

# RAM INDUSTRIES TEST REPORT

## SCOPE OF WORK

AAMA/WDMA/CSA 101/I.S.2/A440 TESTING ON SERIES S840 INTERIOR SILICONE GLAZED HEAVY PICTURE WINDOW

## REPORT NUMBER

L3960.01-801-44-R0

## TEST DATE(S)

09/21/20

## ISSUE DATE

11/03/20

## RECORD RETENTION END DATE

09/21/24

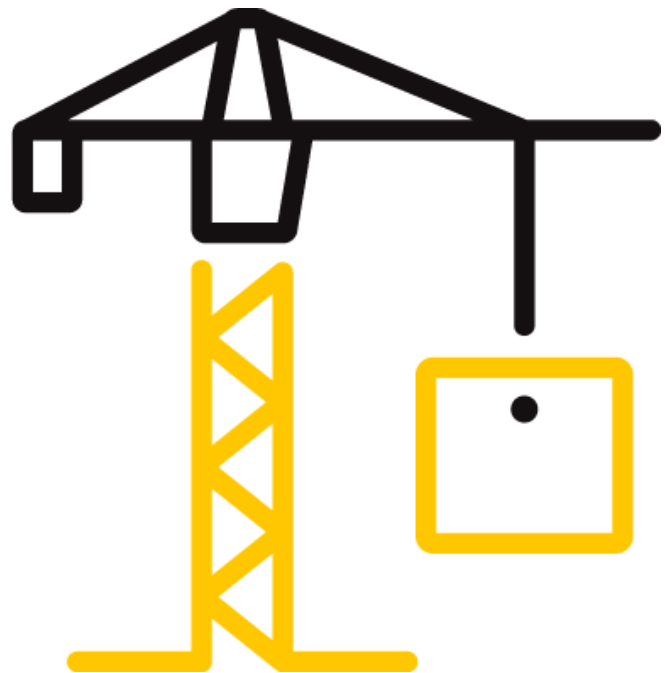
## PAGES

13

## DOCUMENT CONTROL NUMBER

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

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## TEST REPORT FOR RAM INDUSTRIES

Report No.: L3960.01-801-44-r0

Date: 11/03/20

### 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 S840 Interior Silicone Glazed Heavy Picture 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-PG90-FW
Design Pressure	±4320 Pa (±90.23 psf)
Air Infiltration	<0.10 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )
Water Penetration Resistance Test Pressure	580 Pa (12.11 psf)

Reference must be made to Intertek B&C Report No. J6600.01-801-44, dated 02/13/20 for complete test specimen description and detailed test results.

For INTERTEK B&C:

<b>COMPLETED BY:</b>	Jeffrey Crump	<b>REVIEWED BY:</b>	Andy Cost
<b>TITLE:</b>	Sr. Project Manager – AWS	<b>TITLE:</b>	Laboratory Manager
<b>SIGNATURE:</b>		<b>SIGNATURE:</b>	
<b>DATE:</b>	11/03/20	<b>DATE:</b>	11/03/20

JC:cm

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## TEST REPORT FOR RAM INDUSTRIES

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

**ASTM F588-17**, *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 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	Snap in 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.

### SECTION 6

#### LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Jeffrey Crump	Intertek B&C
Jason Gossage	Intertek B&C

## TEST REPORT FOR RAM INDUSTRIES

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### SECTION 7

#### TEST SPECIMEN DESCRIPTION

**Product Type:** Fixed Window

**Series/Model:** S840 Interior Silicone Glazed Heavy Picture Window

#### Product Size(s):

OVERALL AREA:	WIDTH		HEIGHT	
	millimeters	inches	millimeters	inches
1.95 m <sup>2</sup> (21 ft <sup>2</sup> )				
Overall size	2134	84	914	36
Daylight Opening	2054	80-7/8	835	32-7/8

#### Frame Construction:

MEMBER	MATERIAL	DESCRIPTION
Head, sill, jambs, and snap in nail fin	Aluminum	Extruded aluminum 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 sealed with silicone.

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

**Weatherstripping:** *No weatherstripping was utilized.*

**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	3/16" annealed	3/16" annealed	Interior glazed with silicone at the exterior face of glass and aluminum glazing bead with rubber stop at the interior face of glass.

**TEST REPORT FOR RAM INDUSTRIES**

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Date: 11/03/20

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Head sill and jambs	2	2054 x 835	80-7/8 x 32-7/8	9/16

**Drainage:** Weeps were not utilized

**Hardware:** No hardware was utilized.

**SECTION 8  
TEST RESULTS**

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

TITLE OF TEST	RESULTS	ALLOWED	NOTE
<b>Air Leakage,</b> Infiltration per ASTM E283 at 300 Pa (6.24 psf)	<0.10 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1, 2
<b>Air Leakage,</b> Exfiltration per ASTM E283 at 300 Pa (6.24 psf)	<0.10 L/s/m <sup>2</sup> (<0.01 cfm/ft <sup>2</sup> )	1.5 L/s/m <sup>2</sup> (0.3 cfm/ft <sup>2</sup> ) max.	1, 2
<b>Water Penetration,</b> per ASTM E547 at 580 Pa (12.11 psf)	Pass	No leakage	
<b>Uniform Load Structural,</b> per ASTM E330 Deflections taken at Anchors +4320 Pa (+90.23 psf) -4320 Pa (-90.23 psf)	.51 mm (0.02") 1.02 mm (0.04")	1.8 mm (0.07") max. 1.8 mm (0.07") max.	

TITLE OF TEST	RESULTS	ALLOWED	NOTE
<b>Uniform Load Structural,</b> per ASTM E330 Permanent Set taken at Anchors +6480 Pa (+135.33 psf) -6480 Pa (-135.33 psf)	<.10 mm (<0.01") <.10 mm (<0.01")	1 mm (0.04") max. 1 mm (0.04") max.	3
<b>Forced Entry Resistance,</b> per ASTM F588, Type: D - Grade: 10	Pass	No entry	

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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 09/21/20 / Time: 10:00 AM(Air Note Only)*

*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. In our opinion, the tape and film did not influence the results of the test.*

## TEST REPORT FOR RAM INDUSTRIES

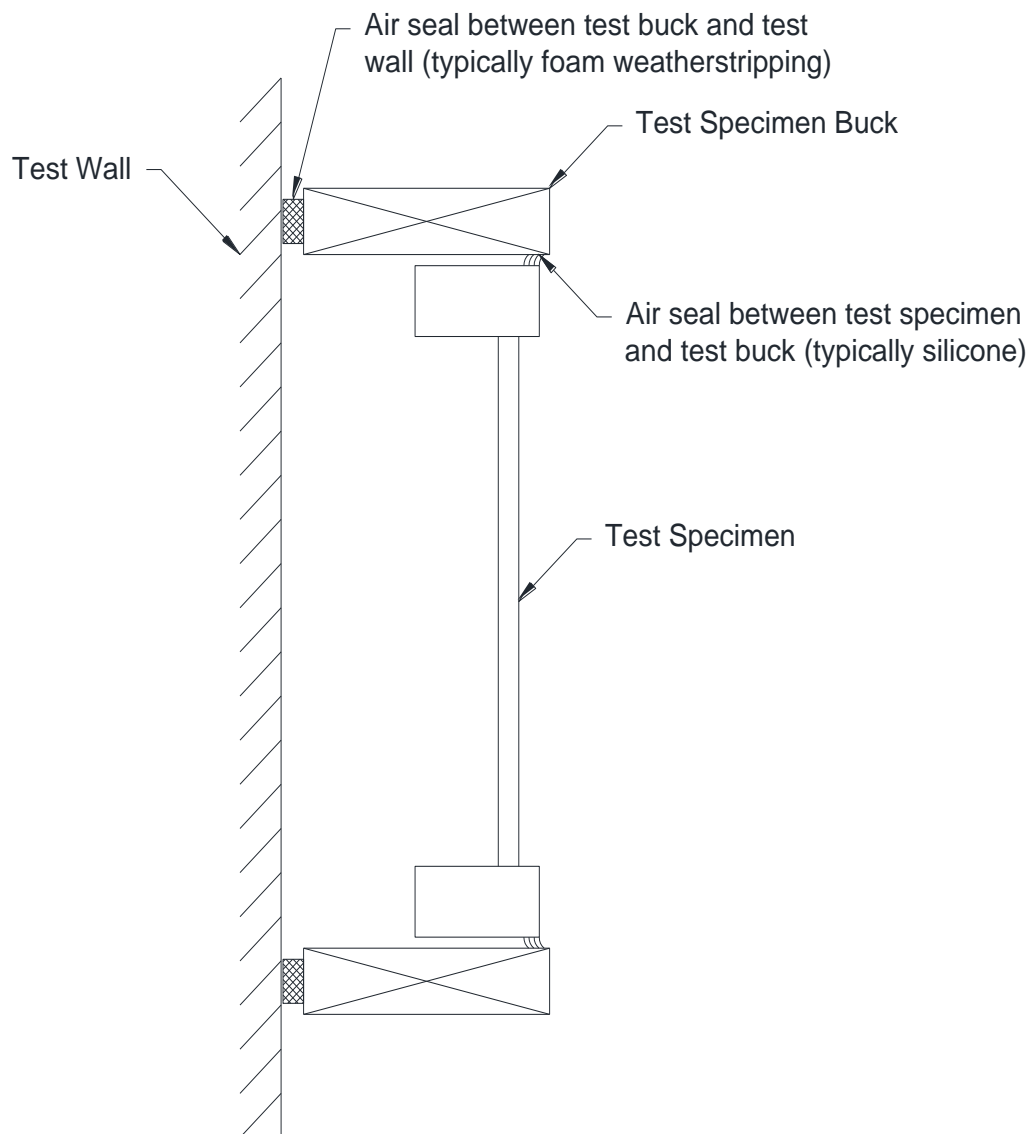
Report No.: L3960.01-801-44-r0

Date: 11/03/20

### SECTION 9

#### 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.







Total Quality. Assured.

## TEST REPORT FOR RAM INDUSTRIES

Report No.: L3960.01-801-44-r0

Date: 11/03/20

1909 10th Street, Suite 100  
Plano, Texas 75074

Telephone: 469-814-0687  
[www.intertek.com/building](http://www.intertek.com/building)

### SECTION 10

#### CONCLUSION

The specimen tested successfully met the performance requirements for a **CW-PG90-FW** rating.

Reference Intertek B&C Report No. J6600.010-801-44, dated 02/13/20 for complete *Gateway* test specimen description and test results.



Total Quality. Assured.

## TEST REPORT FOR RAM INDUSTRIES

Report No.: L3960.01-801-44-r0

Date: 11/03/20

1909 10th Street, Suite 100  
Plano, Texas 75074

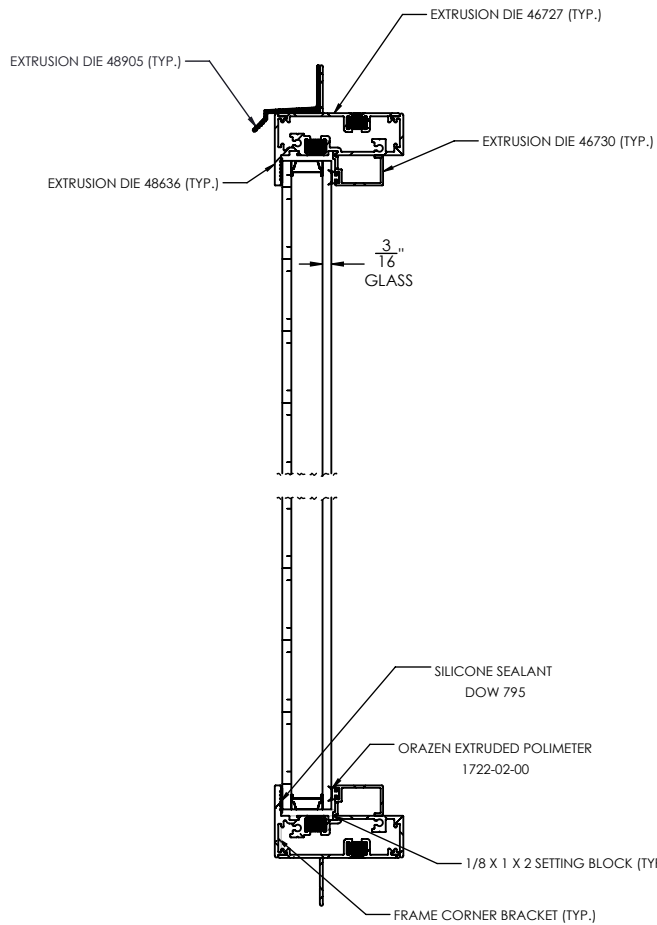
Telephone: 469-814-0687  
[www.intertek.com/building](http://www.intertek.com/building)

### SECTION 11

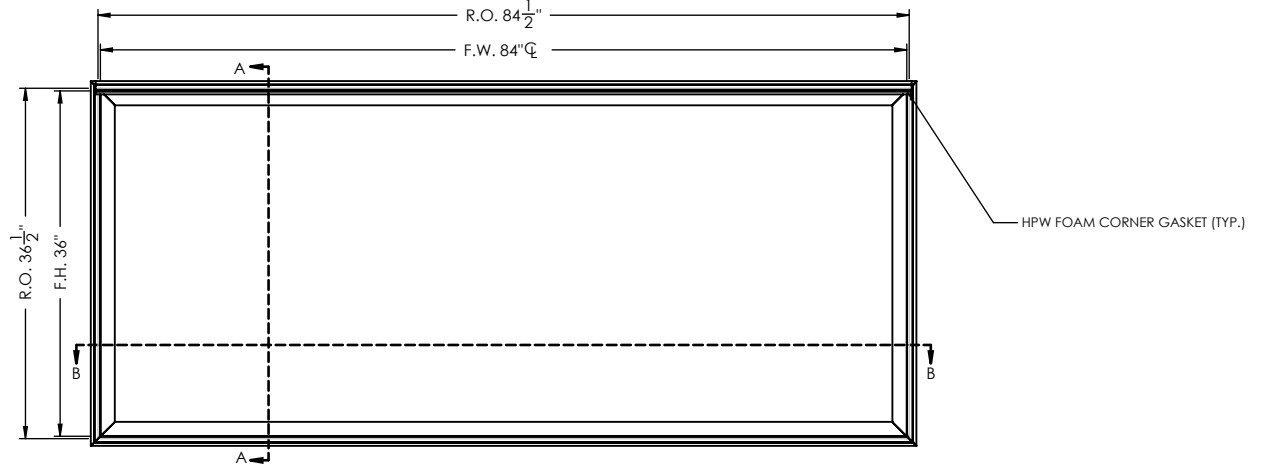
#### DRAWINGS

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.

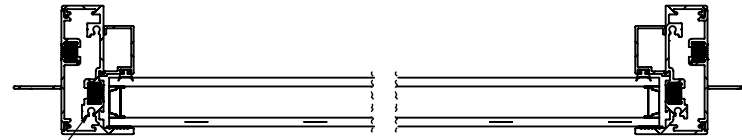
**Ram S840 Heavy Picture Window**



SECTION A-A  
SCALE 1 : 4



	Report #:	L3960.01-801-44
	Date:	11/03/20
	Verified by:	J.Crump



SECTION B-B  
SCALE 1 : 4

REV	DESCRIPTION	BY	DATE
~	~	~	~
~	~	~	~

<p><b>PROPRIETARY AND CONFIDENTIAL</b></p> <p>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.</p>	LEAD TIME	8+	WEEKS	CUSTOMER	Commercial Test Units
	GLASS WARRANTY	2	YEARS	PROJECT	Brinkmann Constructors
	FRAME WARRANTY	2	YEARS	CITY	Plano
	FINISH WARRANTY	2	YEARS	STATE	TX
	U-FACTOR	0.35		OUTER GLASS	3/16" Cardinal 366 LoE
	SHGC	0.23		AIR SPACE	5/8" Argon
	OA GLASS THICKNESS	1"		INNER GLASS	3/16" Clear

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
FRACTIONAL TOLERANCES:
FRACTIONAL ± 1/16
ANGULAR: MACH/BEND ± .5
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .004
MATERIAL
<b>6063-T5 ALUMINUM</b>
DO NOT SCALE DRAWING

NAME	DATE
CG	5/12/2020
MARK	Type C
QTY.	1
FINISH	Dark Bronze
DP	CW40
COMMENTS:	

<b>RAM INDUSTRIES</b>		
TITLE:		
Commercial Test Units		
Brinkmann Constructors		
SIZE	DWG. NO.	REV
<b>A</b>	38755-300-1- DETAILS	~
SCALE: 1:20	WEIGHT: 121.49	SHEET 1 OF 1

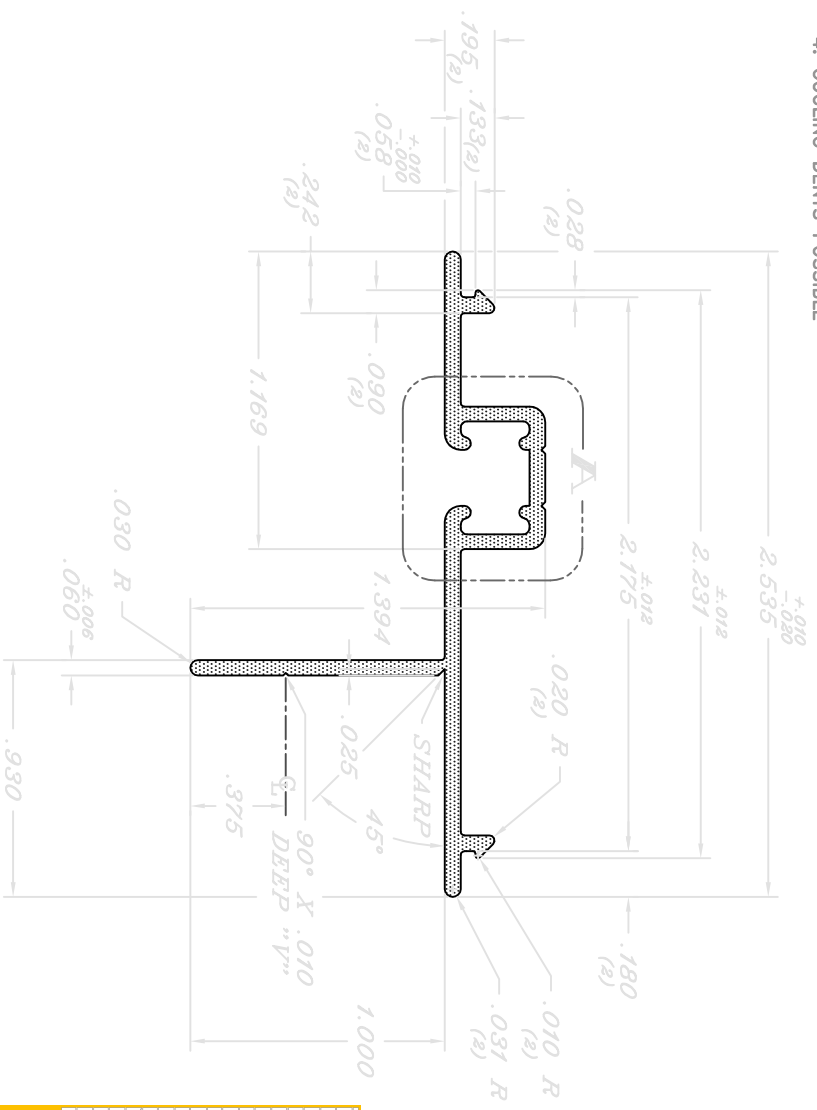
**DRAWING APPROVAL**

- 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.

- 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



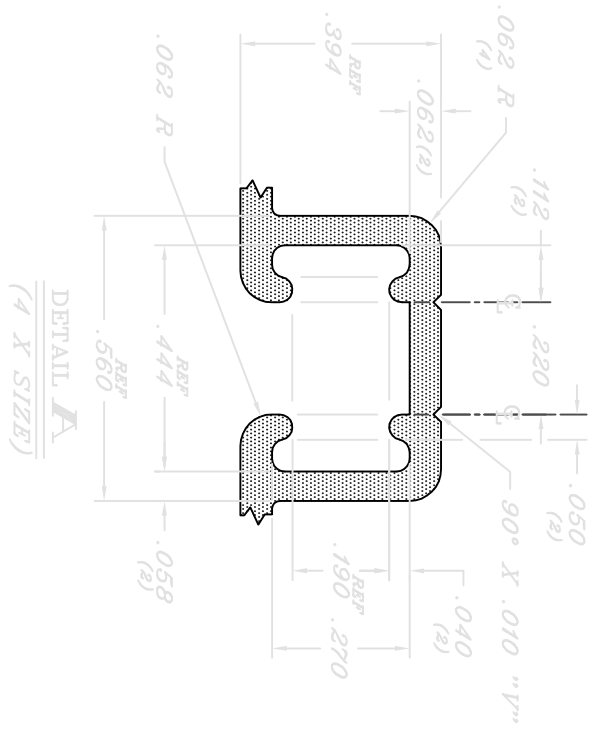
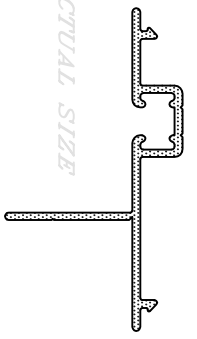
**intertek**  
Total Quality Assured.

Report #:	L3960.01-801-44
Date:	11/03/20
Verified by:	J.Crump

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

ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

**NO EXPOSED SURFACES**



**International Extrusion Corporation**  
202 SINGLETON DRIVE  
WAKAHACHIE, TX 75165  
TEL: 972-957-7032, FAX: 972-958-5271

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

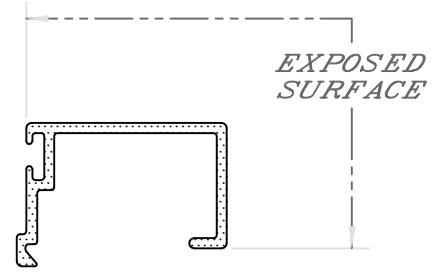
EST AREA:	.289	UT-NO.:	UT-1022	POINTS:	2
EST WT/LT:	.347	CORSE SIZE:	2.5	BACKER:	9 X 46727
EST PERL:	9.495	GLASS:	SOLID	BOOSTER:	2-1
FACTOR:	27	RATIO:	7" = 71	FEEDER:	---

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

ALUMINUM ASSOCIATION TOLERANCES FOR EXTRUSION SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

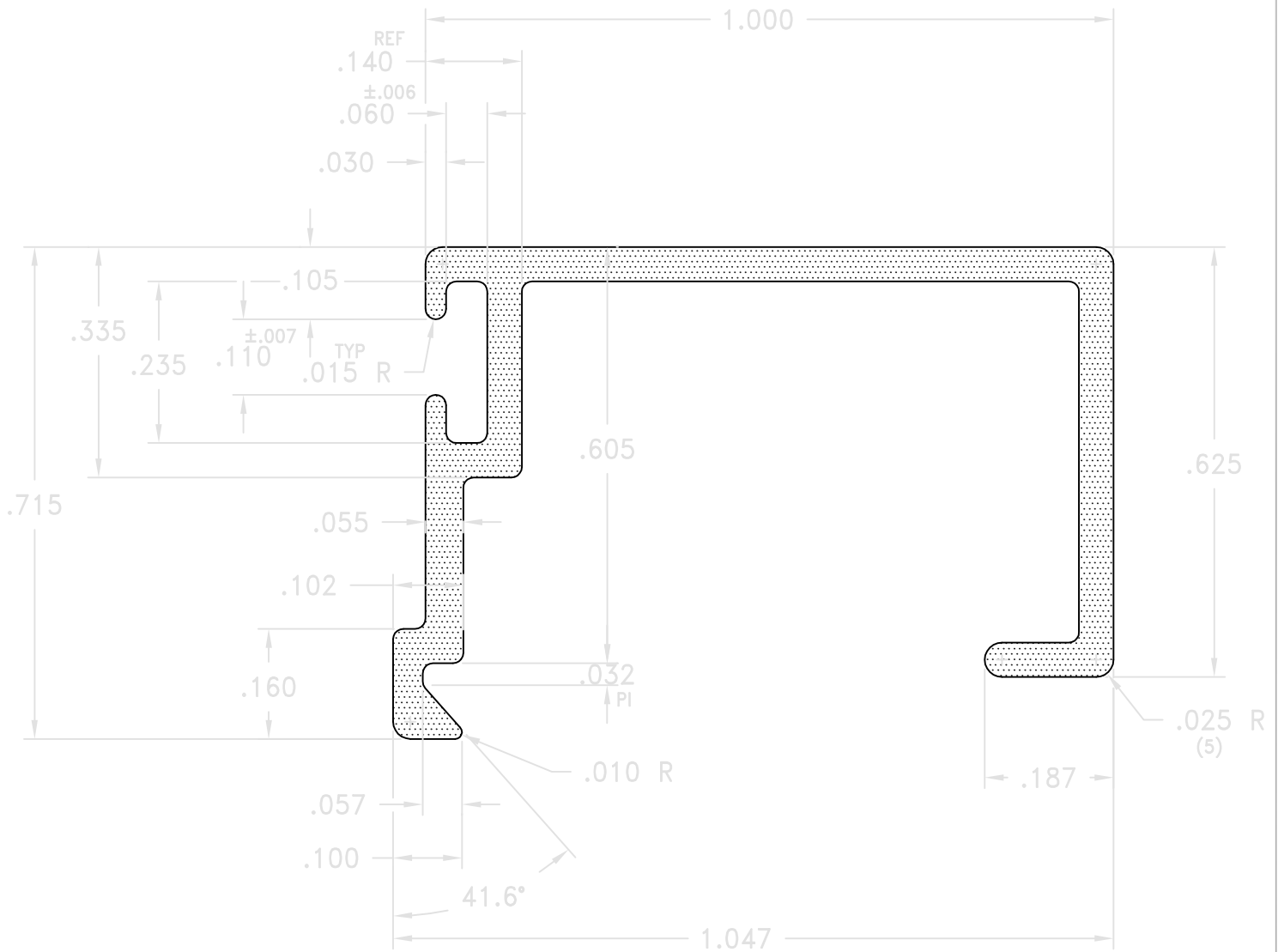
**NOTE:**

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



ACTUAL SIZE

<b>Intertek</b> Total Quality Assured.	Report #:	L3960.01-801-44
	Date:	11/03/20
	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

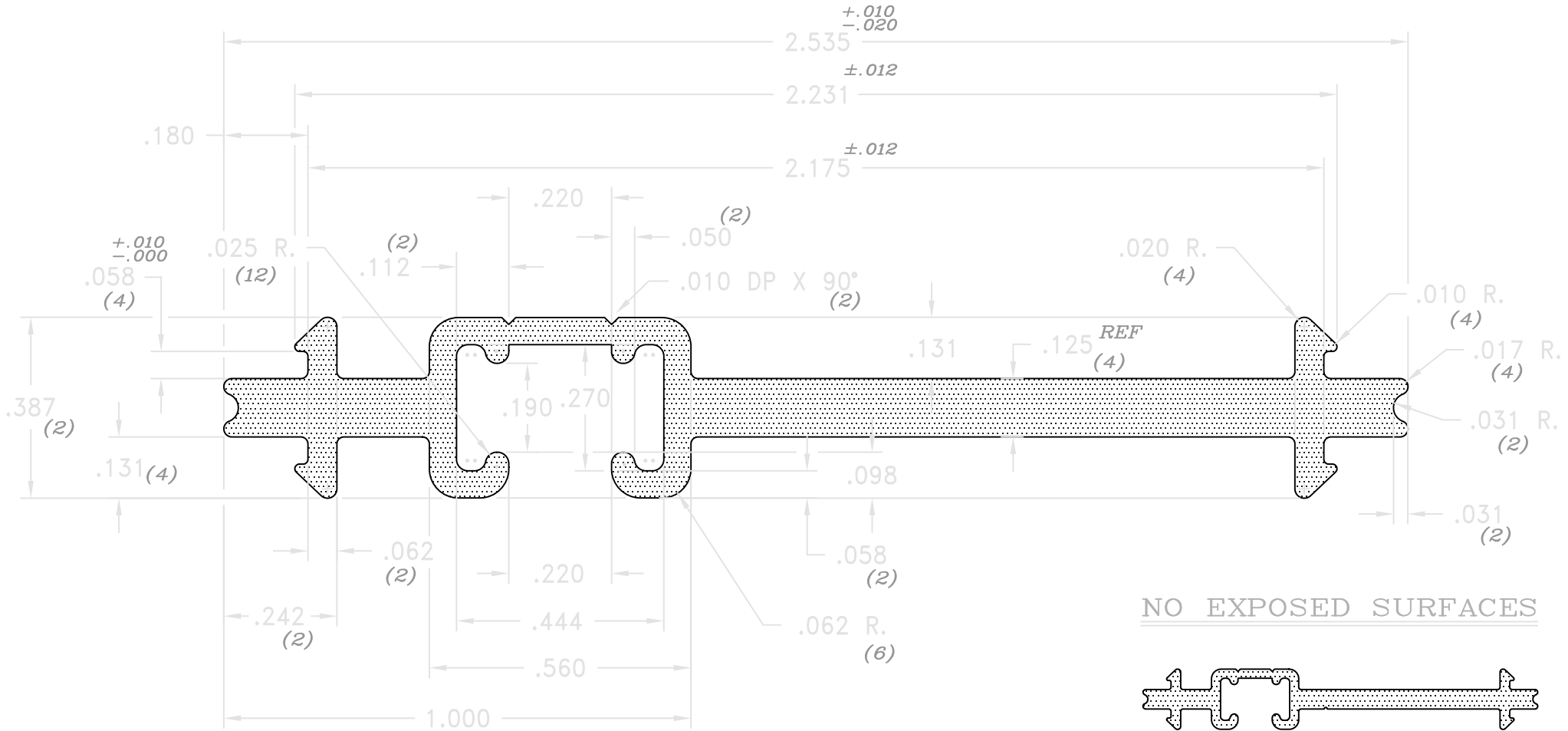
TEL: 972-937-7032, FAX: 972-938-3271

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		

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



	Report #:	L3960.01-801-44
	Date:	11/03/20
	Verified by:	J.Crump

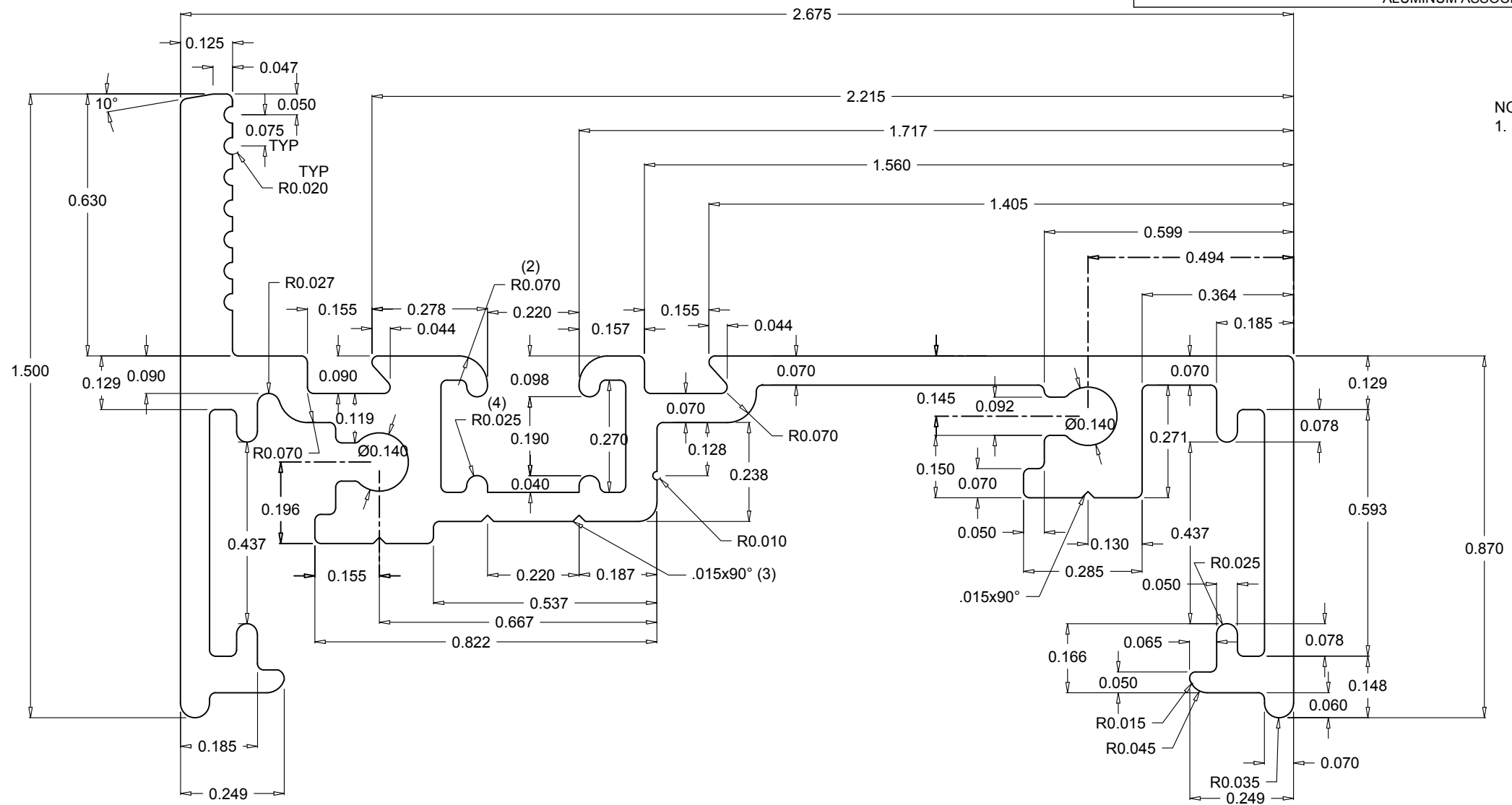


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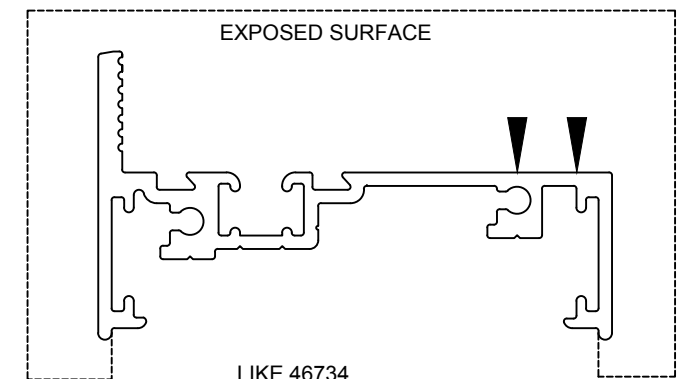
UNLESS OTHERWISE NOTED.  
ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS \_\_\_\_

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		

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



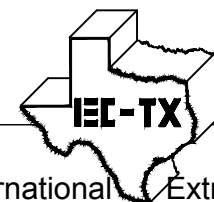
NOTES:  
1. INDICATES POSSIBLE STREAKING IN THIS AREA ARE NOT CAUSE FOR REJECTION.



LIKE 46734

ACTUAL SIZE

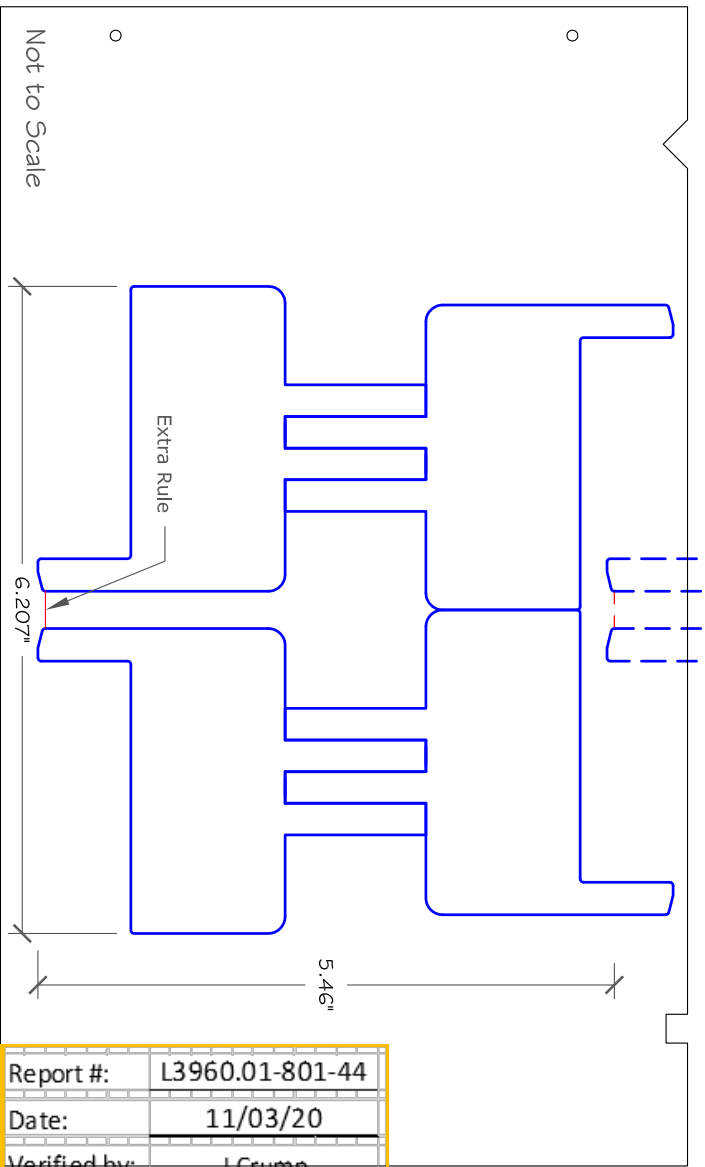
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	Date:	11/03/20
	Verified by:	J.Crump



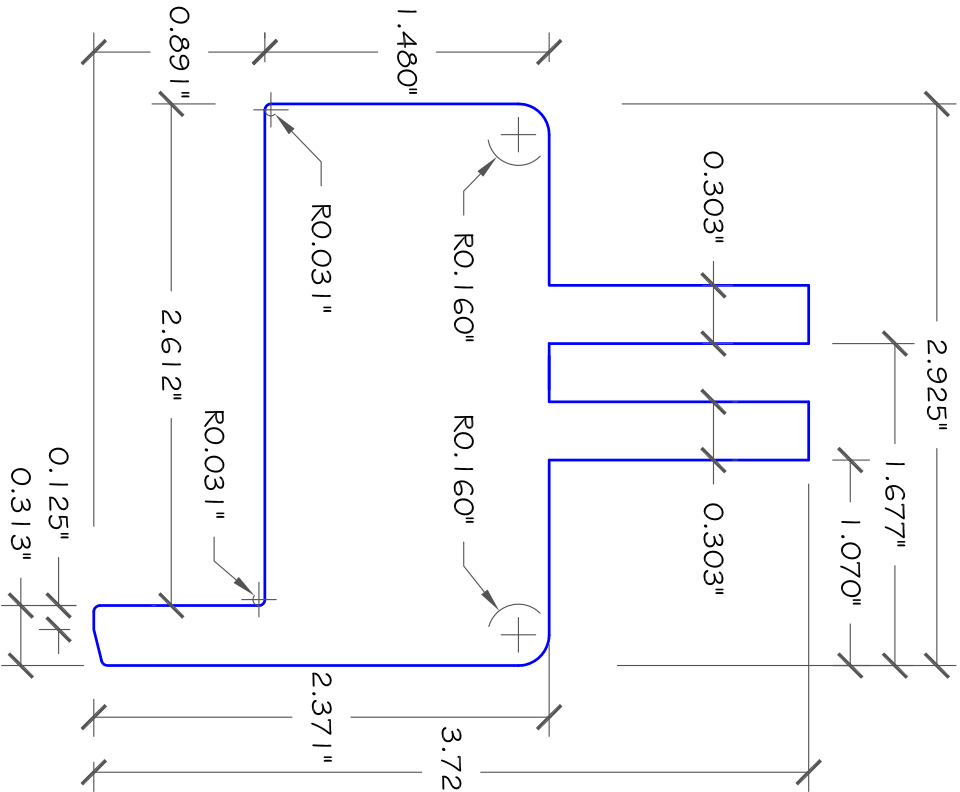
**International Extrusion Corporation**  
202 SINGLETON DRIVE  
WAXAHACHIE, TX 75165  
TEL: 972-937-7032, FAX: 972-938-0860

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
				BACKER: 48636		BOLSTER: 2-23		FEEDER: 12X7 1/2	



Report #:	L3960.01-801-44
Date:	11/03/20
Verified by:	J.Crump



Micrometer:	3.598	PRECO DIE #749	
Progression:	5.350	Board:	5/8" thick wood
Batch / Amount:		Typ/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

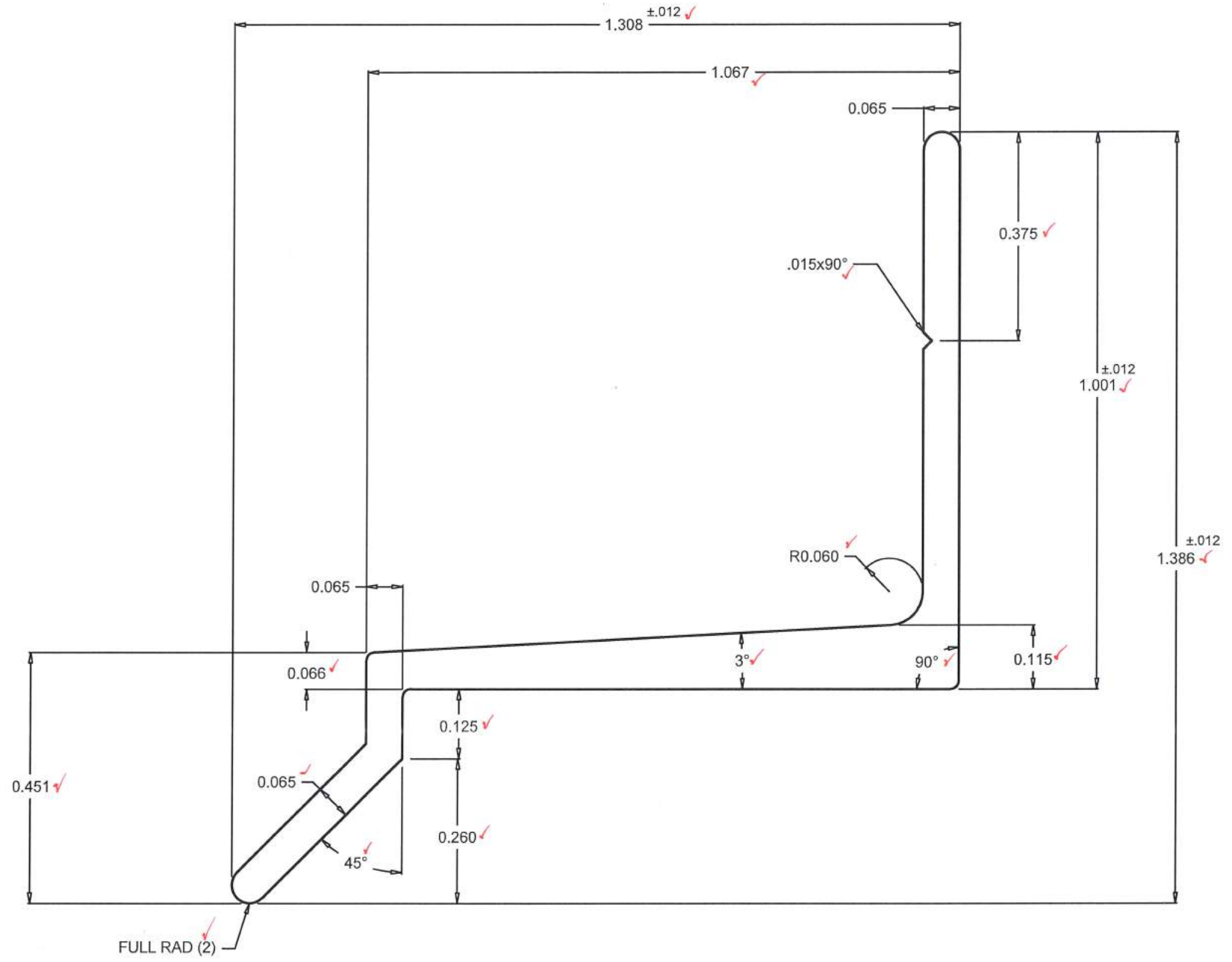
TOLERANCES UNLESS OTHERWISE SPECIFIED		SCALE		SHEET	
APPROVALS	DATE	1:1	HPW Corner Gskt Rev. B	1 of 1	
DRAWN BY: A.V.	9-28-2018	FRANK LOWE 44 Hanning Blvd • Spring Lake, MI 49682-4018 RUBBER & GASKET CO., INC. 814-777-2791 • 800-377-0202 • fax 814-877-2480			
CHECKED BY:	SPLIT WIDTH:	Ram Industries			
FEED LENGTH / SPF / PPF:	7"				
4.40 SPF					



This Document is subject to ethyl aluminum group standard terms and conditions as Found on the aluminum group's purchase order acknowledgement which includes the following provision, 10: Buyer's Designs, Plans, Drawings, specifications, and requirements: on any material which is not included in seller's standard line offered to the trade generally in the usual course of seller's business. It is agreed that buyer has engaged seller to manufacture such material to buyer's specifications and requirements. Buyer recognizes that seller is not responsible for the prints, drawings, specifications and requirements or for the design represented thereby and that materials with such design were requested and specified by buyer. Buyer is responsible for testing or otherwise determining the sufficiency and applicability of the design. Regardless of whether the material purchased is included in seller's standard line offered to the trade generally in the usual course of seller's business, buyer recognizes that seller is not responsible for determining the sufficiency and applicability of the material for buyer's intended use and buyer is responsible for testing or otherwise determining the sufficiency and applicability of the material for buyer's intended use. Buyer will defend, indemnify and hold seller harmless from any claim, liability or damage arising in whole or in part from the requested design and materials made with such design or the insufficiency or inapplicability of the material for buyer's intended use. Seller makes no warranty of merchantability or fitness for a particular purpose or otherwise as to the design or as to any item or items produced using such design and seller's only warranty and the limitation of seller's liability with respect to such design or item shall be as stated on this agreement.

SYM	REVISION	BY	DATE	CUSTOMER	DIE NO.	QUOTE NO.
				<b>STOCK</b>		
				PART NAME RAM WINDOWS DRIP CAP	DRAWN SD	DATE 7/1/2019
			PART NO. RAM 1.0 DRIP CAP DIE	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.



### DIE DRAWING APPROVAL

I, the undersigned hereby approve this print  
 As Drawn       As Marked

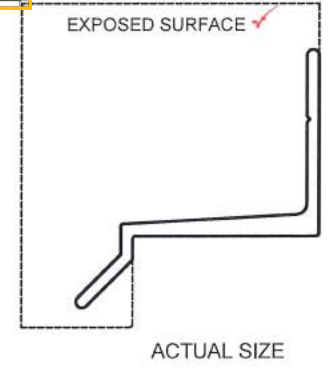
This includes my approval of Tolerances & Dimensions as shown & I authorize the preparation of extrusion die & acknowledge that I will pay the cost of making this die and any cost to revise this die after the production of this die has started.

SIGNATURE *J. Crump*

DATE 7-8-2019

PLEASE INDICATE EXPOSED SURFACE  
IF NOT INDICATED WILL PROCESS AS  
NO EXPOSED SURFACES

<b>intertek</b> <small>Total Quality. Assured.</small>	Report #:	L3960.01-801-44
	Date:	11/03/20
	Verified by:	J. Crump



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

### FOR QUOTING ONLY

UNLESS OTHERWISE NOTED ALL CORNERS ARE .015 RAD. AND TYPICAL WALL THICKNESS IS .065

EST AREA: .188	P-NO:	PORTS:	SIZE:
EST WT/FT: .226	CIRCLE SIZE: 3	BACKER:	
EST. FIN. PERI: 4.969	EST. FULL PERI: 4.969	CLASS: SOLID	BOLSTER:
FACTOR: 22	T-DWG # T-00063	FEEDER:	

7/1/2019 11:45:59 AM



Total Quality. Assured.

## TEST REPORT FOR RAM INDUSTRIES

Report No.: L3960.01-801-44-r0

Date: 11/03/20

1909 10th Street, Suite 100  
Plano, Texas 75074

Telephone: 469-814-0687  
[www.intertek.com/building](http://www.intertek.com/building)

### SECTION 12

#### REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	11/03/20	N/A	Original Report Issue