

**NFRC U-FACTOR, SHGC, VT, &
CONDENSATION RESISTANCE
COMPUTER SIMULATION REPORT**

**Rendered to:
TUBELITE, INC.**

**SERIES/MODEL:
Thermal Door w/ T24000 Framing**

**Report Number: C5869.03-116-45
Report Date: 11/06/13**

**NFRC U-FACTOR, SHGC, VT, & CONDENSATION RESISTANCE
COMPUTER SIMULATION REPORT**

Rendered to:
TUBELITE, INC.
4878 Mackinaw Trail
Reed City, Michigan 49677

Report Number: C5869.03-116-45
Simulation Date: 11/06/13
Report Date: 11/06/13

Project Summary:

Architectural Testing, Inc. was contracted to perform U-Factor, Solar Heat Gain Coefficient, Visible Transmittance, and Condensation Resistance* computer simulations in accordance with the National Fenestration Rating Council (NFRC). The products were evaluated in full compliance with NFRC requirements to the standards listed below.

**NFRC's Condensation Resistance rating is NOT equivalent to a Condensation Resistance Factor (CRF) determined in accordance with AAMA 1503.*

Standards:

NFRC 100-2010: Procedure for Determining Fenestration Product U-Factors
NFRC 200-2010: Procedure for Determining Fenestration Product Solar Heat Gain Coefficient and Visible Transmittance at Normal Incidence
NFRC 500-2010: Procedure for Determining Fenestration Product Condensation Resistance Values

Software:

Frame and Edge Modeling: THERM 6.3.46
Center-of-Glass Modeling: WINDOW 6.3.74
Total Product Calculations: WINDOW 6.3.74
Spectral Data Library: IGDB 32.0

Simulations Specimen Description:

Series/Model: Thermal Door w/ T24000 Framing
Type: Swinging Door, Single Leaf Entrance Door
Frame Material: AP Aluminum w/ Thermal Breaks - Partial
Sash Material: AT Aluminum w/ Thermal Breaks - All Members
Standard Size: 960mm x 2090mm

Modeling Assumptions/Technical Interpretations:

- 1) To prevent air infiltration, tape was applied to all interior sash crack locations.
- 2) This product is available in either a painted or anodized finish. These two finish types were grouped for simulation purposes in accordance with NFRC 100-2010, Section 4.2.1.L. The painted finish was simulated since it is worst case (highest emissivity).

Specialty Products Table:

The specialty products method allow the manufacturer to determine the overall product SHGC and VT for any glazing option. The center of glass SHGC and/or VT must be determined using WINDOW 6.3.74. The method gives overall product SHGC and VT indexed on center of glass properties. All values used in the calculations are truncated to six decimal place precision.

	No Dividers	Dividers < 1	Dividers > 1
SHGC0	0.031627	0.034126	0.036412
SHGC1	0.508259	0.434361	0.380321
VT0	0.000000	0.000000	0.000000
VT1	0.476633	0.400236	0.330350

$$SHGC = SHGC0 + SHGCc (SHGC1 - SHGC0)$$

$$VT = VT0 + VTc (VT1 - VT0)$$

Validation Matrix:

The following products are part of a validation matrix. Only one is required for validation testing.

<i>Product Line</i>	<i>Report Number</i>
None	-

Spacer Option Description

		<i>Sealant</i>		
<i>Spacer Type</i>	<i>Primary</i>	<i>Secondary</i>	<i>Code</i>	
Aluminum Dual Seal Spacer	Butyl Rubber	Butyl Rubber	A1-D	

Grid Option Description

<i>Grid Size</i>	<i>Grid Type</i>	<i>Grid Pattern</i>
None	-	-

Reinforcement Option Description

<i>Location</i>	<i>Material</i>
None	-

Gas Filling Technique Description

<i>Fill Type</i>	<i>Method</i>
84.48% Xenon	Single Probe Timed
76.14% Argon	Single Probe Timed
88.47% Argon	Single Probe Timed
78.56% Argon	Single Probe Timed
78.10% Krypton	Single Probe Timed
87.41% Argon	Single Probe Timed
64.98% Argon	Single Probe Timed
74.70% Argon	Single Probe Timed
60.78% Argon	Single Probe Timed
62.43% Argon	Single Probe Timed
86.02% Argon	Single Probe Timed
81.60% Xenon	Single Probe Timed
94.54% Xenon	Evacuated Chamber
76.90% Krypton	Single Probe Timed
71.54% Xenon	Single Probe Timed
76.45% Krypton	Single Probe Timed
66.67% Xenon	Single Probe Timed
82.16% Xenon	Single Probe Timed

Edge-of-Glass Construction

<i>Interior Condition</i>	EPDM Gasket Between Aluminum Glazing Bead and Glass
<i>Exterior Condition</i>	EPDM Gasket Between Aluminum Glazing Bead and Glass

Weatherstripping

<i>Type</i>	<i>Quantity</i>	<i>Location</i>
Bulb Weatherseal	1 Row	Head and Jamb Frames
Concealed Screw Weatherstrip	1 Row	Sill Frame

Frame/Sash Materials Finish

<i>Interior</i>	Painted Aluminum
<i>Exterior</i>	Painted Aluminum

NFRC 100/200/500 Summary Sheet
Thermal Door w/ T24000 Framing

ID	Pane Thickness 1	Gap Width 1	Pane Thickness 2	Gap Width 2	Pane Thickness 3	Gap Width 3	Pane Thickness 4	Gap Fill	Low-e (Surface#)	Tint	Spacer	Grid Type
	U-Factor			Solar Heat Gain Coefficient (SHGC) Grids (None / <1 / >=1)				Visible Transmittance (VT) Grids (None / <1 / >=1)			Condensation Resistance	
1	COG=0.4400											
	0.222	0.500	0.225					XEN84		CL	A1-D	N
	U-Factor 0.64			SHGC (N) 0.36				VT (N) 0.35			CR 37	
2	COG=0.4200											
	0.236	0.500	0.225					ARG76	0.654(#2)	RC	A1-D	N
	U-Factor 0.63			SHGC (N) 0.20				VT (N) 0.15			CR 37	
3	COG=0.4000											
	0.223	0.500	0.225					ARG88	0.571(#2)	CL	A1-D	N
	U-Factor 0.62			SHGC (N) 0.14				VT (N) 0.08			CR 37	
4	COG=0.3800											
	0.236	0.500	0.225					ARG79	0.465(#2)	RC	A1-D	N
	U-Factor 0.61			SHGC (N) 0.13				VT (N) 0.07			CR 38	
5	COG=0.3600											
	0.221	0.500	0.225					KRY78	0.406(#2)	SR	A1-D	N
	U-Factor 0.60			SHGC (N) 0.13				VT (N) 0.09			CR 38	
6	COG=0.3400											
	0.232	0.500	0.225					ARG87	0.318(#2)	GY	A1-D	N
	U-Factor 0.59			SHGC (N) 0.25				VT (N) 0.27			CR 38	
7	COG=0.3200											
	0.223	0.500	0.225					ARG65	0.215(#2)	CL	A1-D	N
	U-Factor 0.59			SHGC (N) 0.33				VT (N) 0.35			CR 38	
8	COG=0.3000											
	0.233	0.500	0.225					ARG75	0.166(#2)	CL	A1-D	N
	U-Factor 0.58			SHGC (N) 0.24				VT (N) 0.25			CR 38	
9	COG=0.2800											
	0.223	0.500	0.225					ARG61	0.087(#2)	CL	A1-D	N
	U-Factor 0.57			SHGC (N) 0.29				VT (N) 0.36			CR 38	
10	COG=0.2600											
	0.223	0.500	0.225					ARG62	0.035(#2)	CL	A1-D	N
	U-Factor 0.56			SHGC (N) 0.21				VT (N) 0.33			CR 38	

NFRC 100/200/500 Summary Sheet
Thermal Door w/ T24000 Framing

ID	Pane Thickness 1	Gap Width 1	Pane Thickness 2	Gap Width 2	Pane Thickness 3	Gap Width 3	Pane Thickness 4	Gap Fill	Low-e (Surface#)	Tint	Spacer	Grid Type
	U-Factor			Solar Heat Gain Coefficient (SHGC) Grids (None / <1 / >=1)				Visible Transmittance (VT) Grids (None / <1 / >=1)			Condensation Resistance	
11	COG=0.2400											
	0.223	0.500	0.223					ARG86	0.035(#2) / 0.035(#3)	CL	A1-D	N
	U-Factor 0.55			SHGC (N) 0.20				VT (N) 0.30			CR 38	
12	COG=0.2200											
	0.223	0.500	0.223					XEN82	0.018(#2) / 0.018(#3)	CL	A1-D	N
	U-Factor 0.54			SHGC (N) 0.15				VT (N) 0.25			CR 38	
13	COG=0.2000											
	0.223	0.500	0.223					XEN95	0.018(#2) / 0.018(#3)	CL	A1-D	N
	U-Factor 0.53			SHGC (N) 0.15				VT (N) 0.25			CR 38	
14	COG=0.1800											
	0.223	0.250	0.003	0.250	0.221			KRY77/AIR	0.018(#2)/0.755(#3)/0.122(#4)/0.028(#5)	CL	A1-D	N
	U-Factor 0.52			SHGC (N) 0.15				VT (N) 0.21			CR 38	
15	COG=0.1600											
	0.223	0.250	0.003	0.250	0.223			XEN72/AIR	0.018(#2, #5) / 0.755(#3) / 0.122(#4)	CL	A1-D	N
	U-Factor 0.51			SHGC (N) 0.15				VT (N) 0.22			CR 38	
16	COG=0.1400											
	0.223	0.250	0.003	0.250	0.223			KRY76	0.018(#2, #5) / 0.755(#3) / 0.122(#4)	CL	A1-D	N
	U-Factor 0.51			SHGC (N) 0.14				VT (N) 0.22			CR 38	
17	COG=0.1200											
	0.223	0.250	0.003	0.250	0.223			XEN67	0.018(#2, #5) / 0.755(#3) / 0.122(#4)	CL	A1-D	N
	U-Factor 0.50			SHGC (N) 0.14				VT (N) 0.22			CR 38	
18	COG=0.1000											
	0.223	0.250	0.003	0.250	0.223			XEN82	0.018(#2, #5) / 0.755(#3) / 0.122(#4)	CL	A1-D	N
	U-Factor 0.49			SHGC (N) 0.14				VT (N) 0.22			CR 38	

The Condensation Resistance results obtained from this procedure are for controlled laboratory conditions and do not include the effects of air movement through the specimen, solar radiation, and the thermal bridging that may occur due to the specific design and construction of the fenestration system opening.

Ratings values included in this report are for submittals to an NFRC-licensed IA and are not meant to be used directly for labeling purposes. Only those values identified on a valid Certification Authorization Report (CAR) by an NFRC accredited Inspection Agency (IA) are to be used for labeling purposes. The ratings values were rounded in accordance to NFRC 601, NFRC Unit and Measurement Policy.

Architectural Testing, Inc. is an NFRC accredited simulation laboratory and all simulations were conducted in full compliance with NFRC approved procedures and specifications. The NFRC procedure requires that the computational results be verified through actual test results.

Architectural Testing will service this report for the entire test record retention period. Test records that are retained such as detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation will be retained by Architectural Testing, Inc. for the entire test record retention period. The test record retention end date for this report is November 6, 2017.

Results obtained are simulated values and were secured by using the designated test methods. 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 product simulated. This report may not be reproduced, except in full, without the written approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, INC.:

SIMULATED BY:

REVIEWED BY:

Kristen L. Livelsberger
Senior Simulation Technician
NFRC Certified Simulator

Michael J. Thoman
Director - Simulations and Thermal Testing
Simulator-In-Responsible-Charge

KLL:kl

C5869.03-116-45

Attachments (pages): This report is complete only when all attachments listed are included.
Appendix A: Drawings and Bills of Material (37)

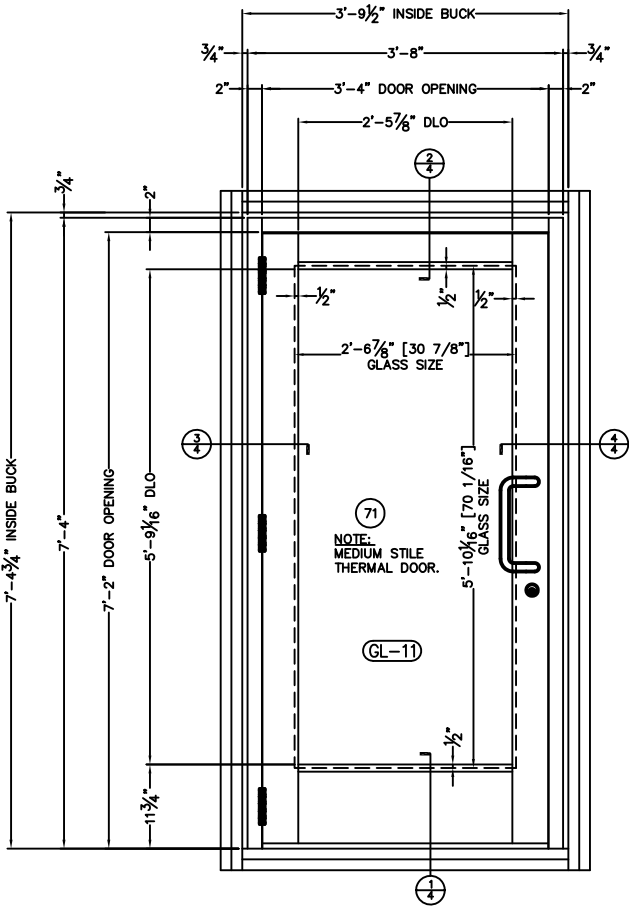
Revision Log

<u>Rev. #</u>	<u>Date</u>	<u>Page(s)</u>	<u>Revision(s)</u>
.03R0	11/06/13	All	Original Report Issued to Tubelite, Inc.

All drawings and Bills of Material used to simulate this product are enclosed in this Appendix

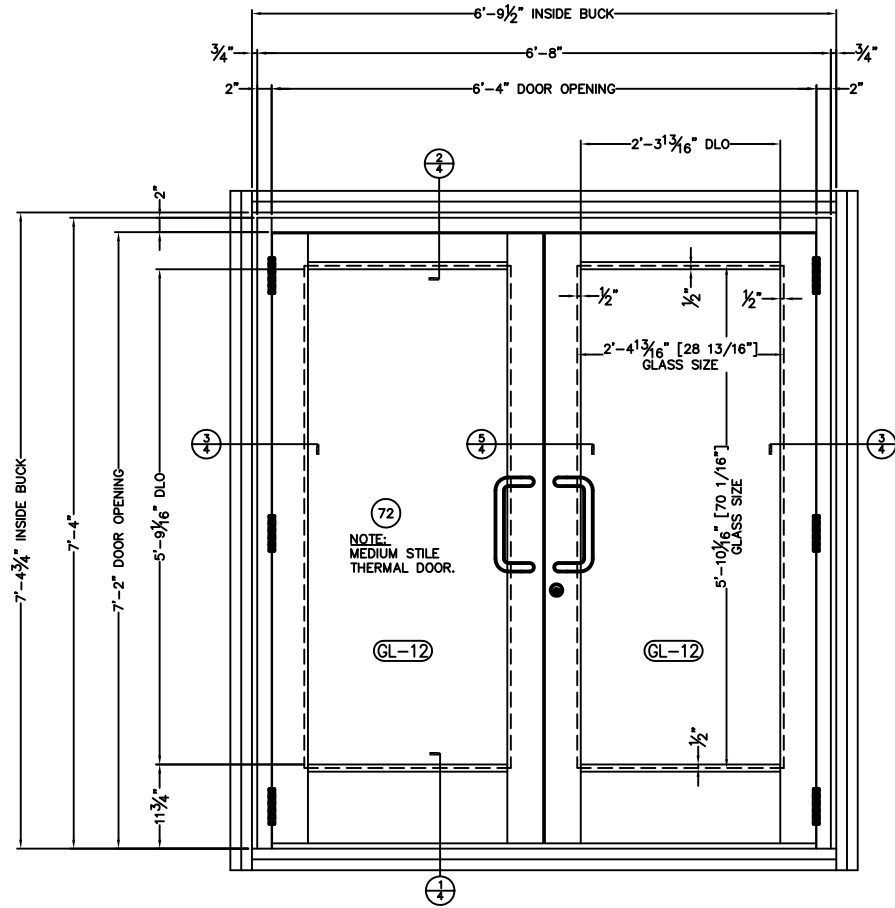
Appendix A

C5869.03-116-45



T24000 STOREFRONT TEST SPECIMEN 2
SINGLE DOOR ~ NON IMPACT

GLAZING NOTES:
 1" GLASS ~ 1/4 TEMPERED 1/2 AIR SPACE 1/4" TEMPERED
 DRY GLAZED



T24000 STOREFRONT TEST SPECIMEN 3
DOUBLE DOOR ~ NON IMPACT

GLAZING NOTES:
 1" GLASS ~ 1/4 TEMPERED 1/2 AIR SPACE 1/4" TEMPERED
 DRY GLAZED

TUBELITE
 NON IMPACT
 T24000 STOREFRONT
 THERMAL & ACOUSTIC TESTING

TUBELITE
 DEPENDABLE
 LEASERS IN COEFFICIENT STOREFRONT,
 CURTAINWALL, AND ENTRANCE SYSTEMS

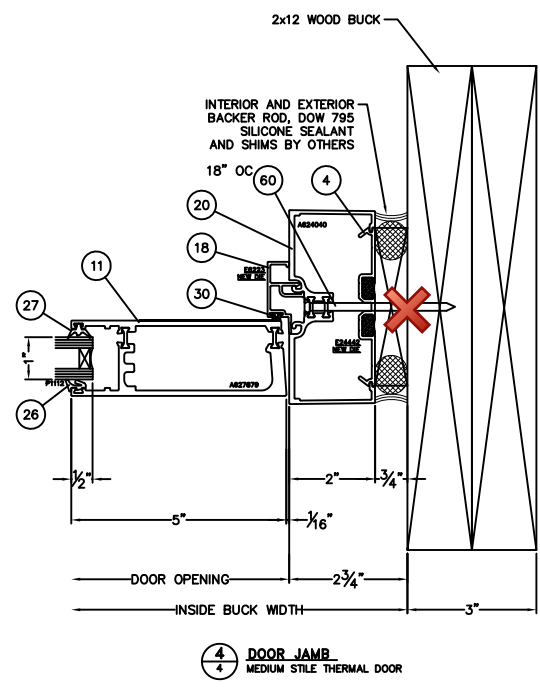
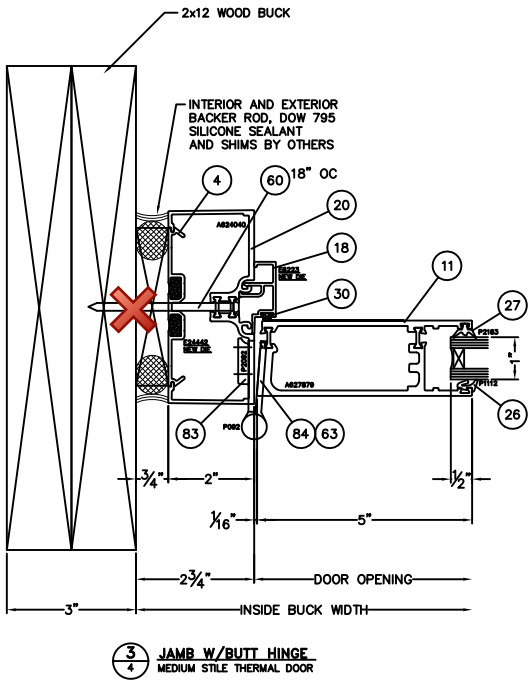
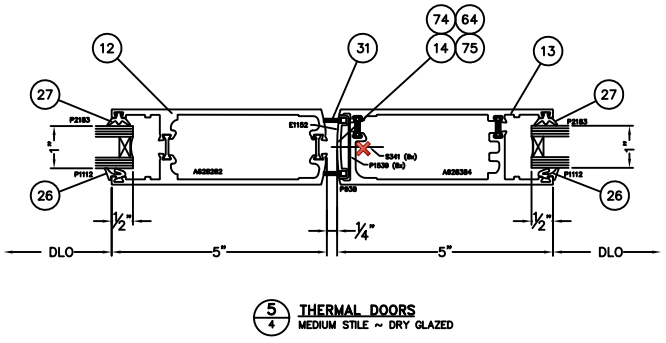
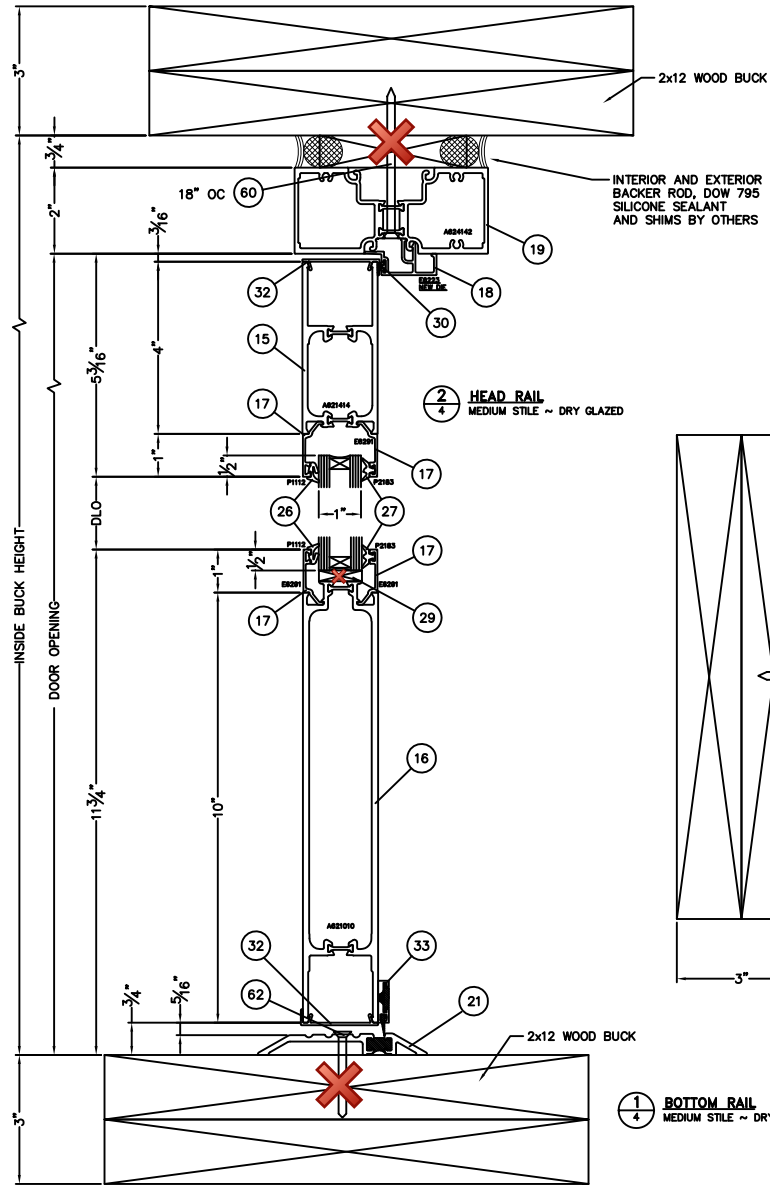
3056 WALKER RIDGE DRIVE N.W.
 WALKER, MICHIGAN 49544
 PH: 800.866.2227
 FX: 616.301.0008
 WEB SITE: WWW.TUBELITEINC.COM

REVISIONS	
NO.	DESCRIPTION

DATED	LATEST RELEASE
1-07-13	1-18-13
DRAWINGS BY: HLP	
ENGINEERED BY:	
TEST ELEVATION	

2.0

2 OF 6



1 BOTTOM RAIL MEDIUM STILE ~ DRY GLAZED
 4

TUBELITE
 NON IMPACT
 T24000 STOREFRONT
 THERMAL & ACOUSTIC TESTING

TUBELITE
 DEFENDABLE
 LEADERS IN COEFFICIENT OF THERMAL EXPANSION,
 CURTAINWALL AND ENTRANCE SYSTEMS
 3056 WALKER RIDGE DRIVE N.W.
 WALKER, MICHIGAN 49544
 PH: 800.866.2227
 FX: 616.301.0008
 WEB SITE: WWW.TUBELITEINC.COM

NO.	DATE	DESCRIPTION

DATED 1-07-13 LATEST RELEASE 1-18-13
 DRAWINGS BY: HLP
 ENGINEERED BY:
 TEST ELEVATION

4.0

4 OF 6

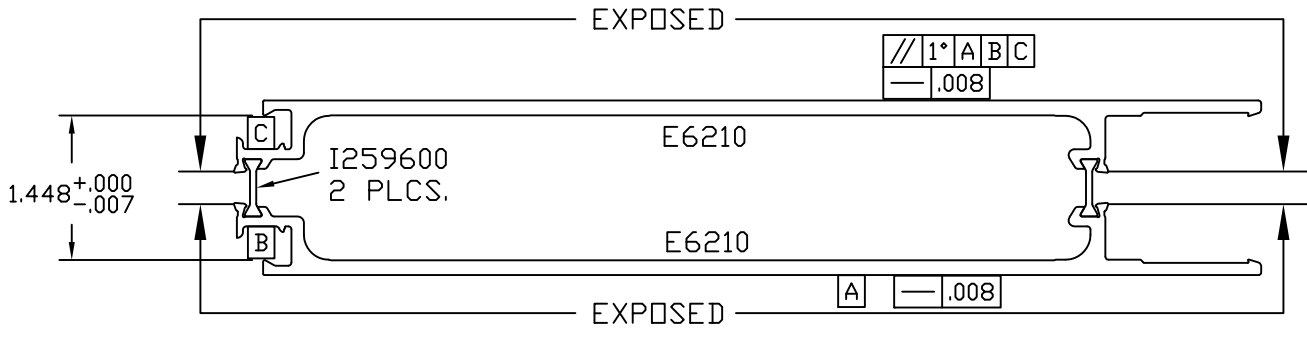


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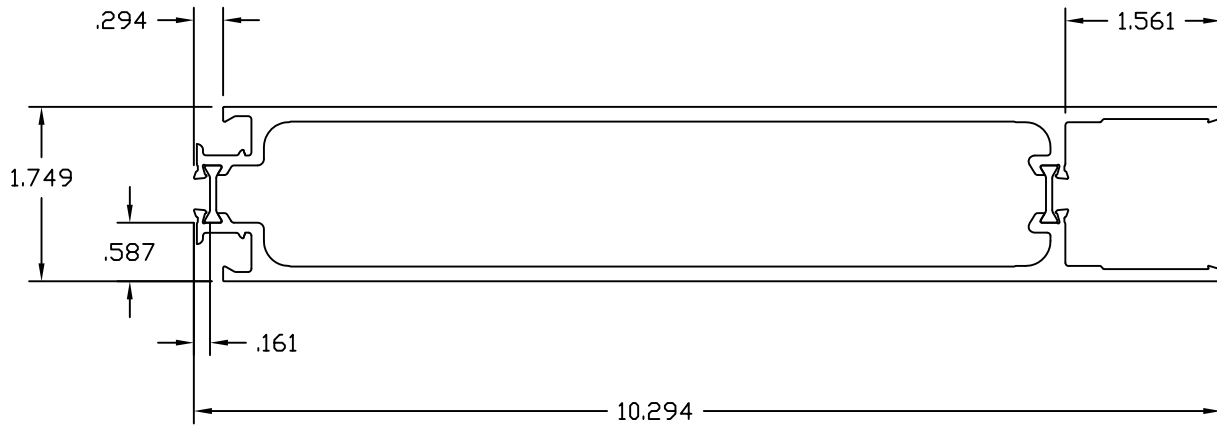
Date: 10/24/13

Architectural Testing Verified by: *Kristen R. Levelsberger*

A621010
X



HALF SCALE



FINISH: PAINTED or ANODIZED ALUMINUM

Use w/ lug P6282

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ALL UNSPECIFIED RADII .015

* INDICATES .031 RADIUS

□ DENOTES CRITICAL DIMENSION

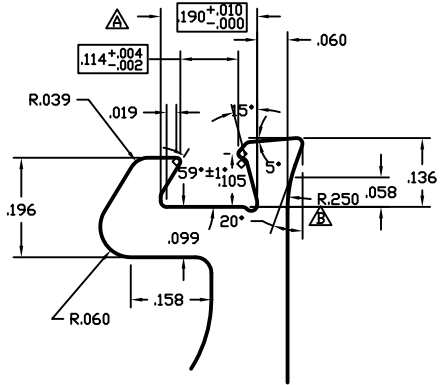
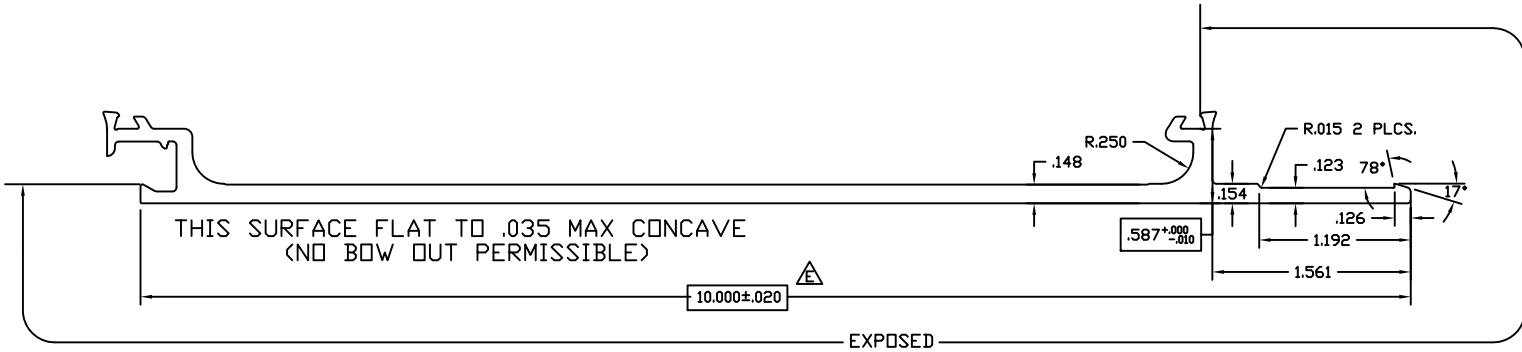
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3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

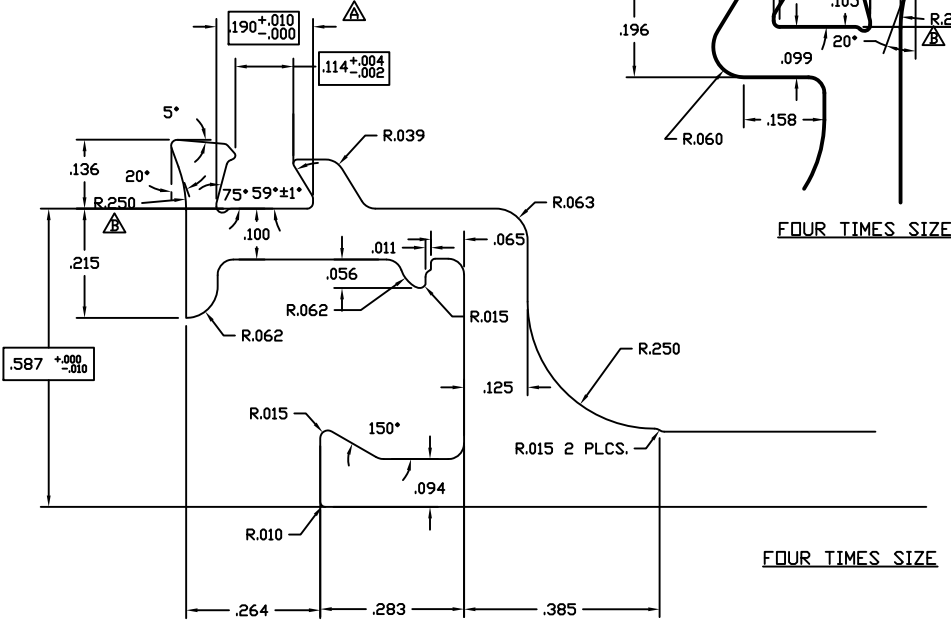
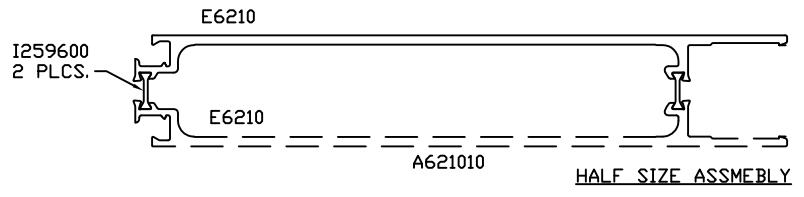
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DRWG SCALE 1:2	PRODUCT CODE 111	A621010	REV X

E6210
E



LONGITUDINAL (length):
 NO TWIST ALLOWED
 Straightness must be
 maintained.



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 WALKER, MICHIGAN 49544

WALL THK	NOTED	SECTION CLASS	MAT'L	6063-T5	RATIO	33	
PERIMETER (BUT TOTAL)	24.626	AREA	1.717	WGT/FT	2.020		
FACTOR	50	CIRCLE SIZE	12	INFILL VOLUME	N/A		
RXX	.153	SXX	.068	IXX	.040	CXX	.592
RYY	3.090	SYY	3.134	IYY	16.396	CYY	5.232

10 INCH BOTTOM RAIL
 THERMAL DOOR

DRAWN BY	NJK	DRWG DATE	6/15/07	APP'D BY		DATE APP'D	
DWG SCALE	FULL	PRODUCT CODE	111	E6210	REV	E	

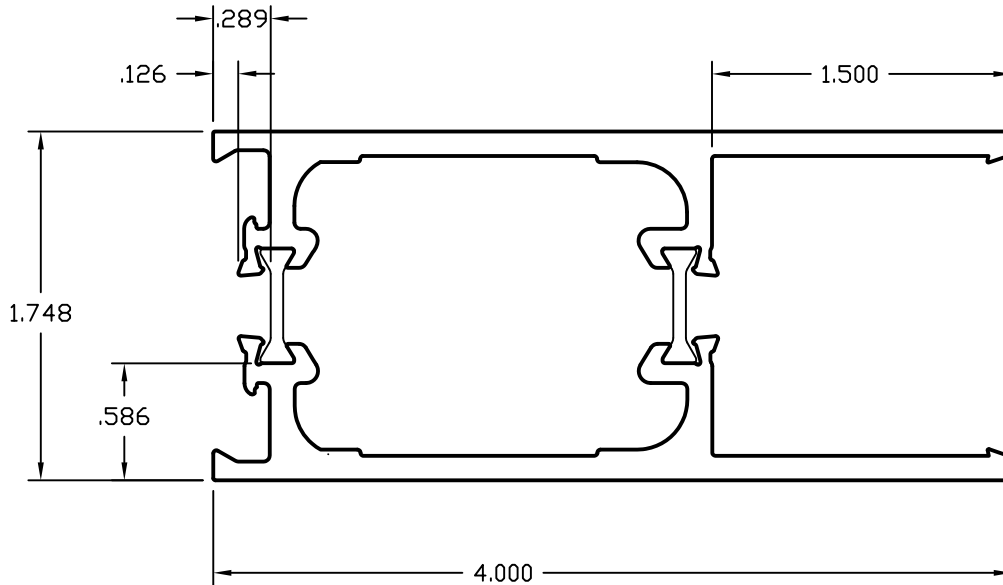
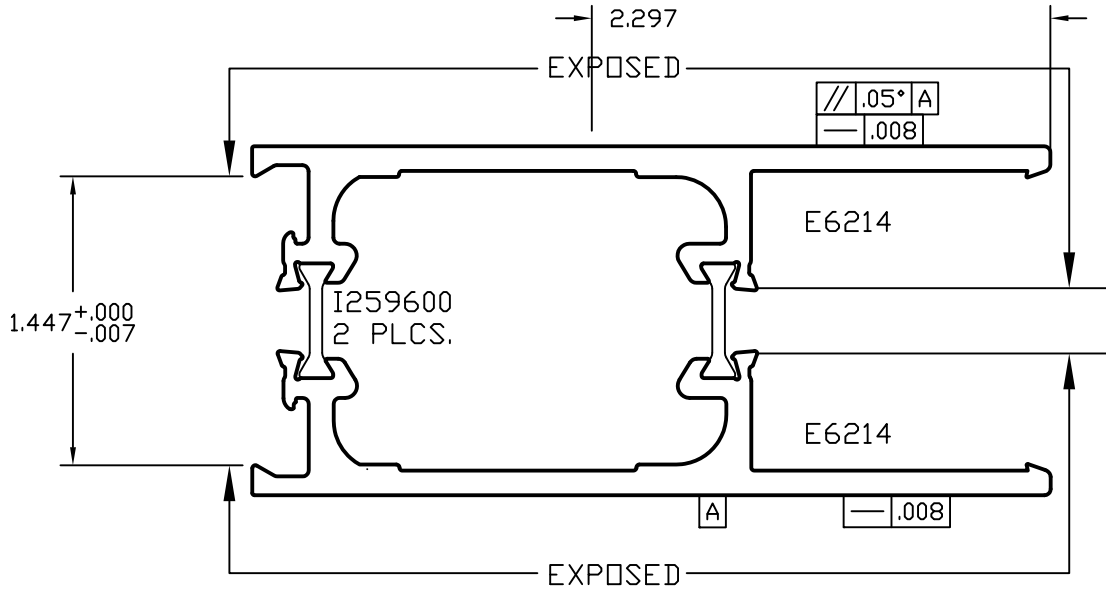
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Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen R. Lindenberg*

A621414

B



FINISH: PAINTED or ANODIZED ALUMINUM

Use w/ P6280lugs.

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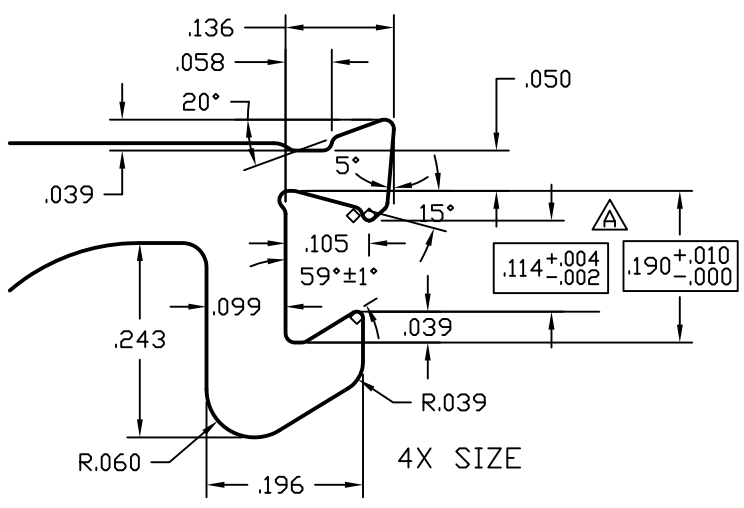
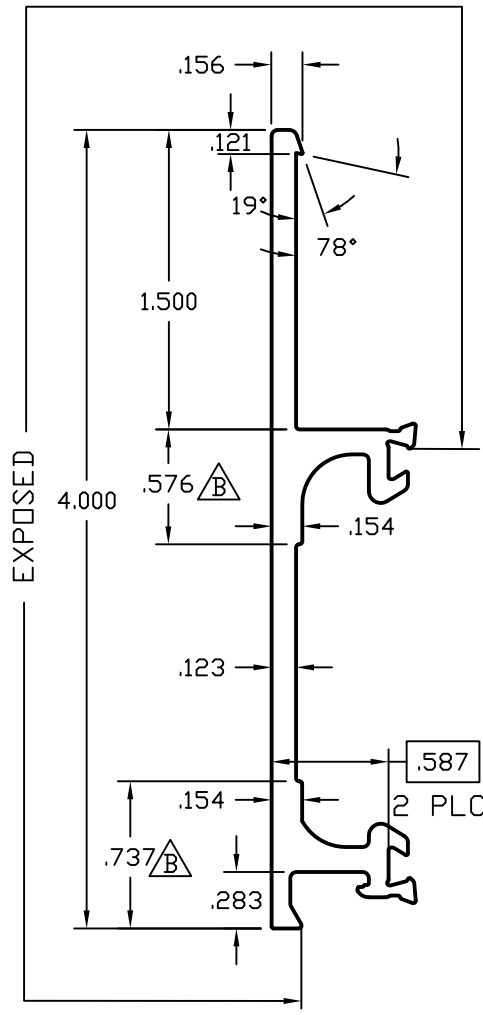
3056 WALKER RIDGE NW, SUITE G
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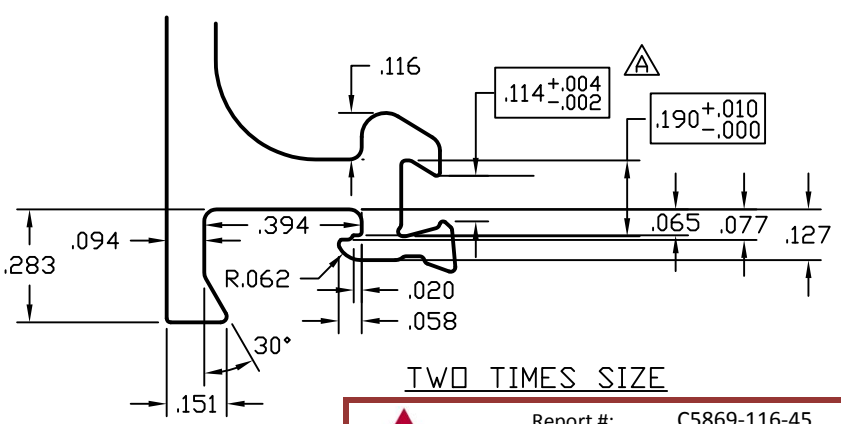
TOP RAIL 4 INCH
 THERMAL DOOR

DRAWN BY NIK	DRWG DATE 10/02/07	APPV'D BY XXXXXX	DATE APPV'D XXXX
DRWG SCALE FULL	PRODUCT CODE 111	A621414	REV B

E6214
D



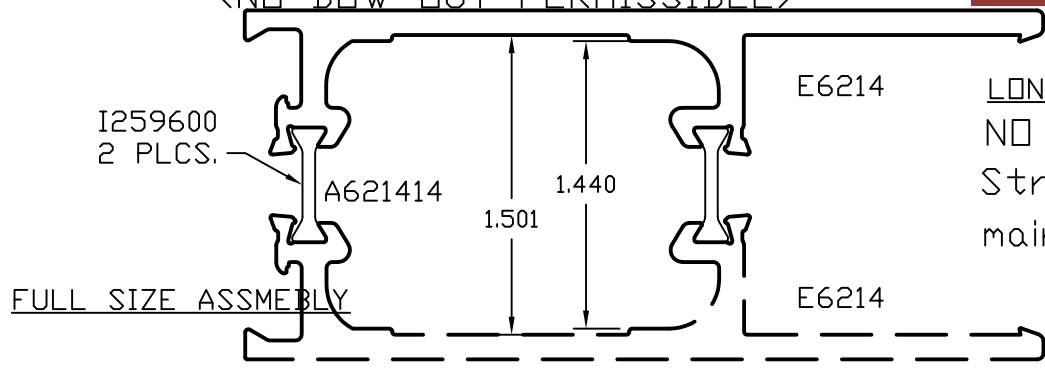
FOUR TIMES SIZE



TWO TIMES SIZE

Report #: C5869-116-45
 Date: 10/24/13
 Architectural Testing Verified by: *Kristen S. Ruedsberger*

THIS SURFACE FLAT TO .015 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



LONGITUDINAL (length):
NO TWIST ALLOWED
Straightness must be maintained.

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WALL THK.	NOTED	SECTION CLASS	S	MAT'L	6063-T5	RATIO	75:1
PERIMETER OUT (TOTAL)	11.952	AREA	.739	WGT/FT	.870		
FACTOR	14	CIRCLE SIZE	4.125	INFILL VOLUME			

RXX	.195	SXX	.052	IXX	.195	CXX	.546
RYY	1.144	SYX	.440	IYY	1.144	CYY	2.198

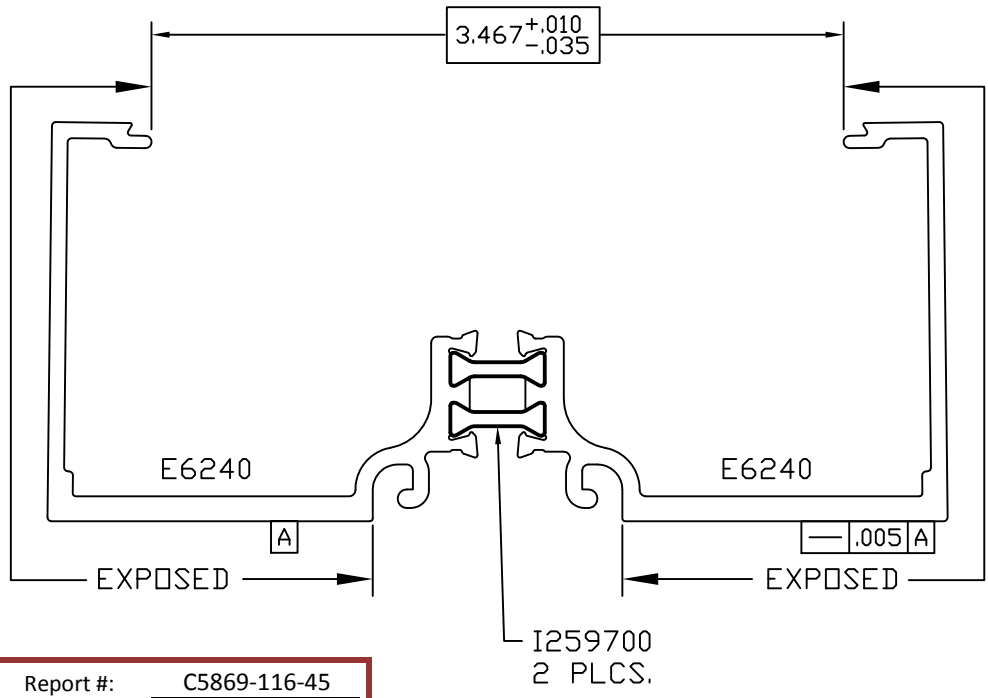
4 INCH TOP RAIL
THERMAL DOOR


DRAWN BY	TT	DRWG DATE	11/19/09	APPV'D BY		DATE APPV'D	
DWG SCALE	NOTED	PRODUCT CODE	111	E6214		REV	D

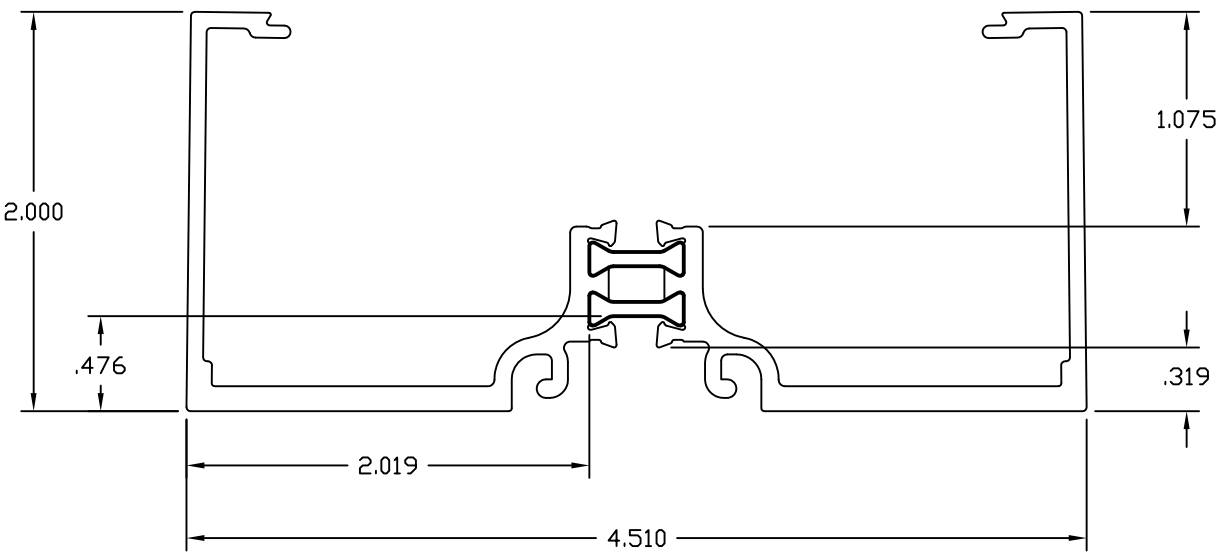
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C	01/13/10	ADDED FLATNESS NOTE	TT
D	02/18/10	ADDED STRAIGHTNESS & TWIST NOTE	TT

FINISH: PAINTED or ANODIZED ALUMINUM

A624040
X




 Report #: C5869-116-45
 Date: 10/24/13
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 □ DENOTES CRITICAL DIMENSION

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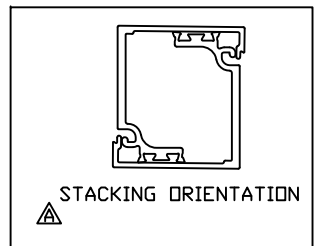
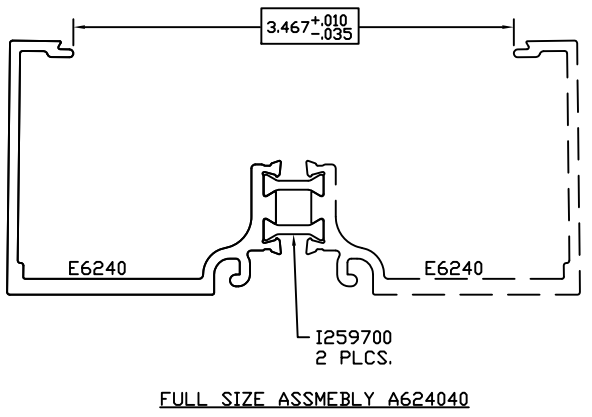
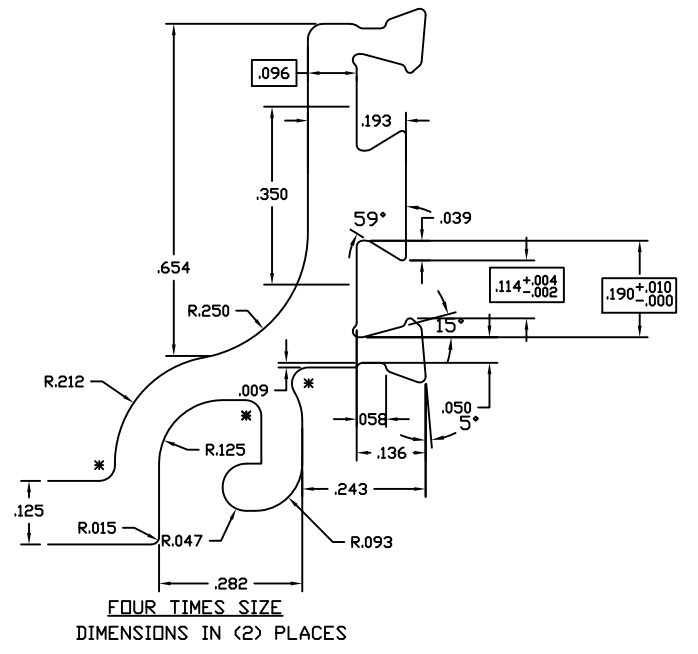
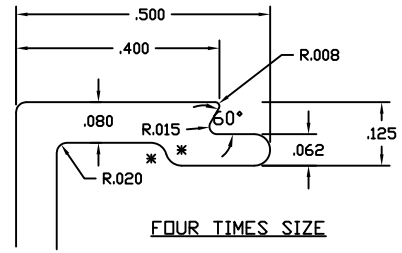
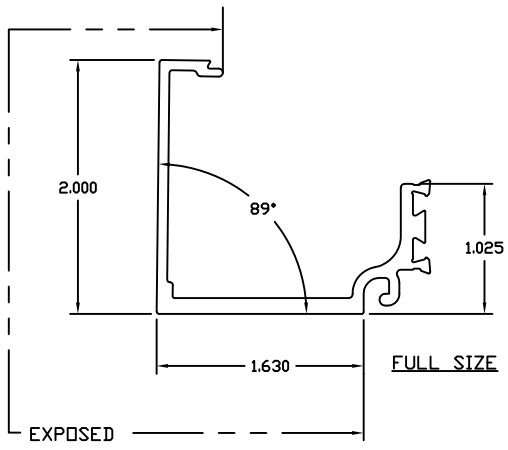
3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
X	XXXXXXXX	XXXXXX	XXX

2" OPEN BACK DOOR JAMB
THERMAL DOOR

DRAWN BY NIK	DRWG DATE 11/02/07	APPV'D BY XXXXXX	DATE APPV'D XXXX
DRWG SCALE FULL	PRODUCT CODE 111	A624040	REV X

E6240
A



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 CURTAINWALL AND ENTRANCE SYSTEMS

3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

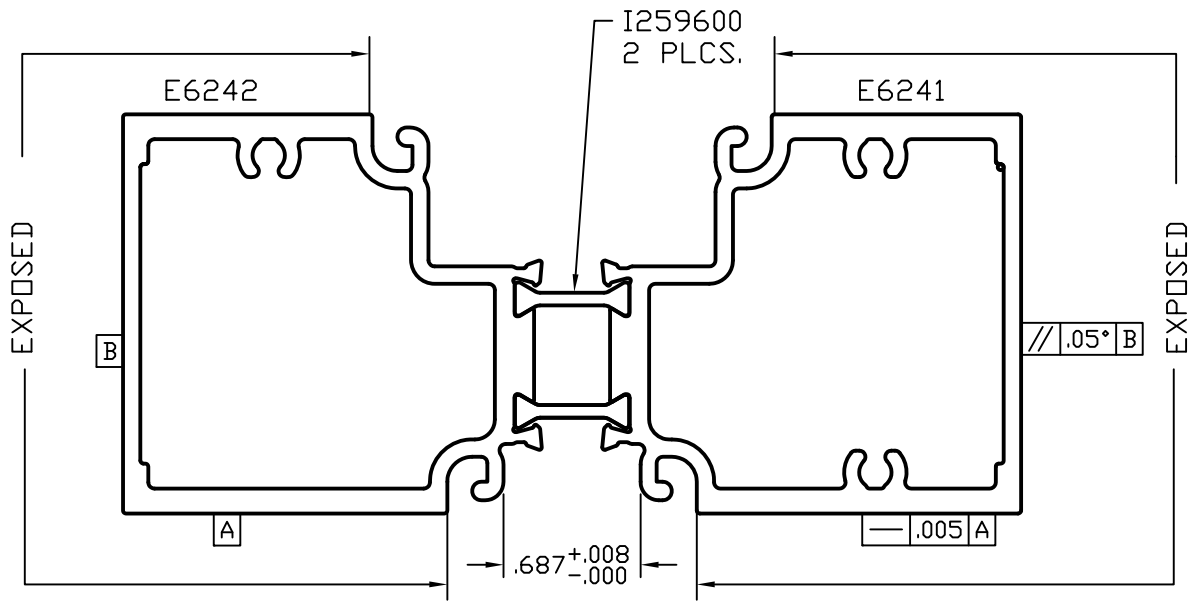
WALL THK	NOTED	SECTION CLASS	MAT'L 6063-T5	RATIO 96			
PERIMETER (NET TOTAL)	11.878	AREA	.575	WGT/FT .676			
FACTOR	18	CIRCLE SIZE	INFILL VOLUME				
RXX	.792	SXX	.293	IXX	.361	CXX	1.232
RYY	.610	SYX	.151	IYY	.214	CYY	1.417

2" OPEN BACK DOOR FRAME
 THERMAL DOOR

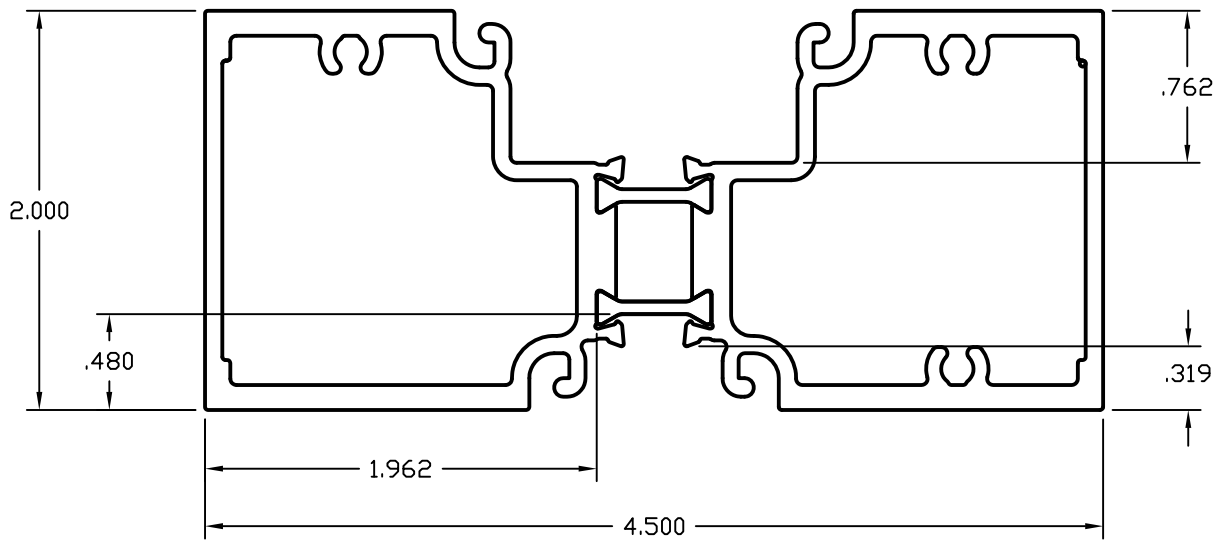
DRWN BY	NIK	DRWG DATE	11/02/07	APPV'D BY	JEM	DATE APPV'D	
DWG SCALE	NOTED	PRODUCT CODE	111	E6240	REV	A	

FINISH: PAINTED or ANODIZED ALUMINUM

A624142




 Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen S. Friedberger*



FINISH: PAINTED or ANODIZED ALUMINUM

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 * INDICATES .031 RADIUS
 □ DENOTES CRITICAL DIMENSION

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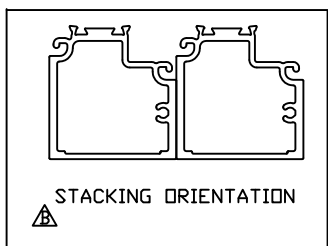
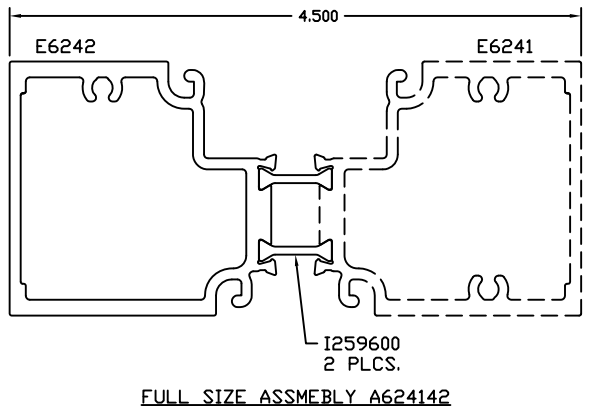
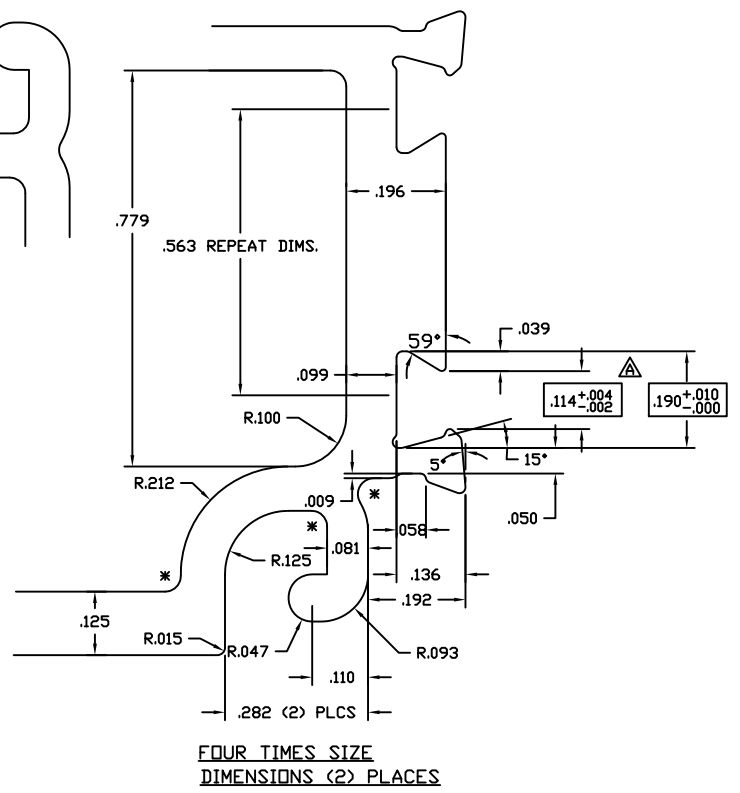
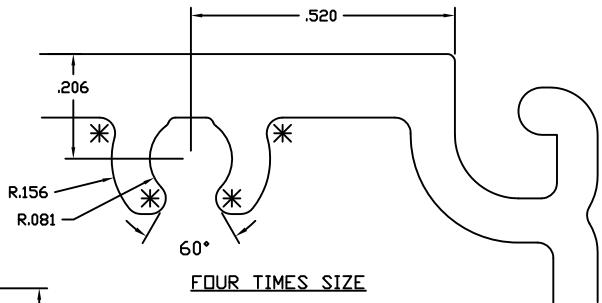
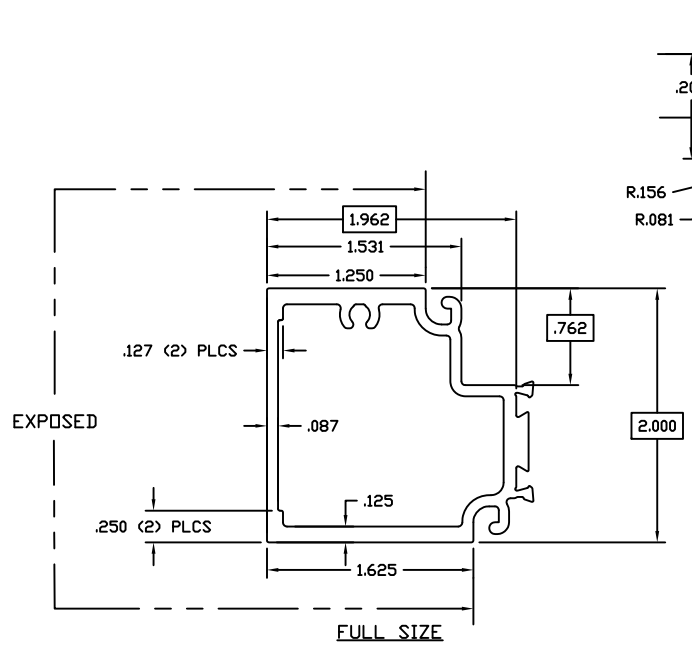
3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL

THERMAL SIDELIGHT/TRANSOM 2"
THERMAL DOOR

DRAWN BY JRJ	DRWG DATE 12/07/07	APPV'D BY	DATE APPV'D	REV
DRWG SCALE FULL	PRODUCT CODE 111	A624142		

E6242
B



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 WALKER, MICHIGAN 49544

WALL THK	NOTED	SECTION H	MAT'L 6063-T5	RATIO 62
PERIMETER OUT (TOTAL)	9.752	(17.0943)	AREA .895	WGT/FT 1.052
FACTOR 17	CIRCLE SIZE	2.699	INFLL VOLUME	

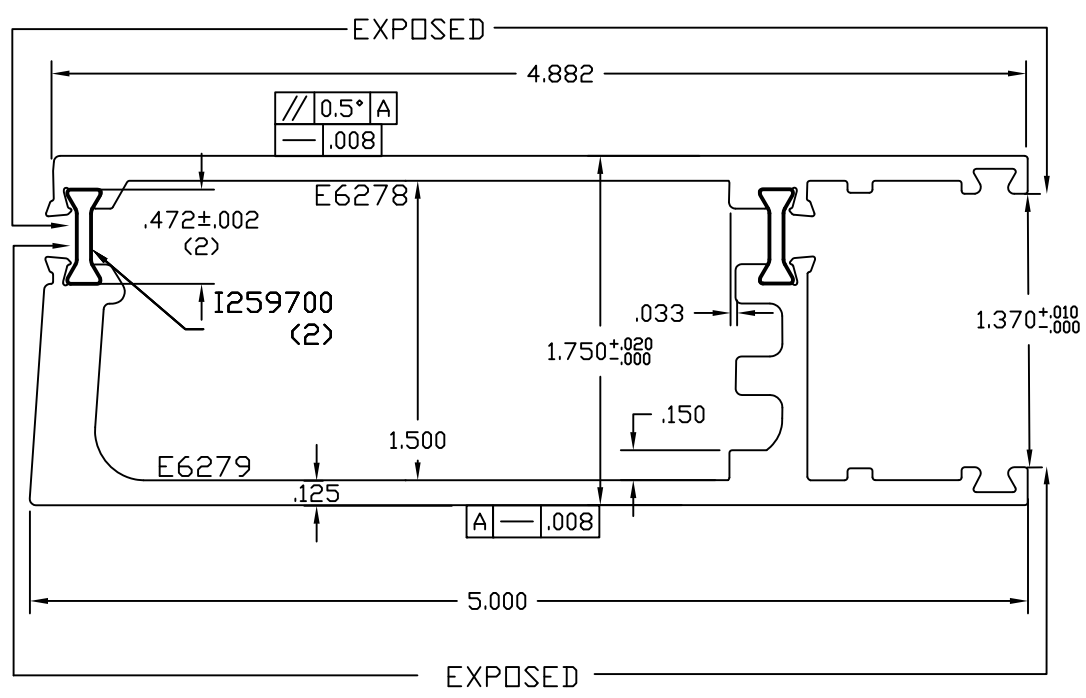
RXX .711	SXX .409	IXX .452	CXX 1.106
RYX .730	SYX .462	IYY .477	CYY 1.033

2" EXTERIOR FRAME SIDELITE/TRANSOM THERMAL DOOR

DRAWN BY	DATE	APPV'D BY	DATE
NIK	11/04/07		

DWG SCALE: NOTED PRODUCT CODE: 111 E6242 REV: B

FINISH: PAINTED or ANODIZED ALUMINUM



LONGITUDINAL (length):
 NO TWIST ALLOWED
 Straightness must be maintained.

FINISH: PAINTED or ANODIZED ALUMINUM

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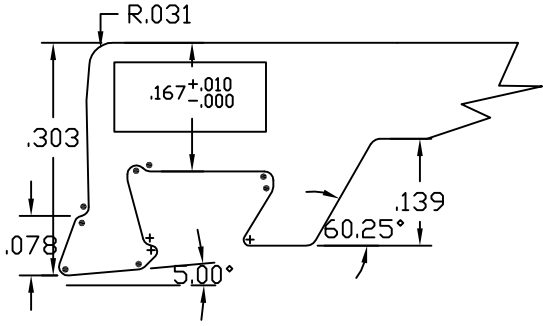
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3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

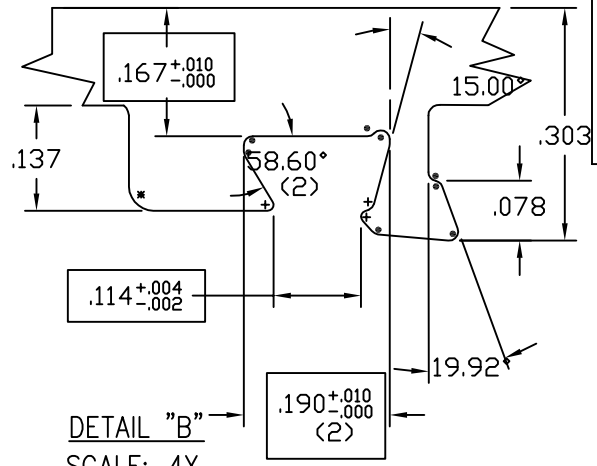
REV	DATE	DESCRIPTION	INTL
A	01/25/10	RELEASE FOR TOOLING	TT
A	08/30/10	RELEASE FOR Production, ER 081007	TT

STANDARD MEDIUM DOOR STILE
 THERMAL DOOR

DRAWN BY TT	DRWG DATE 01/00/10	APPV'D BY	DATE APPV'D
DRWG SCALE FULL	PRODUCT CODE 111	A627879	
			REV A



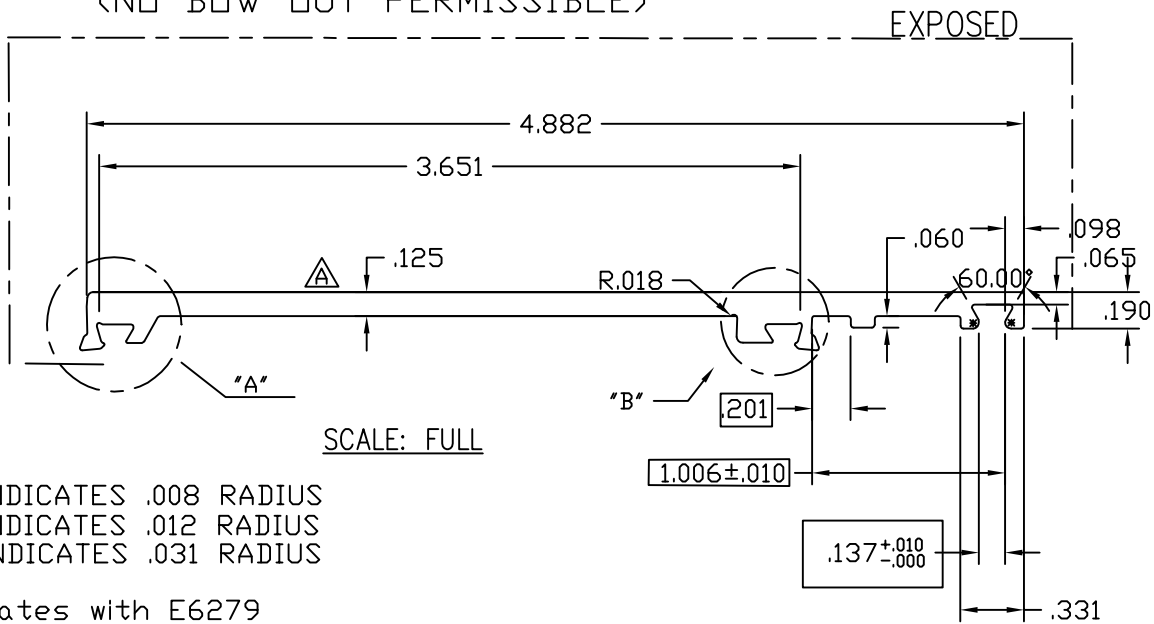
DETAIL "A"
SCALE: 4X



DETAIL "B"
SCALE: 4X


 Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen S. Lindsberger*

THIS SURFACE FLAT TO .018 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



SCALE: FULL

- + INDICATES .008 RADIUS
- INDICATES .012 RADIUS
- * INDICATES .031 RADIUS

Mates with E6279

FINISH: PAINTED or ANODIZED ALUMINUM

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3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	01/20/10	Release for Tooling	TT

WALL THK.	.125	SECTION CLASS	S	MAT'L	6063-T5	RATIO	79
PERIMETER OUT (TOTAL)	18.292	AREA	.696	WGT/FT	.818		
FACTOR	26.28	CIRCLE SIZE	4.919	INFILL VOLUME	N/A		

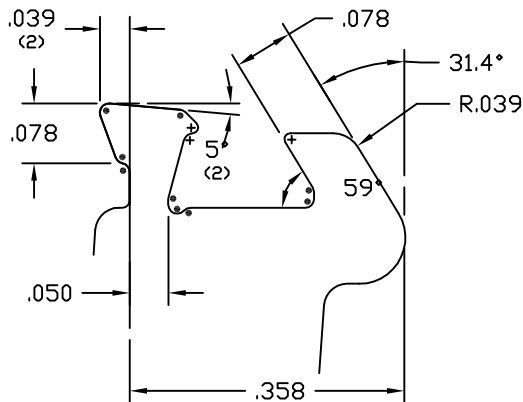
RXX	.058	SXX	.010	IXX	.002	CXX	.080
RYY	1.454	SYY	.596	IYY	1.470	CYY	2.468

STANDARD MEDIUM STILE - INSIDE 4"
THERMAL DOOR

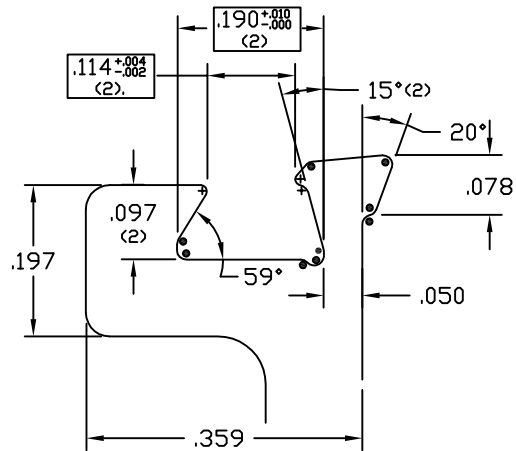
DRAWN BY	TT	DRWG DATE	01/30/10	APPV'D BY	XXX	DATE APPV'D	XX/XX/XX
DWG SCALE	FULL	PRODUCT CODE	111	E6278		REV	A

E6279

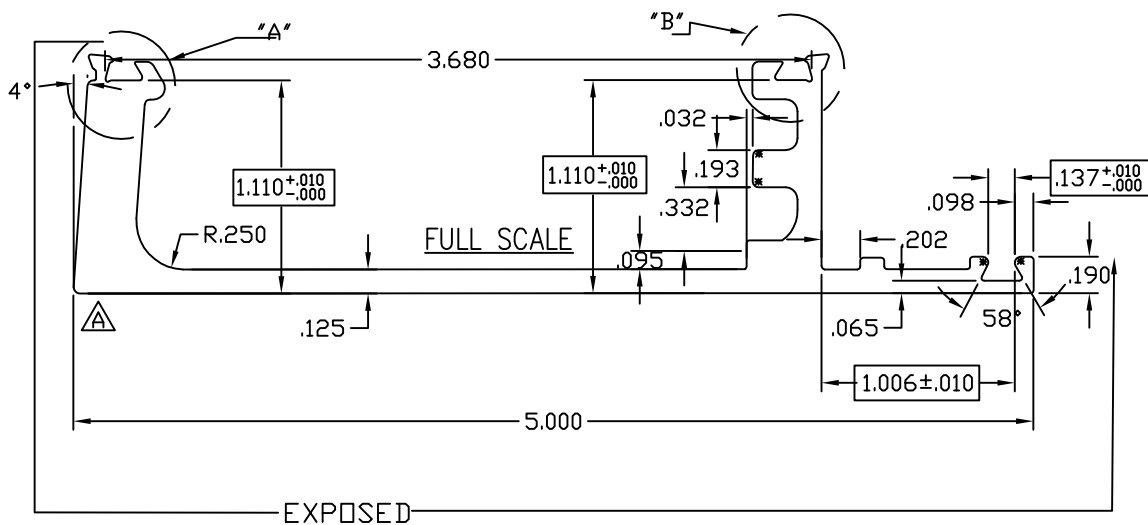
A




DETAIL "A"
SCALE: 4X



DETAIL "B"
SCALE: 4X



THIS SURFACE FLAT TO .018 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)


 Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen A. Bredelberger*

FINISH: PAINTED or ANODIZED ALUMINUM

NOTES:

- + INDICATES .008 RADIUS
- INDICATES .012 RADIUS
- * INDICATES .031 RADIUS

MATES WITH E6276

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03/09/09

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WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	01/25/10	RELEASED FOR TOOLING,	TT

WALL THK.	NOTED	SECTION CLASS	S	MAT'L	6063-T5	RATIO	45
PERIMETER OUT (TOTAL)	16.550	AREA	1.237	WGT/FT	1.454		
FACTOR	12	CIRCLE SIZE	5.097	INFILL VOLUME	N/A		

RXX	.369	SXX	.188	IXX	.169	CXX	.348
RYY	1.651	SYX	1.178	IYY	3.372	CYY	2.862

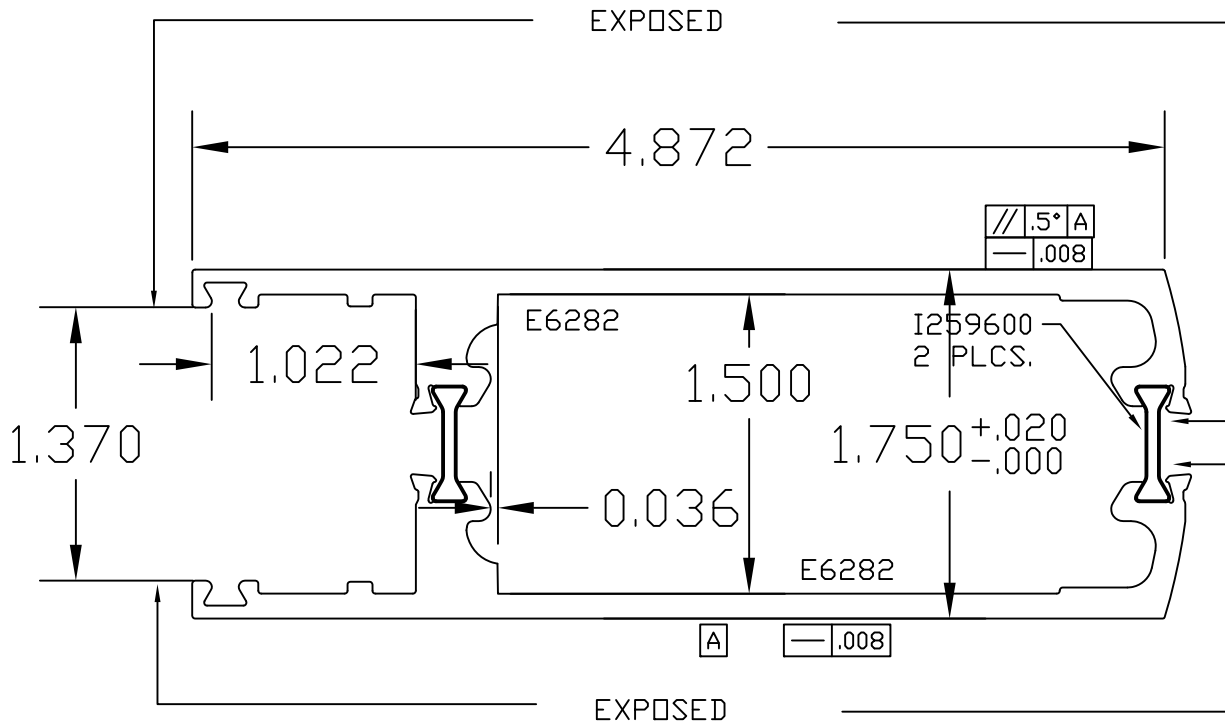
STANDARD MEDIUM STILE - OUTSIDE 4"
THERMAL DOORS

DRAWN BY	TT	DRWG DATE	01/25/10	APPV'D BY		DATE APPV'D	
DWG SCALE	NOTED	PRODUCT CODE	111	E6279		REV	A



Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen S. Luedtke*

A628282
 A



LONGITUDINAL (length):
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 □ DENOTES CRITICAL DIMENSION

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3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

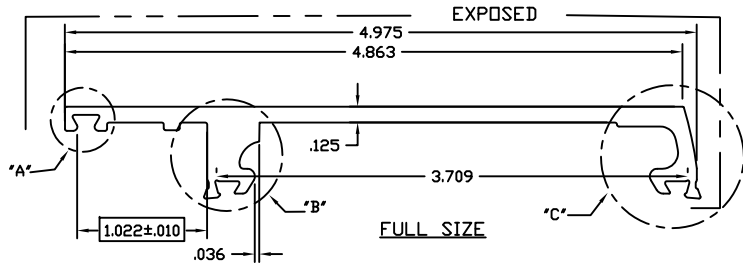
REV	DATE	DESCRIPTION	INTL
A	02/25/11	RELEASE FOR TOOLING	TT

ADJUSTABLE ASTRAGAL MEDIUM LOCK STILE
 INACTIVE LEAF 4" THERMAL DOOR

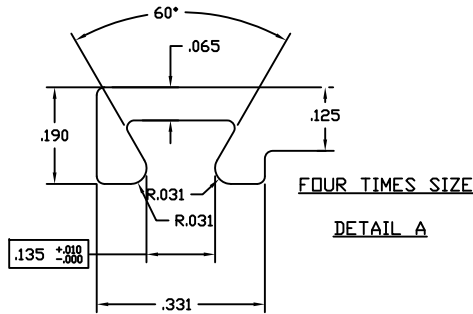
DRAWN BY TT	DRWG DATE 01/25/10	APPV'D BY XXXXXX	DATE APPV'D XXXX
DRWG SCALE FULL	PRODUCT CODE 111	A628282	REV A

E6282
A

THIS SURFACE FLAT TO .017 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



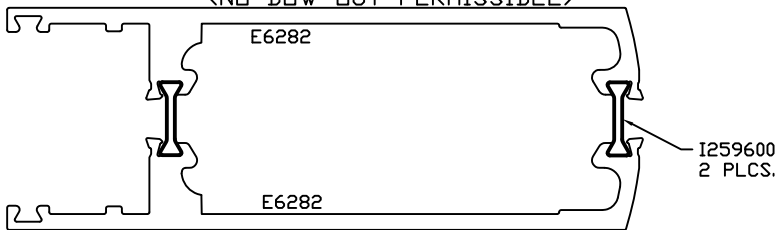
FULL SIZE



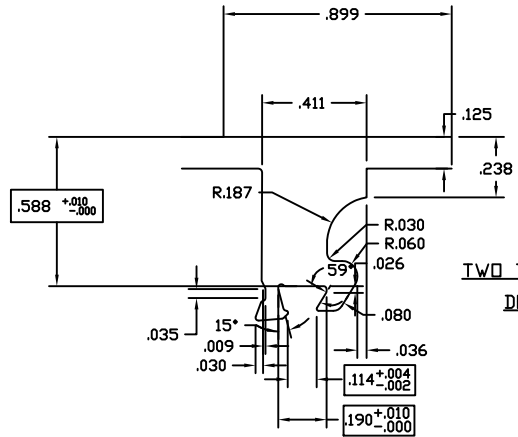
FOUR TIMES SIZE

DETAIL A

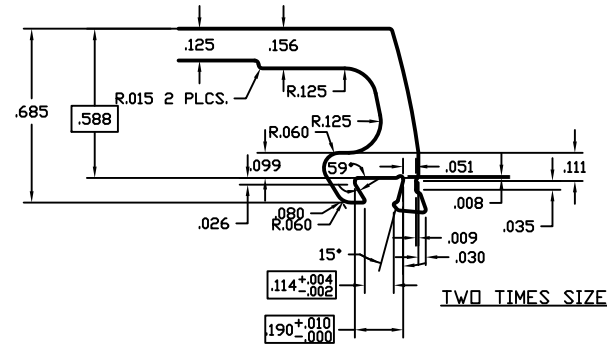
THIS SURFACE FLAT TO .017 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



FULL SIZE ASSMEBLY A68282



TWO TIMES SIZE
DETAIL B



TWO TIMES SIZE

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WALKER, MICHIGAN 49544

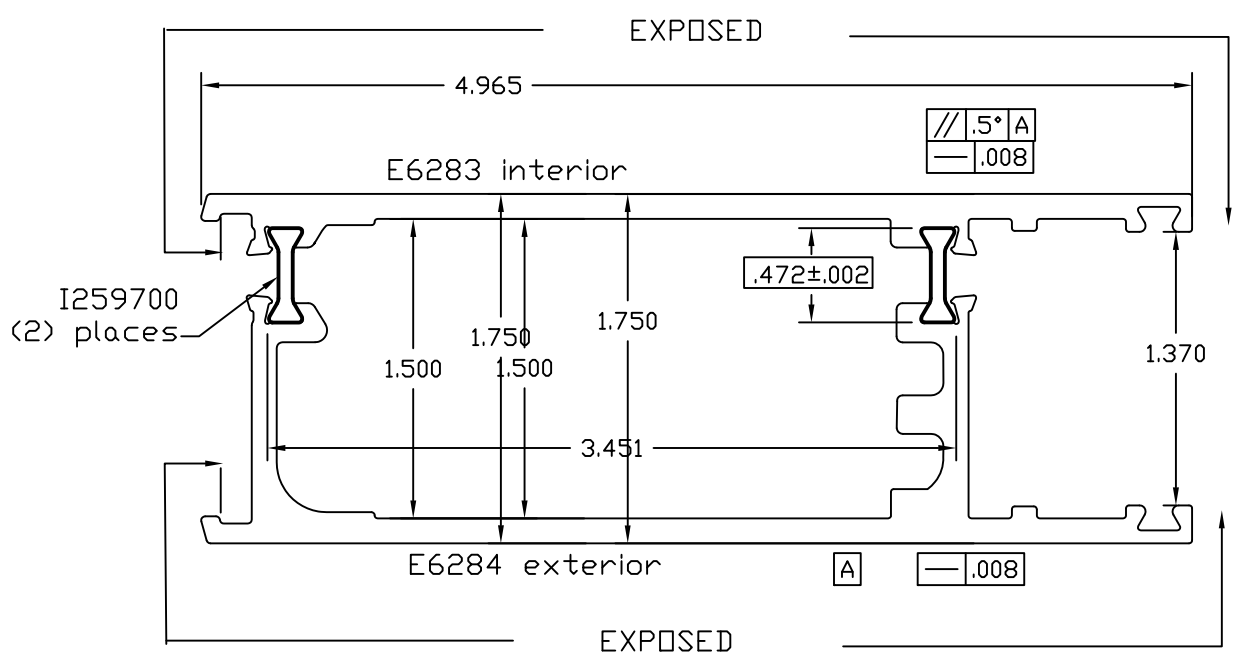
WALL THK	.125	SECTION CLASS	S	MAT'L	6063-T5	RATIO	60
PERIMETER (OUT TOTAL)	13.906	AREA	.919	WGT/FT	1.081		
FACTOR	12.86	CIRCLE SIZE	5.042	INFILL VOLUME	N/A		
RXX	.185	SXX	.057	IXX	.032	CXX	.173
RYY	1.531	SYY	.855	IYY	2.154	CYY	2.484

REV	DATE	DESCRIPTION	INTL
A	02/25/11	RELEASE FOR TOOLING	TT

ADJUSTABLE ASTRAGAL MEDIUM LOCK STILE
INACTIVE LEAF THERMAL DOOR - 4"

DRAWN TT	DRWG DATE	01/25/10	APPV'D BY	DATE APPV'D	REV
DWG SCALE	NOTED	PRODUCT CODE	111	E6282	A

FINISH: PAINTED or ANODIZED ALUMINUM



LONGITUDINAL (length):
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FULL SIZE ASSMEBLY A628384

FINISH: PAINTED or ANODIZED ALUMINUM

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 DENOTES CRITICAL DIMENSION

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WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	02/25/11	RELEASE FOR TOOLING	TT

ADJUSTABLE ASTRAGAL MEDIUM ACTIVE LEAF THERMAL DOOR - LOCK SIDE 4"			
DRAWN BY TT DRWG DATE 10/29/10 DRWG SCALE FULL	APPV.D BY XXXXXX DATE APPV'D XXXX	PRODUCT CODE 111 A628384	REV A



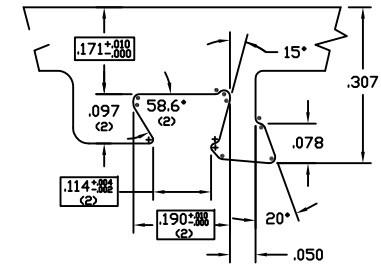
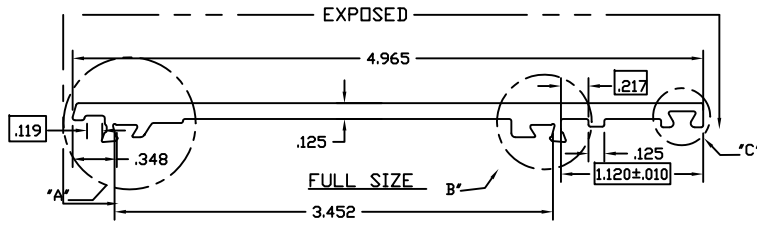
Report #: C5869-116-45

Date: 10/24/13

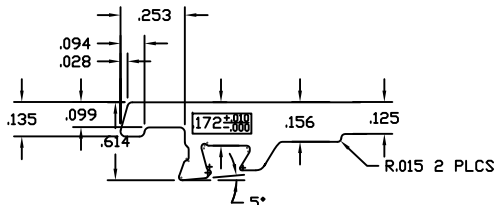
Verified by: *Kristen R. Fordslager*

E6283
A

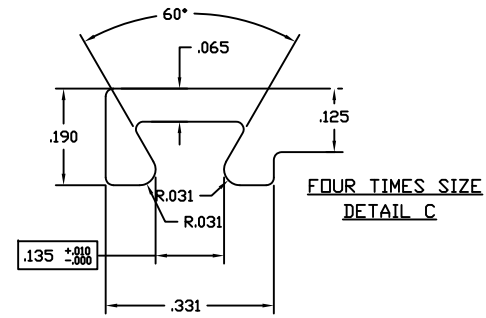
THIS SURFACE FLAT TO .17 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



DETAIL "B"
SCALE: 4X



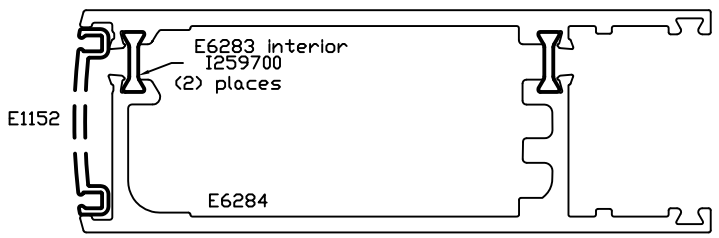
TWO TIMES SIZE
DETAIL A



FOUR TIMES SIZE
DETAIL C

- NOTES:
- + INDICATES .008 RADIUS
 - INDICATES .012 RADIUS
 - * INDICATES .031 RADIUS
 - INDICATES .062 RADIUS
- MATES WITH E6284

THIS SURFACE FLAT TO .017 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



FULL SIZE ASSMBLY A628384

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WALKER, MICHIGAN 49544

WALL THK	1.25	SECTION CLASS	S	MAT'L	6063-T5	RATIO	78
PERIMETER OUT (TOTAL)	11.960	AREA	.712	WGT/FT	.838		
FACTOR	14.27	CIRCLE SIZE	4.964	INFILL VOLUME	N/A		
RXX	.059	SXX	.011	IXX	.002	CXX	.081
RYY	1.456	SYY	.604	IYY	1.510	CYY	2.465

MEDIUM ADJUSTABLE ASTRAGAL
ACTIVE LEAF THERMAL DOOR - 4'

DRWN TT BY	DRWG DATE	10/29/10	APPV'D BY	DATE APPV'D
DRWG SCALE	NOTED	PRODUCT CODE	111	E6283
				REV A

FINISH: PAINTED or ANODIZED ALUMINUM



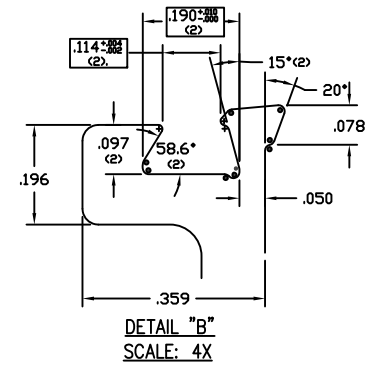
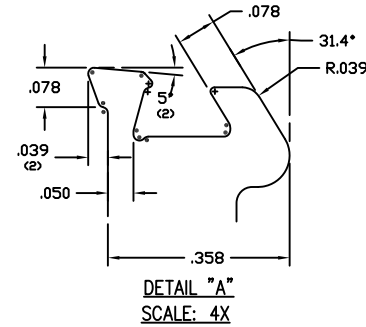
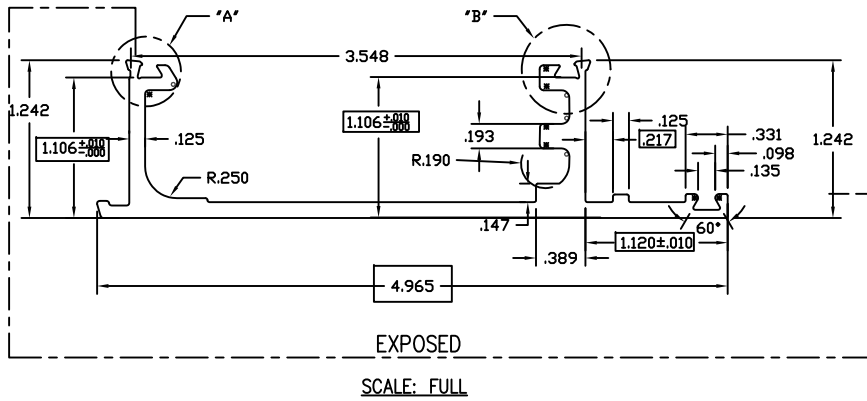
Report #: C5869-116-45

Date: 10/24/13

Verified by: *Kristen S. Herdberger*

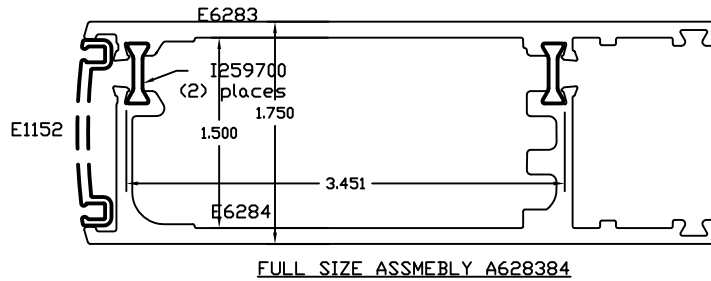
E6284
A

THIS SURFACE FLAT TO .17 MAX CONCAVE
(NO BOW OUT PERMISSIBLE)



- NOTES:
- + INDICATES .008 RADIUS
 - INDICATES .012 RADIUS
 - INDICATES .031 RADIUS
 - INDICATES .062 RADIUS
- MATES WITH E6283

THIS SURFACE FLAT TO .017 MAX CONCAVE
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3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

WALL THK	1.25	SECTION CLASS	S	MAT'L	6063-T5	RATIO	51
PERIMETER OUT (TOTAL)	16.797	AREA	1.079	WGT/FT	1.269		
FACTOR	13.24	CIRCLE SIZE	4.964	INFILL VOLUME	N/A		
RXX	.369	SXX	.158	IXX	.147	CXX	.313
RYY	1.527	SYY	.987	IYY	2.517	CYY	2.416

DENOTES CRITICAL DIMENSION
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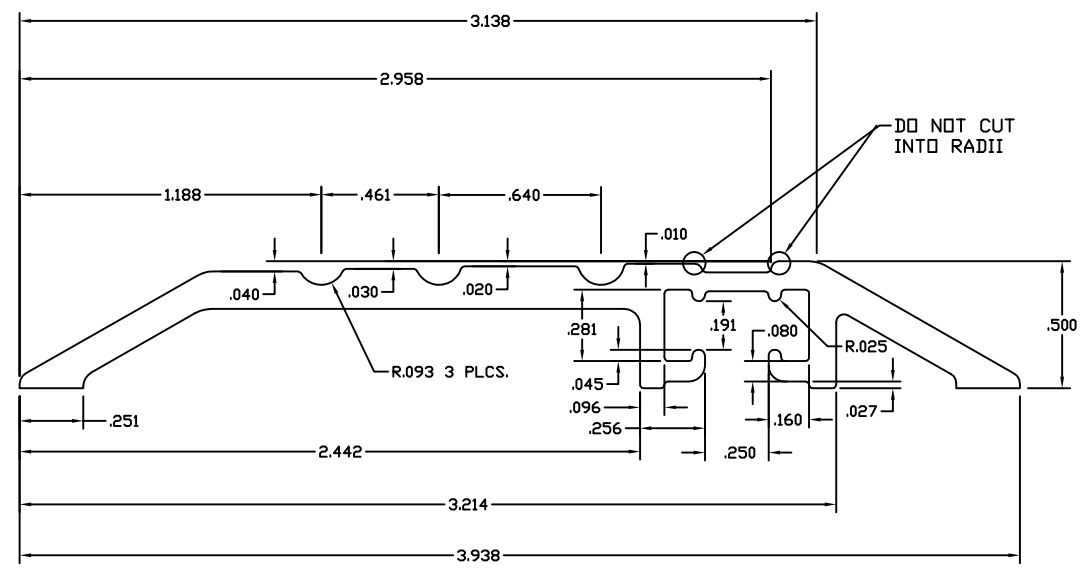
REV	DATE	DESCRIPTION	INTL
A	02/25/11	RELEASE FOR TOOLING	TT

MEDIUM ADJUSTABLE ASTRAGAL
ACTIVE LEAF THERMAL DOOR - 4'

DRAWN TT	DRWG DATE	10/29/10	APP'D BY	DATE APP'D
DRWG SCALE	NOTED	PRODUCT CODE	111	E6284

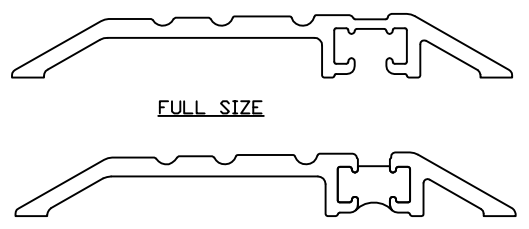
FINISH: PAINTED or ANODIZED ALUMINUM

E6250
C



TWO TIMES SIZE

THIS PART TO BE AZOBRABE BB
 FULL POURED AND DEBRIDGE
 THERE ARE NO EXPOSED SURFACES



This part becomes T6250 after it's poured and debridged.

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3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

WALL THK	NOTED	SECTION CLASS	MAT'L	6063-T5	RATIO	89	
PERIMETER (OUT TOTAL)	10.693	AREA	.627	WGT/FT	.737		
FACTOR	15	CIRCLE SIZE	4.5	INFILL VOLUME	.157		
RXX	.137	SXX	.040	IXX	.012	CXX	.295
RYX	1.087	SYX	.355	IYX	.737	CYX	2.074

THERMALLY BROKEN THRESHOLD
 THERMAL DOOR

DRAWN BY	NIK	DRWG DATE	06/18/07	APPV'D BY		DATE APPV'D	
INWG SCALE	NOTED	PRODUCT CODE	111	E6250		REV	C

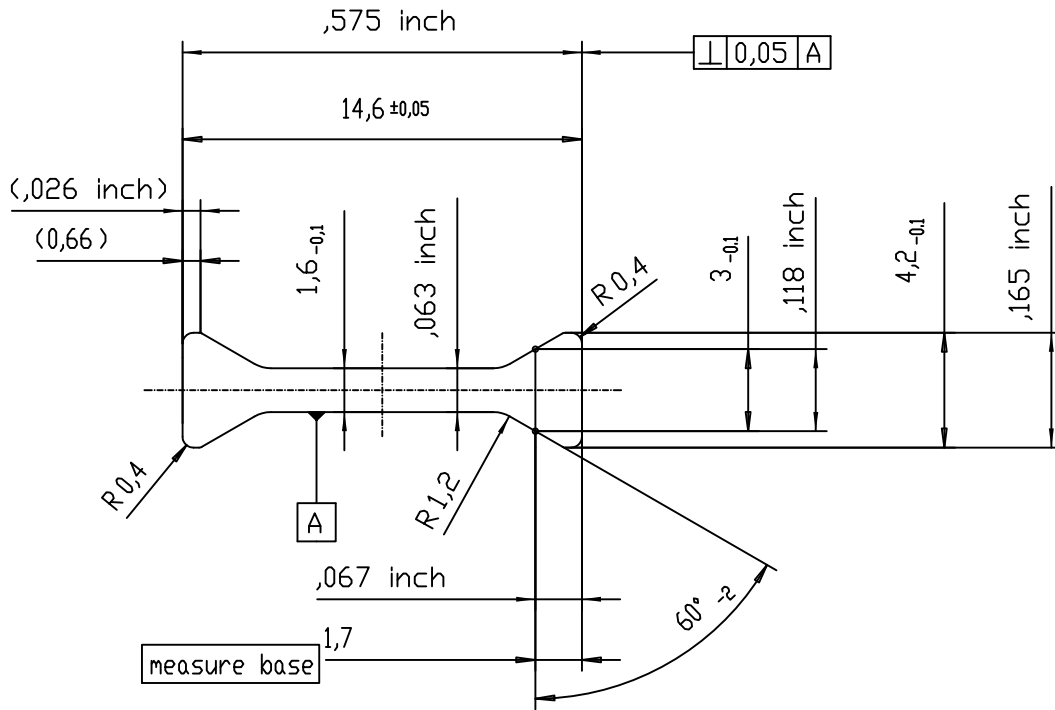
FINISH: MILL FINISH ALUMINUM



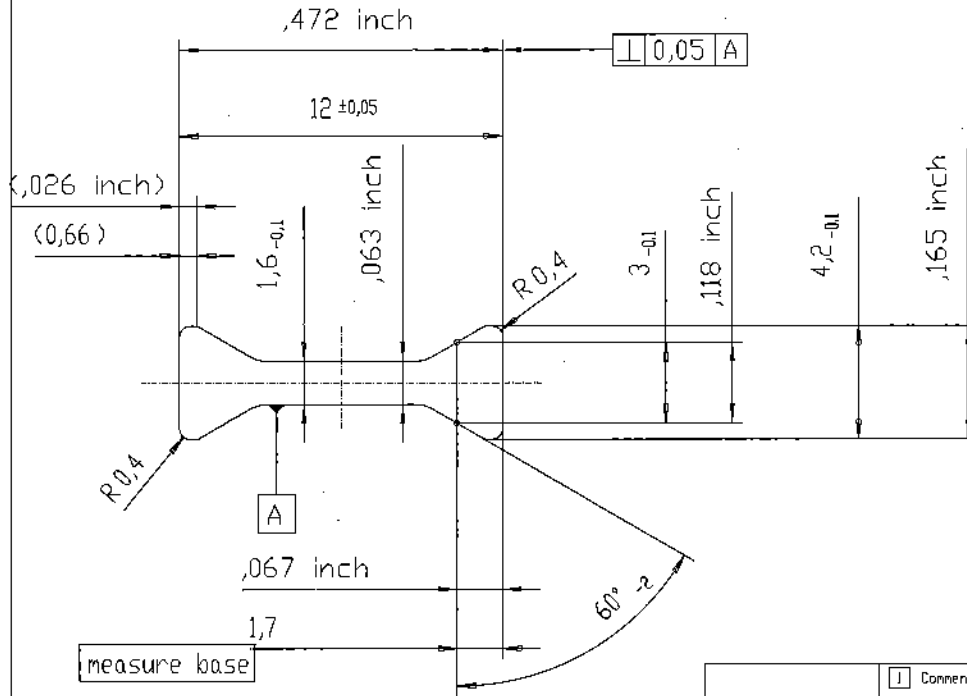
Report #: C5869-116-45

Date: 10/24/13

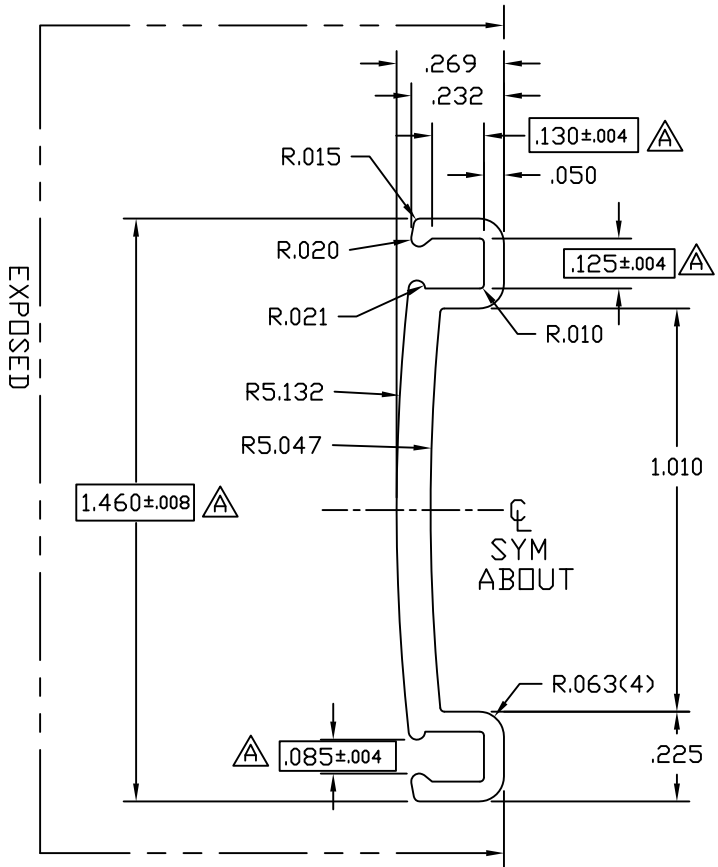
Verified by: *Kristen R. Siedsberger*



1 Comments				2 scale 1:1	
3		4 Not specified dimensions	5 (construction dimension)		
6 customer		7 customer reference		8 Not specified tolerances DIN 16941 class 2	
9 = 1,508 inch (38,3 mm) = 1,28 inch sq (32,5 mm)		10 Status		11 scale M 5:1 (1:1)	
		ST Date Resp. Check		12 material PA 66 GF 25, dry impact	
		1 20.07. HSch		13	
		2		Insulating Strip	
		3			
		Technoform BAUTEC Kunststoffprodukte GmbH 34277 Fuldaabrück		14 259600 page	
No: Modification		Date Name		This Drawing is issued subject to the condition that it shall not be reproduced. Communicated to third parties or copied either totally or partially without written permission of Technoform Bautec GmbH	



1 Comments				2 scale H	
3 Bending: X = +/- 15 mm/m Y = +/- 50 mm/m Distorsion: +/- 15%/m		4 Not specified dimensions		5 (construction dimension)	
6 customer		7 customer reference		8 Not specified tolerances DIN 16941 class 2	
9 = 1,303 inch (33,1mm) = 1,12 inch sq (28,35mm)		10 Status		11 scale M 5:1 (1:1)	
		12 material PA 66 GF 25, dry impact		13	
		14 Technoform BAUTEC Kunststoffprodukte GmbH 34277 Fuldabruck		259700	
15 This drawing is issued subject to the condition that it shall not be reproduced, communicated to third parties or copied either totally or partially without written permission of Technoform Bautec GmbH		16		page	
No.	Modification	Date	Name		



FULL SIZE

Report #: C5869-116-45
 Date: 10/24/13
 Architectural Testing Verified by: *Quinton K. Fiedelberger*

FINISH: PAINTED or ANODIZED ALUMINUM

DENOTES CRITICAL DIMENSION

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3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

WALL THK.	NOTED	SECTION CLASS	S	MAT'L	6063-T5	RATIO	380:1
PERIMETER OUT (TOTAL)	4.371	AREA	.145	WGT/FT	.170		
FACTOR	26	CIRCLE SIZE	1.468	INFILL VOLUME	N/A		

RXX	.455	SXX	.041	IXX	.030	CXX	.730
RYY	.074	SYY	.008	IYY	.001	CYY	.173

ADJUSTABLE ASTRAGAL FOR DOOR PAIRS
 STOCK DOORS

DENOTES CRITICAL DIMENSION
 ALL DIES PROPERTY OF TUBELITE

REV	DATE	DESCRIPTION	INTL
		RELEASED FOR PRODUCTION - WAS E902H06 - ER-080702	LDD
A	01/31/12	ADDED TOLERANCES	CRH

DRAWN BY	LDD	DRWG DATE	02/08/07	APPV'D BY		DATE APPV'D	
DWG SCALE	NOTED	PRODUCT CODE	100	E1152		REV	A

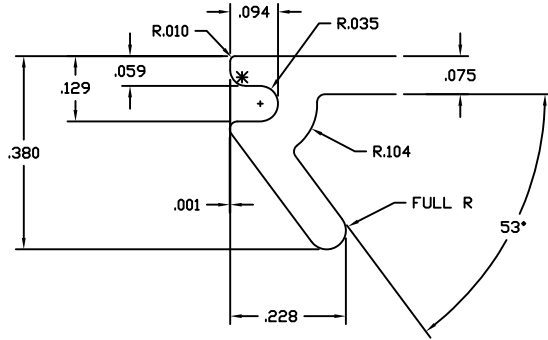


Report #: C5869-116-45

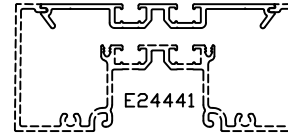
Date: 10/24/13

Verified by: *Kristen R. Fordslager*

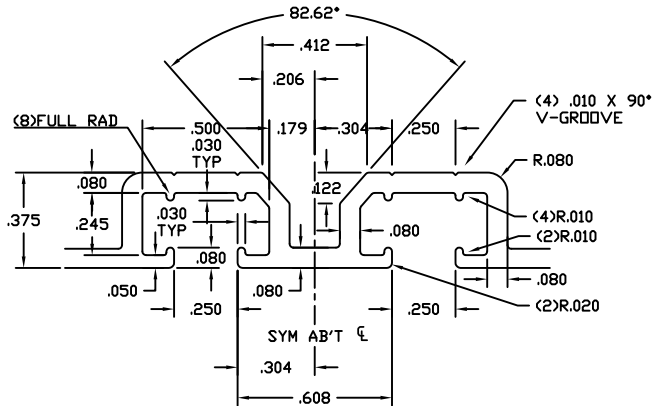
E24442



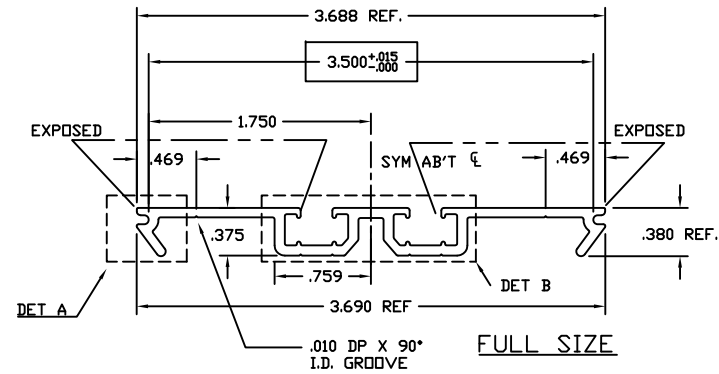
DETAIL "A"
FOUR TIMES SIZE



HALF SIZE ASSEMBLY



DETAIL "B"
TWO TIMES SIZE



FULL SIZE

NOTES:
MATES WITH E24441, E24243
FULLY DEBRIDGE
P & D THERMAL BREAK

LANCED AND FULLY DEBRIDGE

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3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

WALL THK	.075	SECTION CLASS	S	MAT'L	6063-T5	RATIO	122:1
PERIMETER OUT (TOTAL)	12.323	AREA	.453	WGT/FT	.532		
FACTOR	23	CIRCLE SIZE	3.696	INFILL VOL/INE	.261		

RXX	1.060	SXX	.276	IXX	.509	CXX	1.845
RYY	.127	SYX	.031	IYY	.007	CYY	.235

REV	DATE	DESCRIPTION	INTL
	12/07/2012	RELEASED FOR TOOLING, ACCT#4827300000.7020.770	CRH

SNAP IN FILLER
T24000 THERMAL STOREFRONT

DRAWN BY	HLP	DRWG DATE	12-04-12	APPV'D BY		DATE APPV'D	
DWG SCALE	NOTED	PRODUCT CODE	180	E24442		REV	

FINISH: PAINTED or ANODIZED ALUMINUM



Report #: C5869-116-45

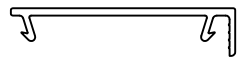
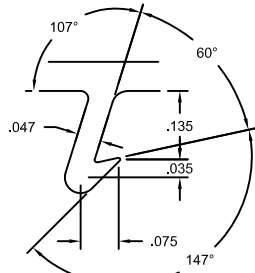
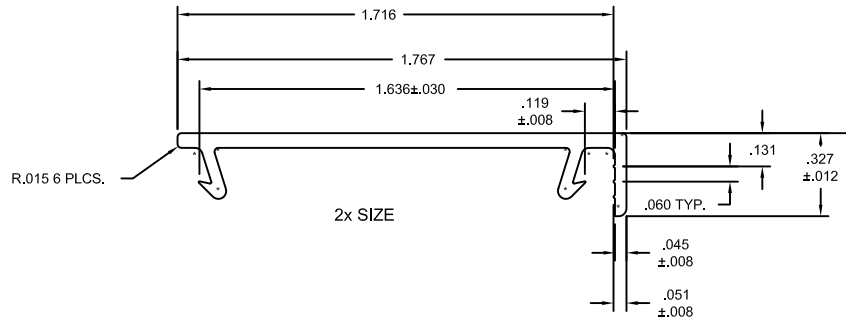
Date: 10/24/13

Verified by: *Kristen R. Berendsen*

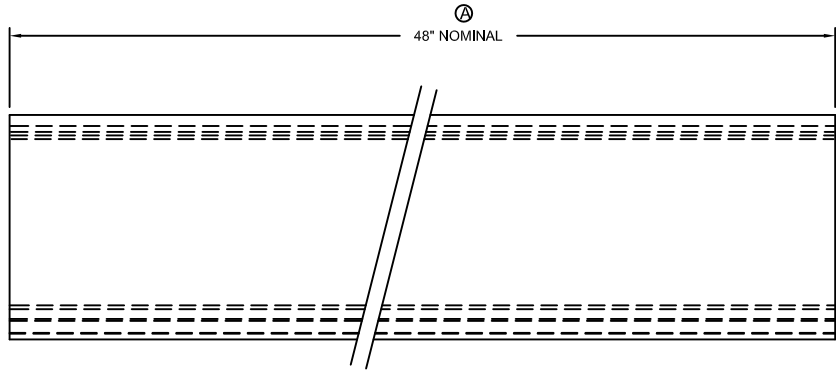
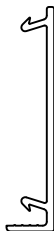
Architectural Testing

P6240

A



4x SIZE 2 PLCS.
(ONE MIRRORED)



EPG 80D RIGID PVC.

EPG PART NUMBER: 7358-01-02

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3056 WALKER RIDGE NW, SUITE G
WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	08/14/09	REVISED STANDARD PART LENGTH TO 48"	DWS

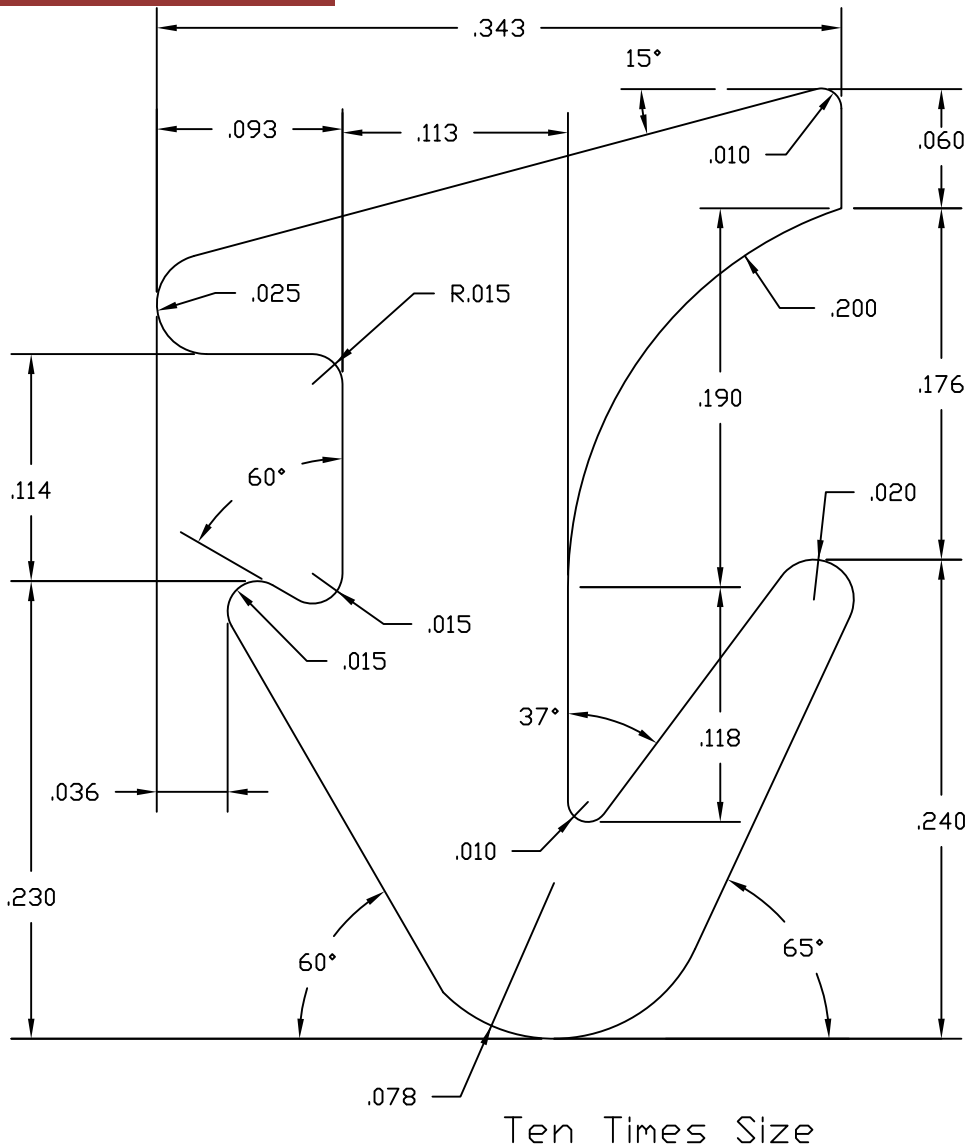
**ELEMENT INHIBITOR
THERMAL DOOR**

DRAWN BY: NIK	DRWG DATE: 10-08-07	APPV'D BY:	DATE APPVD:
DRWG SCALE: NOTED	PRODUCT CODE: 111	P6240	REV: A



Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen L. Swedberg*

P1112
 B



Actual Size

Notes

- (A) 5 to 1 Silicone Bath
 Purchased Part
 Material: EPDM Rubber, 70 Durometer with silicone
 Replaces P854

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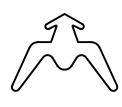
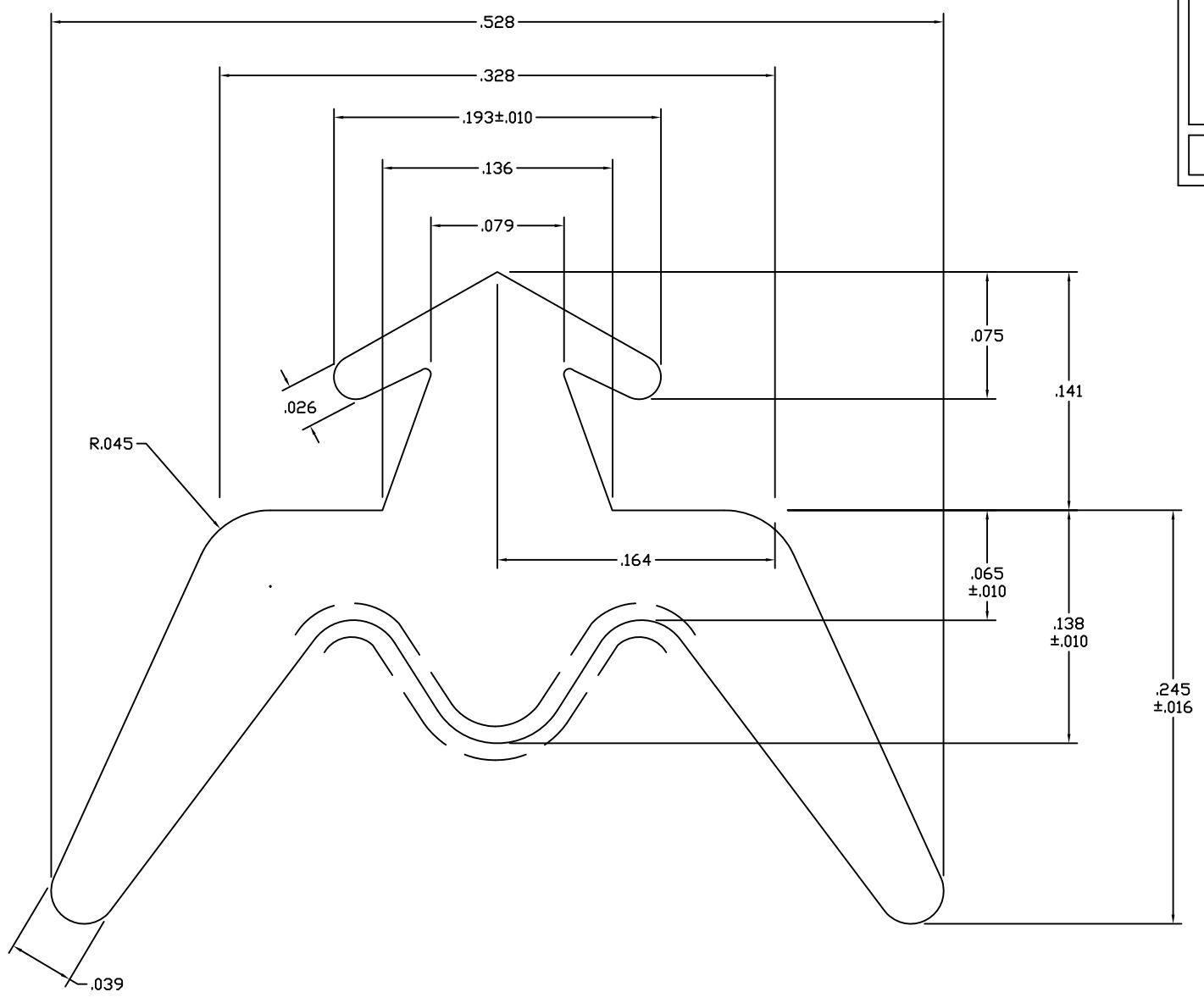


3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	06/22/87	Added Silicone Bath per ED 761	CB
B	05/29/02	Redrawn for CAD	DMT
C	01/11/10	RMV reference to E1479	TT


Roll in Glazing Bead to use
 with E0987

DRAWN BY PJ	DATE 06/02/78	APPV'D BY	DATE APPV'D	REV
DRWG SCALE Noted	PRODUCT CODE 380	P1112		B



ACTUAL SIZE

SUPPLIER - TRELLEBORG
 PART# - 8093-04-00

 Architectural Testing	Report #:	C5869-116-45
	Date:	10/24/13
	Verified by:	<i>Kristen S. Friedberger</i>

MATERIAL: EPDM 50 DUROMETER W/ SILICONE BATH
 250' PER ROLL - 500' PER BOX

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3056 WALKER RIDGE NW, SUITE G
 WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A1	03/18/09	Release for Tooling to EPG / Trelleborg	DWS
A2	07/28/09	Release for Production ER-	DWS

3/16" GASKET
 VERSA-THERM

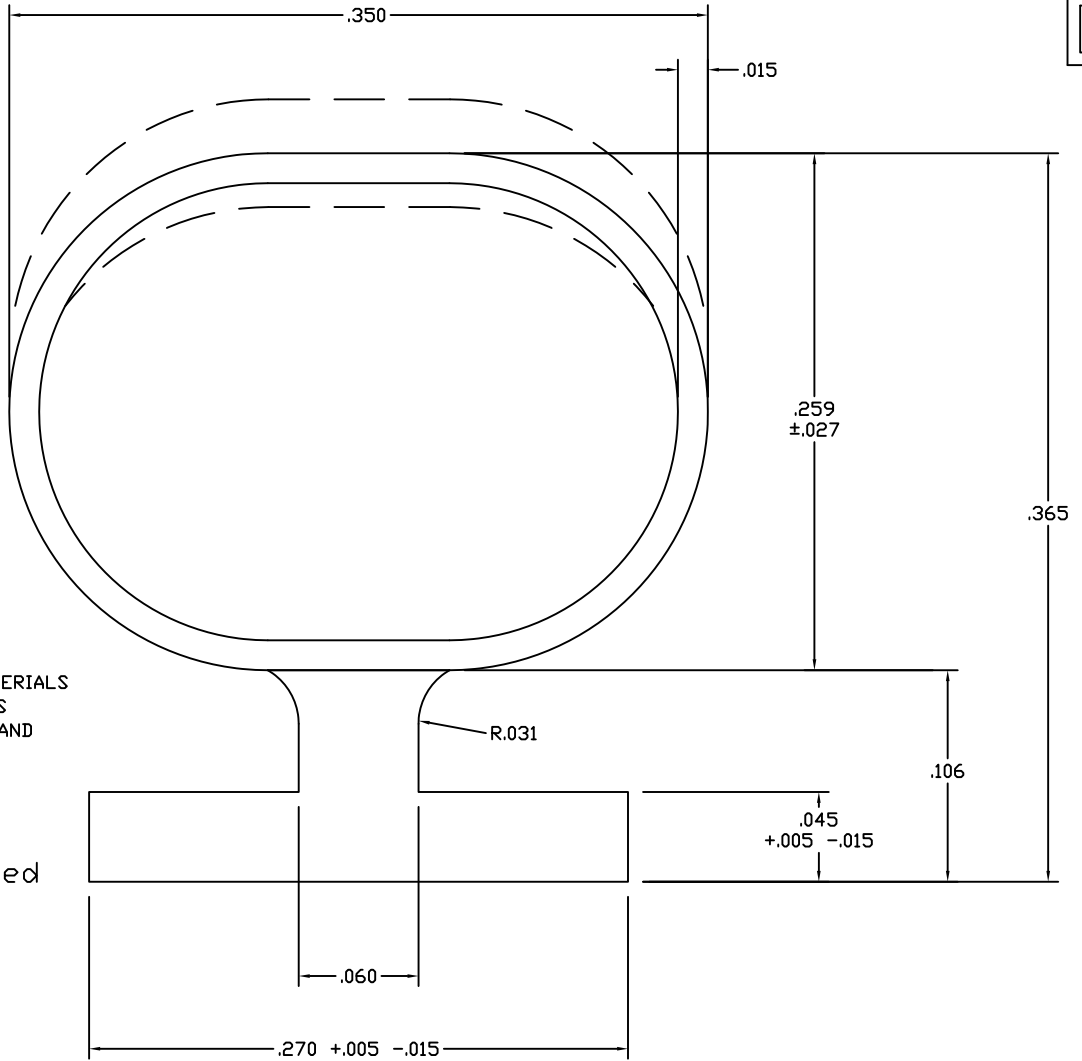
DRAWN BY	DWS	DRWG DATE	03/23/09	APPV'D BY	DATE APPV'D	REV
DRWG SCALE	NOTED	PRODUCT CODE	390	P2183		



Report #: C5869-116-45
 Date: 10/24/13
 Verified by: *Kristen R. Luedersberger*

P6296

A



BOND MUST BE TIGHT. THE 2 MATERIALS MUST NOT EASILY SEPARATE, IT IS PREFERABLE IF THE FLEX TEARS AND NOT THE BOND. VERY IMPORTANT!

Tolerances are RMA class II unless noted otherwise.



ACTUAL SIZE

MATERIAL: SANTOPRENE (EPDM)

can be used on door stop E4531

EPG 5319 SANTOPRENE CO-EXTRUSION
 0.259HTX0.015W □ T.270 CO-EX SANTO

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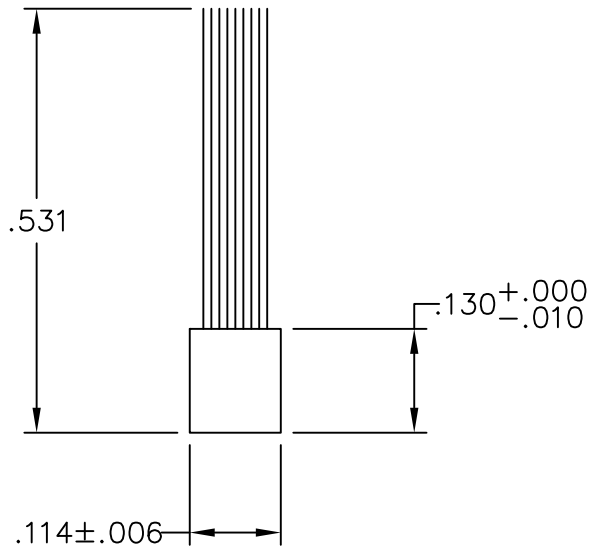
REV	DATE	DESCRIPTION	INTL
	03/13/08	Released for Production	NIK
A	01/26/10	added note for use on E4531	TT
B	11/04/10	Release for production	TT

Door Stop Bulb Gasket
 Thermal Door

DRAWN BY: NIK	DRWG DATE: 03/11/08	APPV'D BY:	DATE APPV'D:	REV
DRWG SCALE: Noted	PRODUCT CODE: 111	P6296		A




Actual Size



Four Times Size

Purchased Part

Schlege Pile Weathering
Part Number 364-1006-5101

 Architectural Testing	Report #:	C5869-116-45
	Date:	10/24/13
	Verified by:	<i>Kristen S. Finckelbein</i>

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 WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	05/03/02	Redrawn for CAD	DMT

Pile Weathering to use with E1195 and E1152			
DRAWN BY PJ	DRWG DATE 10/03/75	APPV,D BY	DATE APPV'D
DRWG SCALE Noted	PRODUCT CODE 110	P938	
			REV A



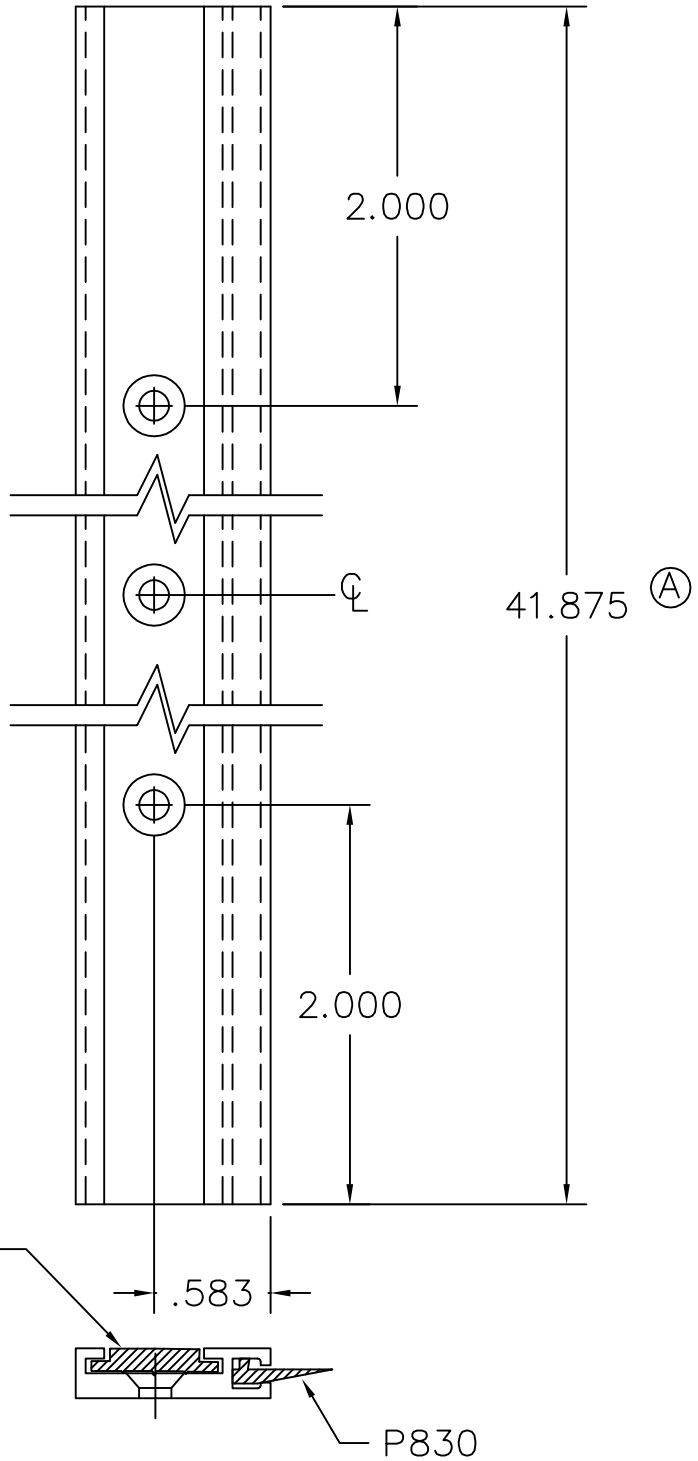
Report #: C5869-116-45

Date: 10/24/13

Architectural Testing Verified by: *Kristen S. Svendsen*

P1276

C



Operations:

1. Cut to length as required
2. Drill 3 holes with #25 Drl & Ctsk for S-064 (#6)
3. Cut P830 to length, Install, & Crimp ends
4. Cut P914 to length and install
5. Paint ends as required
6. Ship with three (3) S064 Screws.

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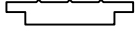
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WALKER, MICHIGAN 49544

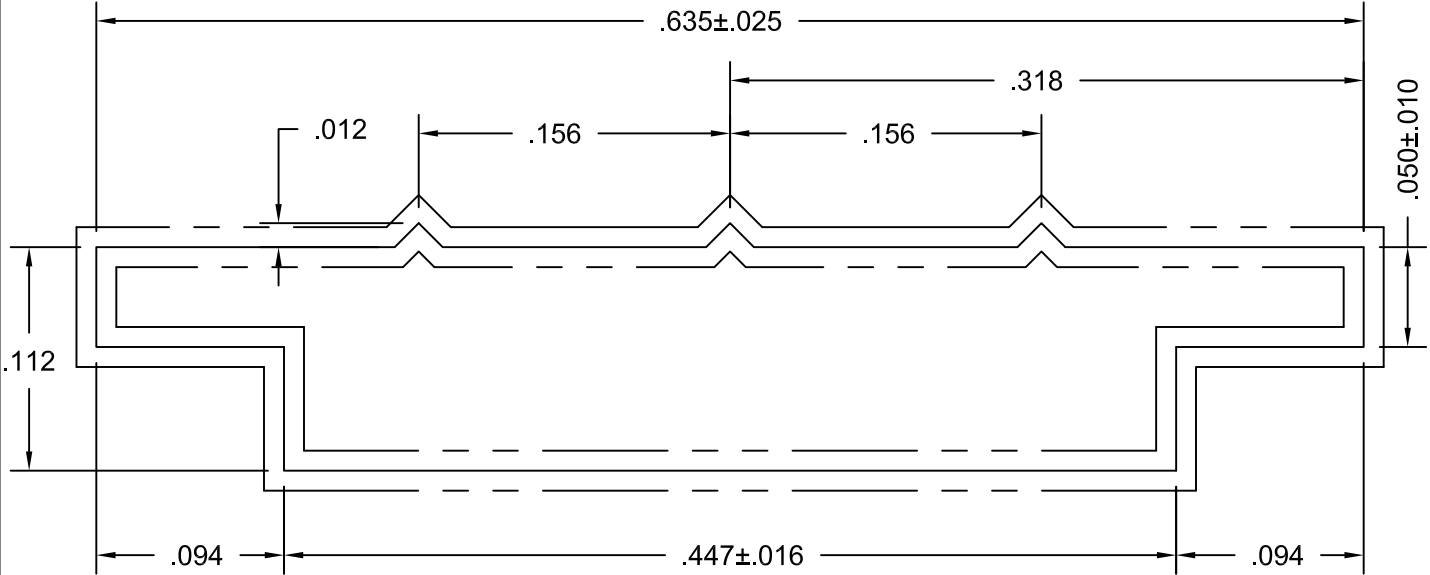
REV	DATE	DESCRIPTION	INTL
	7/29/83	Released Part per ED 128	PJ
A	05/17/90	Dimension was 40.875 per ED 1222	KMH
B	8/24/01	Redrawn for CAD	DMT
C	06/19/03	OUTSOURCE - ADD S064 SCREWS	SRD

Door Seal to use with
E2058 Threshold

DRAWN BY PJ	DRWG DATE 05/09/83	APPV,D BY	DATE APPV'D
DRWG SCALE Full	PRODUCT CODE 380	P1276	REV C



ACTUAL SIZE



Ten Times Size

MATERIAL: EPDM

NOTE: Part to receive Silicone Bath after Extruding

Purchased Part
Avon Rubber
90 Durometer
250' Rolls

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WALKER, MICHIGAN 49544

REV	DATE	DESCRIPTION	INTL
A	01/19/96	Redrawn for AutoCAD	DMT

EPDM Rubber Glazing Use with M1061, M1063, M1202			
DRAWN BY	KMH	DRWG DATE	01/19/96
APPV,D BY		DATE APPV,D	
DRWG SCALE	Noted	PRODUCT CODE	380
P914			A

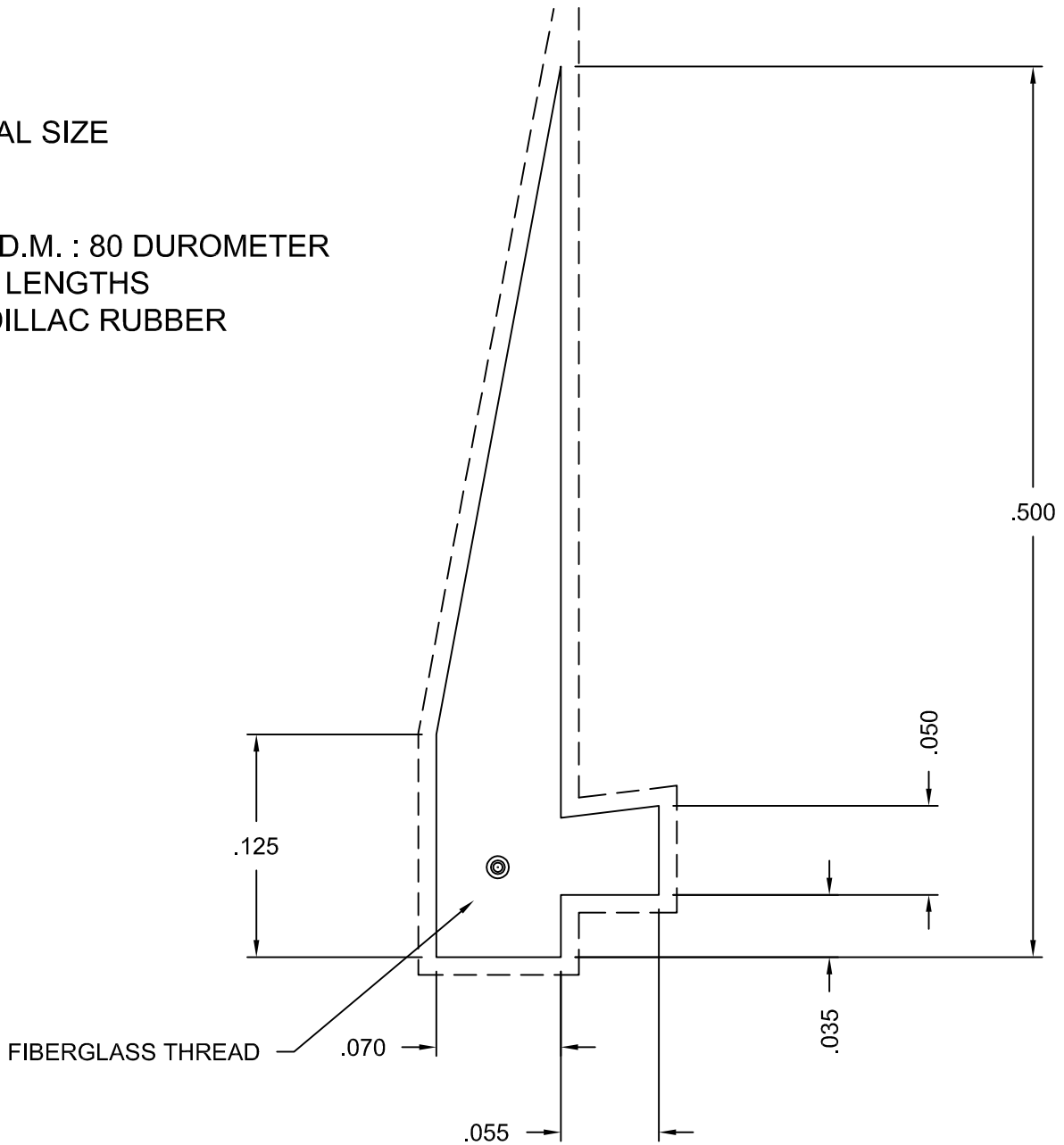
P830

A



ACTUAL SIZE


E.P.D.M. : 80 DUROMETER
250' LENGTHS
CADILLAC RUBBER



SOAP STONE SLURRY

TEN TIMES SIZE

MATERIAL: EPDM


 Report #: C5869-116-45
 Date: 10/24/13
 Verified by: Kristen R. Buehler

REPLACES P-351

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REV	DATE	DESCRIPTION	INTL
A	10/08/02	Updated to P-Part Titleblock	DMT

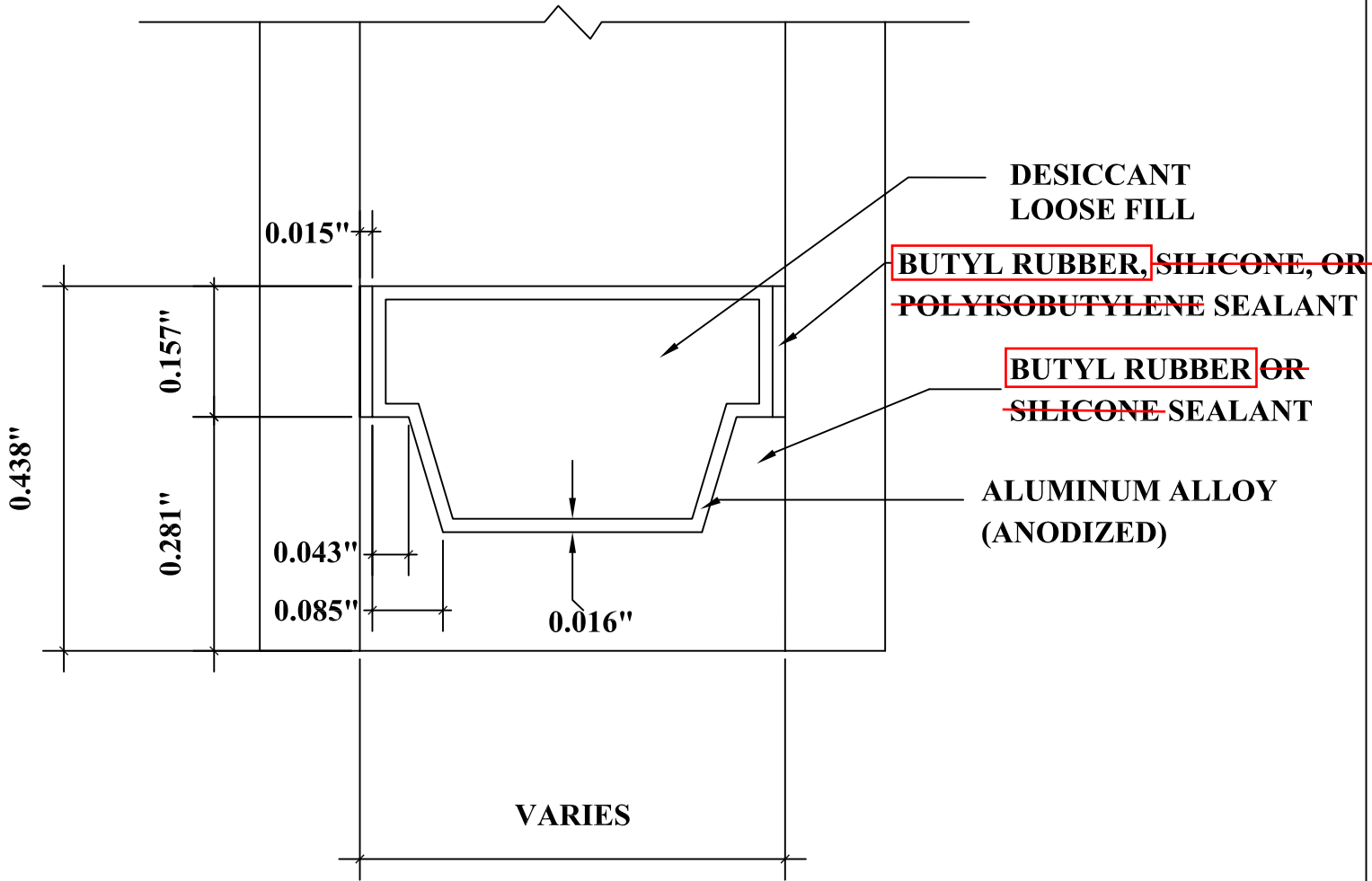
Neoprene Sweep for P1275 Sweep			
DRAWN BY PJ	DRWG DATE 03/06/73	APPV.D BY	DATE APPV'D
DRWG SCALE Noted	PRODUCT CODE 380	P830	REV A



Report #: C5869-116-45

Date: 10/24/13

Architectural Testing Verified by: *Kristen H. Ruedsberger*



DETAIL FOR THERMAL MODELING OF
ALUMINUM SPACER (A1-D)