park Dr.
Houston, TX 77036

SECTION 1

SCOPE

Intertek Building & Construction (B&C) was contracted by Ram Industries to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 on their Series S800 Heavy Picture Window Muller to S900 Outswing Casement Window. Results obtained are tested values and were secured by using the designated test methods. Testing was conducted at the Intertek test facility in Plano, TX. 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
AAMA/WDMA/CSA 101/I.S.2/A440-17	CW-PG50-C*
Design Pressure	±2400 Pa (±50.13 psf)

Reference must be made to Intertek B&C Report No. J4516.01-801-44, dated 10/22/19 for complete test specimen description and detailed test results.

For INTERTEK B&C:

COMPLETED BY:	Jeffrey Crump	REVIEWED BY:	Andy Cost
TITLE:	Sr. Project Manager – AWS	TITLE:	Laboratory Manager
SIGNATURE:		SIGNATURE:	
DATE:	05/12/20	DATE:	05/12/20

JC:cm

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SECTION 3

TEST SPECIFICATION(S)/METHODS

The specimens were 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*

The following test methods were used during testing:

AAMA 205-15, *In-Plant Testing Guidelines for Manufacturers and Independent Laboratories*

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

SECTION 4

MATERIAL SOURCE/INSTALLATION

Test specimens were 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 SPF wood buck. The rough opening allowed for a 1/8" shim space and the exterior perimeter of the specimen was sealed to the test buck. Installation of the tested product was performed by the client.

LOCATION	ANCHOR DESCRIPTION	ANCHOR SPACING
Interior perimeter of frame nail fin	Nail fin frame is installed in a (2" x 6") test buck with #6 x 1-5/8" screws which is attached to outer (2" x 10") SPF wood wrap.	Screws attached 2" from each frame end and 12" on center at frame head, sill and jambs.

SECTION 5

EQUIPMENT

Calibration of test equipment was performed by Intertek B&C in accordance with AAMA 205-15.

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SECTION 6

LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Jeff Ashcraft	Ram Industries
Jeffrey Crump	Intertek B&C
Jason Gossage	Intertek B&C

SECTION 7

GATEWAY

*Reference Intertek B&C Report No. J4516.01-801-44, dated 10/22/19 for complete *Gateway* test specimen description and test results.

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SECTION 8

TEST SPECIMEN DESCRIPTION

Product Type: Heavy Picture Window Muller to Outswing Casement Window

Series/Model: S800/S900

Product Size(s):

OVERALL AREA: 3.3 m ² (36 ft ²)	WIDTH		HEIGHT	
	millimeters	inches	millimeters	inches
Overall size	1829	72	1829	72
Vent Size	886	34-7/8	1797	70-3/4
Vent Daylight Opening	756	29-3/4	1672	65-13/16
Fixed Daylight Opening	838	33	1753	69

Frame Construction:

MEMBER	MATERIAL	DESCRIPTION
Head, sill, jambs, nail fin replacement and vertical mull	Aluminum	Extruded aluminium thermally broken with polyurethane.

	JOINERY TYPE	DETAIL
All corners	Mechanical	Frame corners are attached with two (2) #8 x 1" HX WSHR Type A SMA, each. Aluminum frame corner bracket (2" x .062" thick) located at frame interior pocket. All corners and vertical mull sealed with silicone.
Vertical mull	Mechanical	Frame vertical mull is attached with four (4) #8 x 1" HX WSHR Tek 2 SMS, two at fixed jamb and two at casement jamb. Aluminum frame corner bracket (2" x .062" thick) located at frame interior pocket. All corners sealed. Fixed frame jamb and casement frame jamb snap onto one piece vertical mullion (part #46733). Replacement nail fins snap onto frame perimeter at head, sill and jambs, sealed in place.

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Vent Construction:

MEMBER	MATERIAL	DESCRIPTION
Rails and stiles	Aluminum	Extruded aluminum thermally broken with polyurethane.

	JOINERY TYPE	DETAIL
All corners	Mechanical	Vent corners are attached with two (2) #8 x 1" HX WSHR Type A SMA, each. Aluminum vent corner bracket (2" x .062" thick) located at frame interior pocket. All corners sash foam corner gasket.

Reinforcement: *No reinforcement was utilized.*

Weatherstripping:

DESCRIPTION	QUANTITY	LOCATION
Ultrafab Vinyl bulb weather-strip	4	Exterior perimeter face of frame interior leg.
HPW Rubber Stop	4	Interior face of exterior leg of vent top rail, bottom rail and stiles.
Truth Gasket	1	At roto-operator to frame connection.

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" IG	Aluminum	1/8" annealed	1/8" annealed	Exterior glazed with 1/16" x 3/8" glazing tape at the interior face of glass and aluminum glazing bead with rubber stop at the exterior face of glass.

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Fixed Head sill and jambs	2	756 x 1652	29-3/4 x 65-13/16	9/16
Vent Rails and Stiles	2	838 x 1753	33 x 69	

Drainage:

METHOD	SIZE	QUANTITY	LOCATION
Weep slot	3/8" x 1/8"	2	Each end of vent and fixed sill glazing bead.

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Hardware:

DESCRIPTION	QUANTITY	LOCATION
Roto-operator	1	Located at frame sill, attached with six (6), #8 x 3/4" phil flat type A SMS.
Lever Lock with support plate with guide bar and tie bar and lock buttons	1	Lever lock attached to frame jamb with #10-24 x 5/8" phil pan type F.
Truth keepers	3	Located appx. 4" from each end and 26" from top, attached with #8 x 3/8" Phil Pan SMS.
Three bar friction hinge	2	Hinge attached to frame and vent with #10 x 1/2" Phil Pan Type A SMS 410SS.

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SECTION 9

TEST RESULTS

The temperature during testing was 23°C (73°F). The results are tabulated as follows:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Operating Force, per ASTM E 2068	Initiate motion: 58 N (13 lbf) Maintain motion: 45 N (10 lbf) Pass	Report Only No leakage	
Uniform Load Structural, per ASTM E330 Deflections taken at hinge rail +1440 Pa (+30.08 psf) -14400 Pa (-30.08 psf)	.76 mm (0.03") 8.4 mm (0.33")	10 mm (0.38") max. 10 mm (0.38") max.	
Uniform Load Structural, per ASTM E330 Deflections taken at vertical mull +1440 Pa (+30.08 psf) -14400 Pa (-30.08 psf)	4.8 mm (0.19") 5.6 mm (0.22")	10 mm (0.39") max. 10 mm (0.39") max.	
OPTIONAL PERFORMANCE			
Uniform Load Deflection, per ASTM E330 Deflections taken at hinge rail +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	.30 mm (0.01") 9.7 mm (0.38")	10 mm (0.38") max. 10 mm (0.38") max.	3
Uniform Load Deflection, per ASTM E330 Deflections taken at vertical mull +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	7 mm (0.28") 9.7 mm (0.38")	10 mm (0.39") max. 10 mm (0.39") max.	
Uniform Load Structural, per ASTM E330 Permanent Set taken at hinge rail +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	<0.10 mm (<0.01") 1.52 mm (0.06")	5 mm (0.20") max. 5 mm (0.20") max.	3

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Uniform Load Structural, per ASTM E330 Permanent Set taken at Vertical Mull +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	1.8 mm (0.07") 1 mm (0.04")	5.3 mm (0.21") max. 5.3 mm (0.21") max.	3
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Note 1: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.

Note 2: Loads were held for 10 seconds.

Note 3: Tape and film were not used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

TEST REPORT FOR RAM INDUSTRIES

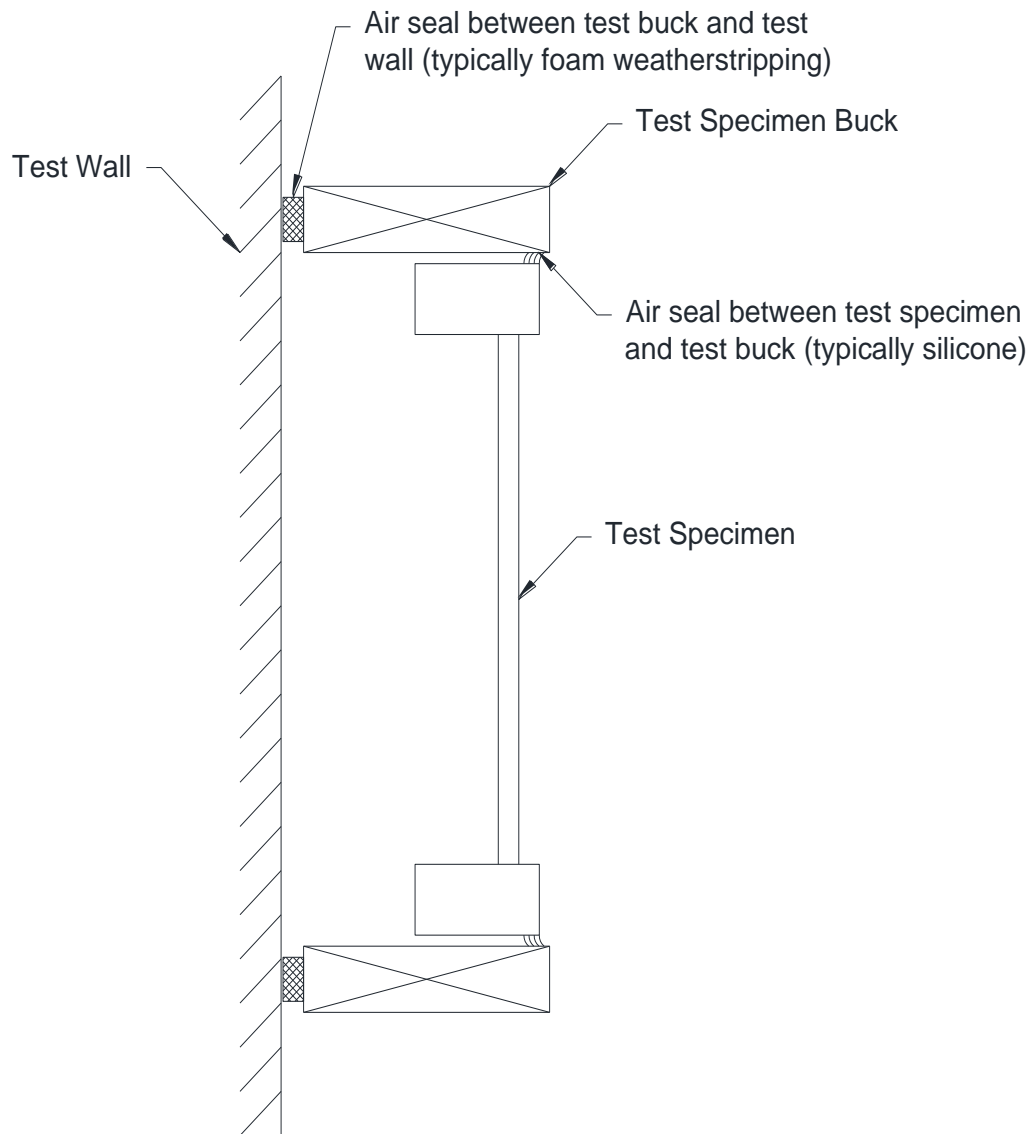
Report No.: J8690.01-801-44-r0

Date: 05/12/20

SECTION 10

LOCATION OF AIR SEAL

The air seal between the test specimen and the test wall is detailed below. The seal is made of foam weatherstripping and is attached to the edge of the test specimen buck. The test specimen buck is placed against the test wall and clamped in place, compressing the weatherstripping and creating a seal.



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Date: 05/12/20

SECTION 11

CONCLUSION

The specimen tested successfully met the performance requirements for a **CW-PG50-C** rating.

Reference Intertek B&C Report No. J4516.01-801-44, dated 10/22/19 for complete *Gateway* test specimen description and test results.

SECTION 12

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.

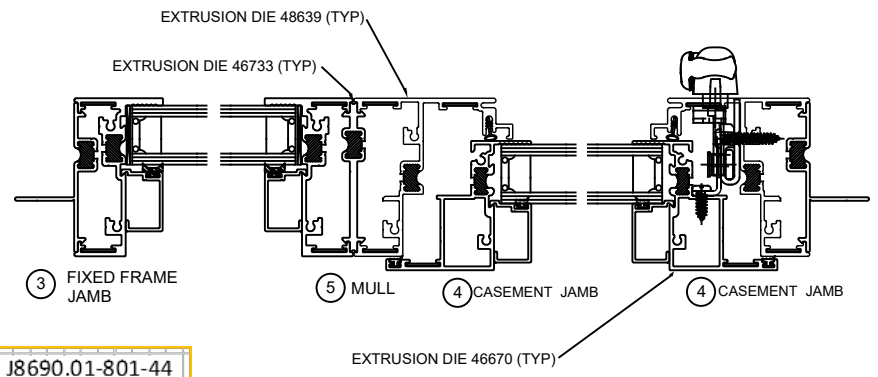
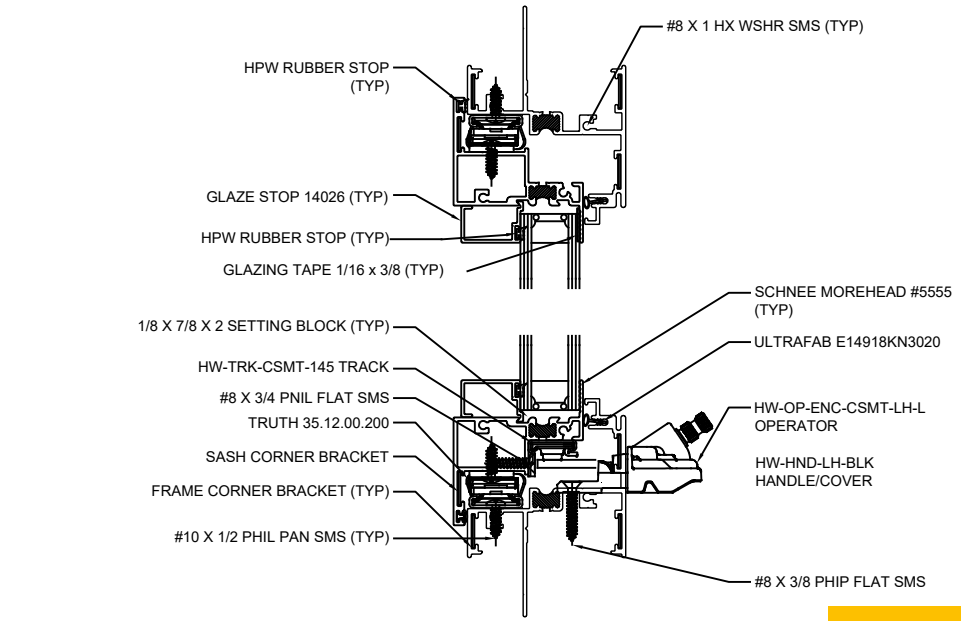
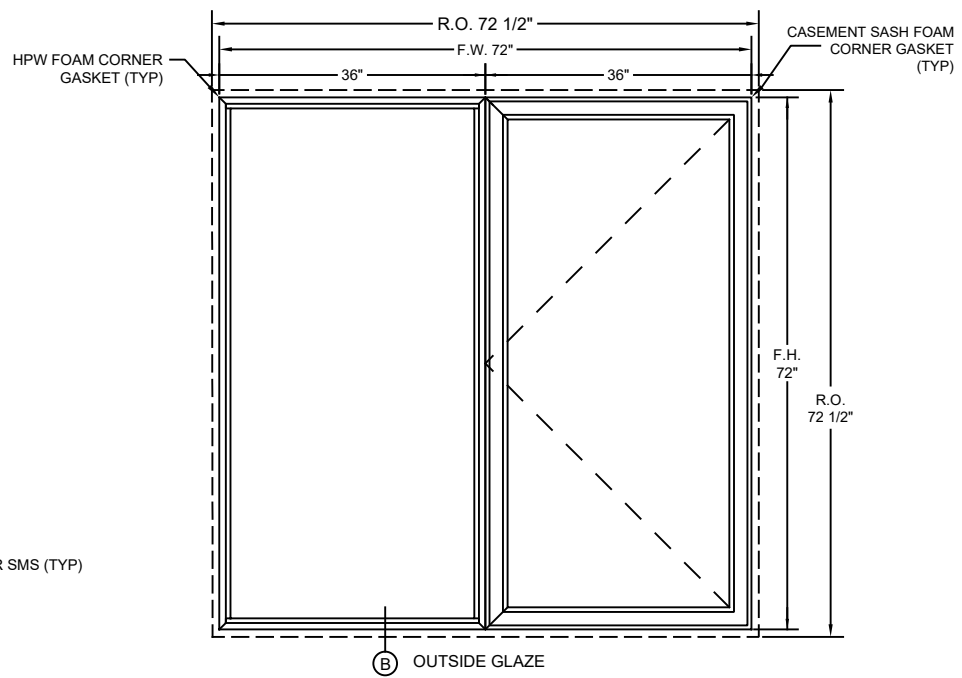
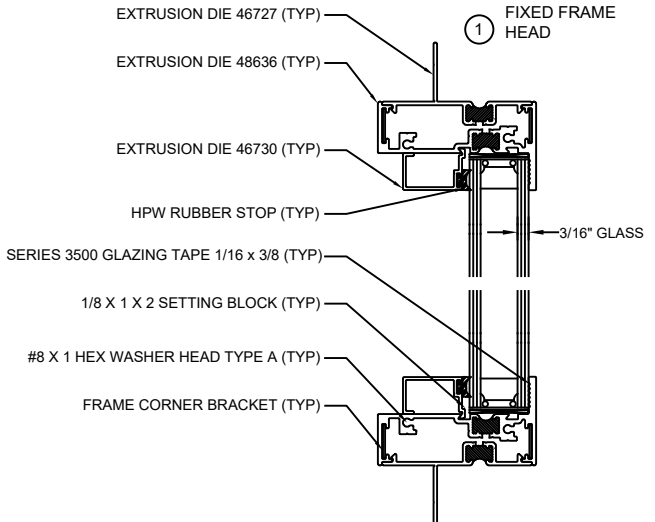
Ram S800 Heavy Picture /S900 Casement

DRAWING APPROVAL

APPROVED
 APPROVED AS NOTED
 REVISE AND RESUBMIT

SIGN _____ DATE _____

Please return one print set marked with your signature, any comments, and notation of approval for fabrication.



intertek
 Total Quality Assured.

Report #: J8690.01-801-44
 Date: 05/12/20
 Verified by: J.Crump

REV	DESCRIPTION	BY	DATE

PROPRIETARY AND CONFIDENTIAL

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RAM INDUSTRIES. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF RAM INDUSTRIES IS PROHIBITED.

LEAD TIME	10-12	WEEKS	CUSTOMER	---
GLASS WARRANTY	2	YEARS	PROJECT	---
FRAME WARRANTY	2	YEARS	CITY	Dallas
FINISH WARRANTY	2	YEARS	STATE	Texas
U-FACTOR			OUTER GLASS	
SHGC			AIR SPACE	
DA GLASS THICKNESS			INNER GLASS	

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

TOLERANCES:

FRACTIONAL ± 1/16
 ANGULAR MACH/BEND ± .5
 TWO PLACE DECIMAL ± .01
 THREE PLACE DECIMAL ± .004

MATERIAL

6063-T5 ALUMINUM

DO NOT SCALE DRAWING

NAME	DATE
DRAWN GKW	5/13/2019
MARK	A
QTY.	---
FINISH	---
DP	
COMMENTS:	

RAM INDUSTRIES

TITLE: 96309 AAMA TESTING

SIZEDWG. NO. S800/S900 TESTING


REV

SCALE: SHEET 1 OF 1

RAM INDUSTRIES

SERIES 800 HPW FIXED (1-LITE)

EXTRUSION		
HPW FRAME	INTERNATIONAL EXT.	DIE 48636
HPW METAL STOP	INTERNATIONAL EXT.	DIE 46730
REPLACEMENT FIN	INTERNATIONAL EXT.	DIE 46727
COMPONENTS		
METAL STOP VINYL WTHST	ORZEN EXTRUDED POLYMERS	1109-02-00
SETTING BLOCK	FRANK LOWE RUBBER	1/8 X 1 X 2
FOAM CORNER GASKET	FRANK LOWE	HPW CORNER GSKT
GLAZING TAPE	TBP CONVERTING	1/8" X 3/8"
FRAME CORNER BRACKET	KELCO TOOL & DESIGN	ALUM .062 X 2"
CORNER SEALANT	TBP CONVERTING	DOW 1199
FRAME FASTENER	ALLOY FASTNER	#8 X 1 HX WSHR SMS TYPE A
GLASS	CARDINAL IG	1" OA ANNEALED

 <small>Total Quality Assured.</small>	Report #:	J8690.01-801-44
	Date:	05/12/20
	Verified by:	J.Crump

RAM INDUSTRIES

SERIES 900 CASEMENT (1-LITE)

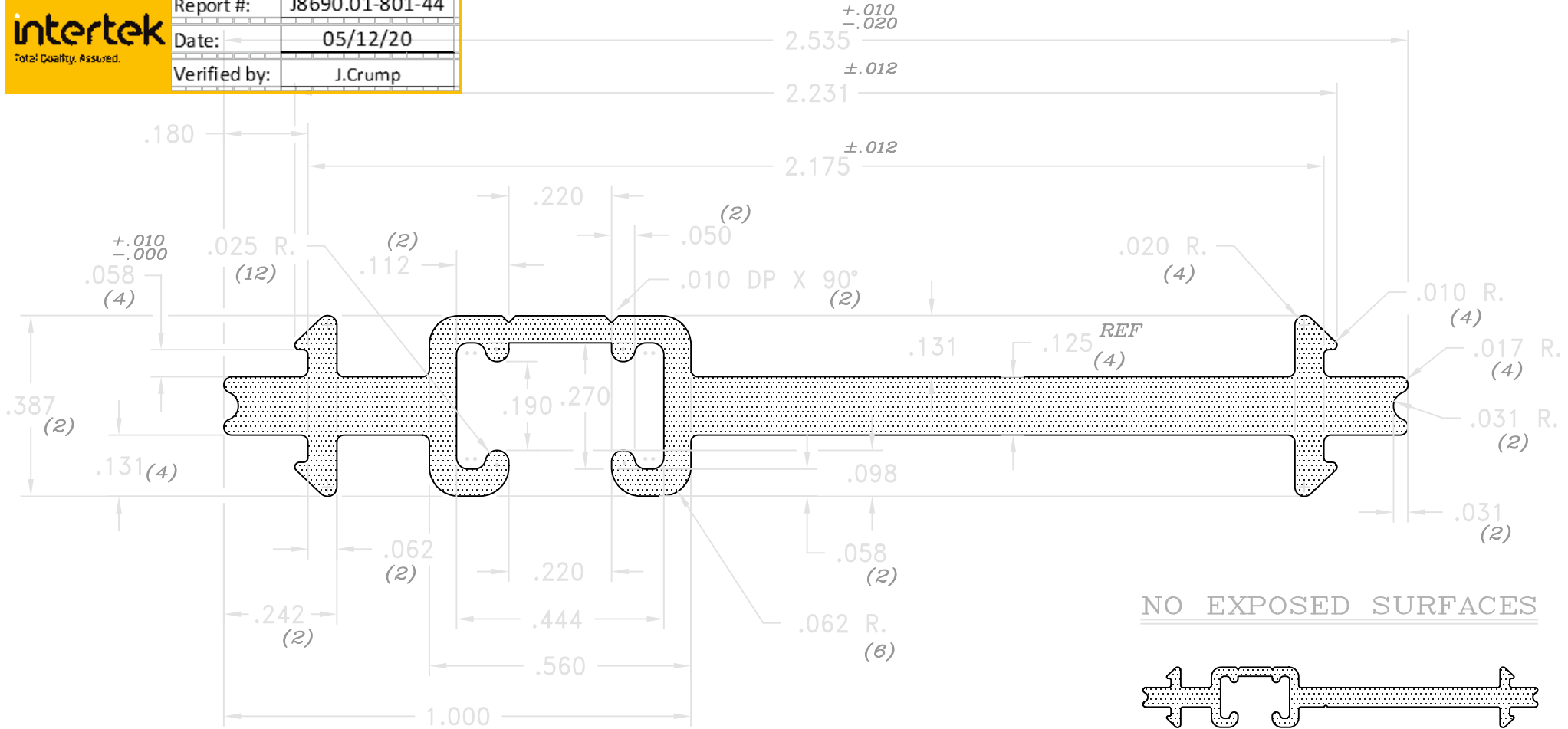
EXTRUSION		
CASEMENT FRAME	INTERNATIONAL EXT.	DIE 48639
CASEMENT INTERNALL MULL	INTERNATIONAL EXT.	DIE 46733
REPLACEMENT FIN	INTERNATIONAL EXT.	DIE 46670
CASEMENT METAL STOP	INTERNATIONAL EXT	DIE 46730
COMPONENTS		
METAL STOP VINYL WTHST	ORZEN EXTRUDED POLYMERS	1109-02-00
SETTING BLOCK	FRANK LOWE RUBBER	1/8 X 1 X 2
FOAM CORNER GASKET	FRANK LOWE	HPW CORNER GSKT
GLAZING TAPE	TBP CONVERTING	1/8" X 3/8"
FRAME CORNER BRACKET	KELCO TOOL & DESIGN	ALUM .062 X 2"
CORNER SEALANT	TBP CONVERTING	DOW 1199
FRAME FASTENER	ALLOY FASTNER	#8 X 1 HX WSHR SMS TYPE A
GLASS	CARDINAL IG	7/8" OA ANNEALED

NOTE:
1. 6063-T5 ALLOY & TAMPER

SYM	REVISION	BY	DATE	CUSTOMER RAM INDUSTRIES, INC.		DIE NO. 46733	
				PART NAME: MULL-THERMAL	DRAWN: JHN	DATE: 8/26/11	
				PART NO. 40770	SCALE: 3X	CHKD.	APPR.

ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

intertek Total Quality Assured.	Report #:	J8690.01-801-44
	Date:	05/12/20
	Verified by:	J.Crump



ACTUAL SIZE

UNLESS OTHERWISE NOTED.
ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS ____



International Extrusion Corporation

202 SINGLETON DRIVE
WAXAHACHIE, TX 75165
TEL: 972-937-7032, FAX: 972-938-3271

EST AREA:	.363	UT-NO.	1023	PORTS	2	WP	----
EST WT/FT:	.436	CIRCLE SIZE:	2.5	BACKER	9 X 44061		
EST PERI:	7.977	CLASS	SOLID	BOLSTER	3606		
FACTOR:	18	ER	7" = 56	DIE NO.	46733		

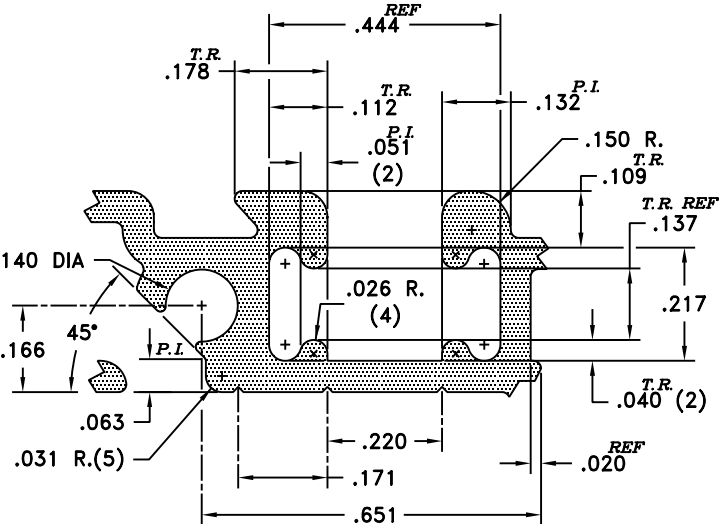
REVISION	BY	DATE	CUSTOMER	DIE NO.
			RAM INDUSTRIES, INC.	46770
			PART NAME: NEW CASEMENT SASH	DATE: 11-25-11
			PART NO. -----	CHKD. APPR.
			SCALE: 2:1	

- NOTE:**
- 6063-T5 ALLOY AND TEMPER
 - POUR AND DEBRIDGE AREA = .115
 - STRUCTURAL STREAKS EXPECTED
 - MIN. .210 DEBRIDGE
 - OUTSIDE PERIMETER 12.988

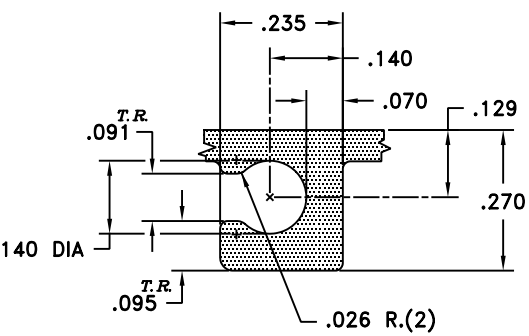
ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

ALL SURFACES EXPOSED

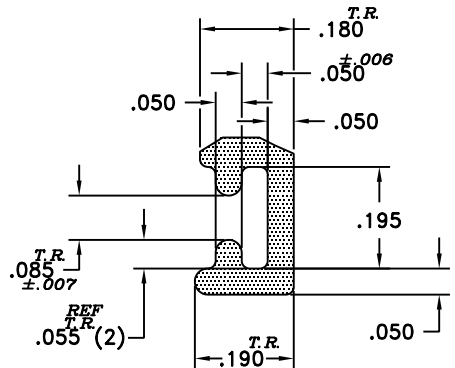
ACTUAL SIZE



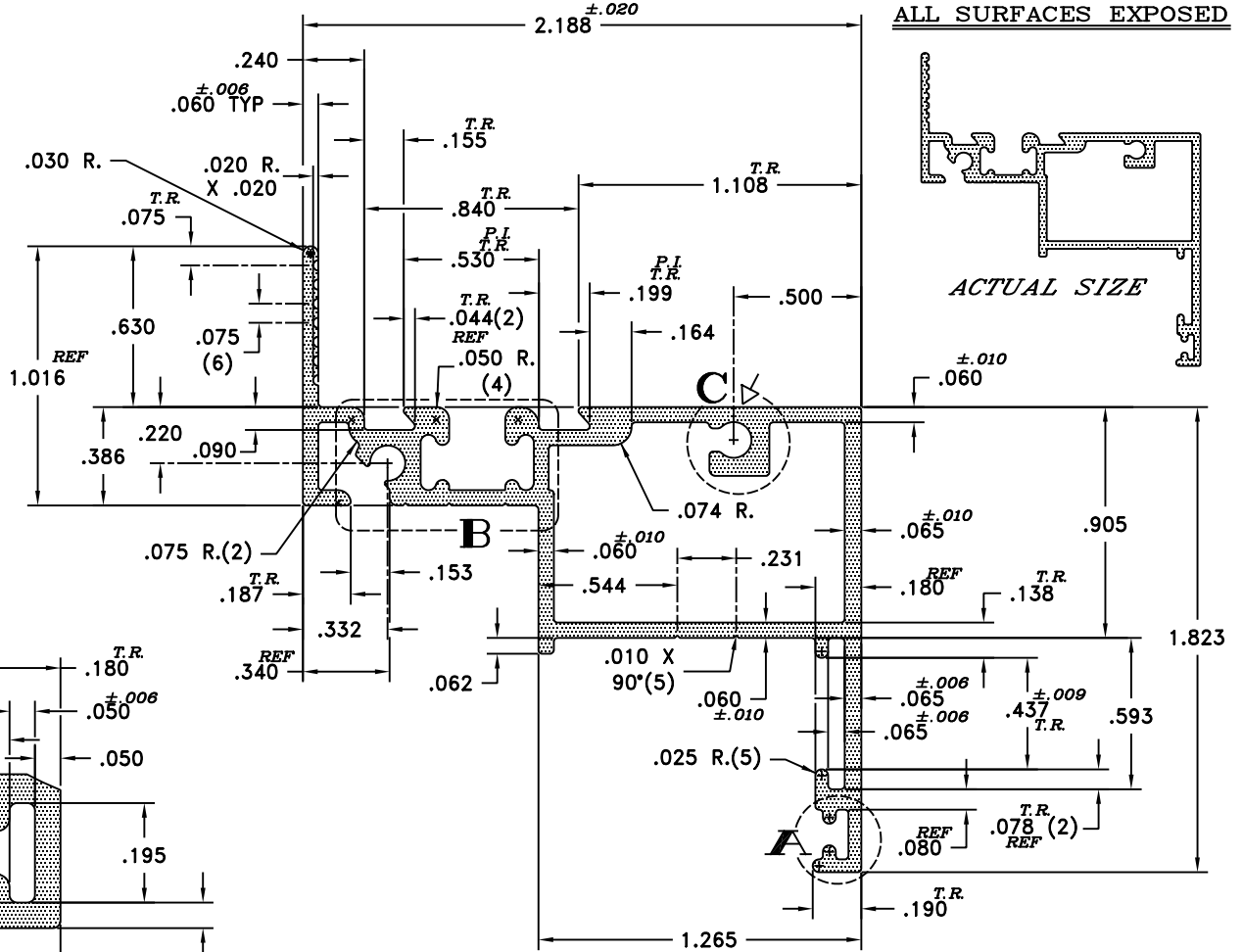
DETAIL B
4:1




DETAIL C
4:1



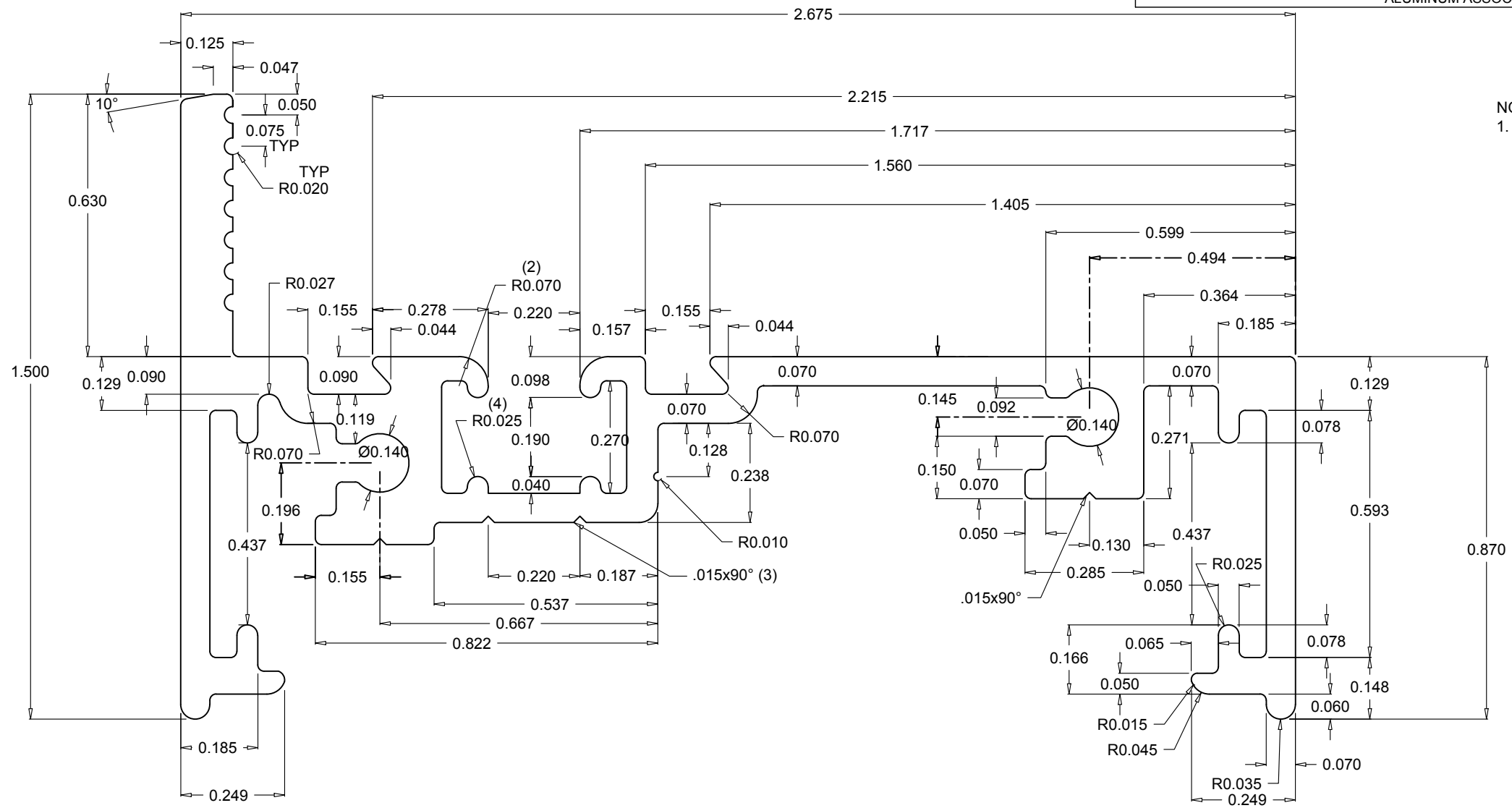
DETAIL A
4:1



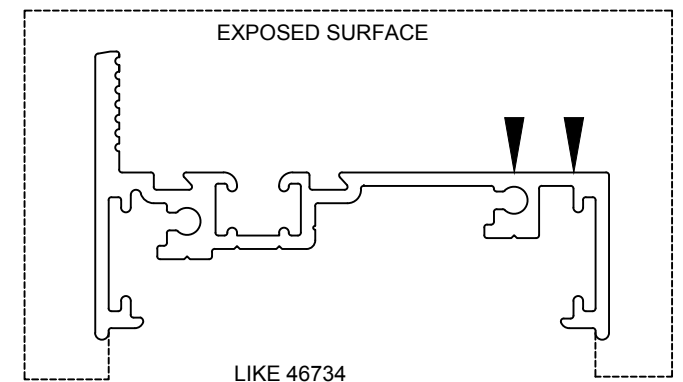
UNLESS OTHERWISE NOTED.
ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS .060 ±.006

 International Extrusion Corporation 202 SINGLETON DRIVE WAXAHACHIE, TX 75165 TEL: 972-937-7032, FAX: 972-938-3271	EST AREA:	.562	UT-NO.	1026A	PORTS	1	WP	----
	EST WT/FT:	.674	CIRCLE SIZE:	3.3	BACKER	----		
	EST PERI:	17.517	CLASS	HOLLOW	BOLSTER	18186		
	FACTOR:	26	ER	7" = 73	DIE NO.	46770		

SYM	REVISION	BY	DATE	CUSTOMER	DIE NO.	QUOTE NO.
				RAM	48636	1823
				PART NAME HPW NO FIN NEW	DRAWN	DATE 12/12/2016
				PART NO.	SCALE 3X	APP.
ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE						

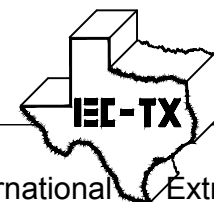


NOTES:
1. INDICATES POSSIBLE STREAKING IN THIS AREA ARE NOT CAUSE FOR REJECTION.



ACTUAL SIZE

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	Verified by:	J.Crump

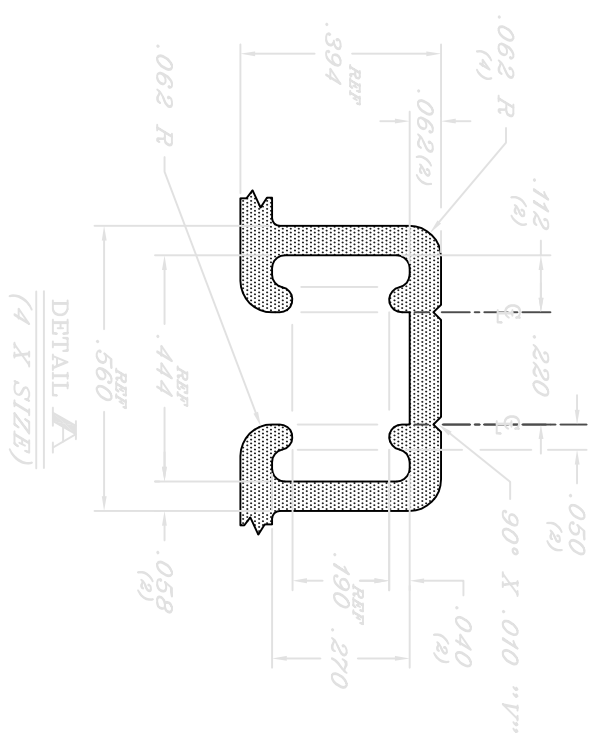
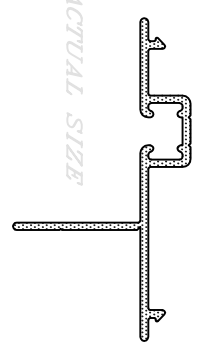
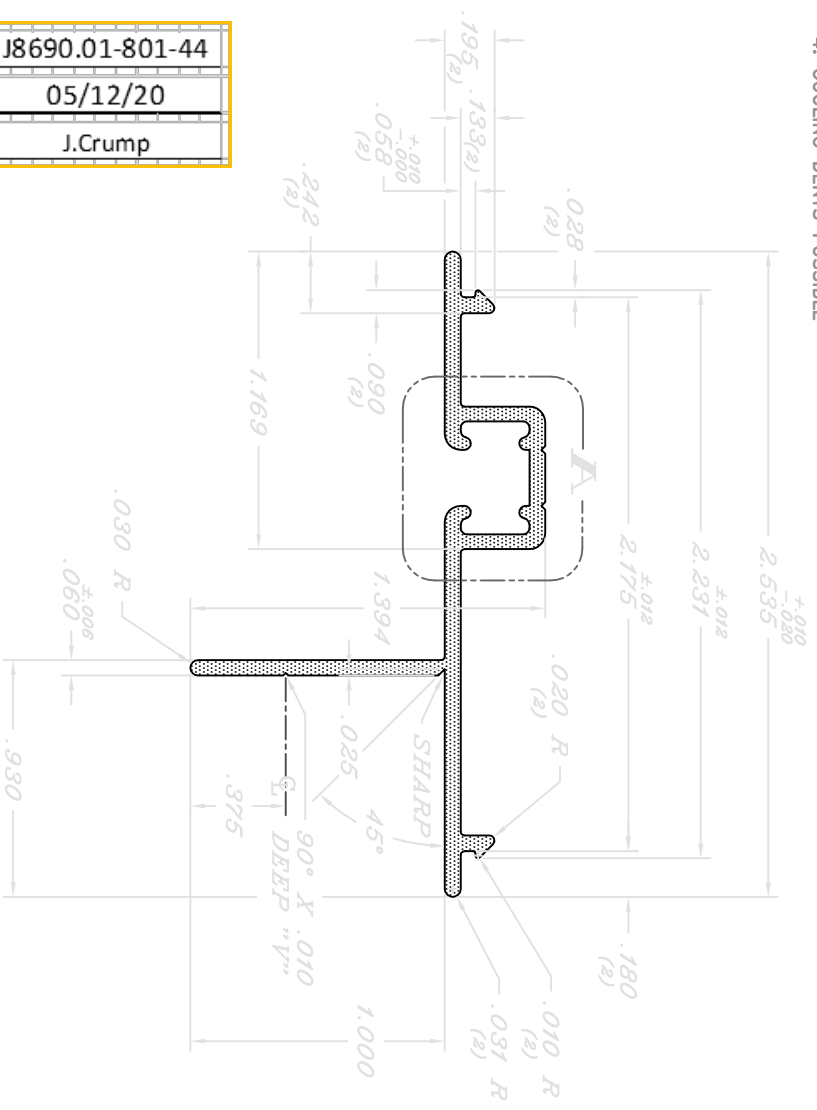


International Extrusion Corporation
202 SINGLETON DRIVE
WAXAHACHIE, TX 75165
TEL: 972-937-7032, FAX: 972-938-0860

UNLESS OTHERWISE NOTED ALL CORNERS ARE .015 RAD. AND TYPICAL WALL THICKNESS IS

EST AREA: .598	EST WT/FT: .718	EST. FIN. PERI: 14.790	EST. FULL PERI: 14.790	P-NO: 7	CIRCLE SIZE: 4	CLASS: SOLID	T-DWG # T-70127326SD	PORTS: 2	SIZE: 9X2
FACTOR: 21								BOLSTER: 2-23	FEEDER: 12X7 1/2

- NOTE:**
1. 6063-T5 ALLOY & TEMPER
 2. SNAP FITS WITH CUST P/N T-46718
 3. POUR AND DEBRIDGE AREA=.110
 4. COOLING DENTS POSSIBLE



STW	REVISION	BY	DATE	CUSTOMER	DIE NO.
				RAM INDUSTRIES	46727
				REPLACEMENT FIN	8-26-11
				T-46719	
				2 X SIZE	

NO EXPOSED SURFACES

ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE



Report #:	J8690.01-801-44
Date:	05/12/20
Verified by:	J.Crump

UNLESS OTHERWISE NOTED,
ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS .082 ±.006

EST AREA:	.289	UT-NO.:	UT-1022	POINTS:	2
EST WT/LT:	.347	CORNER SIZE:	2.5	BACKER:	9 X 46727
EST PERL:	9.495	GLASS:	SOLID	BACKER:	2-1
FACTOR:	27	RATIO:	7" = 71	FEEDER:	---

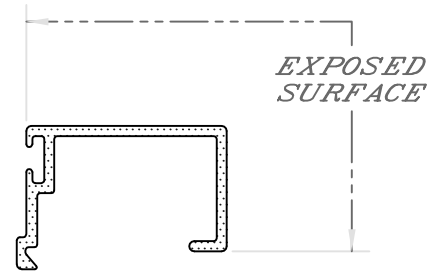
International Extrusion Corporation
202 SINGLETON DRIVE
WAKAHACHIE, TX 75165
TEL: 972-957-7032, FAX: 972-958-3271

SYM	REVISION	BY	DATE	CUSTOMER	DIE NO.
				RAM INDUSTRIES	46730
				PART NAME: GLAZING STOP	DRAWN: LRL
				PART NO. 44195	DATE: 8-22-11
				SCALE: 4 X SIZE	CHKD. APPR.

ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

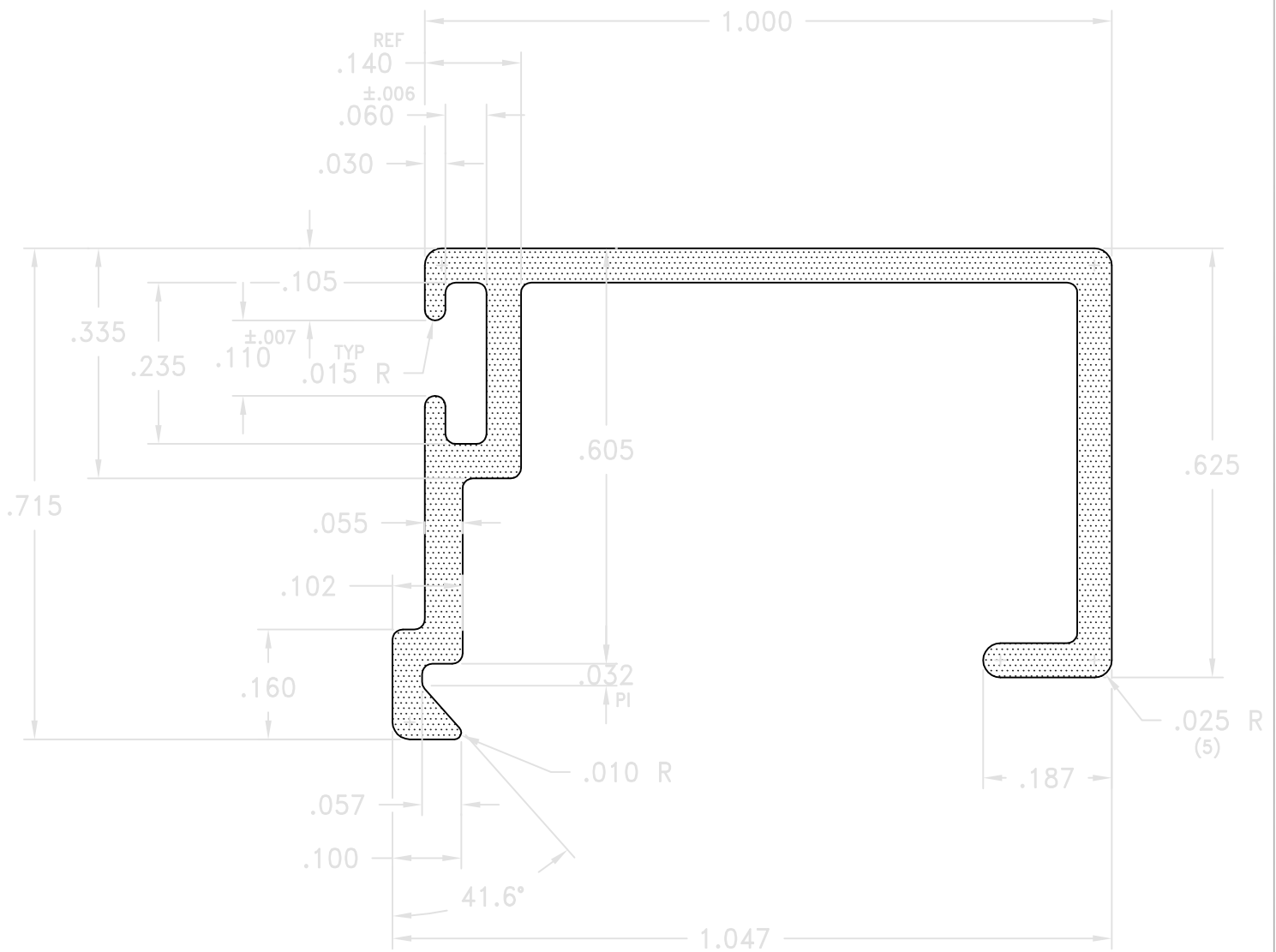
NOTE:

1. 6063-T5 ALLOY & TEMPER
2. MATES WITH PART NO. 44192, 44193, 44194, Q-18694-3 AND Q-18694-8



ACTUAL SIZE

	Report #:	J8690.01-801-44
	Date:	05/12/20
	Verified by:	J.Crump



UNLESS OTHERWISE NOTED. ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS $\pm .006$.050



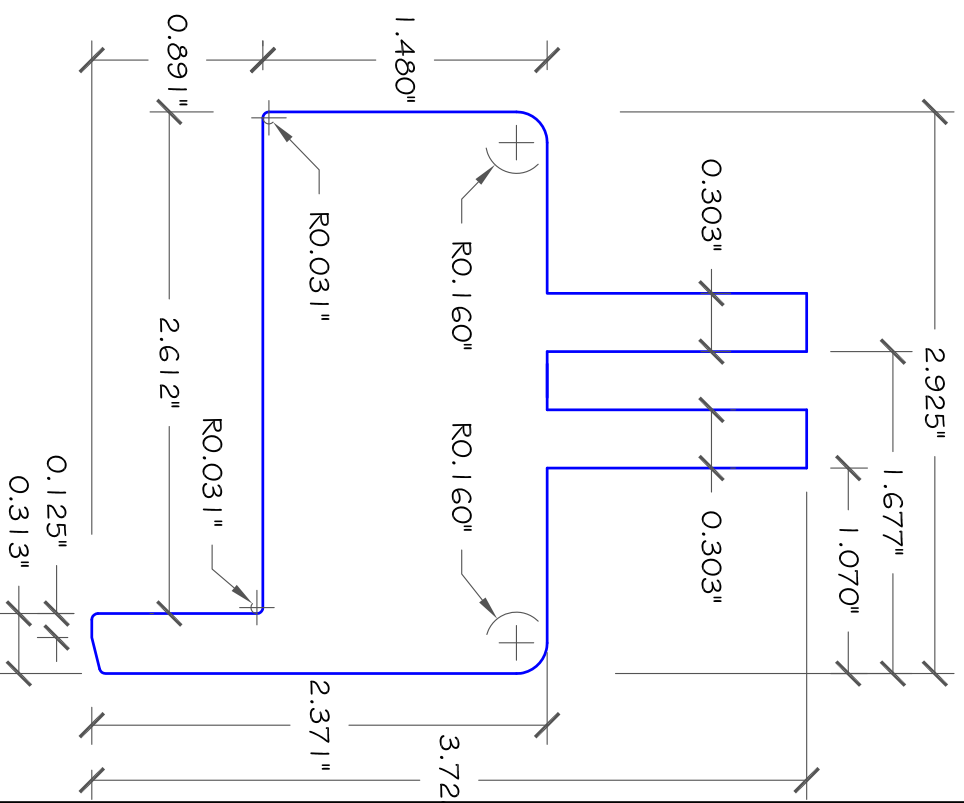
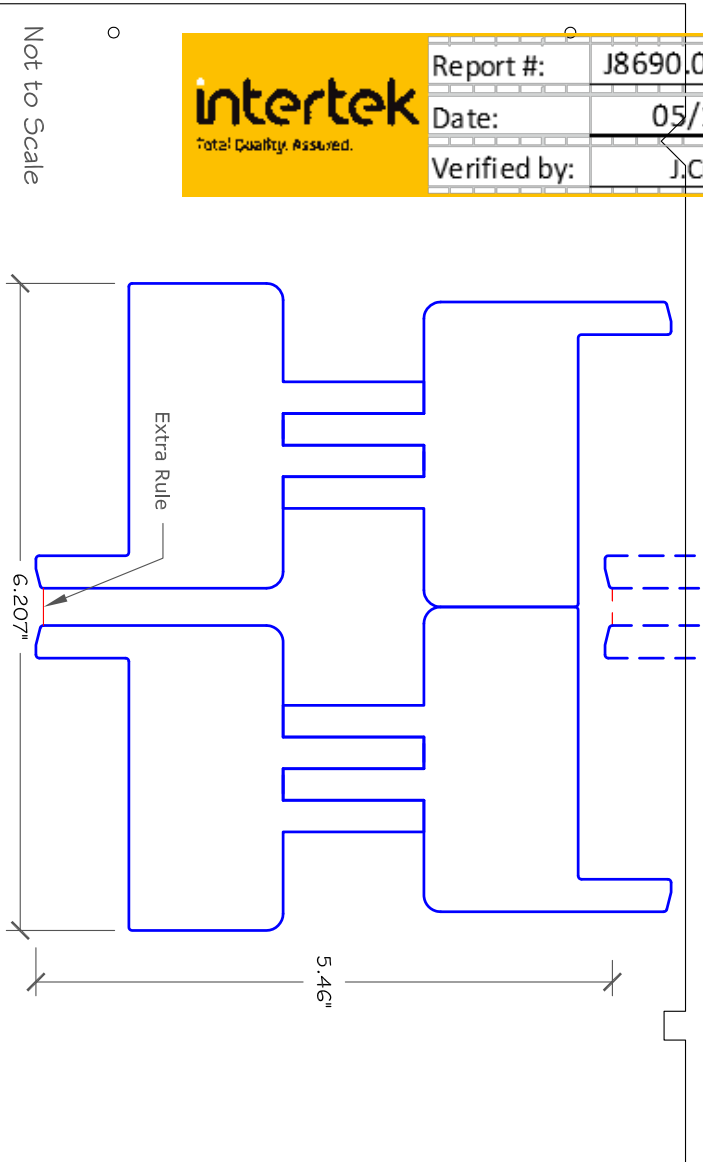
International Extrusion Corporation

202 SINGLETON DRIVE
WAXAHACHIE, TX 75165
TEL: 972-937-7032, FAX: 972-938-3271

EST AREA:	.132	UT-NO.	1019	PORTS	5	WP	----
EST WT/FT:	.158	CIRCLE SIZE:	1.2	BACKER	9 x 30897		
EST PERI:	5.277	CLASS	SOLID	BOLSTER	5-7		
FACTOR:	33	ER	7" = 62	DIE NO.	46730		

intertek
Total Quality. Assured.

Report #:	J8690.01-801-44
Date:	05/12/20
Verified by:	J. Crump



Micrometer:	3.598	PRECO DIE #749
Progression:	5.350	Board: 5/8" thick wood
Batch / Amount:		Type/Size: 12" x 20" Preco
Rate / Acceleration:	10 / 5	Rule: 2 pt 0.937" high long dbl cntr bevel
Tons:	16	Punches: Feed-through
Upstroke:	3.20	/Roll:
RF2/3 / RF3:	10 / 10	/Box:
Feed: Before/After:		Box type:

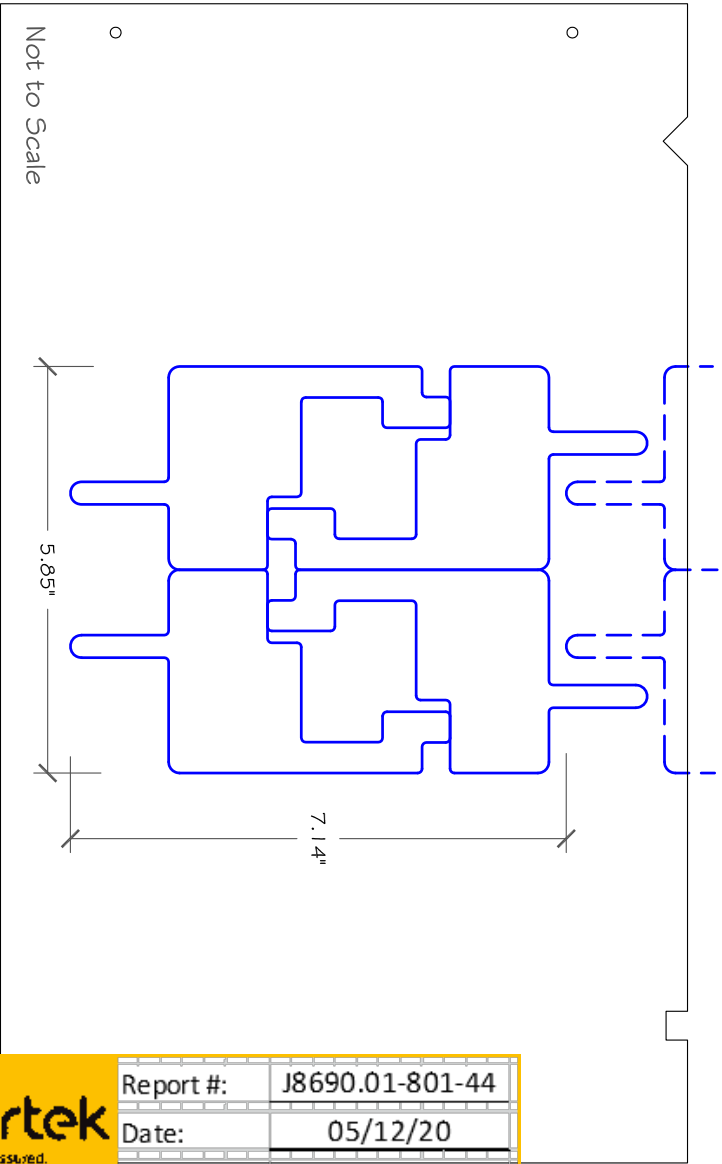
NOTES


1 SET = 1 Left Hand Gasket
+ 1 Right Hand Gasket
Supplied kiss cut on rolls with
web scrap removed

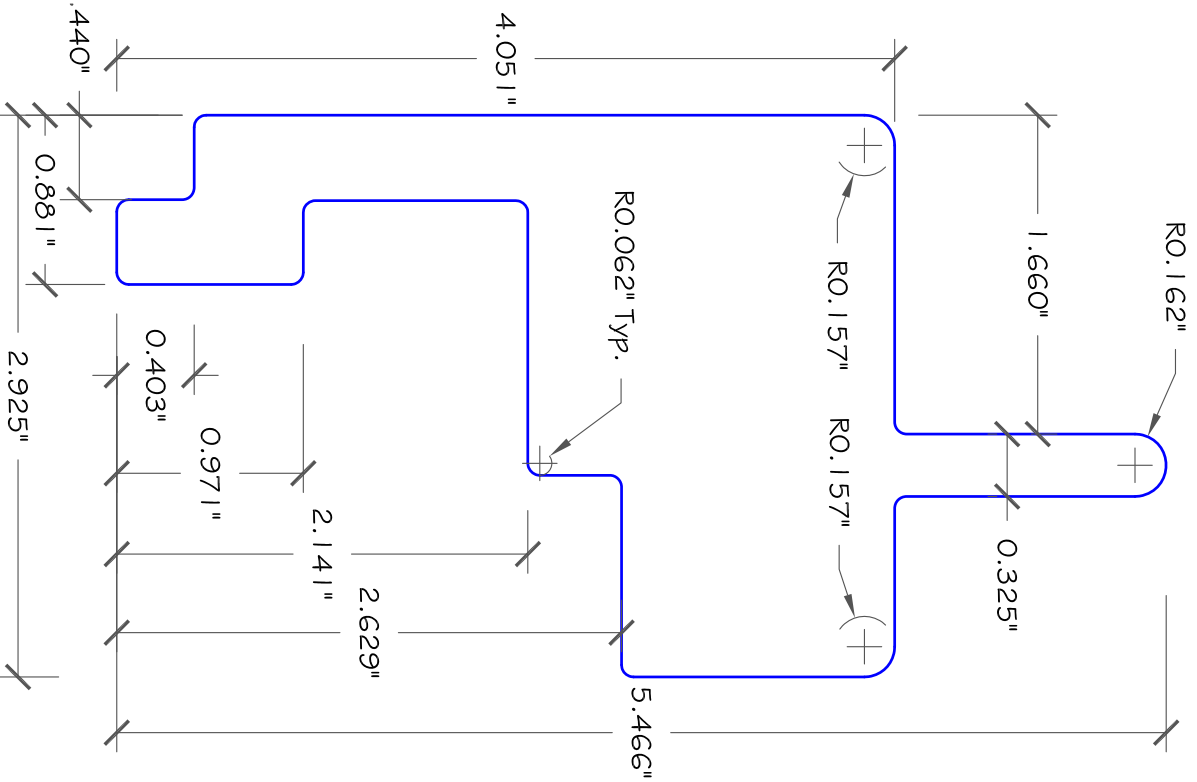
MATERIAL

1/8" thick 2# XLP w/PSA

TOLERANCES UNLESS OTHERWISE SPECIFIED		FRANK LOWE 44 HANCOCK ROAD • SHIRLEY, NEW YORK 11967-4014 RUBBER & GASKET CO., INC. 631-777-2792 • 800-377-6282 • FAX 631-777-2480	
APPROVALS	DATE	SCALE	SHEET
DRAWN BY: A.V.	9-28-2018	0-RA1002-HPWCNRGSKTW125	1 of 1
CHECKED BY:	SPLIT WIDTH:	HPW Corner Gskt Rev. B	
FEED LENGTH / SPF / PPF: 4.40 SPF 5.46"	7"	Ram Industries	



 Total Quality Assured.	Report #:	J8690.01-801-44
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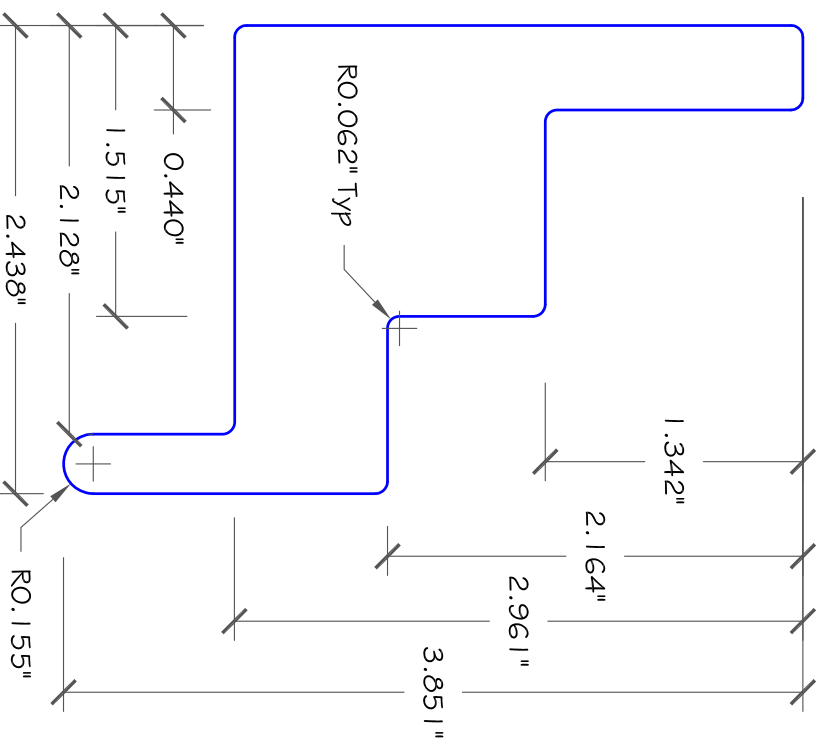
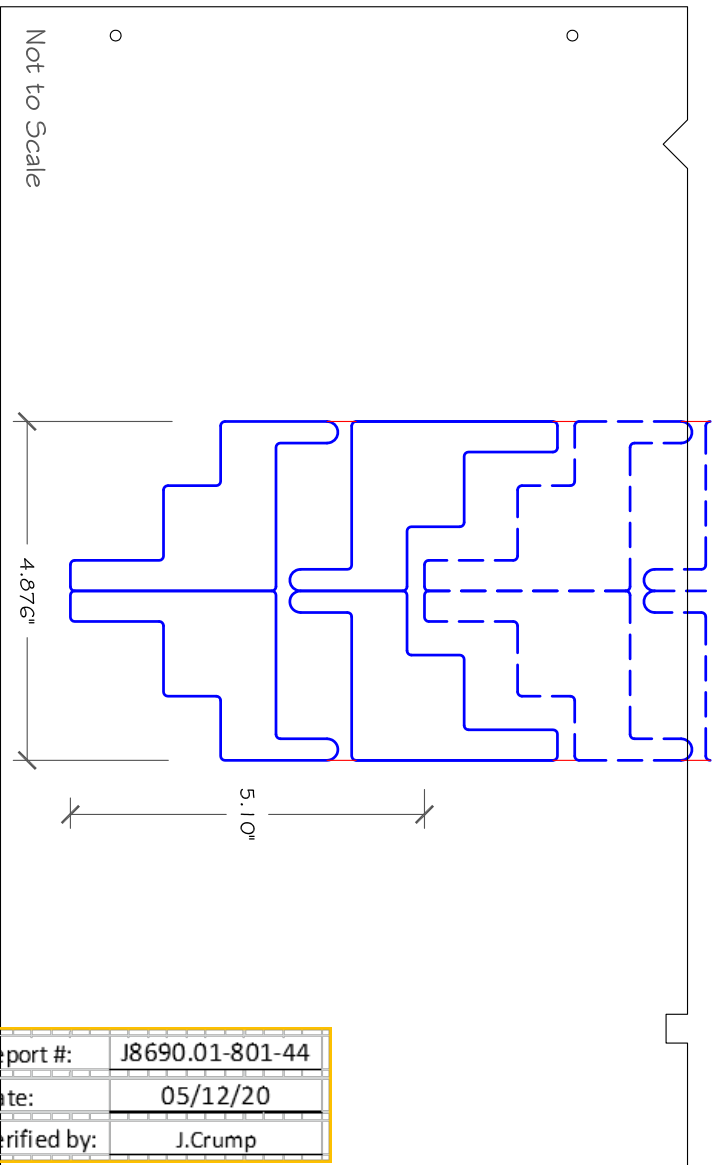
Micrometer:	
Progression:	
Batch / Amount:	
Rate / Acceleration:	
Tons:	
Upstroke:	
RF2/3 / RF3:	
Feed: Before/After:	

PRECO DIE #	
Board:	5/8" thick wood
Type/Size:	12" x 20" Preco
Rule:	2 pt 0.937" high long dbl cntr bevel
Punches:	Feed-through
/Roll:	
/Box:	
Box type:	

NOTES 4 cavity (2 set) Preco die, Wood: 5/8" thick, 12" x 20" Preco wood with cutouts, Rule: 0.937" high, 2pt. long double center bevel. MATERIAL 1/8" thick 2# XLP w/PSA	
TOLERANCES UNLESS OTHERWISE SPECIFIED	
APPROVALS	DATE
DRAWN BY: A.V.	9-28-2018
CHECKED BY:	
FEED LENGTH / SPF / PPF:	SPLIT WIDTH:
7.14"	6.5"
3.36 SPF	



SCALE: 1:1
 SHEET: 1 of 1
 5900-CSMT Frame
 Gasket Rev. B



intertek
Total Quality Assured.

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Verified by:	J.Crump

Micrometer:	
Progression:	
Batch / Amount:	
Rate / Acceleration:	
Tons:	
Upstroke:	
RF2/3 / RF3:	
Feed: Before/After:	

PRECO DIE #	
Board:	5/8" thick wood
Type/Size:	12" x 20" Preco
Rule:	2 pt 0.937" high long dbl cntr bevel
Punches:	Feed-through
/Roll:	
/Box:	
Box type:	

NOTES	
4 cavity (2 set) Preco die, Wood: 5/8" thick, 12" x 20" Preco wood with cutouts, Rule: 0.937" high, 2pt. long double center bevel.	
MATERIAL	
1/8" thick 2# XLP w/PSA	

TOLERANCES UNLESS OTHERWISE SPECIFIED		
APPROVALS	DATE	SCALE
DRAWN BY: A.V.	9-28-2018	1:1
CHECKED BY:		
FEED LENGTH / SPF / PPF:	SUIT WIDTH:	
4.70 SPF	5.5	



5900-CSMT Sash
Gasket Rev. A

SHEET
1 of 1



Total Quality. Assured.

TEST REPORT FOR RAM INDUSTRIES

Report No.: J8690.01-801-44-r0

Date: 05/12/20

1909 10th Street, Suite 100
Plano, Texas 75074

Telephone: 469-814-0687
www.intertek.com/building

SECTION 13

REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	05/12/20	N/A	Original Report Issue