



## TEST REPORT

**Report No.:** F1393.01-801-44

**Rendered to:**

POCAHONTAS ALUMINUM COMPANY, INC.  
Pocahontas, Arkansas

**PRODUCT TYPE:** Insulated Side-Hinged Door  
**SERIES/MODEL:** DD 100

**SPECIFICATION:**

*AAMA 1702.2-02, Voluntary Standard for Utilization in Manufactured Housing for Swinging Exterior Passage Doors.*

*ASTM E 330-02, Test Method for Structural Performance of Exterior Windows, Curtain Walls and Doors by Uniform Static Air Pressure Difference.*

**Test Date:** 09/24/15  
**Report Date:** 10/06/15  
**Record Retention End Date:** 09/24/19

**1.0 Report Issued To:** Pocahontas Aluminum Company, Inc.  
2001 Industrial Drive P.O Box 756  
Pocahontas, Arkansas 72455

**2.0 Test Laboratory:** Intertek-ATI  
1909 10<sup>th</sup> Street Suite 100  
Plano, Texas  
(469) 814-0687

**3.0 Project Summary:**

**3.1 Product Type:** Insulated Side-Hinged Door

**3.2 Series/Model:** DD 100

**3.3 Compliance Statement:** Results obtained are tested values and were secured by using the designated test method(s). The sample tested successfully met the performance requirements listed in the referenced specification(s).

**3.4 Test Date:** 09/24/2015

**3.5 Test Record Retention End Date:** All test records for this report will be retained until September 24, 2019.

**3.6 Test Location:** Intertek-ATI testing facility in Plano, Texas.

**3.7 Test Sample Source:** The test specimen was provided by the client.

**3.8 List of Official Observers:**

<u>Name</u>	<u>Company</u>
Clint Barnett	Architectural Testing, Inc.
Ken Akins	Pocahontas Aluminum Company

**4.0 Test Specification(s):**

*AAMA 1702.2-02, Voluntary Standard for Utilization in Manufactured Housing for Swinging Exterior Passage Doors.*

*ASTM E 330-02, Test Method for Structural Performance of Exterior Windows, Curtain Walls and Doors by Uniform Static Air Pressure Difference.*

**5.0 Test Specimen Description:**

**5.1 Product Sizes:**

**Test Specimen**

Overall Area: 1.8 m <sup>2</sup> (20 ft <sup>2</sup> )	Width		Height	
	millimeters	inches	millimeters	inches
Overall size	914	36	2032	80
Door Leaf	914	36	2032	80

**5.2 Frame Construction:**

Frame Member	Material	Description
All members	Aluminum	Extruded Aluminum

	Joinery Type	Detail
All corners	Mitered & Welded	Thermally Welded

**5.0 Test Specimen Description: (Continued)**

**5.3 Leaf Construction:**

The 1-1/2" thick leaf was constructed of 1-3/8" thick foam with 1-3/8" wide by 3/4" high solid reinforcement along top and bottom rails and stiles. The reinforcement along the head and the lock stile was made of wood, with the remaining reinforcements made of cellular pvc. A 1/16" thick embossed fiberglass skin was utilized on the exterior and interior and was secured to the foam with glue. Leaf frame was formed from extruded aluminum members. Frame corners were coped, butted, and mechanically fastened using two #6 x 1" pan head Phillips screws. The interior of the exterior leg of the frame had vinyl fin weatherstripping inserted into it. The exterior leg of the frame was secured to the fiberglass skin with a sealant compound. A cellular PVC lock block was 4-1/4" x 15" x 1-3/8" thick.

Sash Member	Material	Description
All members	Aluminum	Extruded Vinyl

	Joinery Type	Detail
All corners	Coped & Butted	Sealed and secured with two #6 x 1" Phillips head screws.

**5.4 Weatherstripping:**

Description	Quantity	Location
0.110" x 0.160" pile	1 Row	Interior of exterior leg of leaf frame
0.187" x 0.250" pile	1 Row	Sash stile jamb face-interior lateral edge
0.187" x 0.250" pile	1 Row	Sash bottom rail sill face- interior lateral edge

**5.5 Glazing:** *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

Glass Type	Glazing	Glazing Method
Monolithic	1/8 Tempered	Interior Wet Glazed

Location	Quantity	Daylight Opening		Glass Bite
		millimeters	inches	
Door	1	486 x 889	19-1/8 x 35	0.50

### 5.0 Test Specimen Description: (Continued)

**5.6 Drainage:** No drainage was utilized.

### 5.7 Hardware:

Description	Quantity	Location
Handle with lock	1	Lock stile of door leaf
Strike plate	1	Midpoint of lock jamb
Single barrel hinge	6	On center from interior corner of sill at 4-1/2", 12", 36", 43-1/2", 67-1/2" and 75"

### 6.0 Installation:

The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/4" shim space.

Location	Anchor Description	Anchor Location
Nail fin	#6 x 1-5/8" screw	4" from each corner and 8" on center thereafter

**7.0 Test Results:** The temperature during testing was 27°C (81°F). The results are tabulated as follows:

### Test Specimen

Title of Test	Results	Allowed	Note
<b>Structural Performance,</b> per ASTM E 330 +1190 Pa (+25.0 psf) -595 Pa (-12.5 psf)	Pass	No damage	2, 3
<b>Air Leakage,</b> per ASTM E 283 at 75 Pa (1.57 psf)	0.10 L/s/m <sup>2</sup> (0.02 cfm/ft <sup>2</sup> )	2.5 L/s/m <sup>2</sup> (0.5 cfm/ft <sup>2</sup> ) max.	
<b>Water Penetration,</b> per ASTM E 547 at 140 Pa (2.92 psf)	Pass	No leakage	
<b>Optional Performance (24 CFR 3280.305(c))</b>			
<b>Uniform Load Structural,</b> per ASTM E 330 +2202 Pa (+46.00 psf) -2202 Pa (-46.00 psf)	Pass	No damage	2, 3
<b>Uniform Load Deflection,</b> per ASTM E 330 taken on lock stile +1440 Pa (+30.08 psf) -1440 Pa (-30.08 psf)	2 mm (0.06") 6 mm (0.24")	Report Only	1, 2, 3
<b>Uniform Load Structural,</b> per ASTM E 330 taken on lock stile +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	< 1 mm (<0.01") 1 mm (0.04")	8 mm (0.31") max. 8 mm (0.31") max.	1, 2, 3

*Note 1: With and without insect screen.*

*Note 2: Loads were held for 10 seconds.*

*Note 3: 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.*

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.

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 Architectural Testing, Inc.

For ARCHITECTURAL TESTING, Inc.

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Clint Barnett  
Technician

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Tyler Westerling, P.E.  
Senior Project Engineer

CB:ac/ms/ss

Attachments (pages): This report is complete only when all attachments listed are included.  
Appendix-A: Drawing(s) (9) Complete drawings packet on file with Architectural Testing, Inc.

## **APPENDIX A**

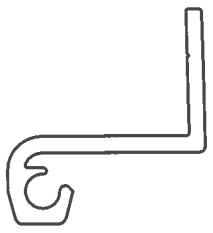
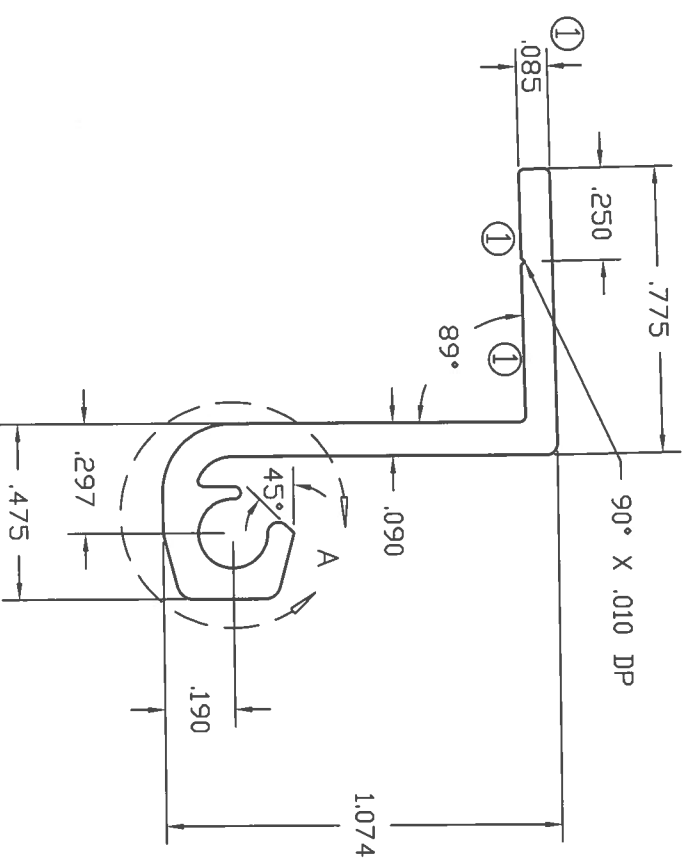
### **Drawings**



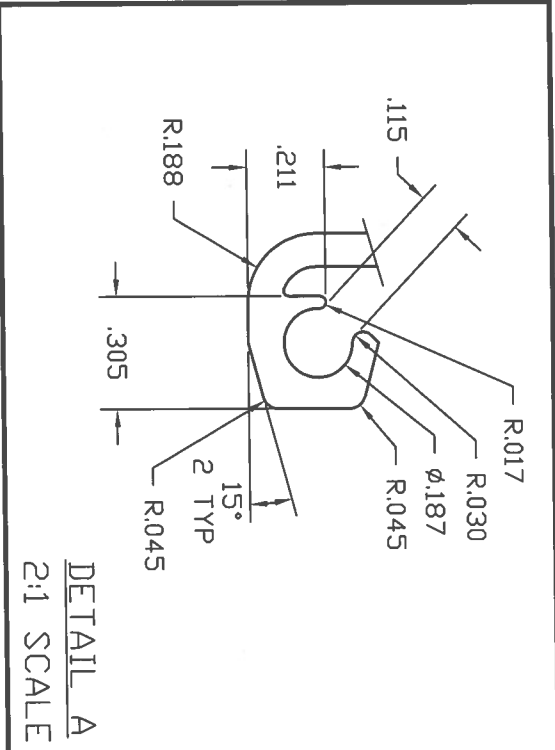


ALUMINUM ASSOCIATION STD TOLERANCES APPLY UNLESS NOTED  
 .090 TYP. WALL EXCEPT AS SHOWN. BREAK SHARP CORNERS .010

DIE NO. S-2913 REV 1



ACTUAL SIZE  
 ALL SURFACES EXPOSED



DETAIL A  
 2:1 SCALE



Architectural Testing, Inc  
 Test sample complies with  
 details shown herein. Any  
 deviations are noted in the  
 test report or drawings.

Report #: E1393.01  
 Date: 10/08/15 By: CB

REV	DESCRIPTION	DATE
1	REMOVE GROOVE AND ID MARK. .085 WAS .090	4/15/04 DLB

<input checked="" type="checkbox"/> SOLID <input type="checkbox"/> SEMI HOLLOW <input type="checkbox"/> HOLLOW CLASS		PART NO. HINGE	
AREA	WT/FT	QTY	SCALE
.216	.259	1.6	2:1
QTY	QTY	QTY	QTY
5.043	5.043	2913S	2913S
OUTSIDE PERIM	INSIDE PERIM	QTY	QTY
		SQ. IN.	SQ. IN.

**JORDAN**

P.O. BOX 18377  
 MEMPHIS, TN, 38118  
 PHONE (901) 363-2121

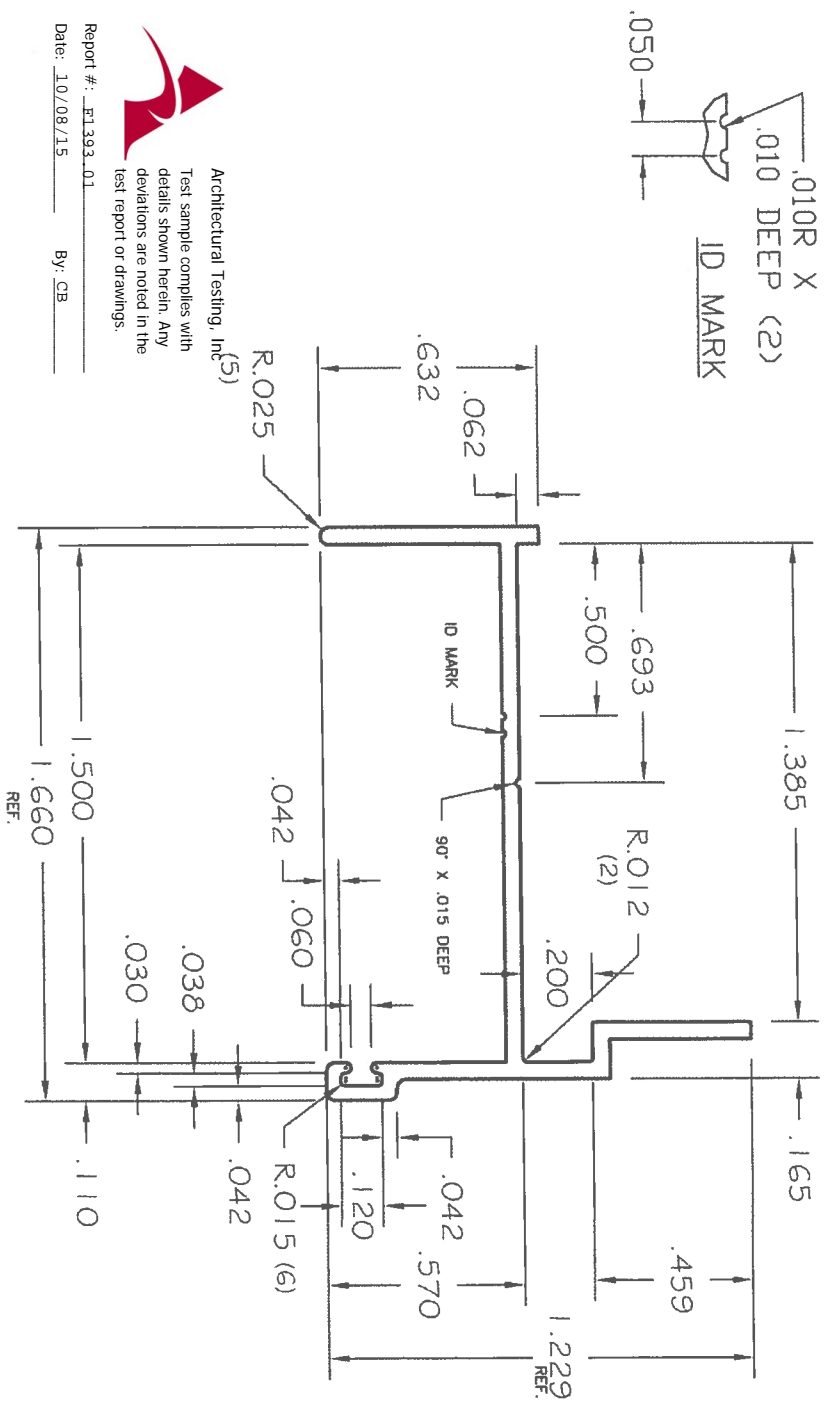
CUSTOMER  
 POCOCHONTAS

DATE 3/24/04

REV 1

DIE NO. S-3212

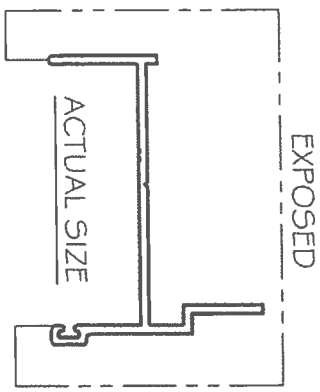
ALUMINUM ASSOCIATION STD TOLERANCES APPLY UNLESS NOTED  
 .050 TYP. WALL EXCEPT AS SHOWN. BREAK SHARP CORNERS .015R



Report #: E1393.01  
 Date: 10/08/15 By: CB



Architectural Testing, Inc. (ATI)  
 Test sample complies with details shown herein. Any deviations are noted in the test report or drawings.



KEY-SIONS		AREA		W/T		PERM		OUTSIDE PERM	
<input checked="" type="checkbox"/>	SOLID	<input type="checkbox"/>	SO. IN.	<input type="checkbox"/>	SO. IN.	<input type="checkbox"/>	SO. IN.	<input type="checkbox"/>	SO. IN.
	SO. HOLLOW		SO. IN.		SO. IN.		SO. IN.		SO. IN.
	HOLLOW GLASS		SO. IN.		SO. IN.		SO. IN.		SO. IN.
	ALLOY		SO. IN.		SO. IN.		SO. IN.		SO. IN.
	6063T5		SO. IN.		SO. IN.		SO. IN.		SO. IN.
	SCALE		SCALE		SCALE		SCALE		SCALE
	2.1		2.1		2.1		2.1		2.1
	DWG. NO.		DWG. NO.		DWG. NO.		DWG. NO.		DWG. NO.
	07062201		07062201		07062201		07062201		07062201
	POC		POC		POC		POC		POC
	DIE NO.		DIE NO.		DIE NO.		DIE NO.		DIE NO.
	S-3212		S-3212		S-3212		S-3212		S-3212

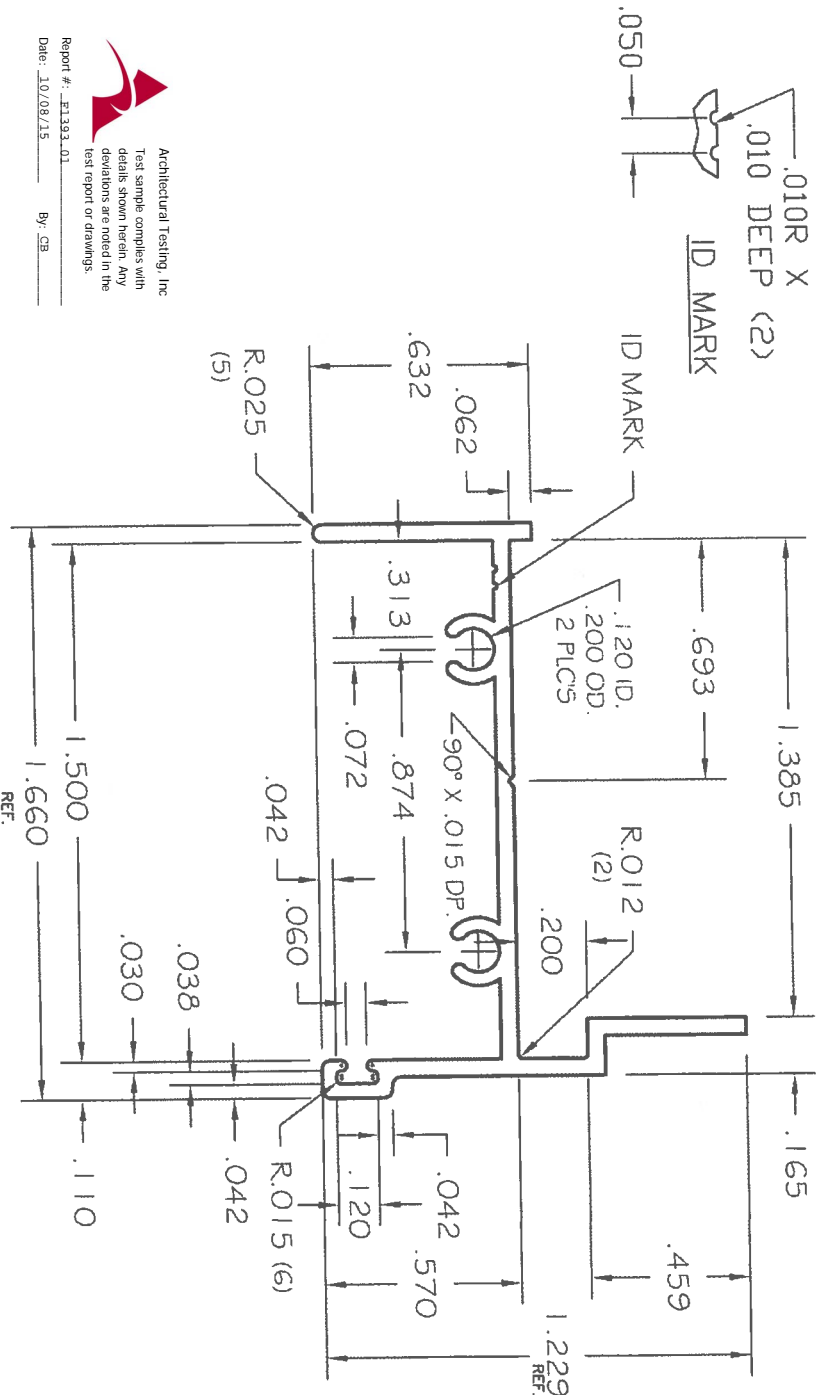
**JORDAN**

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 MEMPHIS, TN, 38118  
 PHONE (901) 363-2121

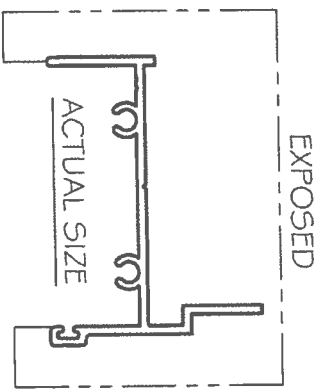
CUSTOMER: FOCALHONTAS ALUMINUM  
 PART NO.: DOOR INNER FRAME  
 Dwg. No.: 07062201  
 POC  
 DATE: 6/22/07

ALUMINUM ASSOCIATION STD TOLERANCES APPLY UNLESS NOTED  
 .050 TYP. WALL EXCEPT AS SHOWN. BREAK SHARP CORNERS .015R

DIE S-3213



Architectural Testing, Inc  
 Test sample complies with  
 details shown herein. Any  
 deviations are noted in the  
 test report or drawings.  
 Report #: AT393.01  
 Date: 10/08/15 By: GB

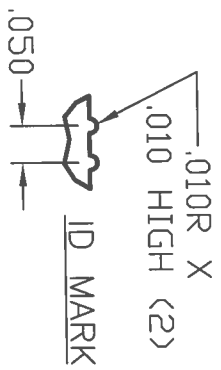
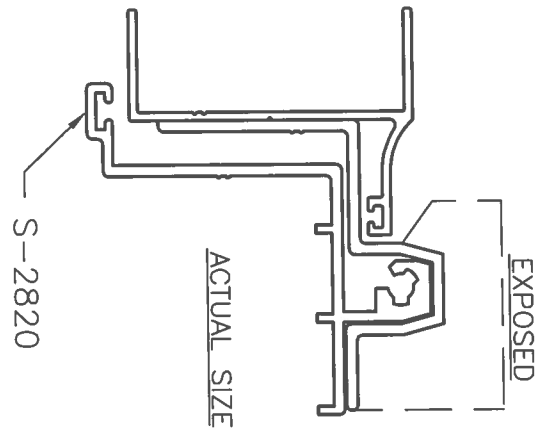
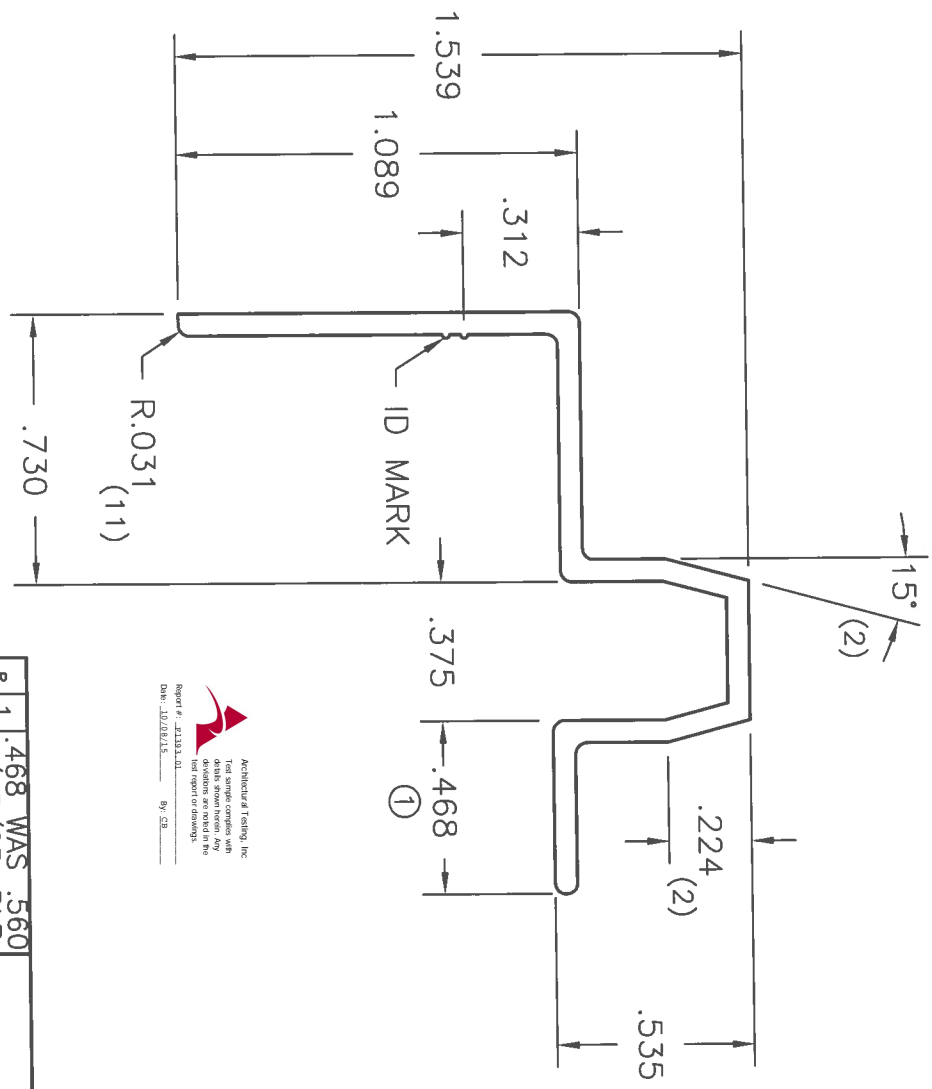


REVISIONS				<b>JORDAN</b>				CUSTOMER: POCAHONTAS ALUMINUM				
<input checked="" type="checkbox"/>	SOLID	<input type="checkbox"/>	SEMI HOLLOW	<input type="checkbox"/>	HOLLOW GLASS	PART NO.	END USE	SCALE	DWG. BY	DATE	DWG. NO.	DWG. DATE
	.203		.244		6063T5	INNER FRAME TOP AND BOTTOM	2:1	DLB		6/26/07	07062601 POC	S-3213
	WT/T	US	IN.	C.C.D.	IN.	QTY	IN.	QTY	IN.	QTY	IN.	QTY
	8.412			1.9								
	OUTSIDE PERM		INSIDE PERM		SQ. IN.							
REF: S-2720												

P.O. BOX 18377  
 MEMPHIS, TN, 38118  
 PHONE (901) 363-2121

ALUMINUM ASSOCIATION STD TOLERANCES APPLY UNLESS NOTED  
 .060 TYP. WALL EXCEPT AS SHOWN. BREAK SHARP CORNERS .010R

DIE NO. S-2832 R 1  
 V 1



Architectural Testing, Inc.  
 Test sample conforms with  
 details shown herein. Any  
 deviations are noted in the  
 test report or drawing.  
 Report # 41333-04 By: SBL  
 Date: 10/20/05

REV	DATE	BY	DESCRIPTION
1	4/68	WAS	.560
	6/13/05	DLB	

AREA	.205	SQ. IN.	ALLOW	6063T5
WT/FT	.246	LBS.	C.C.D.	2.0
PERIM	6.972	IN.	CAVITY SIZE	
OUTSIDE PERIM		IN.	CAVITY AREA	
			SQ. IN.	

<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
SOLID	SEMI HOLLOW	HOLLOW	CLASS

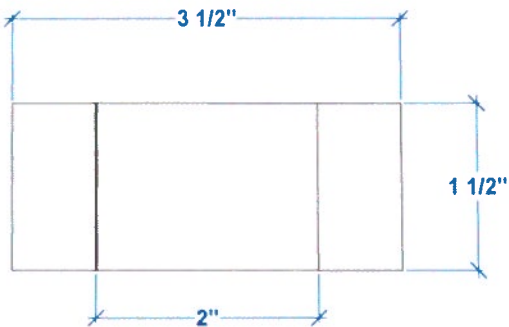
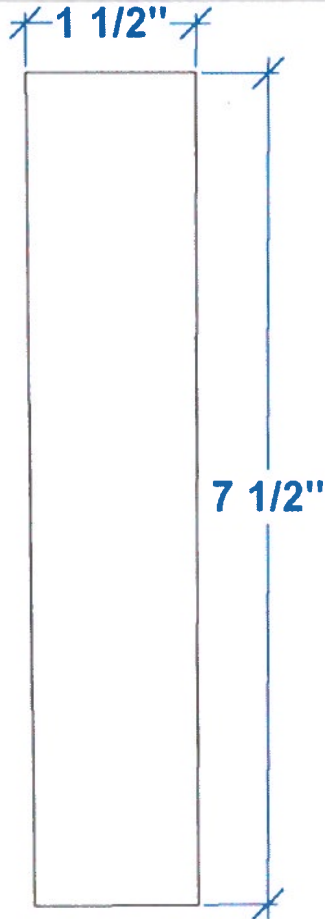
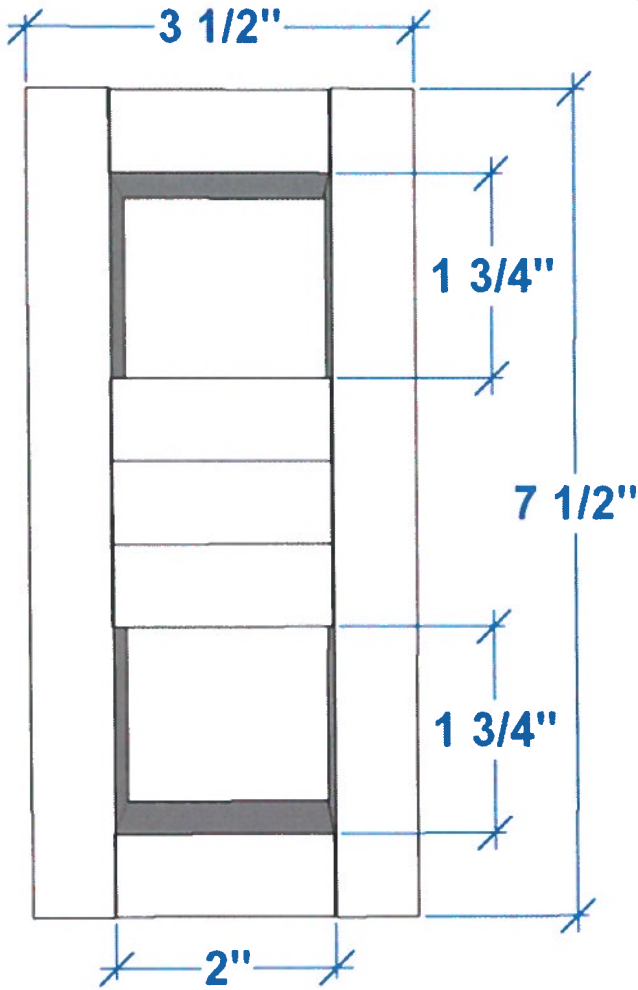
CUSTOMER	POCAHONTAS ALUMINUM
PART NO.	
END USE	SHIPPING CLIP FOR S-2820
SCALE	
DWG. NO.	03061401
DIE NO.	S-2832

P.O. BOX 18377
MEMPHIS, TN, 38118
PHONE (901) 363-2121

**JORDAN**

**PVC LOCK BLOCK**



Architectural Testing, Inc  
 Test sample complies with details shown herein. Any deviations are noted in the test report or drawings.

Report #: F1393\_01

Date: 10/08/15 By: CB

SCALE: NTS  
 DWN BY: AMM  
 CHK BY: KEA  
 DATE: 9/16/15

TITLE:  
 PVC LOCK BLOCK

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

COPYING OR  
 DUPLICATION IS  
 PROHIBITED WITHOUT  
 WRITTEN PERMISSION  
 FROM POCAHONTAS  
 ALUMINUM  
 COMPANY, INC.



LV Seq	Stock code	Description	Wh	Route	Qty per	Material	Labor and set-up	Fix and overhead	Total cost
0	DD36805111624	36 X 80 FBR WTE/WTE RH	03	0		77.29527	8.71340	9.35034	95.35901
1	000001 02313500783411	34-3/4 X 80 FBR XK WTE	01	0	2.000000	24.72000	0.00000	0.00000	24.72000
1	000002 DD3680-IF	DD 36 X 80 IS FRAME ASSY	01	0	1.000000	6.69672	1.26540	0.00000	7.96212
2	000001 0158404681473675	100 IS SB 147"	01	0	0.500000	2.13000	0.00000	0.00000	2.13000
2	000002 01545121628075	100 IS FR 162"	01	0	1.000000	4.22000	0.00000	0.00000	4.22000
2	000003 035161	6 X 1" #61PQAZ	01	0	8.000000	0.04752	0.00000	0.00000	0.04752
2	000005 0342785	TOP RAIL VINYL IS	01	0	20.000000	0.29920	0.00000	0.00000	0.29920
1	000003 DD3680-OF	DD 36 X 80 OS FRAME ASSY	01	0	1.000000	15.61861	3.88170	0.00000	19.50031
2	000001 015291216040	DD OS FRAME 160"	01	0	0.500000	3.82000	0.00000	0.00000	3.82000
2	000002 015291217184	DD OS FRAME 171"	01	0	1.000000	8.17000	0.00000	0.00000	8.17000
2	000004 0066080	1/8 DIA GALV. ROD	01	0	1.000000	0.28160	0.00000	0.00000	0.28160
2	000005 0062913	BCY DD HINGE ASSY	01	0	6.000000	2.10000	0.00000	0.00000	2.10000
2	000006 019226	STRIKER PLATE BCY	01	0	1.000000	0.06900	0.00000	0.00000	0.06900
2	000007 035163730	6 X 3/8TRUS 638TPAZ	01	0	2.000000	0.00950	0.00000	0.00000	0.00950
2	000008 0051286	#109 VINYL BULB	01	0	40.657900	1.16851	0.00000	0.00000	1.16851
1	000004 DD3680PVC-TED	DD 36 X 80 PVC ASSY TED	01	0	1.000000	13.17144	1.89050	0.00000	15.06194
2	000005 001507012	PVC CODE #1038-RG 74"	01	0	1.000000	1.57900	0.00000	0.00000	1.57900
2	000005 0015077	PVC CODE #1038-RG 78"	01	0	2.000000	3.32000	0.00000	0.00000	3.32000
2	000005 0021720	5/8" STAPLE #1720	01	0	24.000000	0.14496	0.00000	0.00000	0.14496
2	000005 004349023A	HOT MELT	01	0	0.702800	2.67064	0.00000	0.00000	2.67064
2	000005 01990	PVC LOCK BLOCK DB	01	0	1.000000	0.56684	0.30875	0.00000	0.87559
3	000001 0015044	1/4X1-1/4" CRN STAPLE	01	0	0.556800	0.52284	0.00000	0.00000	0.52284
3	000002 0024808	1-3/8 X 1-11/16 X 2 NN	01	0	10.000000	0.03400	0.00000	0.00000	0.03400
3	000003 02231015820010	1-3/8X33-3/8X77 1N LARK	01	0	1.000000	0.01000	0.00000	0.00000	0.01000
2	000006 02233300763411	20X36 9-LT HP1-3/8	01	0	1.000000	4.89000	0.00000	0.00000	4.89000
1	000005 922369	DD BS PREP ASSY	01	0	1.000000	16.22000	0.00000	0.00000	16.22000
1	000006 DDPREP-BS	DD SHIP CLIP DKE	01	0	1.000000	0.86850	0.00000	0.00000	0.86850
2	000001 0152832144	PAC LABEL	01	0	2.000000	0.28000	0.00000	0.00000	0.28000
2	000002 012700	8 X 3/8 HWH 838HWABZ	01	0	1.000000	0.03300	0.00000	0.00000	0.03300
2	000003 035283740	8X3/4 TRUS PHIL TPAZ	01	0	2.000000	0.01390	0.00000	0.00000	0.01390
2	000004 035287520	8 X 3/4" HWH 834HWFZ	01	0	4.000000	0.02500	0.00000	0.00000	0.02500
2	000006 035287540	5/8" PLASTIC BAND	01	0	18.000000	0.13392	0.00000	0.00000	0.13392
2	000007 0028204258	2"X4"X8' 3&4 MIX BOARD	01	0	1.500000	0.04055	0.00000	0.00000	0.04055
2	000008 0991248	PLASTIC PLUGS	01	0	0.266666	0.08533	0.00000	0.00000	0.08533
2	000009 005111	DAUBOND CLEANER 8029047	01	0	1.000000	0.04520	0.00000	0.00000	0.04520
2	000011 0043521		01	0	0.040000	0.21160	0.00000	0.00000	0.21160

End of report



Architectural Testing, Inc  
Test sample complies with  
details shown herein. Any  
deviations are noted in the  
test report or drawings.

Report #: F1393.01  
Date: 10/08/15 By: CB

# Door Installation Instructions

1. Center door in opening (height and width)
2. Insert 1 screw in top hinge side of door, bottom hinge side of door, and middle hinge side of door
3. Remove screw from shipping clip to outside frame
4. Center frame on door knob side so gap at top and bottom are equal
5. Install rest of screws
6. remove shipping clip from inside frame



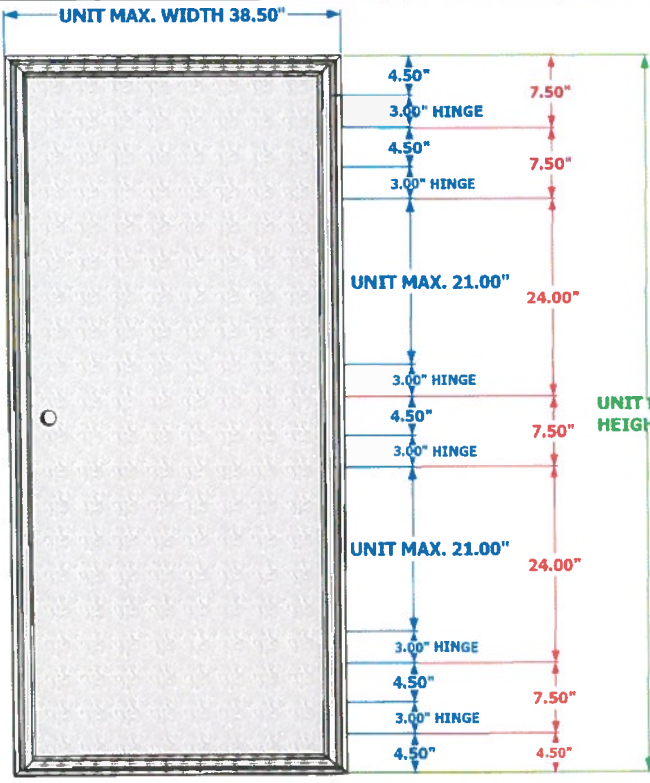
Architectural Testing, Inc

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Report #: F1393\_01

Date: 10/08/15 By: CB





**INSTALLATION METHOD  
100 DD SINGLE DOOR  
ELEVATION & ANCHOR  
LAYOUT**

← **ELEVATION EXTERIOR VIEW**

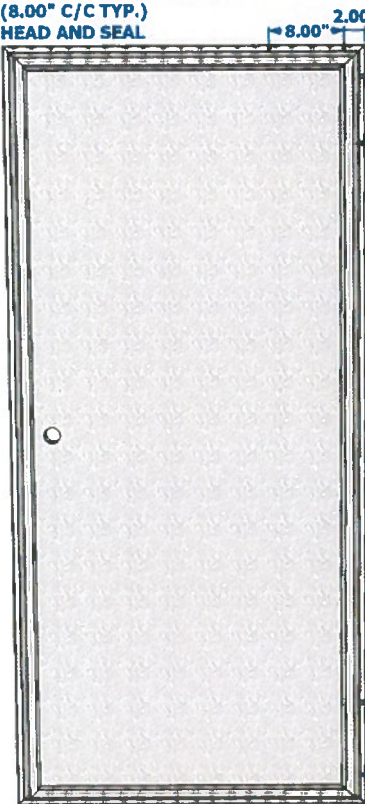


Architectural Testing, Inc  
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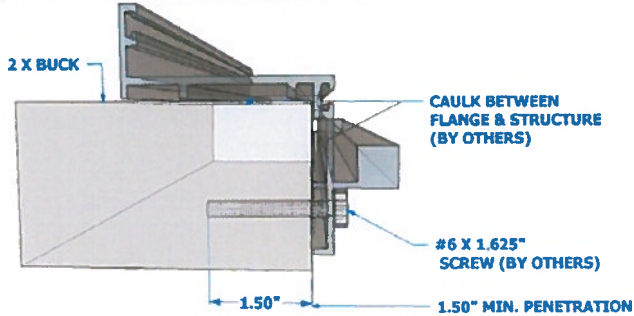
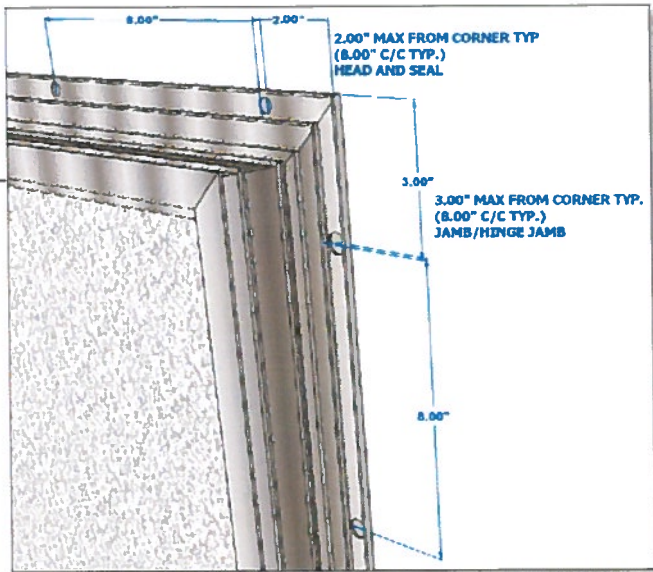
Report #: F1393\_01  
Date: 10/08/15 By: CB

**FLANGE ANCHOR INSTALLATION VIEW**

2.00" MAX FROM CORNER TYP  
(8.00" C/C TYP.)  
HEAD AND SEAL



**FLANGE ANCHOR  
INSTALLATION POINT**



SCALE: NTS  
DWN BY: AMM  
CHK BY: KEA  
DATE: 08/06/13

TITLE:  
100 DD SINGLE DOOR 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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