



# Structural Performance Certification Authorization Report

## Pocahontas Aluminum Company, Inc.

PO Box 756, 2001 Industrial Drive  
Pocahontas, AR 72455, USA

<b>Certification ID:</b>	757-150
<b>Company Code:</b>	757
<b>Certification Date:</b>	3/8/2024
<b>Revision No:</b>	0
<b>Revision Date:</b>	3/8/2024
<b>Expiration Date:</b>	3/8/2028

### Product Rating Information:

<b>Model:</b>	SHL21WW PVC Single Hung Window			
<b>Operator Type:</b>	H			
<b>Configuration:</b>	AV/EM/IM			
<b>Referenced Standard:</b>	AAMA 1701.2-95			
<b>Product Rating:</b>	Wind Zone II @ +48/-58 psf, 30x68 (Corner of Wall / Field of Wall)			
<b>Rated Dimensions:</b>	<b>Max Width:</b>	30 in	<b>Max Height:</b>	68 in

### Qualifying Test Information:

<b>Test Report No:</b>	MOL-27587.01-109-12-R1
<b>Test Report Expiration:</b>	3/8/2028

This Certification Authorization Report (CAR) is issued by Keystone Certifications, Inc. (KCI) after full validation review, and is based on a standardized evaluation of the product conducted by an independent accredited laboratory in accordance with the specified referenced standard. Actual fenestration product performance may vary based on many factors, including installation, condition of the wall/roof substrate and the age of the product and installation components.

This report indicates the product is eligible for the application of Keystone Certification Program certification labels. Licensee stipulates in affixing certification labels to products, that those products are representative of the specimen evaluated and documented for certification authorization. Only products bearing such a certification label shall be considered certified. The information in this report can be verified at [www.keystonecerts.com](http://www.keystonecerts.com)



Authorized By:



Keystone Certifications, Inc.  
145 Limekiln Rd, Suite 100B  
New Cumberland, PA 17070  
Phone: 717-932-8500



# Structural Performance Certification Authorization Report

## Revision History

Rev #	Date	Description
0	3/8/2024	Initial Issuance.



# Structural Performance Certification Authorization Report

## Pocahontas Aluminum Company, Inc.

PO Box 756, 2001 Industrial Drive  
Pocahontas, AR 72455, USA

<b>Certification ID:</b>	757-151
<b>Company Code:</b>	757
<b>Certification Date:</b>	3/8/2024
<b>Revision No:</b>	0
<b>Revision Date:</b>	3/8/2024
<b>Expiration Date:</b>	3/8/2028

### Product Rating Information:

<b>Model:</b>	SHL21WW PVC Single Hung Window			
<b>Operator Type:</b>	H			
<b>Configuration:</b>	AV/EM/IM			
<b>Referenced Standard:</b>	AAMA 1701.2-95			
<b>Product Rating:</b>	Wind Zone III @ 58 psf, 30x60.25 (Corner of Wall / Field of Wall)			
<b>Rated Dimensions:</b>	<b>Max Width:</b>	30 in	<b>Max Height:</b>	60 in

### Qualifying Test Information:

<b>Test Report No:</b>	MOL-27587.01-109-12-R1
<b>Test Report Expiration:</b>	3/8/2028

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Authorized By:



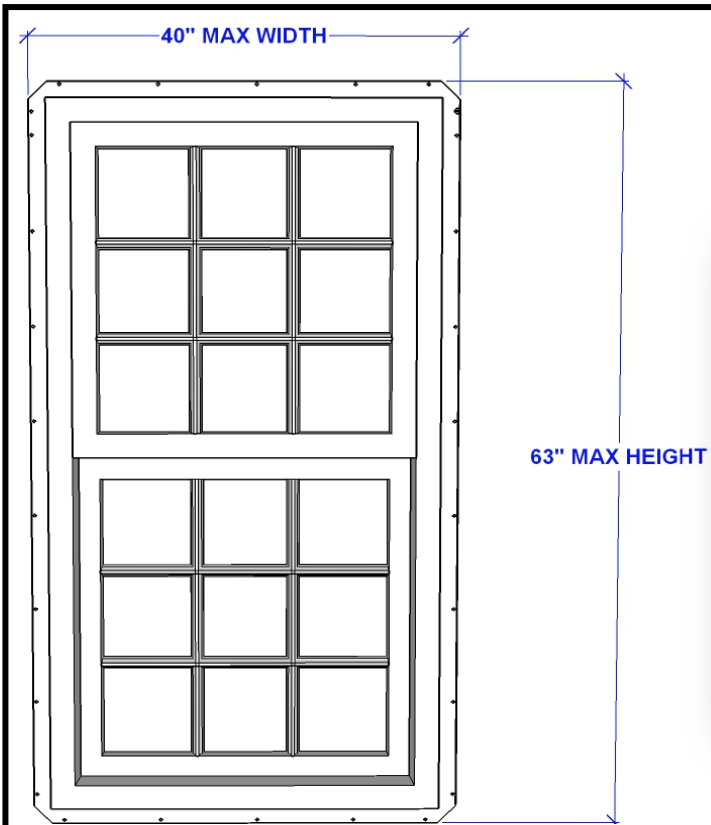
Keystone Certifications, Inc.  
145 Limekiln Rd, Suite 100B  
New Cumberland, PA 17070  
Phone: 717-932-8500



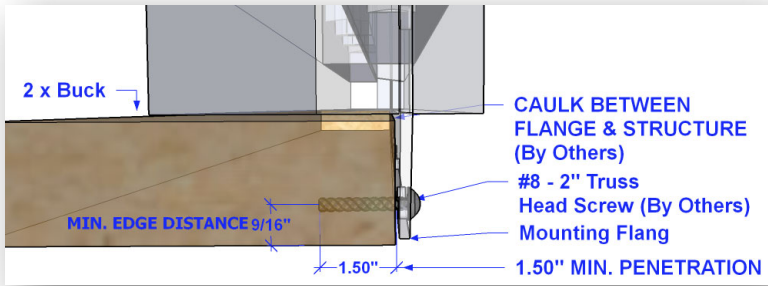
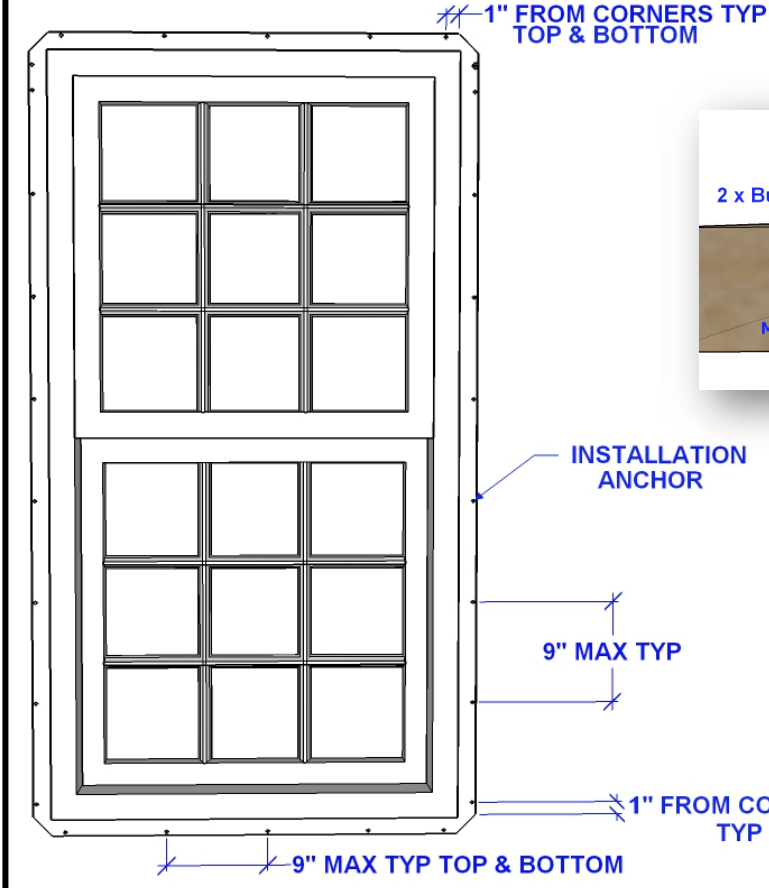
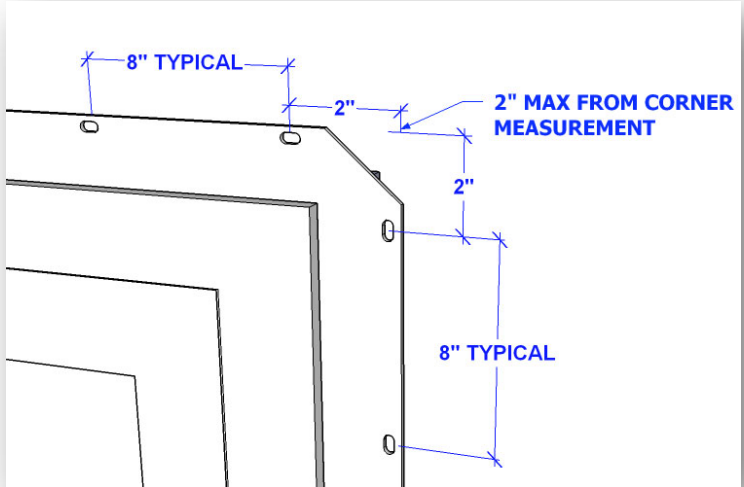
# Structural Performance Certification Authorization Report

## Revision History

Rev #	Date	Description
0	3/8/2024	Initial Issuance.



**INSTALLATION METHOD  
PVC (VINYL) SH21 SINGLE HUNG  
ELEVATION & ANCHOR LAYOUT**



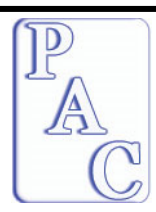
SCALE: NTS  
DWN BY: AMM  
CHK BY: KEA  
DATE: 10/13/15

TITLE:  
INSTALLATION METHOD  
PVC (VINYL) SH21 SINGLE HUNG  
ELEVATION & ANCHOR LAYOUT

PREPARED BY:  
POCAHONTAS ALUMINUM COMPANY, INC.  
2001 INDUSTRIAL DRIVE  
POCAHONTAS, AR 72455  
PH: 870-892-3689 FAX: 870-892-9858

REVISIONS			
NO.	DESCRIPTION	BY	DATE

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ALUMINUM  
COMPANY, INC.



## TEST REPORT

AAMA 1701.2-95

AAMA 1704-85

AAMA 1704-85

REPORT No.: 27587.01-109-12-R1

RENDERED TO: POCAHONTAS ALUMINUM COMPANY, INC.  
Pocahontas, AR

PRODUCT TYPE: PVC Single Hung Window

SERIES / MODEL: SHL21WW

**Test Date:** 10/31/2023  
**Through:** 11/1/2023  
**Report Date:** 11/6/2023  
**Revision Date:** 01/12/2024

**CLIENT INFORMATION:** POCAHONTAS ALUMINUM COMPANY, INC.  
 2001 Industrial Dr  
 Pocahontas, AR 72455

**TEST LABORATORY:** Molimo, LLC  
 1140 Lincoln Avenue  
 Springdale, Pennsylvania 15144  
 724-410-7324

**PROJECT SUMMARY:**

**PRODUCT TYPE:** PVC Single Hung Window

**SERIES/MODEL:** SHL21WW

**PROJECT SUMMARY:**

Molimo, LLC was contracted to perform testing on the above-referenced product. The results are tested values and were secured by using the designated test methods. The specimens tested successfully met the performance requirements listed in the referenced specifications.

Specimen	Structural Load	Wind Zone Achieved
1	+2298 Pa (+48.0 psf)	Wind Zone II – Corner of wall Wind Zone III – Field of wall
1	-2777 Pa (-58.0 psf)	Wind Zone III – Corner of wall Wind Zone III – Field of wall
2	±2777 Pa (±58.0 psf)	Wind Zone III – Corner of wall Wind Zone III – Field of wall

**PROJECT DETAILS:**

**Test Dates:** 10/31/2023 – 11/1/2023

**Test Record Retention End Date:** 11/1/2027

**Test Location:** Veka, Inc. test facility in Fombell, Pennsylvania.

**Test Specimen Source:** The test specimens were provided by the client. Representative samples of the test specimens will be retained by Molimo for a minimum of four years from the test completion date.

**Drawing Reference:** The test specimen drawings were supplied by the client. The test specimen construction was verified by Molimo and was found to be representative of the products tested. Test specimen drawings are located in Appendix A of this report.

**WITNESSES:**

The following representatives witnessed all or part of the testing.

Name	Company
Doug Merry	VEKA, Inc.
Cornell Charles	VEKA, Inc.
Joseph Allison	Molimo, LLC

**TEST METHODS:**

AAMA 1701.2-95 – *Voluntary Standard for Utilization in Manufactured Housing for Primary Windows and Sliding Glass Doors*

AAMA 1704-85 – *Voluntary Standard for Egress Window Systems for Utilization in Manufactured Housing*

AAMA 1704-12 – *Voluntary Standard for Egress Window Systems for Utilization in Manufactured Housing*

Code of Federal Regulations, Part 3280 – *Manufactured Home Construction and Safety Standards*, Subpart D, Section 3280.305(c)(1)(ii)(B)

**TEST SPECIMEN DESCRIPTION:**
**PRODUCT SIZES:**

Test Specimen #1				
Overall Area: 1.32 m <sup>2</sup> (14.22 ft <sup>2</sup> )	Width		Height	
	Millimeters	Inches	Millimeters	Inches
<b>Overall Size:</b>	762	30	1734	68-1/4
<b>Sash:</b>	714	28-1/8	870	34-1/4
<b>Screen Size:</b>	724	28-1/2	845	33-1/4

Test Specimen #2				
Overall Area: 1.17 m <sup>2</sup> (12.55 ft <sup>2</sup> )	Width		Height	
	Millimeters	Inches	Millimeters	Inches
<b>Overall Size:</b>	762	30	1530	60-1/4
<b>Sash:</b>	714	28-1/8	768	30-1/4
<b>Screen Size:</b>	724	28-1/2	743	29-1/4



**TEST SPECIMEN DESCRIPTION:** (Continued)

**FRAME CONSTRUCTION:**

Frame Member	Material	Detail
Head, sill and jambs	PVC	Extruded
Corner construction	--	Miter-cut and thermally welded
Fixed meeting rail	PVC	The fixed meeting rail was fastened to the jambs with four #8 x 3" pan head screws, two at each end. Each intersection was sealed with silicone sealant.

**SASH CONSTRUCTION:**

Sash Member	Material	Detail
Rails and stiles	PVC	Extruded
Corner construction	--	Miter-cut and thermally welded

**REINFORCEMENT:**

Drawing Number	Material	Location
AF-5569	Extruded aluminum	Fixed meeting rail
AF-5570	Extruded aluminum	Lock rail, stiles

**GLAZING DETAILS:** *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimens can be made.*

Description	Detail
Glass type	5/8" IG
Glazing construction (exterior to interior)	3/32" thick annealed glass 7/16" Butyl spacer with corrugated metal substrate 3/32" thick annealed glass
Glazing method	Exterior glazed against a bed of silicone sealant and secured with rigid vinyl glazing beads
Glazing bite	1/2"
Daylight opening	
#1 Sash:	635 mm x 791 mm (25" x 31-1/8")
#1 Fixed:	695 mm x 791 mm (27-3/8" x 31-1/8")
#2 Sash:	635 mm x 689 mm (25" x 27-1/8")
#2 Fixed:	695 mm x 689 mm (27-3/8" x 27-1/8")

**WEATHERSTRIPPING:**

Description	Quantity	Location
0.187" backed by 0.270" high center fin pile	1 Row	Lock rail
0.187" backed by 0.270" high center fin pile	2 Rows	Sash stiles, bottom rail

**DRAINAGE:**

Description	Quantity	Location
1-1/8" wide by 5/32" high weepslot	2	Exterior sill face, one 2-3/4" in from each end.
1-1/8" wide by 5/32" high weepslot	2	Interior sill track, one at each end

**TEST SPECIMEN DESCRIPTION:** (Continued)

**HARDWARE:**

Description	Quantity	Location
Composite sweep lock	2	Lock rail, one 7" from each end mating with integral groove in the fixed meeting rail
Composite surface mount tilt latch	2	Lock rail, one at each end
Interlocking metal tilt pin	2	Bottom rail, one at each end
Block and tackle balance system	2	One per jamb

**SCREEN CONSTRUCTION:**

<b>Frame Material</b>	Roll-formed aluminum
<b>Corner Construction</b>	Square-cut and keyed
<b>Mesh Type</b>	Fiberglass mesh
<b>Mesh Attachment Method</b>	Flexible vinyl spline

**INSTALLATION:** The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/8" shim space. The nailing fin perimeter of the specimen was sealed with sealant.

Location	Anchor Description	Anchor Spacing
Head, sill, jambs	#8 x 2" truss head screw	Nominally spaced at 8-1/2" on center, and beginning at each corner fastened through the nailing fin and into the wood buck

**TEST RESULTS:** The temperature during testing was 19°C (67 °F).

**TEST SPECIMEN #1:**

**STRUCTURAL TESTING:** (per ASTM E 330)

Test	Results	Allowable
+1190 Pa (+25.0 psf) -595 Pa (-12.5 psf)	Pass	No Damage

*Note 1: All loads were held for 10 seconds.*

*Note 2: Tape and film were not used to seal against air leakage.*

**AIR LEAKAGE TESTING:** (per ASTM E 283)

Test	Results	Allowable
Infiltration @ 75 Pa (1.57 psf)	2.0L/s/m <sup>2</sup> (0.40 cfm/ft <sup>2</sup> )	2.5 L/s/m <sup>2</sup> (0.5 cfm/ft <sup>2</sup> )

**WATER PENETRATION TESTING:** (per ASTM E 547)

Test	Results	Allowable
140 Pa (2.92 psf)	Pass	No Leakage

*Note 3: Water Penetration testing was performed with and without an insect screen.*

**OPTIONAL STRUCTURAL PERFORMANCE TESTS:** (per ASTM E 330)

Test	Results	Allowable
+2298 Pa (+48.0 psf) -2777 Pa (-58.0 psf)	Pass	No Damage

*Note 1: All loads were held for 10 seconds.*

*Note 2: Tape and film were used to seal against air leakage. In our opinion, the tape and film did not influence the results of the test.*

**SECONDARY TESTS:**

Test	Results	Allowable
Safety Drop Test (per AAMA 1701.2)	Pass	Sash stops at the next lower position while retaining glass

**TEST RESULTS:** Continued

**TEST SPECIMEN #1: CONTINUED**
**AAMA 1704 TESTING**

Test	Results	Allowable
Clear Opening Width	695 mm (27-3/8")	510 mm (20") min.
Clear Opening Height	787 mm (31")	610 mm (24") min.
Clear Opening Area	0.55 m <sup>2</sup> (5.89 ft <sup>2</sup> )	0.46 m <sup>2</sup> (5.0 ft <sup>2</sup> ) min.
Locks and Latches	22 N (5 lbf)	90 N (20 lbf) max.
Operable Sash	89 N (20 lbf)	90 N (20 lbf) max.
Removable Screen	9 kg (20 lb)	9 kg (20 lb) max.

**TEST SPECIMEN #2:**
**STRUCTURAL TESTING:** (per ASTM E 330)

Test	Results	Allowable
+1190 Pa (+25.0 psf) -595 Pa (-12.5 psf)	Pass	No Damage

*Note 1: All loads were held for 10 seconds.*

*Note 2: Tape and film were not used to seal against air leakage.*

**AIR LEAKAGE TESTING:** (per ASTM E 283)

Test	Results	Allowable
Infiltration @ 75 Pa (1.57 psf)	2.5 L/s/m <sup>2</sup> (0.50 cfm/ft <sup>2</sup> )	2.5 L/s/m <sup>2</sup> (0.5 cfm/ft <sup>2</sup> )

**WATER PENETRATION TESTING:** (per ASTM E 547)

Test	Results	Allowable
140 Pa (2.92 psf)	Pass	No Leakage

*Note 3: Water Penetration testing was performed with and without an insect screen.*

**OPTIONAL STRUCTURAL PERFORMANCE TESTS:** (per ASTM E 330)

Test	Results	Allowable
+2777 Pa (+58.0 psf) -2777 Pa (-58.0 psf)	Pass	No Damage

*Note 1: All loads were held for 10 seconds.*

*Note 2: Tape and film were used to seal against air leakage. In our opinion, the tape and film did not influence the results of the test.*

**TEST RESULTS:** Continued

**TEST SPECIMEN #2:** CONTINUED

**SECONDARY TESTS:**

Test	Results	Allowable
Safety drop test (per AAMA 1701.2)	Pass	Sash stops at the next lower position while retaining glass

**AAMA 1704 TESTING**

Test	Results	Allowable
Clear opening width	695 mm (27-3/8")	510 mm (20") min.
Clear opening height	686 mm (27.0")	610 mm (24") min.
Clear opening area	4.8 m <sup>2</sup> (5.13 ft <sup>2</sup> )	0.46 m <sup>2</sup> (5.0 ft <sup>2</sup> ) min.
Locks and latches	22 N (5 lbf)	90 N (20 lbf) max.
Operable sash	89 N (20 lbf)	90 N (20 lbf) max.
Removable screen	9 kg (20 lb)	9 kg (20 lb) max.

A copy of this report, detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation will be retained by Molimo, LLC for the entire test record retention period. At the end of this retention period, the service life of this report will expire.

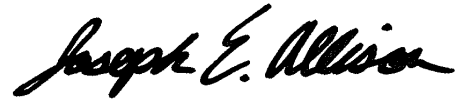
Results obtained are tested values and were secured by using the designated test methods. This test report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimen(s) tested. This report may not be reproduced, except in full, without the written permission of Molimo, LLC.

For MOLIMO, LLC:



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James Grippo  
Technician



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Joseph E. Allison  
Regional Project Manager

JG:JEA/SLD

Attachments (pages): This report is complete only when all attachments listed are included.  
Appendix-A: Drawing(s) (12)

### Revision Log

<b>Rev. #</b>	<b>Date</b>	<b>Page(s)</b>	<b>Revision(s)</b>
0	11/16/2023		Original
1	01/12/2024	Drawings	Added sash drawing to drawing packet



## **Appendix A**

### **Drawings**



# BILL OF MATERIALS

## WELDED TILT SINGLE HUNG (SHL21WW Keeperless)

<b>Molimo</b> Architectural Product Testing
Report #: 27587.01-109-12
Date: 11/2/2023
By: J. Allison

**NOTE: THIS BILL OF MATERIALS REFLECTS THE SYSTEM AS TESTED. DEVIATION FROM THE BILL OF MATERIALS IS NOT RECOMMENDED BY VEKA INC. AND MAY REDUCE THE PERFORMANCE OF THE FINISHED PRODUCT.**

<u>PVC PROFILES:</u>	<u>PART #</u>	<u># PER UNIT</u>	<u>SOURCE</u>
JAMBS	SHL21	2	VEKA
HEAD	SHL21	1	VEKA
SILL	SHL23	1	VEKA
KEEPER RAIL	SHS214	1	VEKA
STILES / BOTTOM RAIL	SHS25	3	VEKA
LOCK RAIL	SHS26	1	VEKA
BALANCE COVER	BC01	2	VEKA
GLAZING BEADS	BVP01	8	VEKA
INTERMEDIATE JAMB	SHL220	A/R	VEKA

**REINFORCING PROFILES:**

**NOTE:** Refer to test reports in technical manual for reinforcing guidelines.

JAMBS (SHL21)		A/R	
SILL (SHL23)		A/R	
KEEPER RAIL (SHS214)	RF SHS214 A0 M	A/R	OTHER
STILES / BOTTOM RAIL (SHS25)	RF SHS25 A0 M	A/R	OTHER
LOCK RAIL (SHS26)	RF SHS26 A0 M	A/R	OTHER
	RF SHS26 S0 M	A/R	VEKA

**HARDWARE:**

SWEEP LATCH	3174*	1-2	VISION
FLUSH MOUNT TILT LATCH ASSY	79910	1	ASHLAND
(STANDARD) OR	79915	1	ASHLAND
(WITH SCALLOP)	79920	1	ASHLAND
	79925	1	ASHLAND
BALANCE	INVERTED BLOCK AND TACKLE	2	AMESBURY
BALANCE SHOE		2	AMESBURY
PIVOT BAR		2	AMESBURY
DRYWALL CLIP	"L" BRACKET	2	HMS

**GLAZING:**

GLAZING SHIMS	5/8" X 5/8" X 1/8"	A/R	TREMCO
	5/8"x 5/8" x 1/8"	A/R	FRANK LOWE CO
GLAZING TAPE	1/16" X 1/2" (AWT)	A/R	ARLON
	1/16" X 1/2"	A/R	NORTON
	1/16" X 1/2"	A/R	VENTURE



# BILL OF MATERIALS

## WELDED TILT SINGLE HUNG (SHL21WW Keeperless)

**NOTE:** THIS BILL OF MATERIALS REFLECTS THE SYSTEM AS TESTED. DEVIATION FROM THE BILL OF MATERIALS IS NOT RECOMMENDED BY VEKA INC. AND MAY REDUCE THE PERFORMANCE OF THE FINISHED PRODUCT.

<u>GLAZING:</u>	<u>PART #</u>	<u># PER UNIT</u>	<u>SOURCE</u>
SILICONE SEALANT	NOVAFLEX**	A/R	NOVAGUARD
LIQUID BACK BEDDING	SBC1M150	A/R	NOVAGUARD
SILICONE	896	A/R	PECORA
	5733	A/R	SCHNEE MOREHEAD
	899	A/R	DOW CORNING

### WEATHERSTRIPPING:

WEATHERPILE	.260-.187	FS7825-187 (WHITE)	A/R	SCHLEGEL
	.260-.187	3026W (WHITE)	A/R	ULTRAFAB
	.260-.187	26018758WHWF (WHITE)	A/R	AMESBURY

### SCREWS:

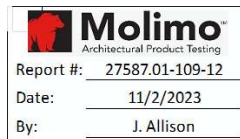
**NOTE:** All screws are zinc plated or stainless steel sheet metal type, unless otherwise noted.

SWEEP LATCH		#6 X 3/4" FHP **	2-4	MERCHANTS
BALANCE		#8 X 1" FHP	2	MERCHANTS
PIVOT BAR		#6 X 3/8" TYPE F TRUSS HD	4	MERCHANTS
KEEPER RAIL		#6 X 1-1/2" THP	4	MERCHANTS
DRYWALL CLIP				
(CLIP TO JAMB)		#6 X 3/4" FHP	4	MERCHANTS
(CLIP TO KEEPER RAIL)		GRADE 10 #44	4	MERCHANTS
		BLIND RIVET		

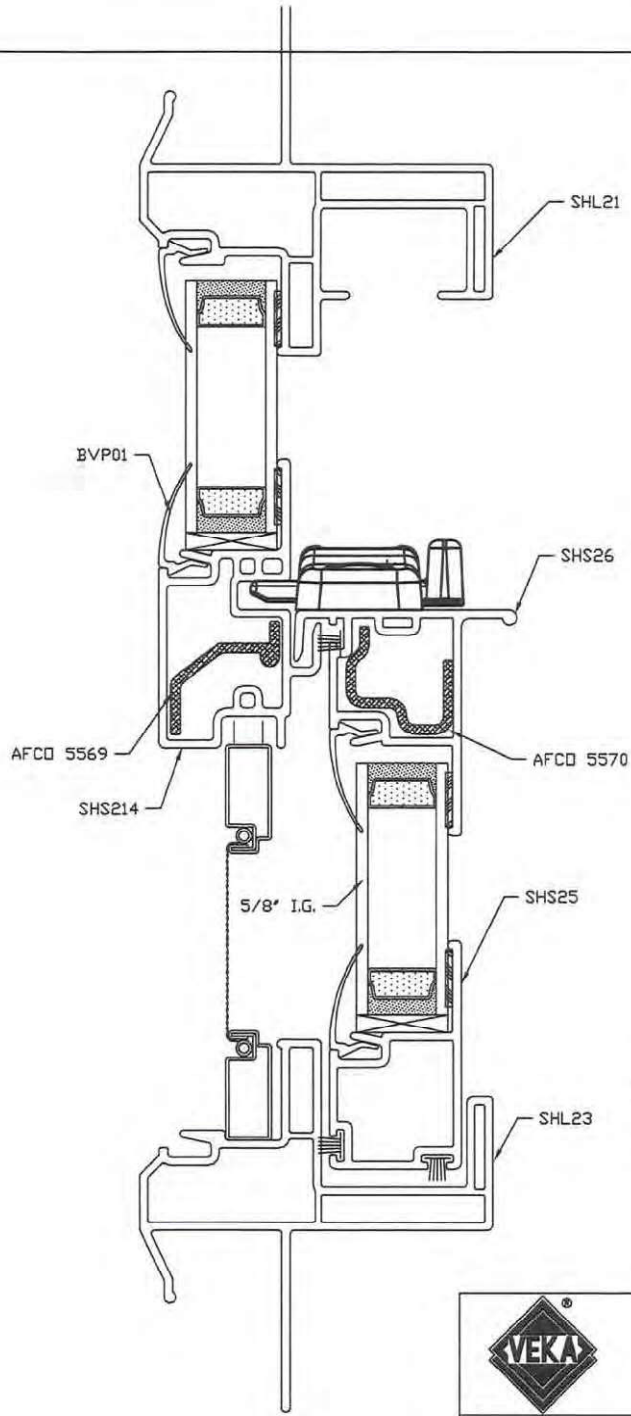
\*\* = COLOR

A/R = AS REQUIRED

04/21/2016  
REV.5/24/16

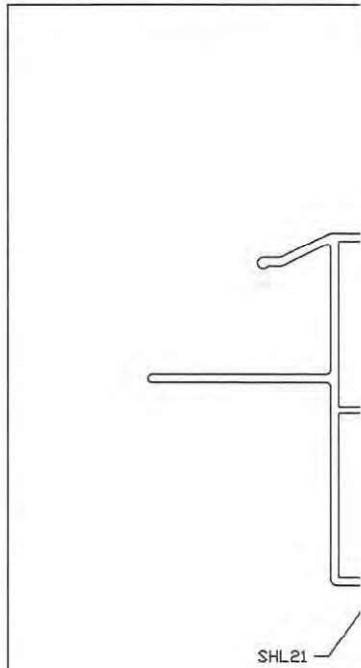


**NOTE:**  
 FOR OTHER PROFILE, GLAZING BEAD,  
 & GLASS OPTIONS, PLEASE SEE THE  
 LINEAL PROFILE CHARTS FOR THIS  
 SYSTEM.



**Molimo**  
 Architectural Product Testing  
 Report #: 27587.01-109-12  
 Date: 11/2/2023  
 By: J. Allison

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POCAHONTAS

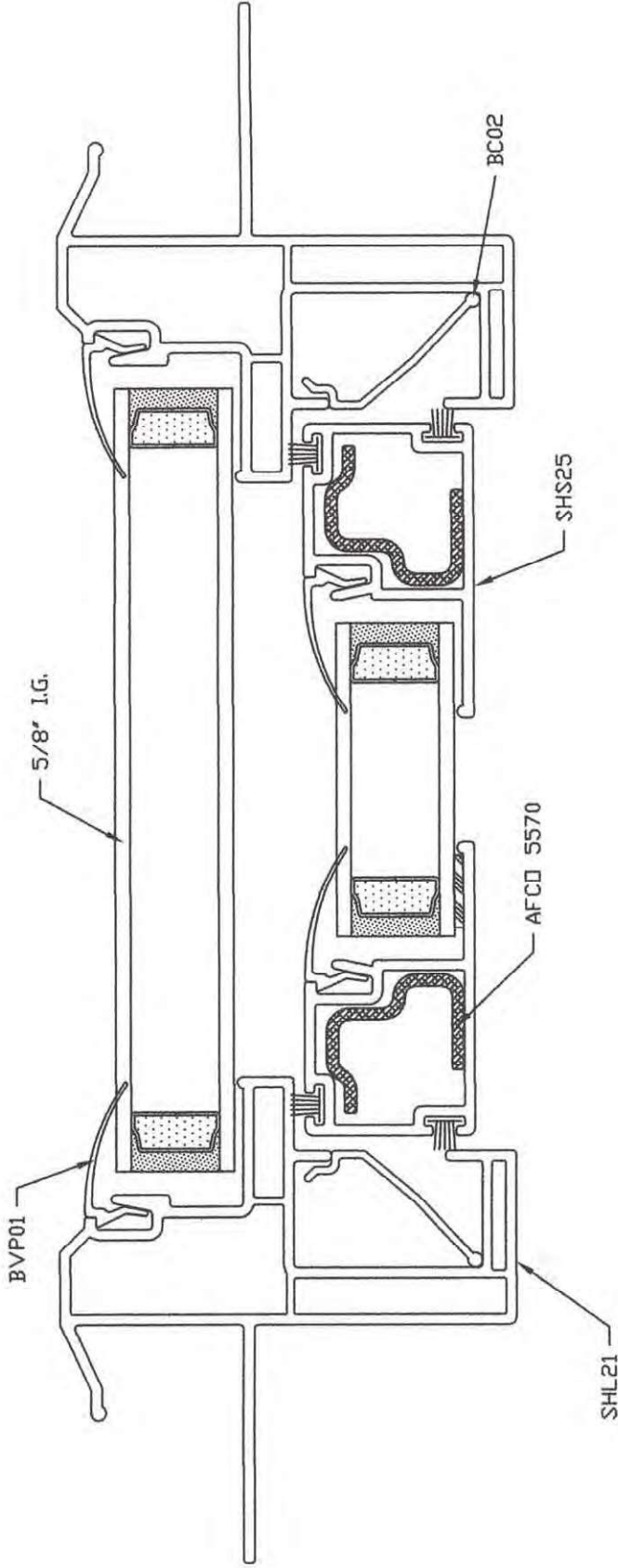


**VEKA INC.**  
 100 VEKA DRIVE  
 FOMBELL, PA 16123

DRAWN: BJF	DATE: 14 DEC 15	SCALE: FULL
CHK'D:	DATE:	APPVD:
TITLE SINGLE HUNG SHL21WW VERTICAL ASSEMBLY		DWG. #SHL21WW KL

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NOTE:  
 FOR OTHER PROFILE, GLAZING BEAD,  
 & GLASS OPTIONS, PLEASE SEE THE  
 LINEAL PROFILE CHARTS FOR THIS  
 SYSTEM.



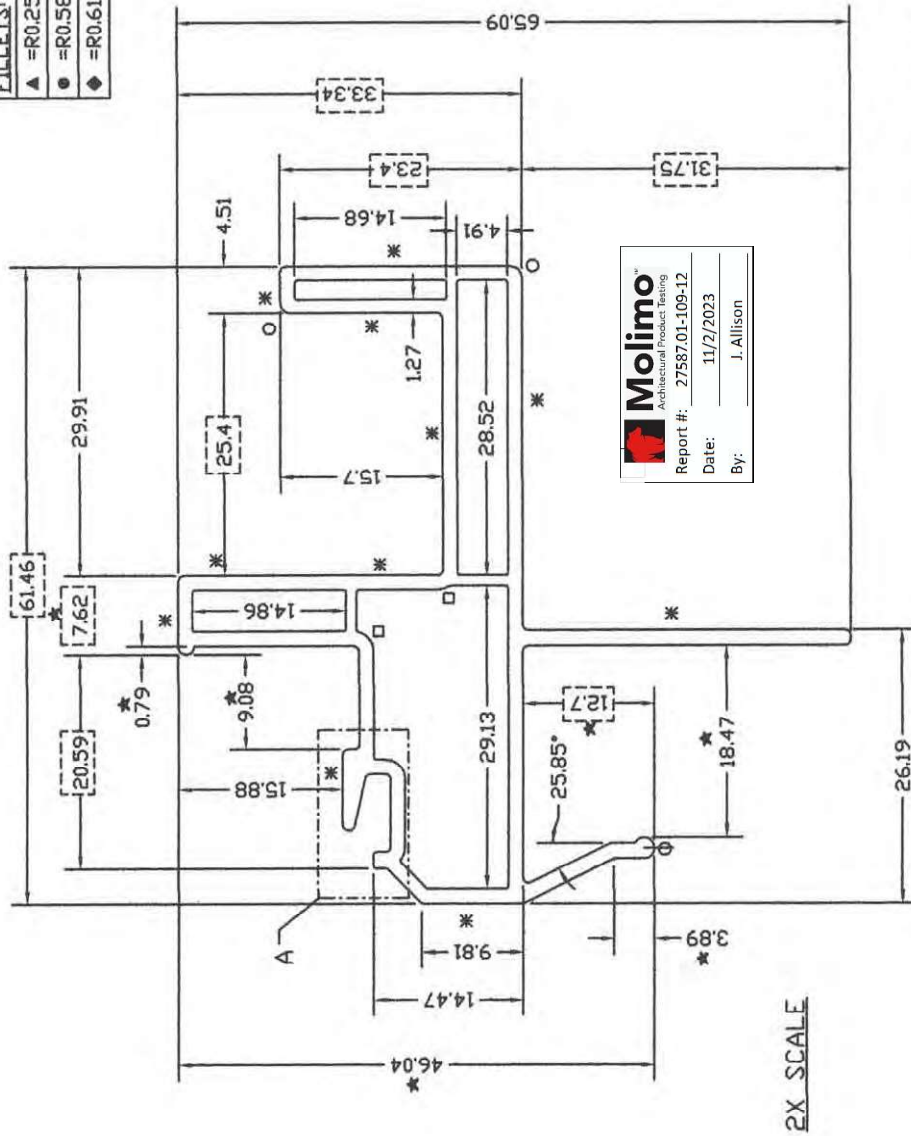
VEKA INC.  
 100 VEKA DRIVE  
 FOMBELL, PA 16123

DRAWN: BJF	DATE: 14 DEC 15	SCALE: FULL
CHK'D:	DATE:	APPV'D:
TITLE: SINGLE HUNG SHL21WW / HORIZONTAL ASSEMBLY		
DWG. # SHL21WW KL		

	Report #:	27587.01-109-12
	Date:	11/2/2023
	By:	J. Allison

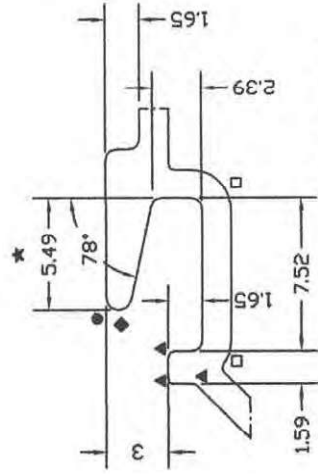
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FILLETS:	
▲ =R0.25	■ =R0.79
● =R0.58	○ =R0.99
◆ =R0.61	□ =R1.91



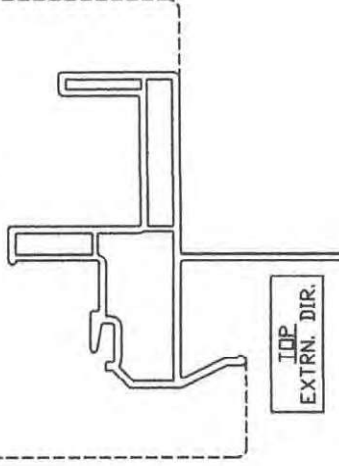
**Molimo**  
Architectural Product Testing  
Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

DETAIL A  
4X SCALE



BOTTOM  
EXTRN. DIR.

VISIBLE  
SURFACE



FULL SCALE

MATERIAL: RIGID PVC



VEKA INC.  
100 VEKA DRIVE  
FOMBELL, PA 16123

DRAWN: JMN	DATE: 4 AUG 00	SCALE: AS NOTED
CHK'D:	DATE:	APPV'D:
TITLE SINGLE HUNG SILL		DWG. # SHL23

\* = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

REVISIONS	DATE

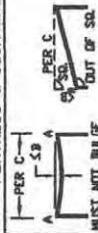
EXTRUDER SIZE: CM-55 EXTRUDER SPEED: 2.5 M/min.  
WEIGHT: 0.381 lb/ft AREA: 389.54mm<sup>2</sup>  
UNSPECIFIED WALL THICKNESS OUTER 1.4 mm INNER 1.02 mm  
UNSPECIFIED RADII EXT. 0.51 UNSPECIFIED RADII INT. 0.25  
UNSPECIFIED TOLERANCE ± 0.2 mm

DIMENSIONS ARE IN MILLIMETERS.

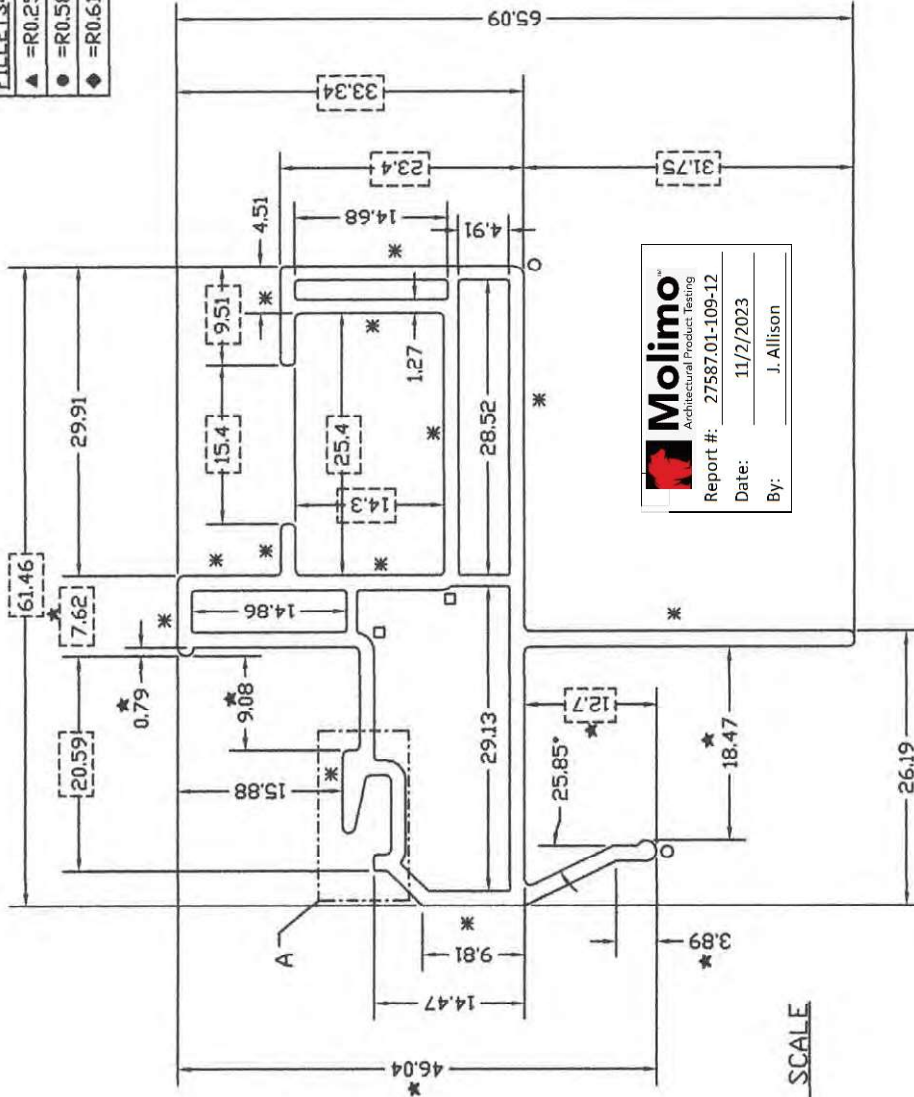
NOTE: ALL DIMENSIONS CAN BE ASSUMED AS ORIGINATING FROM SHARP CORNERS, UNLESS NOTED OTHERWISE.

□ = CRITICAL DIMENSION

W = FLATNESS & SQUARENESS CRITICAL  
 A → PER C →  
 B → PER C →  
 C → PER C →  
 PER C PER 100mm  
 0.5 0.054 PER 100mm  
 5.20mm 130mm  
 5.16mm 105mm  
 5.07mm 45mm  
 MUST NOT BULGE PAST AA

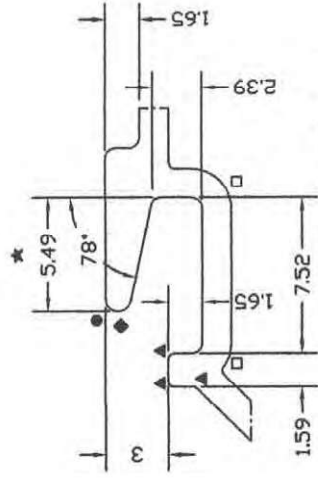


FILLETS:	
▲ = R0.25	■ = R0.79
● = R0.58	○ = R0.99
◆ = R0.61	□ = R1.91



2X SCALE

DETAIL A  
4X SCALE



VISIBLE SURFACE

BOTTOM  
EXTRN. DIR.

TOP  
EXTRN. DIR.

FULL SCALE

**Molimo**  
Architectural Product Testing  
Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

\* = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

DIMENSIONS ARE IN MILLIMETERS.

NOTE: ALL DIMENSIONS CAN BE ASSUMED AS ORIGINATING FROM SHARP CORNERS, UNLESS NOTED OTHERWISE.

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☐ = CRITICAL DIMENSION

\* = FLATNESS & SQUARENESS CRITICAL

—PER C—  
A 1.9  
B 5.054 PER 100mm  
C 5.20mm, 130mm  
D 5.16mm, 105mm  
E 5.07mm, 45mm

PER C  
PER D  
PER E  
PER F  
PER G  
PER H  
PER I  
PER J  
PER K  
PER L  
PER M  
PER N  
PER O  
PER P  
PER Q  
PER R  
PER S  
PER T  
PER U  
PER V  
PER W  
PER X  
PER Y  
PER Z

MUST NOT BULGE OUT OR SOFTEN PAST AA

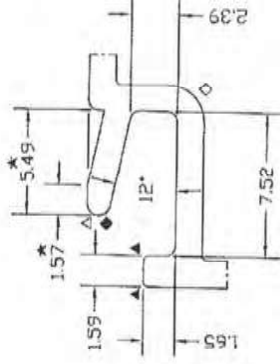
MATERIAL: RIGID PVC



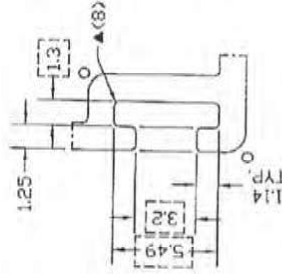
VEKA INC.  
100 VEKA DRIVE  
FOMBELL, PA 16123

DRAWN: JMN	DATE: 3 AUG 00	SCALE: AS NOTED
CHK'D:	DATE:	APPV'D:
TITLE SINGLE HUNG FRAME		DWG. # SHL21

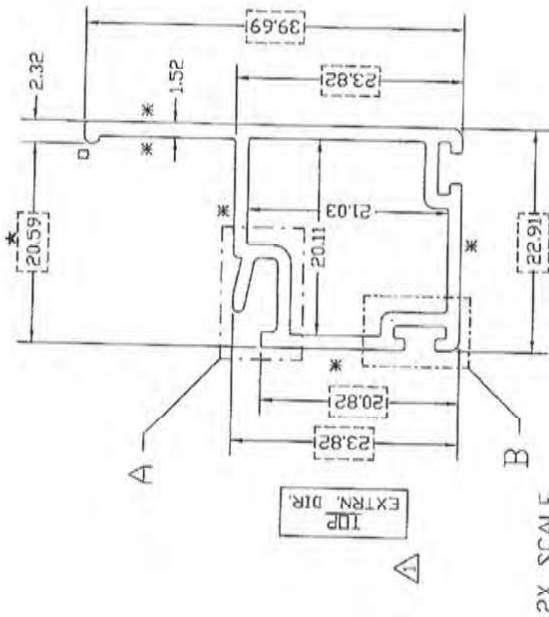
FILLETS:	
▲ =R0.25	◻ =R0.75
△ =R0.58	◇ =R1.91
◆ =R0.6	○ =R1.02



DETAIL A  
4X SCALE



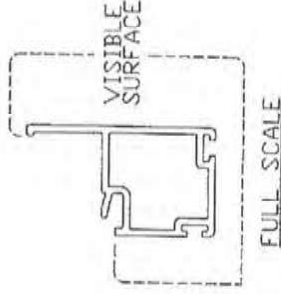
DETAIL A  
4X SCALE  
TYPICAL



2X SCALE

TOP DIR.

BOTTOM DIR.



FULL SCALE

\* = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

DIMENSIONS ARE IN MILLIMETERS.

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K = FLATNESS & SQUARENESS CRITICAL	
PER C-1	PER C-2
PER C-3	PER C-4
PER C-5	PER C-6
PER C-7	PER C-8
PER C-9	PER C-10
PER C-11	PER C-12
PER C-13	PER C-14
PER C-15	PER C-16
PER C-17	PER C-18
PER C-19	PER C-20
PER C-21	PER C-22
PER C-23	PER C-24
PER C-25	PER C-26
PER C-27	PER C-28
PER C-29	PER C-30
PER C-31	PER C-32
PER C-33	PER C-34
PER C-35	PER C-36
PER C-37	PER C-38
PER C-39	PER C-40
PER C-41	PER C-42
PER C-43	PER C-44
PER C-45	PER C-46
PER C-47	PER C-48
PER C-49	PER C-50
PER C-51	PER C-52
PER C-53	PER C-54
PER C-55	PER C-56
PER C-57	PER C-58
PER C-59	PER C-60
PER C-61	PER C-62
PER C-63	PER C-64
PER C-65	PER C-66
PER C-67	PER C-68
PER C-69	PER C-70
PER C-71	PER C-72
PER C-73	PER C-74
PER C-75	PER C-76
PER C-77	PER C-78
PER C-79	PER C-80
PER C-81	PER C-82
PER C-83	PER C-84
PER C-85	PER C-86
PER C-87	PER C-88
PER C-89	PER C-90
PER C-91	PER C-92
PER C-93	PER C-94
PER C-95	PER C-96
PER C-97	PER C-98
PER C-99	PER C-100

[ ] = CRITICAL DIMENSION

1.	REVISE	EXTRUSION DIRECTION	REVISIONS	DATE
				5 OCT 00
EXTRUDER SIZE: CM-SS EXTRUDER SPEED: 3.0 m/min				
WEIGHT: 0.166 lb/ft AREA: 169.20mm <sup>2</sup>				
UNSPECIFIED WALL THICKNESS: 1.4mm				
UNSPECIFIED RADI: INT. 0.25mm				
UNSPECIFIED RADI EXT. 0.51mm				
UNSPECIFIED TOI FRANCF # 0.2mm				



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100 VEKA DRIVE  
FOMBELL, PA 16123

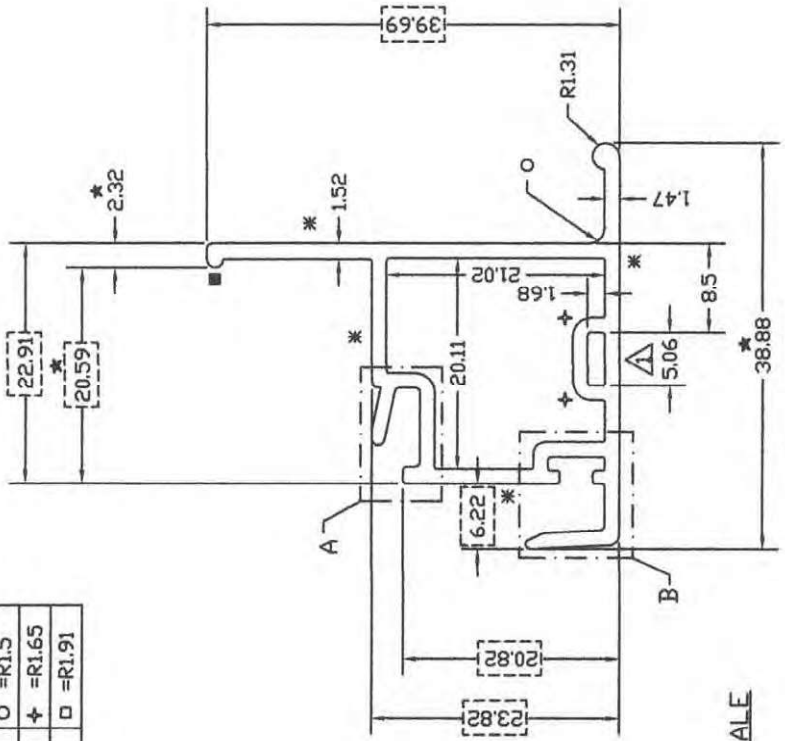
DRAWN: JMN	DATE: 7 AUG 00	SCALE: AS NOTED
CHK'D:	DATE:	APPVD:
TITLE COMMON SASH		DWG. # SHS25

MATERIAL: RIGID PVC



FILLETS:	■ = R0.79
▲ = R0.25	△ = R1.02
◇ = R0.38	○ = R1.5
● = R0.58	⊕ = R1.65
◆ = R0.61	□ = R1.91

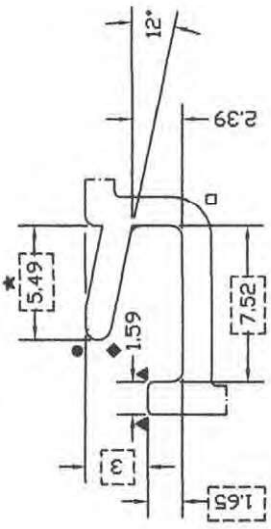
TOP  
EXTRN. DIR.



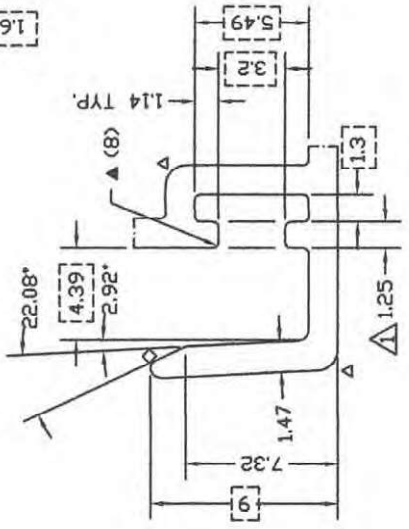
BOTTOM  
EXTRN. DIR.

2X SCALE

DETAIL A  
4X SCALE

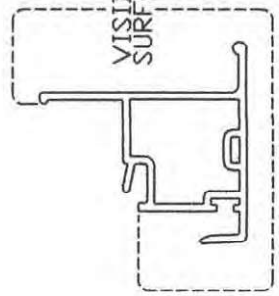


DETAIL B  
4X SCALE



VISIBLE  
SURFACE

FULL SCALE



**Molimo**  
Architectural Product Testing

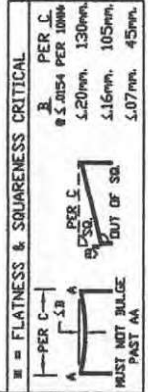
Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

\* = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

DIMENSIONS ARE METRIC.

NOTE: ALL DIMENSIONS CAN BE ASSUMED AS ORIGINATING FROM SHARP CORNERS, UNLESS NOTED OTHERWISE.

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□ = CRITICAL DIMENSION

■ = FLATNESS & SQUARENESS CRITICAL

REVISIONS	DATE
1. REVISE DIM. 124 TO 1.5, 5.05 TO 5.06	15 SEPT 98 JMN

EXTRUDER SIZE: CM-55 EXTRUDER SPEED: 6.0 m/min  
WEIGHT: 0.209 lb/ft AREA: 213.35mm<sup>2</sup>  
UNSPECIFIED WALL THICKNESS: 1.4mm  
UNSPECIFIED RADIUS: 0.51mm UNSPECIFIED TOLERANCE: ±0.2mm

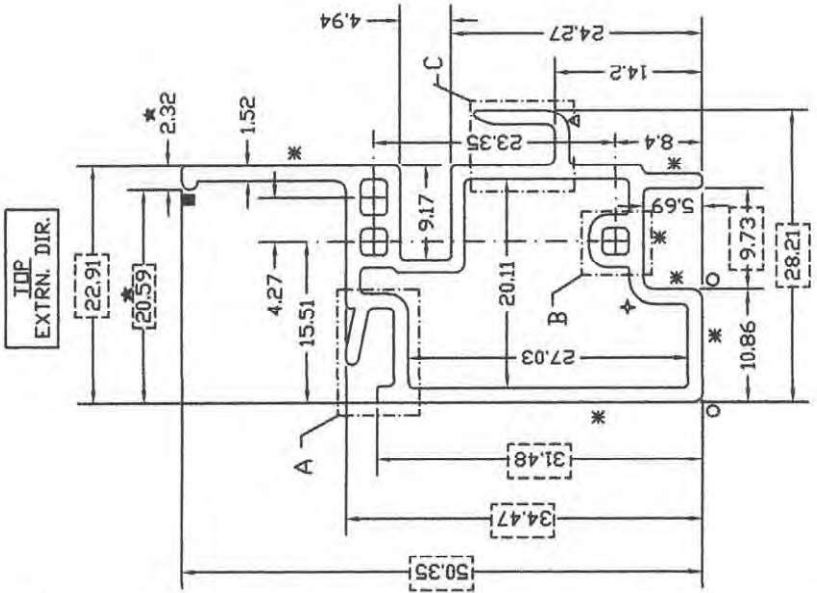


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FOMBELL, PA 16123

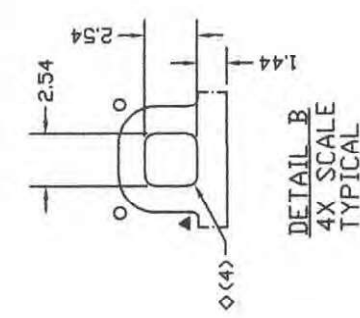
DRAWN: JMN	DATE: 17 AUG 98	SCALE: AS NOTED
CHK'D:	DATE:	APPV'D:
TITLE LOCK RAIL		
DWG. # SHS26		

MATERIAL: RIGID PVC

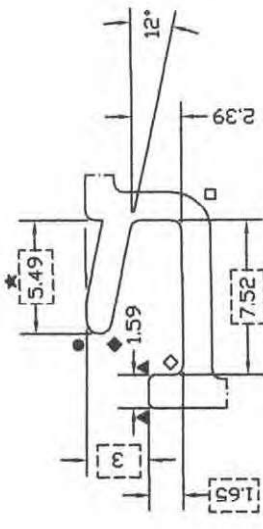
FILLETS:	
▲ = R0.25	■ = R0.79
◇ = R0.51	□ = R1.91
● = R0.58	○ = R1.78
◆ = R0.61	△ = R2.16
⊠ = R0.76	⊕ = R2.39



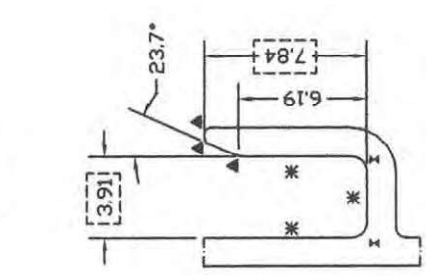
2X SCALE



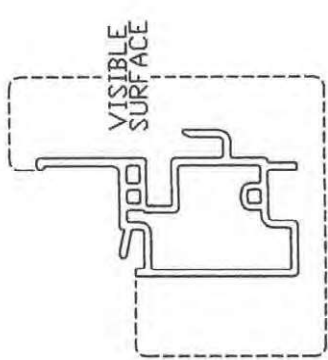
DETAIL B  
4X SCALE  
TYPICAL



DETAIL A  
4X SCALE



DETAIL C  
4X SCALE



FULL SCALE

**Molimo**  
Architectural Product Testing

Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

\* = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

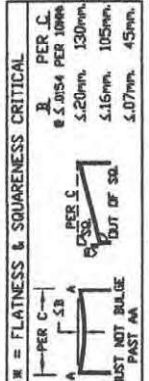
TOP EXTRN. DIR.

BOTTOM EXTRN. DIR.

DIMENSIONS ARE METRIC.

NOTE: ALL DIMENSIONS CAN BE ASSUMED AS ORIGINATING FROM SHARP CORNERS, UNLESS NOTED OTHERWISE.

CRITICAL DIMENSION



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FOMBELL, PA 16123

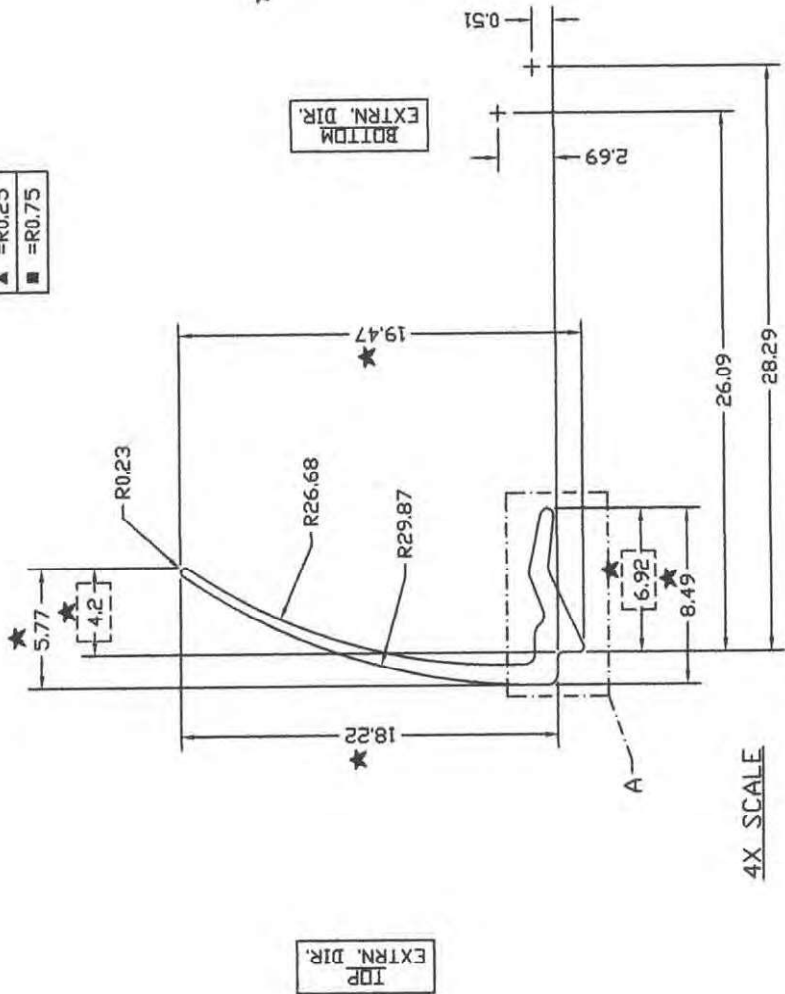
MATERIAL: RIGID PVC

DRAWN: SMB	DATE: 14 OCT 15	SCALE: AS NOTED
CHK'D:	DATE:	APPVD:
TITLE: FIXED MEETING RAIL (KEEPERLESS)		DWG. # SHS214

REVISIONS	DATE

EXTRUDER SIZE: EXTRUDER SPEED:  
WEIGHT: 0.247 lb/ft AREA: 252.2mm<sup>2</sup>  
UNSPECIFIED WALL THICKNESS OUTER: 1.4mm INNER: 1.27mm  
UNSPECIFIED RADI: 0.5mm UNSPECIFIED TOLERANCE: ±0.2mm

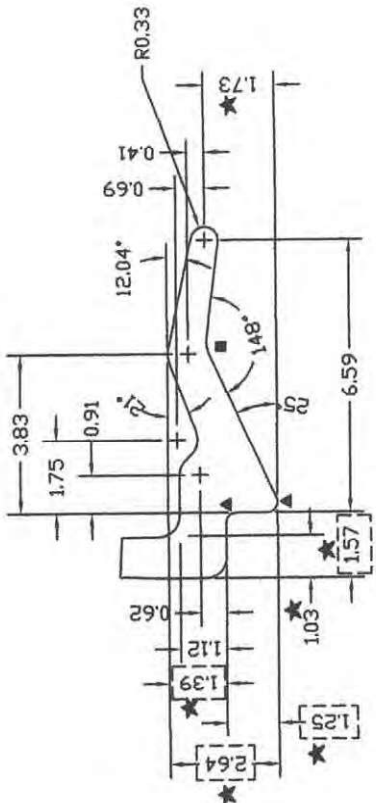
FILLETS:	
▲	=R0.25
■	=R0.75



TOP EXTRN. DIR.

BOTTOM EXTRN. DIR.

4X SCALE



DETAIL A  
8X SCALE



▲▲ FULL SCALE

**Molimo**  
Architectural Product Testing

Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

MATERIAL: RIGID PVC  
NOTE: DIMENSIONS ARE IN MILLIMETERS

★ = DIMENSION TAKEN FROM FURTHEST POINT ON RADIUS

REVISIONS	DATE
3. REVISE AREA/ WEIGHT	18 DEC 95 JMN
2. REVISE PROFILE	18 DEC 95 JMN
1. CHANGE PROFILE NUMBER BV40 TO BV/P01	9 AUG 95

EXTRUDER SIZE: CH35 DOUBLE DIE EXTRUDER SPEED: 10 M./min.  
WEIGHT: .021 lb/ft AREA: 21.45 mm.<sup>2</sup>  
UNSPECIFIED WALL THICKNESS N.A.  
UNSPECIFIED RADII 0.5mm UNSPECIFIED TOLERANCE ±0.3mm

[- -] = CRITICAL DIMENSION

NOTE: ALL DIMENSIONS CAN BE ASSUMED AS ORIGINATING FROM FILLETED CORNERS OF ZERO, UNLESS NOTED OTHERWISE.

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DRAWN: JJS	DATE: 27 MAY 94	SCALE: AS NOTED
CHK'D:	DATE:	APPVD:
TITLE GLAZING BEAD 3/4" GLASS		DWG. # BV/P01

FINISH()  
2PC()

DIE NO.  
**M-15272**

X" PRESS

BKR. NO.

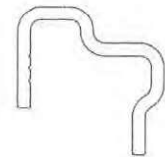
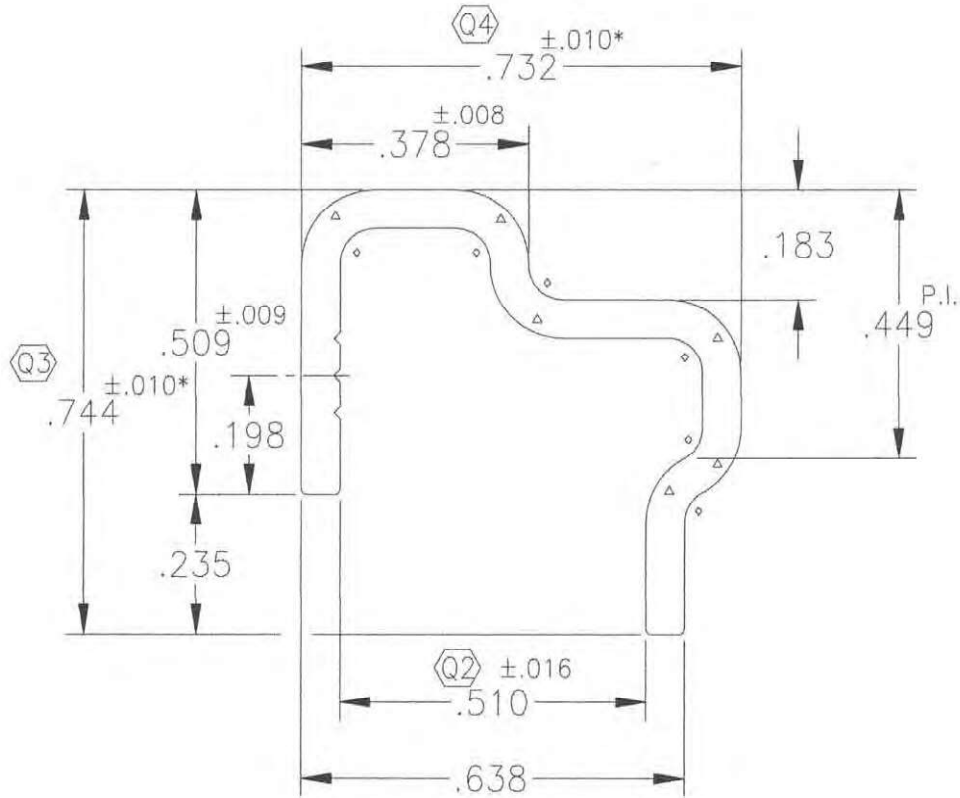
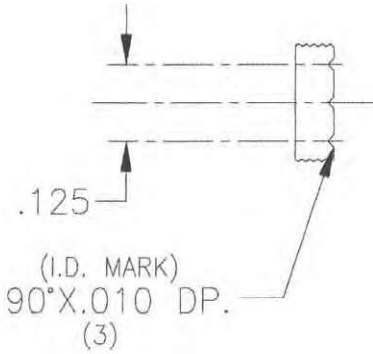
BOLS. NO.

FDR. PLT.

EXT. RATIO

.058 R.-( $\diamond$ ) (6)  
.122 R.-( $\triangle$ ) (6)

**Molimo**  
Architectural Product Testing  
Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison



ACTUAL SIZE

Q1

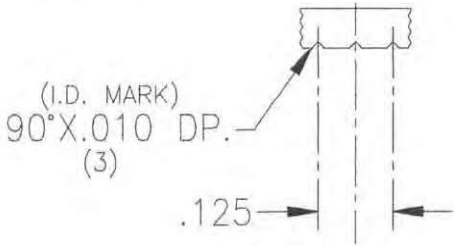
NOTES:  $\pm.006$

- .064 TYP. WALL THKN. EXCEPT AS NOTED.
- BREAK SHARP CORNERS AT .010 R.
- NO EXPOSED SURFACES

				<b>tel TOWER EXTRUSIONS, LTD.</b> WYLIE, TX			
				NAME <b>POCAHONTAS</b>			
				PART NO. AF-5570		DWG. NO. D-062320-02	
				END USE STIFFNER FOR LOCK RAIN			
				CLASS SOLID		ALLOY 6063-T5	CAVITY
						DIE NO. M-15272	
ALUMINUM ASSOCIATION STANDARD TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED							
ST. REA	.111	TOTAL PERIM.	3.611	DATE:	06-23-20	DRAWN BY: S. BATALLA	
ST. T/FT.	.133	CIRCLE SIZE	0.93	HOLES		PREF. PRESS	
OUTSIDE DIM.	3.611	FACTOR	97	DIE SIZE		SCALE	3:1 P

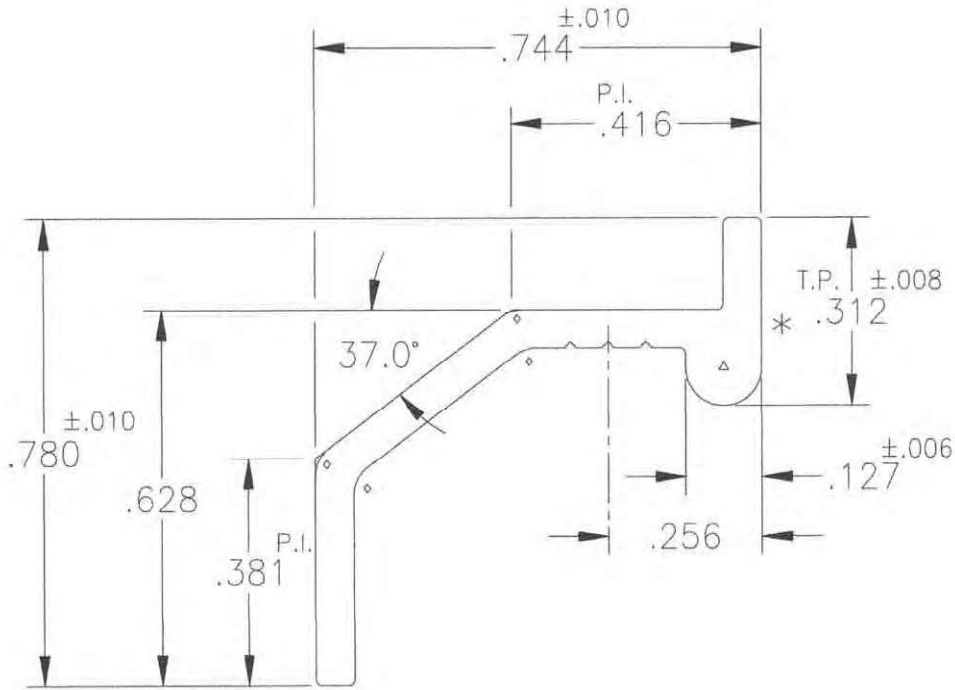
\* STRUCTURAL AND/OR HEAT STREAKS ARE POSSIBLE IN THIS AREA AND MAY NOT BE REASON FOR REJECTION.

FINISH()  
2PC()



**Molimo**  
Architectural Product Testing  
Report #: 27587.01-109-12  
Date: 11/2/2023  
By: J. Allison

DIE NO.	M-15271
X" PRESS	
BKR. NO.	
BOLS. NO.	
FDR. PLT.	
EXT. RATIO	
.058 R.-(◇) (4)	
.063 R.-(△) (1)	



ACTUAL SIZE

Q1

- NOTES: ±.006
1. .064 TYP. WALL THKN. EXCEPT AS NOTED.
  2. BREAK SHARP CORNERS AT .010 R.
  3. NO EXPOSED SURFACES

				<b>tel TOWER EXTRUSIONS, LTD.</b> WYLIE, TX			
				NAME <b>POCAHONTAS</b>			
ALUMINUM ASSOCIATION STANDARD TOLERANCES TO APPLY UNLESS OTHERWISE SPECIFIED				PART NO. AF-5569		DWG. NO. D-062320-01	
ST. REA	.094	TOTAL PERIM.	2.866	DATE:	06-23-20	DRAWN BY: S. BATALLA	
ST. T/FT.	.113	CIRCLE SIZE	1.07	HOLES		PREF. PRESS	
UTSIDE	2.866	FACTOR	25	DIE SIZE		CLASS	SOLID
				SCALE	3:1	ALLOY	6063-T5
				END USE STIFFNER FOR FIXED INTERLOCK			
						CAVITY	
						DIE NO. M-15271	