



TEST REPORT

Report No.: E1391.07-550-44

Rendered to:

GLOBAL PRODUCTS INTERNATIONAL GROUP, LLC
Atlanta, Georgia

PRODUCT TYPE: PVC Slider
SERIES/MODEL: OX-Doors

Title	Summary of Results
AAMA/WDMA/CSA 101/1.S.2/A440-08 and -11	Class R-PG50 1829mm x 2032mm (72 x 80in) - SD
Design Pressure	±2400 Pa (±50.13 psf)
Air Infiltration	0.4 L/s/m ² (0.07 cfm/ft ²)
Water Penetration Resistance Test Pressure	360 Pa (7.52 psf)
Uniform Load Structural Test Pressure	±3600 Pa (±75.19 psf)

Test Dates: 10/08/14
Through: 1/12/15
Report Date: 05/15/15

Reference must be made to Report No. E1391.07-550-44, dated 05/15/15 for complete test specimen description and detailed test results.

1.0 Report Issued To: Global Products International Group, LLC
2765 Bankers Industrial Drive, Building F
Atlanta, Georgia 30360

2.0 Test Laboratory: Architectural Testing, Inc.
an Intertek Company ("Intertek-ATI")
1701 Westfork Drive, Suite 106
Lithia Springs, Georgia 30122
770-941-6916

3.0 Project Summary:

3.1 Product Type: PVC Slider

3.2 Series/Model: OX

3.3 Compliance Statement: Results obtained are tested values and were secured by using the designated test method(s). The specimens tested successfully met the performance requirements for the following ratings:

Test Specimen(s)	Title	Summary of Results
1	101/I.S.2/A440-08 and-11	Class R-PG50 1829mm x 2032mm (72 x 80in) - SD

3.4 Test Dates: 10/08/2014 - 1/12/2015

3.5 Test Record Retention End Date: All test records for this report will be retained until January 12, 2019.

3.6 Test Location: Intertek-ATI test facility in Lithia Springs, Georgia.

3.7 Test Sample Source: The test specimen was provided by the client. Representative samples of the test specimen(s) will be retained by Intertek-ATI for a minimum of four years from the test completion date.

3.8 Drawing Reference: The test specimen drawings have been reviewed by Intertek-ATI and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek-ATI per the drawings located in Appendix D. Any deviations are documented herein or on the drawings.

3.0 Project Summary: (Continued)

3.1 List of Official Observers:

<u>Name</u>	<u>Company</u>
Terry Wiley	Global Products International
Ryan Chapman	Global Products International
Joel Ivey	Intertek-ATI
Jon Gardner	Intertek-ATI
Ian McKenzie	Intertek-ATI
Jacques Johnson	Intertek-ATI

4.0 Test Method(s):

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

5.0 Test Specimen Description:

5.1 Product Sizes:

Overall Area: 2.8 m ² (30.0 ft ²)	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	1816	71-1/2	2019	79-1/2
Operable panel size	907	35-37/64	1934	76-1/8
Stationary panel size	907	35-37/64	1934	76-1/8

5.0 Test Specimen Description: (Continued)

5.2 Frame Construction:

Frame Member	Material	Description
Head/sill/jamb (GPI 100)	PVC	Extruded
Threshold (GPI 114)	Aluminum	Extruded

	Joinery Type	Detail
All corners	Milled and butted	All corners are sealed with silicone. The jambs received holes punched at the ends. The jambs are then milled off at the end and butted with the frame.

5.3 Vent Construction:

Vent Member	Material	Description
Stiles (GPI #101)	PVC	Extruded
Top rail (GPI #101)	PVC	Extruded
Bottom rail (GPI #101)	PVC	Extruded

	Joinery Type	Detail
All corners	Fastened	Silicone is placed between the joint faces. The corners are fastened.

5.4 Weatherstripping:

Description	Quantity	Location
Pile Weathering (GPI 118)	3 rows	One strip along the outer frame sash pocket. One strip on the fixed panel sill. One strip along track support front edge.

5.0 Test Specimen Description: (Continued)

5.5 Glazing:

Glass Type	Spacer Type	Interior Lite	Exterior Lite	Glazing Method
1" IG	Air Space 3/4"	1/8"	1/8"	Glazing tape (13mm x 2mm PE foam) by Ningbo San Ye Tape Co. LTD with acrylic acid glue.

Location	Quantity	Daylight Opening		Glass Bite
		millimeters	inches	
Door Leaf	2	664 x 1694	26.145 x 66.71	3/16"

5.6 Drainage:

Drainage Method	Size	Quantity	Location
Weepholes	1/8"	4	Two in front of each vent. One is located on the sill 10" from each edge and another 4" from the center of the unit.

5.7 Hardware:

Description	Quantity	Location
Single mortise lock (Part #250-148)	1	On Active Sliding Leaf
Handle (Part #250-123)	1	On Active Sliding Leaf
Tandem Roller (Part #250-102)	1	On Active Sliding Leaf

5.8 Reinforcement:

Drawing Number	Location	Material
250-100-6 (GPI 111)	Sash	Fiberglass

6.0 Installation:

The specimen was installed into a 2x8 Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/4" shim space. The exterior perimeter of the door was sealed with sealant.

Location	Anchor Description	Anchor Location
Head, sill & jambs	#8 x 1-1/2" Tapcon screws	5" on center and 2-1/2" from ends through exterior nailing fin

6.0 Test Results: The temperature during testing was 21°C (70°F). The results are tabulated as follows:

Title of Test	Results	Allowed	Note
Air Leakage, Infiltration per ASTM E 283 at 75 Pa (1.57 psf)	0.4 L/s/m ² (0.07 cfm/ft ²)	1.5 L/s/m ² (0.30 cfm/ft ²) max.	1
Water Penetration, per ASTM E 547 at 360 Pa (7.52 psf)	Pass	No leakage	2
Uniform Load Deflection, per ASTM E 330 At vertical of sliding doors +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	35.6 mm (1.4") 33.0 mm (1.3")	Report Only	4, 5, 6
Uniform Load Deflection, per ASTM E 330 taken along bottom of active door +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	2.5 mm (0.1") 2.5 mm (0.1")	Report Only	4, 5, 6
Uniform Load Structural, per ASTM E 330 At vertical of sliding doors +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	2.8 mm (0.11") 0.5 mm (0.02")	7.3 mm (0.288") max	5, 6
Uniform Load Structural, per ASTM E 330 taken along bottom of active door +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	0.8 mm (0.03") 0.3 mm (0.01")	3.7 mm (0.144") max	5, 6
Forced Entry Resistance, per ASTM F 832, Type: N/A - Grade: 10	Pass	No entry	

7.0 Test Results: (Continued)

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: With and without insect screen.

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

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

Note 5: Loads were held for 10 seconds.

Note 6: Tape and film were used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

Intertek-ATI 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 Intertek-ATI for the entire test record retention period.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimen(s) tested. This report may not be reproduced, except in full, without the written approval of Intertek-ATI.

For INTERTEK-ATI:



Digitally Signed by: Jacques Johnson

Jacques R. Johnson
Project Technician



Digitally Signed by: Ian J. McKenzie

Ian J. McKenzie
Lab Manager – Regional Operations

JRJ:IJM/jab

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

Appendix-A: Alteration Addendum (1)

Appendix-B: Location of Air Seal (1)

Appendix-C: Photographs (1)

Appendix-D: Drawings (30)

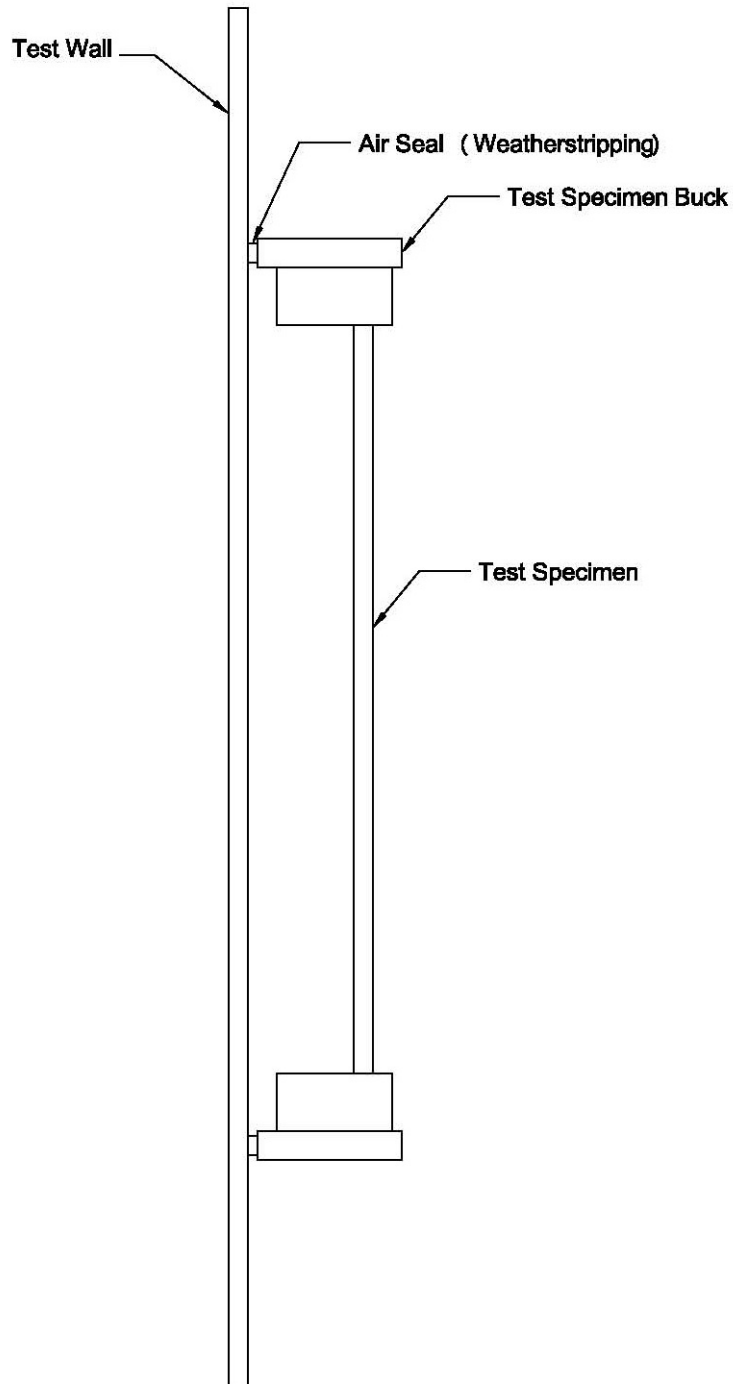
Appendix A

Alteration Addendum

Note: *No alterations were required.*

Appendix B

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.



Appendix C

Photographs



Photo No. 1
Front View



Test Report No.: E1391.07-550-44

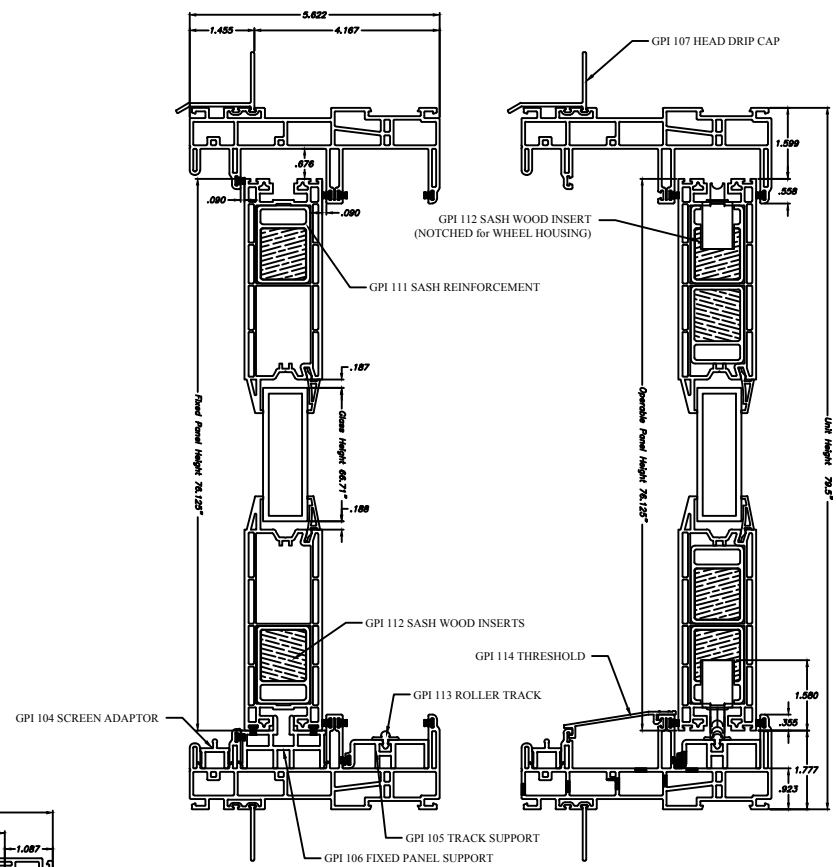
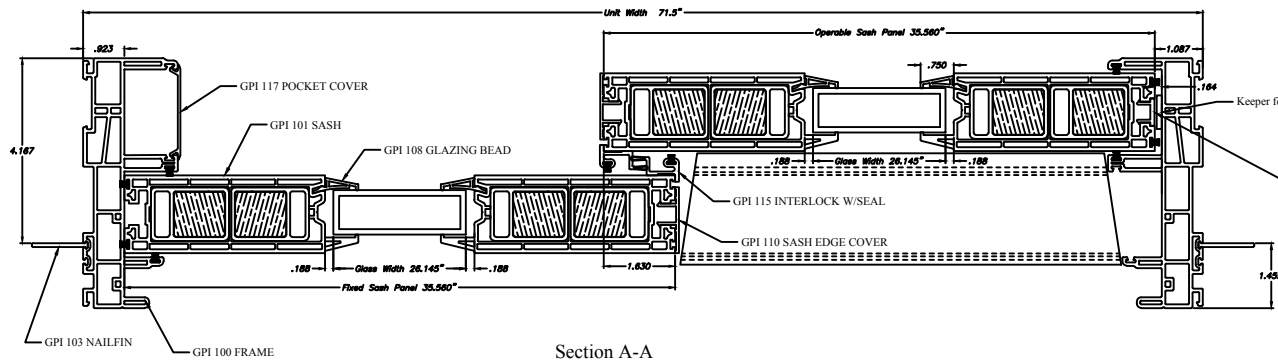
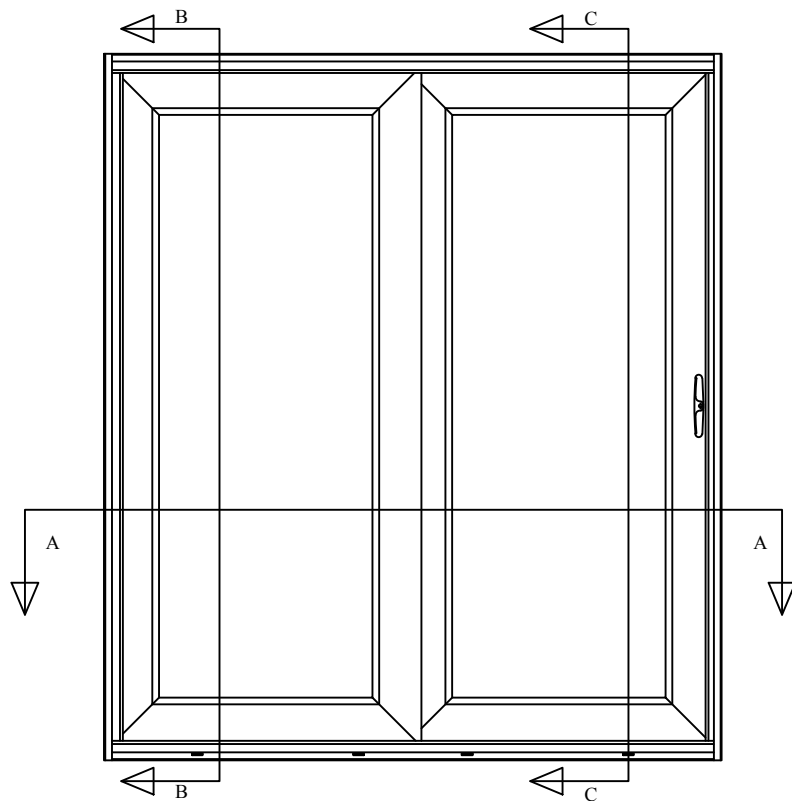
Report Date: 05/15/15

Appendix D

Drawings

NOTES :

1. note



Section B-B

Section C-C

See fabrication details for weeping.

I All Weather Strips are .187" back X .250" Pile

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DIMENSIONS ARE IN INCHES [mm]			
.X	± 0.1	ANGLES	± 1°
.XX	± 0.01	FILLET RADI	.010-.020
.XXX	± 0.005	BREAK EDGE	.005-.010
.XXXX	± 0.0005	FRACTIONS	± 1/64

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APVD		
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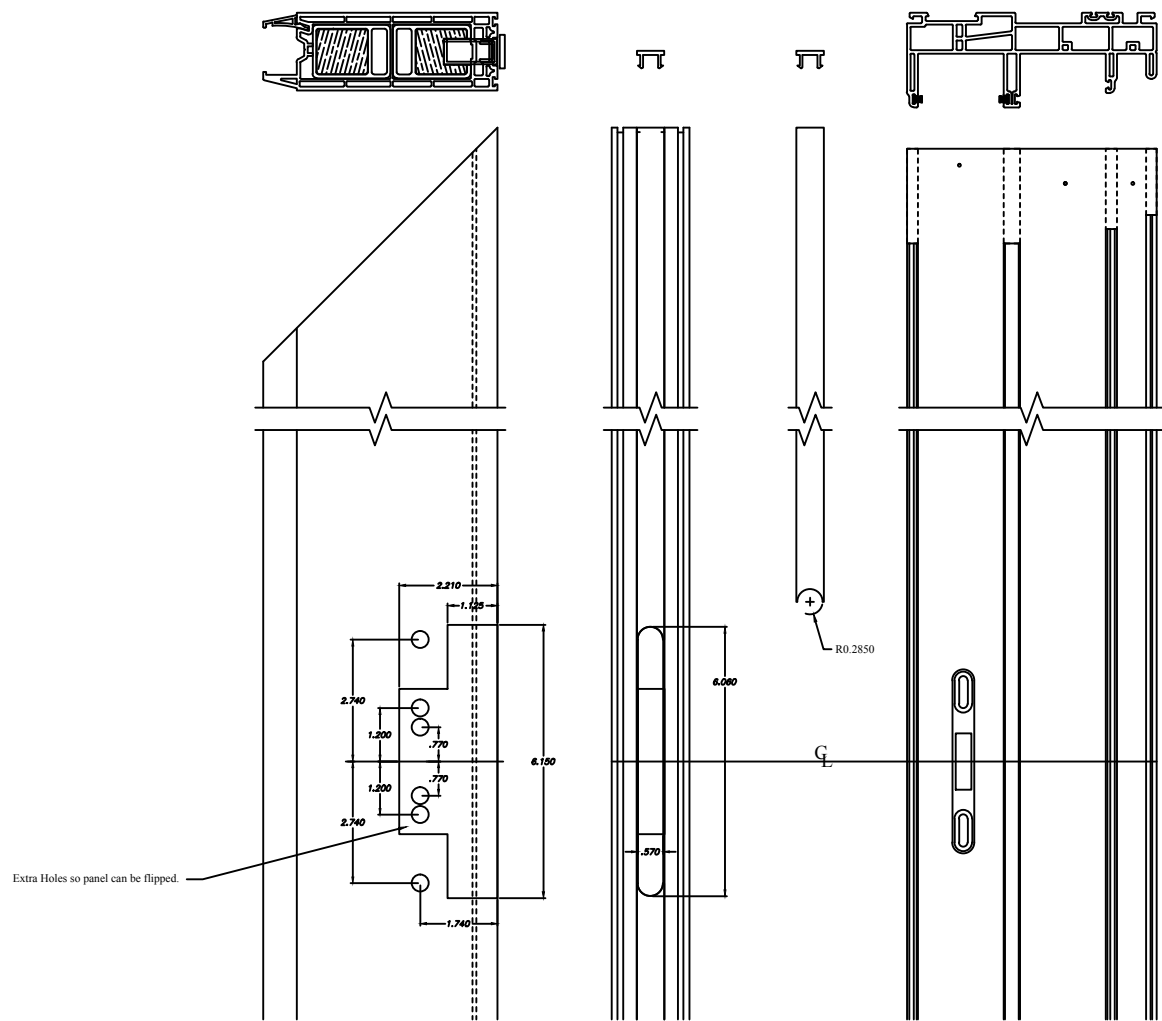


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USA

TITLE: 250 Series Sliding Patio Door 6-0 x 6-8 Opening.	
SIZE B	DWG. NO. 250-100-6 REV B
	SCALE: 1/4" = 1'-0" SHEET: 1 OF 1

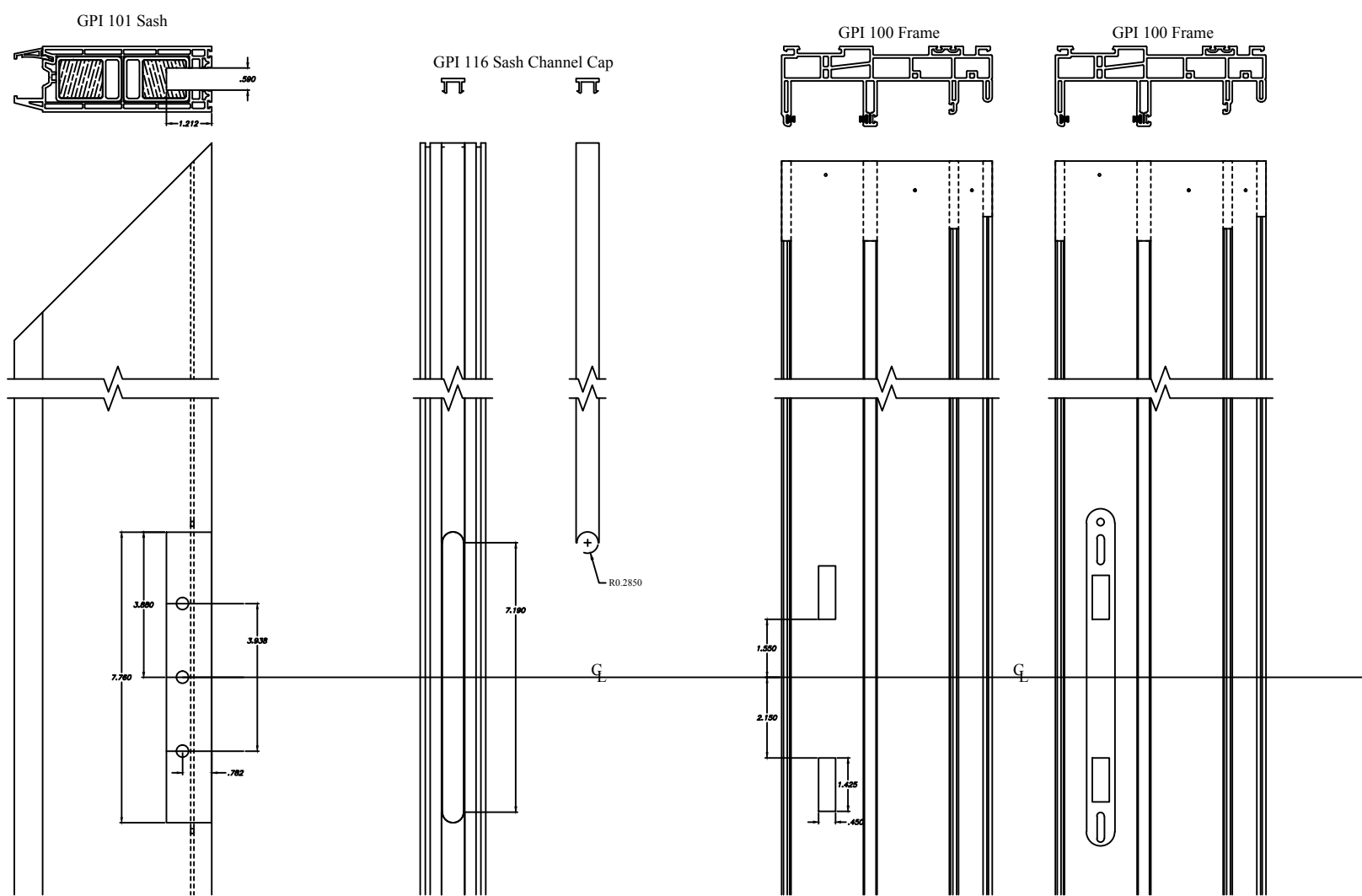
NOTES :
1. note



Layout for 1 pt Lock and Keeper.
Formulas for all parts to be found on Excel Sheet (250-Formulas)

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	.XXX	± .0005	BREAK EDGE	.005-.010							
	.XXXX	± .00005	FRACTIONS	± 1/64							

NOTES :
1. note



Layout for (alternate) 2 pt Lock and Keeper.
Formulas for all parts to be found on Excel Sheet (250-Formulas)

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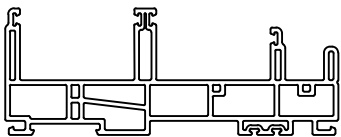
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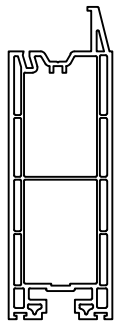
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USA

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NOTES :
1. note



GPI 100 Frame
(See Pg. 250-Fab-Jambs)
(See pg. 250-Fab-1pt Lock)
(See pg. 250-Fab-2pt Lock)
(See Pg Weep layout for 5' Door)
(See Pg Weep layout for 6' Door)



GPI 101 Sash
(See Pg. 250-Fab-Sash-Rollers)
(See pg. 250-Fab-1pt Lock)
(See pg. 250-Fab-2pt Lock)



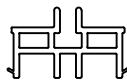
GPI 103 Nailfin
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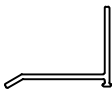
GPI 104 Screen Adaptor
Cut to Length Only



GPI 105 Track Support
(See Pg Weep layout for 5' Door)
(See Pg Weep layout for 6' Door)



GPI 106 Fixed Panel Support
Cut to Length Only



GPI 107 Head Drip Cap
(SeePg. 250-Accessories-Fabs.)



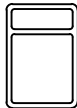
GPI 108 Glazing Bead
Cut to Length Only



GPI 109 Screw Insert



GPI 110 Sash Edge Cover
Cut to Length Only



GPI 111 Sash Refo.
Cut to Length Only
Processed in Sash.



GPI 112 Wood Insert
Cut to Length Only
Processed in Sash.



GPI 113 Roller Track
Cut to Length Only



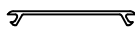
GPI 114 Threshold
(See Pg.250-Accessories-Fabs)



GPI 115 Interlock w/Seal
(See Pg.250-Accessories-Fabs)



GPI 116 Sash Channel Cap
(See Pg. 250-Fab-2pt Lock)



GPI 117 Pocket Cover
Cut to Length Only

Formulas for all parts to be found on Excel Sheet (250-Formulas)

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DIMENSIONS ARE IN INCHES [mm]
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.XXX ±.0005 BREAK EDGE .005-.010
.XXXX ±.00005 FRACTIONS ±1/64

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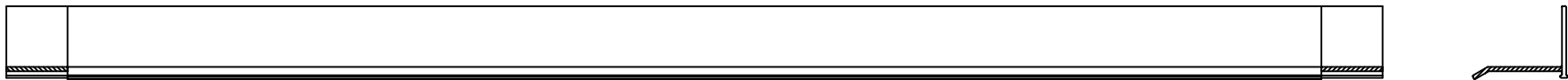
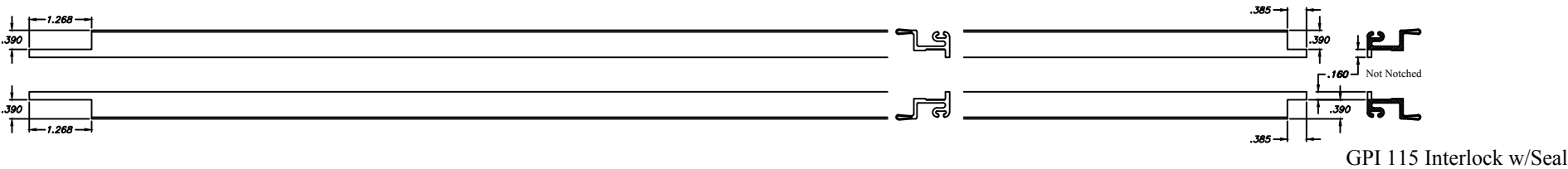
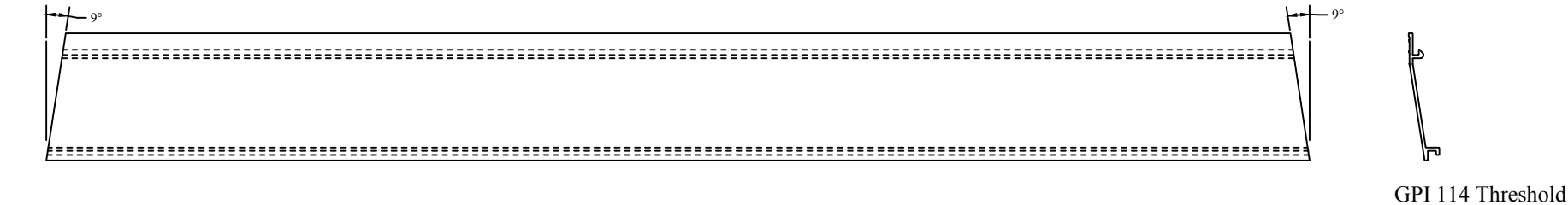
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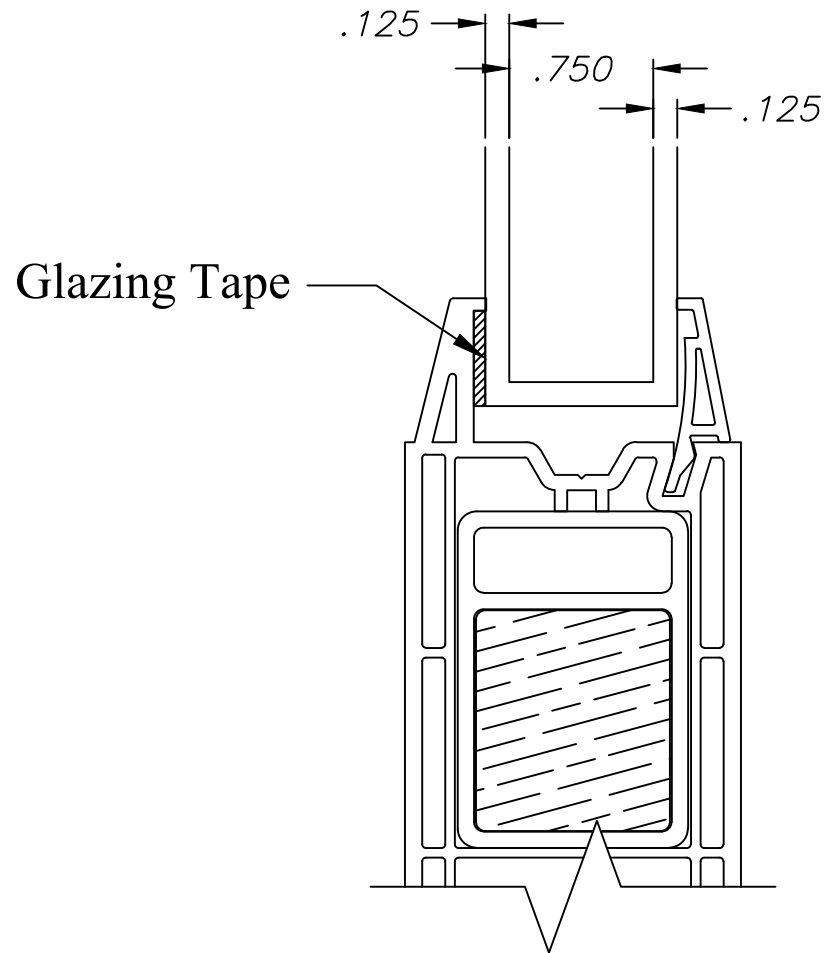
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NOTES :
1. note



Formulas for all parts to be found on Excel Sheet (250-Formulas)

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Glass makeup :
 $\frac{1}{8}$ Tempered / $\frac{3}{4}$ Air / $\frac{1}{8}$ Tempered



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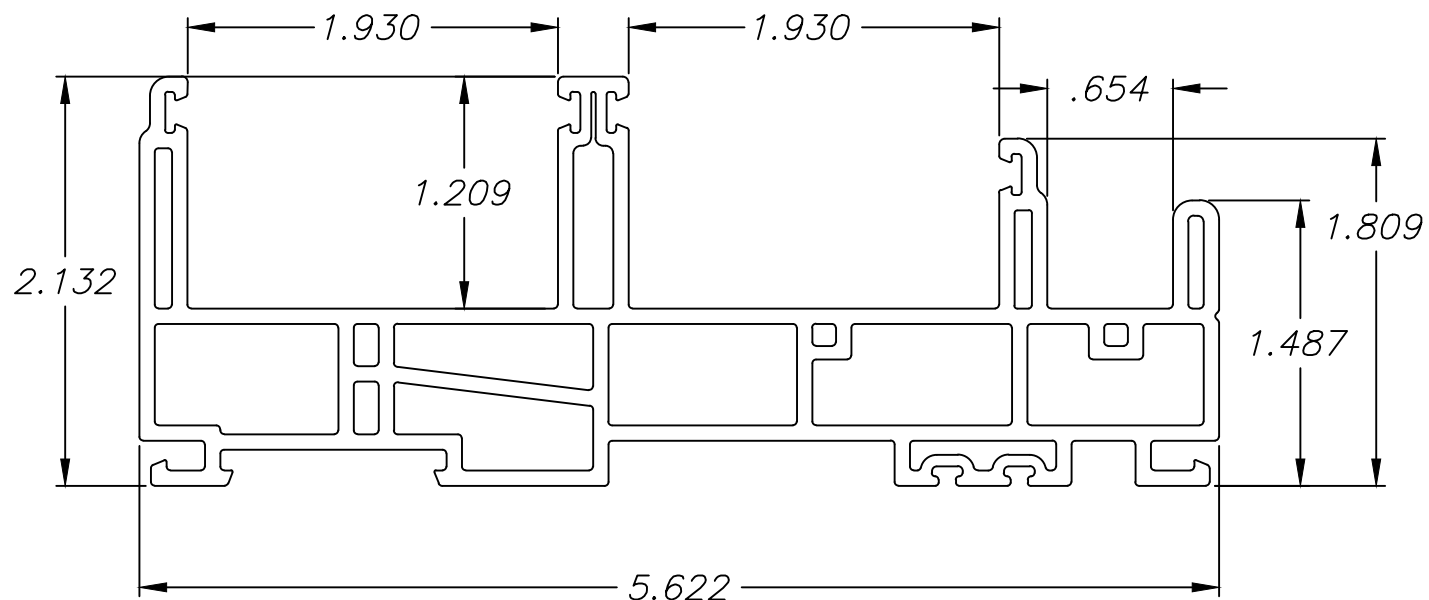
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 Glazing Cross Section

DWG. NO. 250-119-5/6

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REV
 A

GPI 100 Frame



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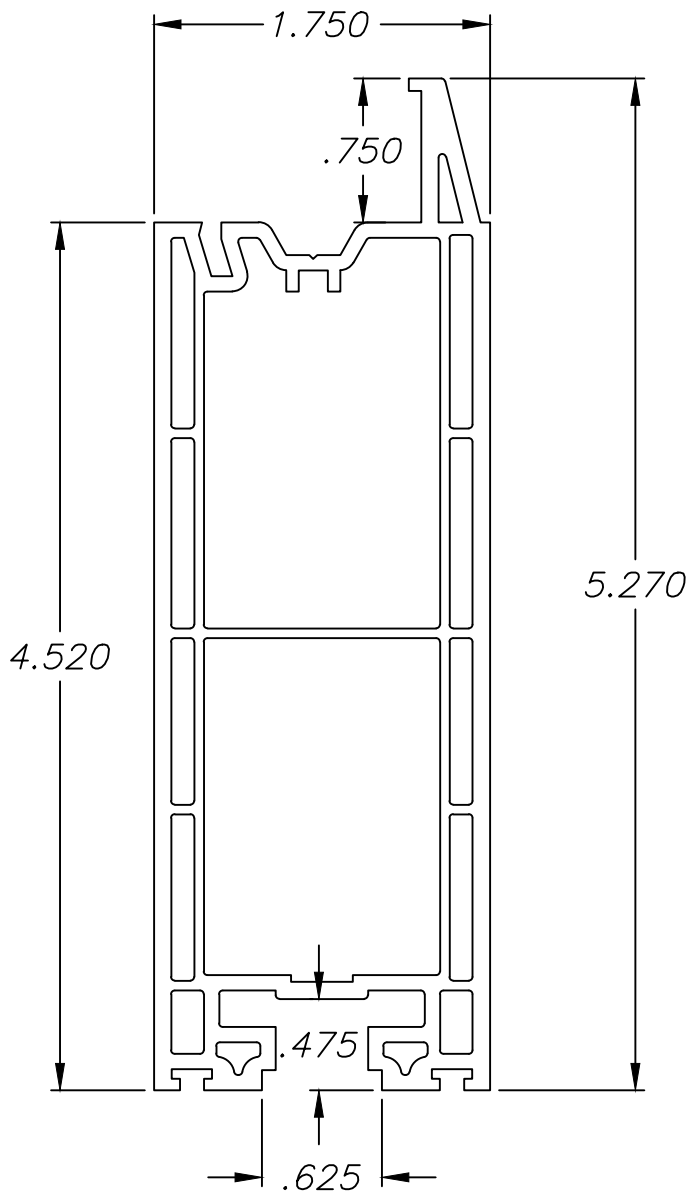
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DWG. NO. 250-102-5/6

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REV
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GPI 101 Sash

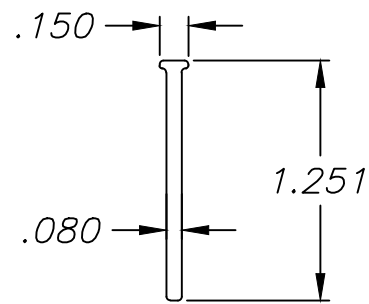


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TITLE: 250 Series Slide Patio Door GPI 101 Sash ~Vinyl		
DWG. NO.	250-103-5/6	REV A
SCALE: NTS	SHEET: 1 OF 1	

GPI 103 Nailfin



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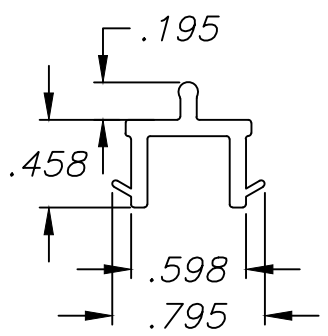
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GPI 103 Nail Fin ~Vinyl

DWG. NO. 250-104-5/6

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REV
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GPI 104 Screen Adaptor

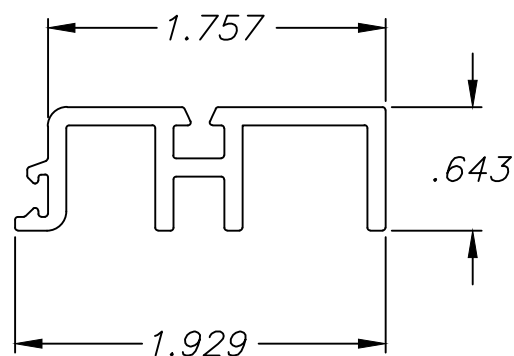


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TITLE: 250 Series Slide Patio Door GPI 104 Screen Adaptor ~Vinyl		
DWG. NO.	250-105-5/6	REV A
SCALE: NTS	SHEET: 1 OF 1	

GPI 105 Track Support



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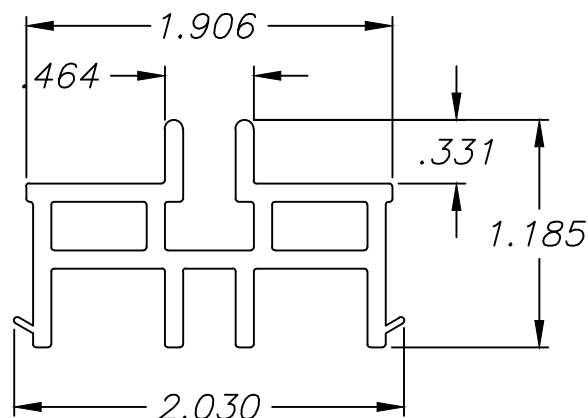
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GPI 105 Track Support ~Vinyl

DWG. NO. 250-106-5/6

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REV
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GPI 106 Fixed Panel Support



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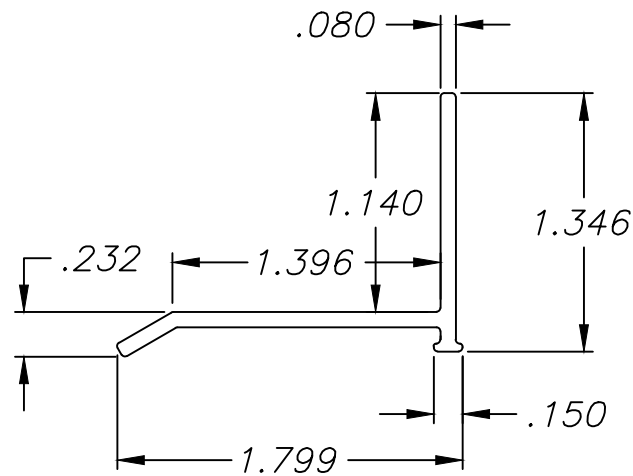
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GPI 106 Fixed Panel Support ~Vinyl

DWG. NO. 250-107-5/6

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GPI 107 Head Drip Cap



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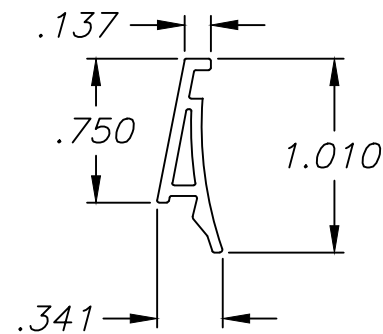
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GPI 107 Head Drip Cap ~Vinyl

DWG. NO. 250-108-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 108 Glazing Bead



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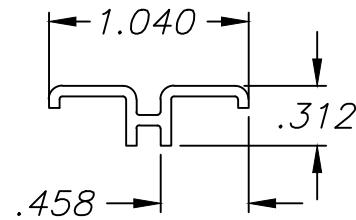
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GPI 108 Glazing Bead ~Vinyl

DWG. NO. 250-109-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 109 Screw Insert



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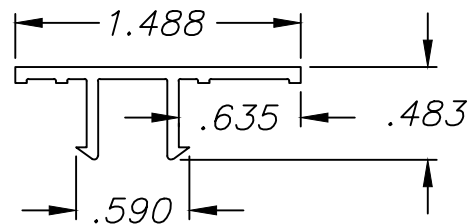
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GPI 109 Screw Insert ~Vinyl

DWG. NO. 250-110-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 110 Sash Edge Cover



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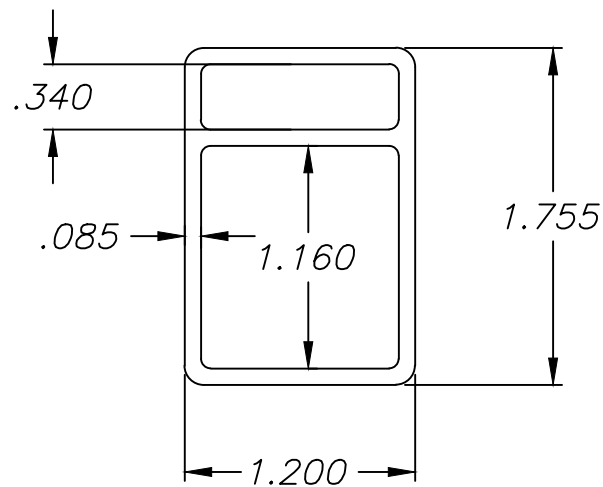
TITLE: 250 Series Slide Patio Door
GPI 110 Sash Edge Cover ~Vinyl

DWG. NO. 250-111-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 111 Sash Refo.



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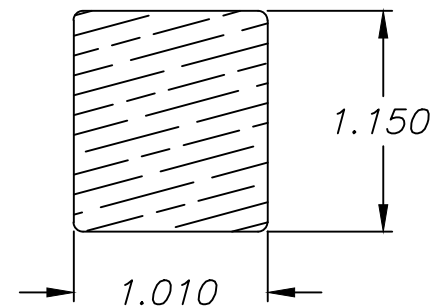
TITLE: 250 Series Slide Patio Door
GPI 111 Sash Refo. ~Vinyl

DWG. NO. 250-112-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 112 Wood Insert



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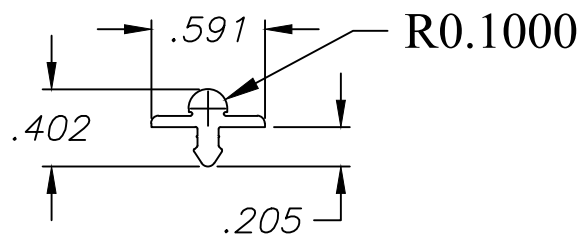
TITLE: 250 Series Slide Patio Door
GPI 112 Wood Insert ~Wood

DWG. NO. 250-113-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 113 Roller Track



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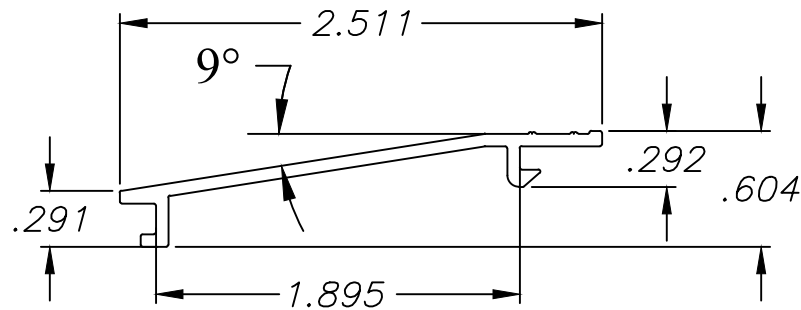
TITLE: 250 Series Slide Patio Door
GPI 113 Roller Track ~Aluminum

DWG. NO. 250-114-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 114 Threshold



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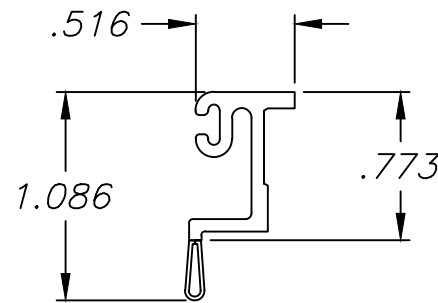
TITLE: 250 Series Slide Patio Door
GPI 114 Threshold ~Aluminum

DWG. NO. 250-115-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 115 Interlock w/Seal



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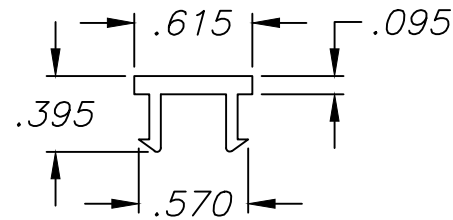
TITLE: 250 Series Slide Patio Door
GPI 115 Interlock w/Seal ~Vinyl

DWG. NO. 250-116-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 116 Sash Channel Cap



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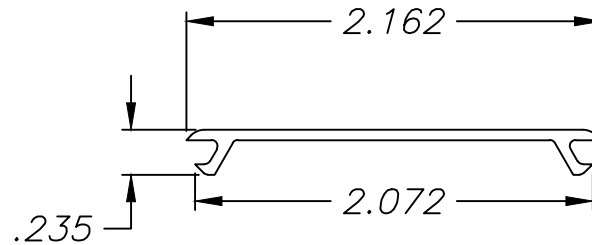
TITLE: 250 Series Slide Patio Door
GPI 116 Sash Channel Cap ~Vinyl

DWG. NO. 250-117-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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GPI 117 Pocket Cover



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TITLE: 250 Series Slide Patio Door
GPI 117 Pocket Cover ~Vinyl

DWG. NO. 250-118-5/6

SCALE: NTS SHEET: 1 OF 1

REV
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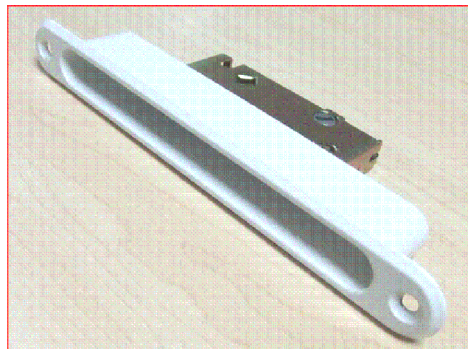
250-123 Patio Door Finger Pull Handle (White)



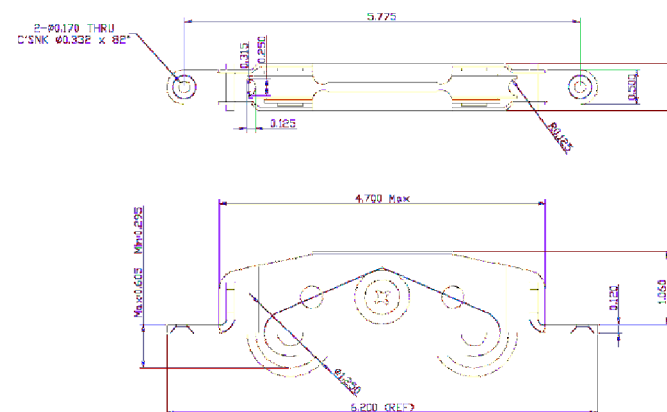
Interior



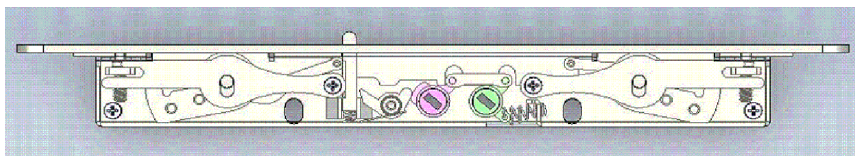
Exterior



250-148 Single Point Lock & Keeper



250-102 Tandem Roller



250-122 Duel Mortise Lock (Alternate)



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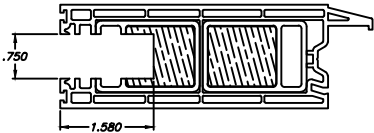
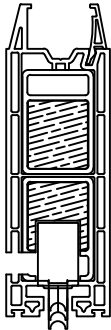
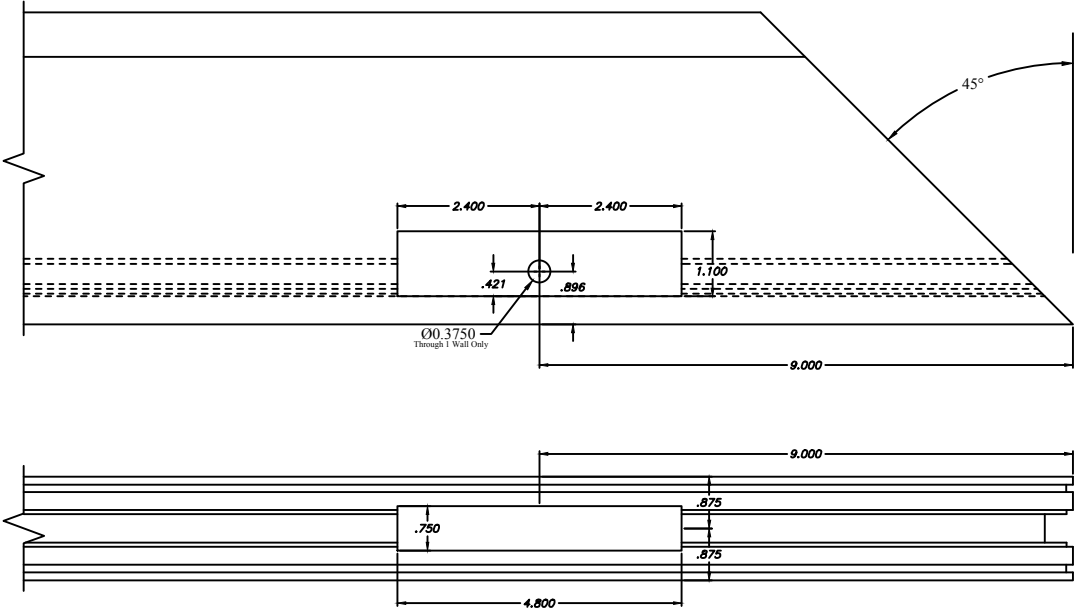
TITLE: 250 Series Slide Patio Door
Hardware

DWG. NO. 250-120-5/6

SCALE: NTS SHEET: 1 OF 1

REV
A

NOTES :
1. note



Head & Sill Rails will have roller holes routed in at
at each end. (4 total per operable panel)

GPI 101 Sash

Formulas for all parts to be found on Excel Sheet (250-Formulas)

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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES [mm]
.X ±.01 ANGLES ±1°
.XX ±.001 FILLET RADIUS .010-.020
.XXX ±.0005 BREAK EDGE .005-.010
.XXXX ±.00005 FRACTIONS ±1/64

DRAWN TLD 02/09/15
CHECK
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Last Modified:
2/9/2015 05:11 PM



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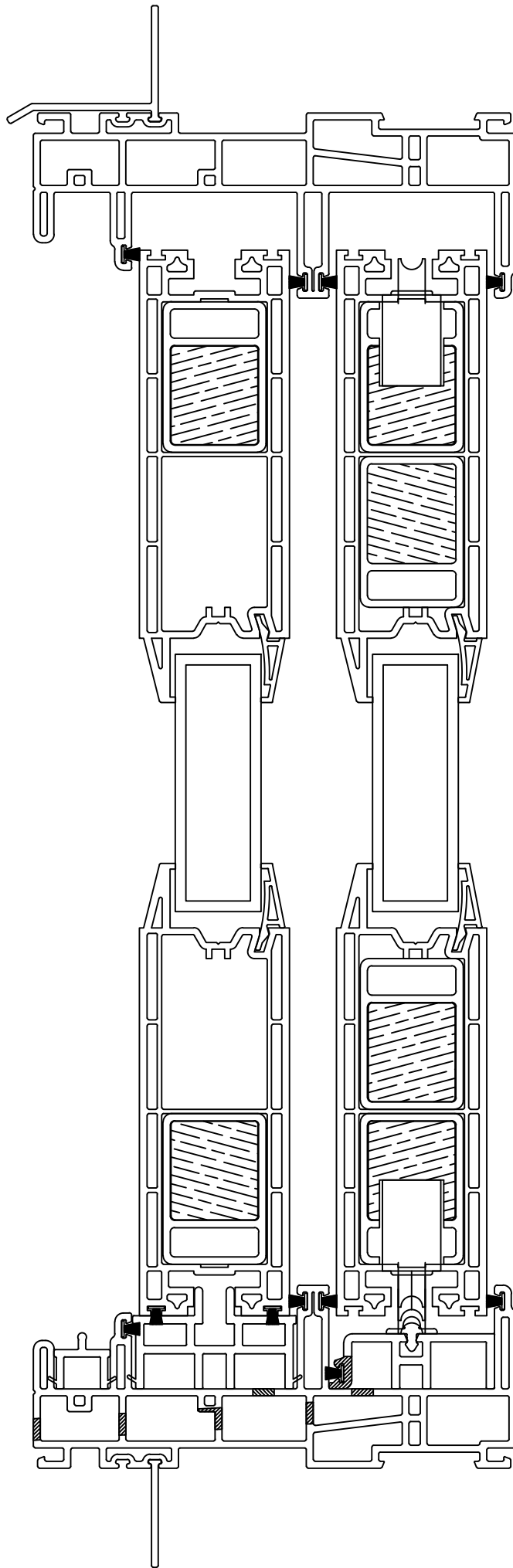
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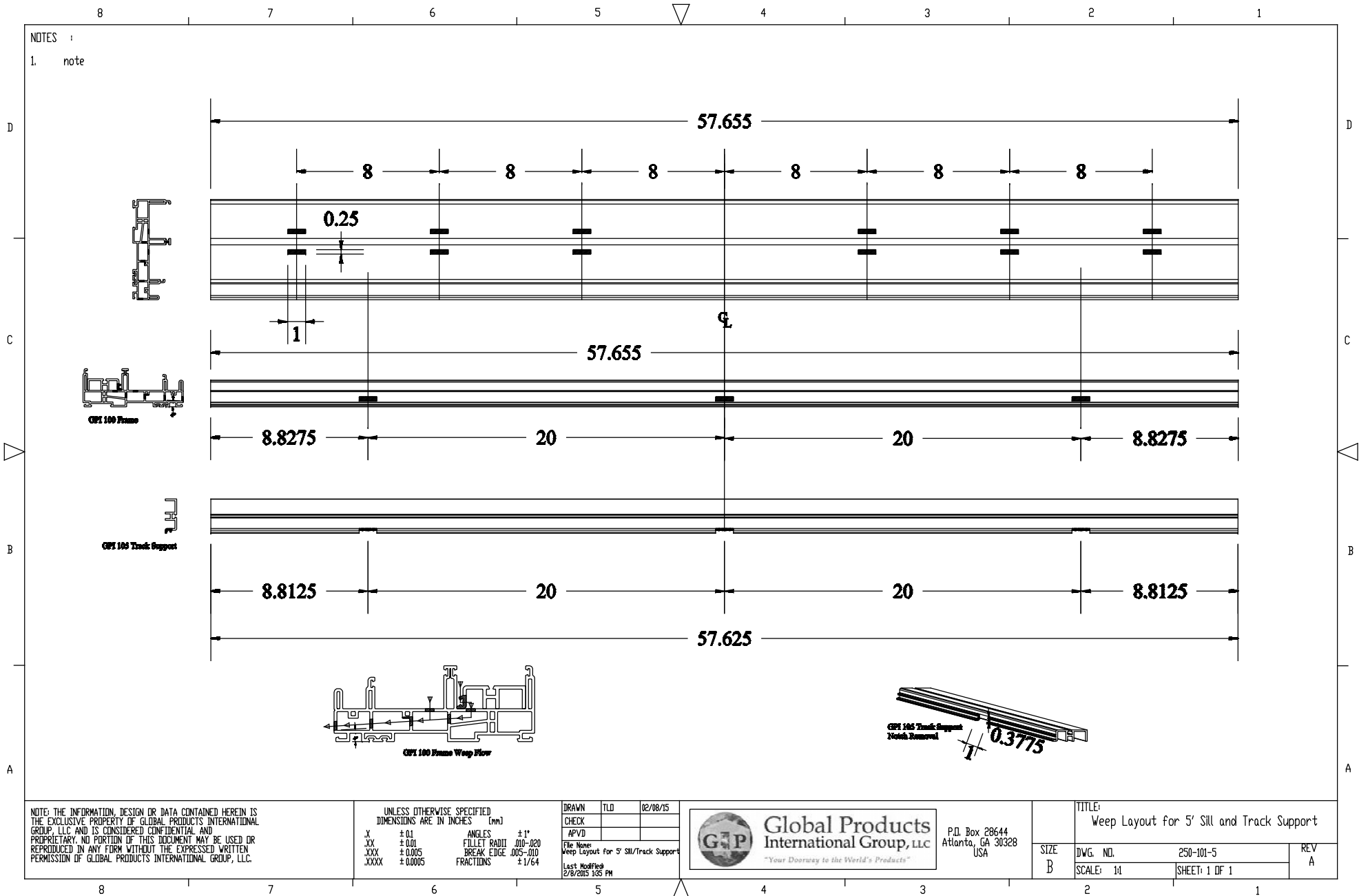
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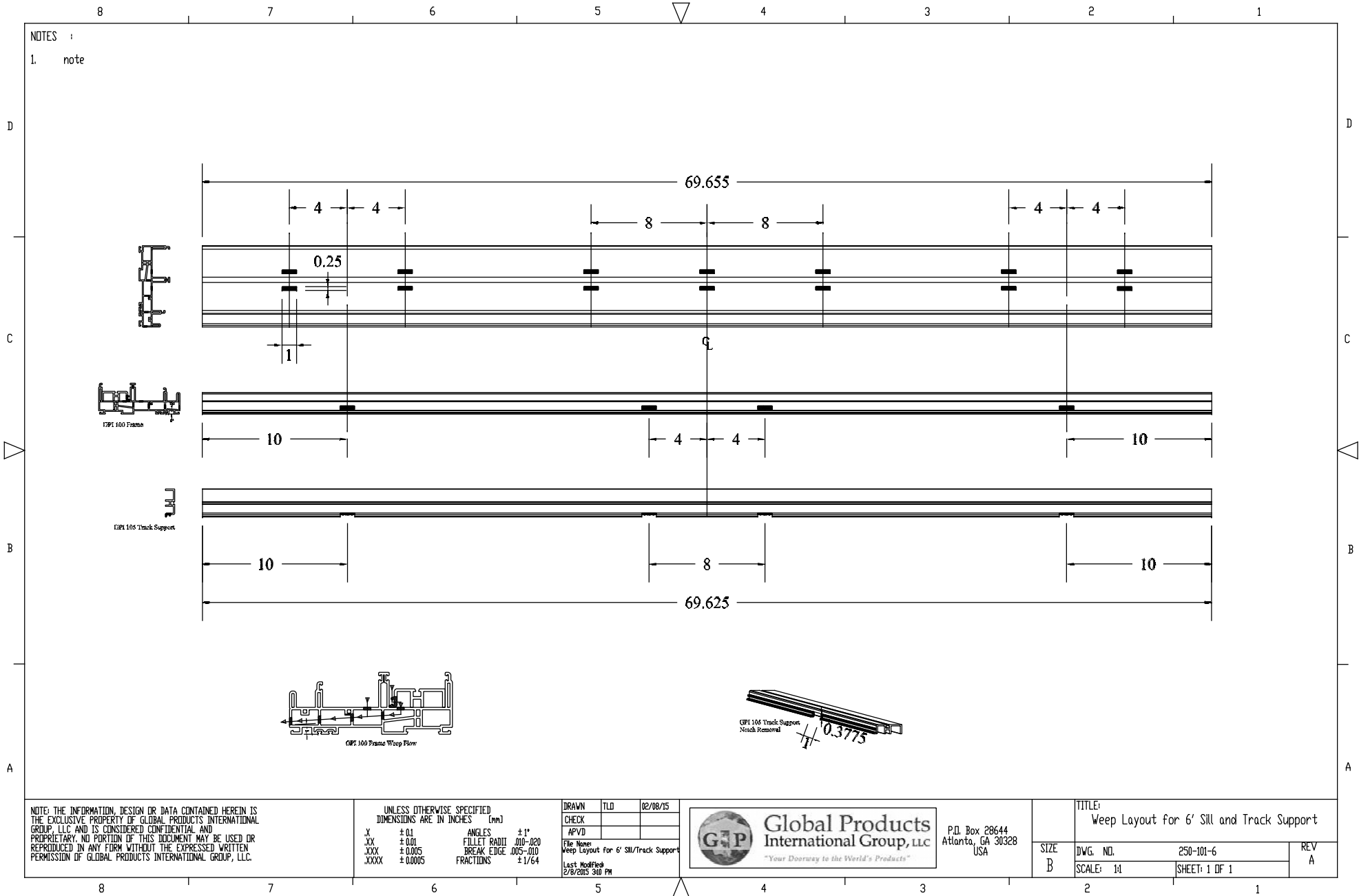
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DWG. NO. 250-Fab-Sash-Rollers
SCALE: 1:1 SHEET: 1 OF 1

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8 7 6 5 4 3 2 1
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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES (mm)

.X	± 0.1	ANGLES	± 1°
.XX	± 0.01	FILLET RADIUS	.010-.020
.XXX	± 0.005	BREAK EDGE	.005-.010
.XXXX	± 0.0005	FRACTIONS	± 1/64

DRAWN	TLD	02/08/15
CHECK		
APVD		

File Name: Weep Layout for 6' Sill/Track Support

Last Modified: 2/8/2015 3:00 PM

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USA

TITLE: Weep Layout for 6' Sill and Track Support						
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DWG. NO.	250-101-6	REV A				
SCALE: 1/4"	SHEET: 1 OF 1					