



# Structural Performance Certification Authorization Report

## Pocahontas Aluminum Company, Inc.

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

Certification ID:	757-141
Company Code:	757
Certification Date:	9/16/2020
Revision No:	1
Revision Date:	9/19/2024
Expiration Date:	9/16/2027

### Product Rating Information:

Model:	PD10WW/PD10JWW - PVC Patio Door			
Operator Type:	SD			
Configuration:	ALL/EM, GS - 1/8" Temp / 1/8" HS IG			
Referenced Standard:	AAMA 1701.2-95/12			
Product Rating:	Wind Zone III @58 psf, 72x76 - (3' from corner of wall)			
Rated Dimensions:	Max Width:	72 in	Max Height:	76 in

### Qualifying Test Information:

Test Report No:	2519.02-109-12-R1
Test Report Expiration:	9/16/2027

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:

*Shaun Shaul* Shaun Shaul  
2024.09.19 07:44:49  
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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	9/16/2020	Initial Issuance.
1	9/18/2024	Granted 3 Year Extension.
1	9/19/2024	Updated Model Name (Removed "(XO)").

## TEST REPORT

AAMA 1701.2-95

AAMA 1701.2-12

REPORT NO.: 2519.02-109-12-R1

RENDERED TO: POCAHONTAS ALUMINUM COMPANY

PRODUCT TYPE: PVC Patio Door, Type XO

SERIES / MODEL: PD10WW/ PD10JWW

**Test Date:** 8/19/2020  
**Through:** 8/20/2020  
**Report Date:** 9/11/2020  
**Revision Date:** 9/15/2020

**CLIENT INFORMATION:** POCAHONTAS ALUMINUM COMPANY  
2001 Industrial Drive  
P.O. Box 756  
Pocahontas, Arkansas 72455

**TEST LABORATORY:** Molimo, LLC  
1410 Eden Road  
York, Pennsylvania 17402  
717-900-6034

**PROJECT SUMMARY:**

**PRODUCT TYPE:** PVC Patio Door, Type XO

**SERIES/MODEL:** PD10WW/ PD10JWW

**PROJECT SUMMARY:**

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

This product was originally tested by Veka, Inc. as Series PD10WW/ PD10JWW PVC Patio Door, Type XO. This report is a reissue of Report No. 2519.01-109-12 in the name of Pocahontas Aluminum Company through written authorization by Veka, Inc.

Specimen	Structural Load	Wind Zone Achieved
1	±2777 Pa (±58.0 psf)	Wind Zone III – 3’0” from corner of wall

**PROJECT DETAILS:**

**Test Dates:** 8/19/2020 – 8/20/2020

**Test Record Retention End Date:** 8/20/2024

**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 1701.2-12 – *Voluntary Standard for Utilization in Manufactured Housing for Primary Windows and Sliding Glass Doors*

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:**

Overall Size: 1816 mm x 1918 mm (71-1/2" x 75-1/2")

Overall Area: 3.48 m<sup>2</sup> (37.49 ft<sup>2</sup>)

Panel: 930 mm x 1861 mm (36-5/8" x 73-1/4")

Screen Size: 924 mm x 1889 mm (36-3/8" x 74-3/8")

**FRAME CONSTRUCTION:**

Material: Extruded PVC

Corner Details: Miter cut and thermally welded

Fixed stile: The fixed meeting stile was fastened to the head/ sill with six #8 x 3" truss head screws, three at each end. Each intersection was sealed with silicone sealant. A snap-fit interlock was then applied to the fixed stile.

Equal lite: The equal lite adaptors were coped, snap fit and sealed with silicone at the head and sill of the fixed lite.

Roller track: Drop-in extruded aluminum roller track

**PANEL CONSTRUCTION:**

Material: Extruded PVC

Corner Details: Miter cut and thermally welded

**TEST SPECIMEN DESCRIPTION: (Continued)**
**REINFORCEMENT:**

Drawing Number	Material	Quantity	Location
RFPD03SOM	Formed Steel	1	Lock Stile, Interlocking Stile, Top Rail, Bottom Rail
RFCV01SOM	Formed Steel	1	Lock stile, Interlocking Stile
RFCV01SOM	Formed Steel	2	Fixed Meeting Stile

**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	3/4" IG
Glazing Construction (exterior to interior)	1/8" Thick tempered glass 1/2" Butyl spacer system, single sealed 1/8" Thick heat strengthened glass
Glazing Method	The panel and the fixed lite were exterior glazed against a bed of silicone sealant. Then a heal bead of silicone sealant was applied and the IG was secured with rigid vinyl glazing beads.
Glazing Bite	1/2"
Daylight Opening	
Panel:	813 mm x 1743 mm (32" x 68-5/8")
Fixed:	819 mm x 1746 mm (32-1/4" x 68-3/4")

**WEATHERSTRIPPING:**

Description	Quantity	Location
0.187" backed by 0.250" high center fin pile	2 Rows	Lock stile, top rail, bottom rail
0.187" backed by 0.250" high center fin pile	1 Row	Interlocking stile, fixed meeting stile interlock

**TEST SPECIMEN DESCRIPTION: (Continued)**
**DRAINAGE:**

Description	Quantity	Location
1" wide by 1/8" high weep slot	4	Exterior sill face, one 3" from each end, through two walls
1" wide by 3/16" high weep slot	4	Interior sill track (below glazing tower), one 1-1/2" from each end, through two walls
1/2" wide by 1/8" high weep slot	4	Exterior sill face, one 1-1/2" from each end, draining the screen track
1-7/8" wide by 1/4" deep weep notch	2	Each end of aluminum roller track

**HARDWARE:**

Description	Quantity	Location
Handle/lock assembly with mortise lock	2	Lock stile with keeper on the mating jamb. Lock assembly was fastened to the stile and stile reinforcement with two #8 x 1-5/8" truss head screws.
Dual steel roller assembly	2	Bottom rail, one at each end
3" long molded rubber sash panel stop	1	Sill track at fixed side jamb

**SCREEN CONSTRUCTION:**

Frame Material: Formed Aluminum  
 Mesh Type: Fiber  
 Corner Construction: Miter cut and secured with metal corner keys  
 Mesh Attachment Method: Flexible vinyl spline

**TEST SPECIMEN DESCRIPTION:** (Continued)

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

<b>Location</b>	<b>Anchor Description</b>	<b>Anchor Spacing</b>
Integral nail fin	#8 x 2" Truss head screw	Spaced approximately 8" on center, and starting in each corner going through the fin and into the wood buck
Lock side jamb	#10 x 3-1/2" Long fastener	Two through the keeper at the jamb



**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)	Pass	No Damage
-595 Pa (-12.5 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.*

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

Test	Results	Allowable
Infiltration @ 75 Pa (1.57 psf)	1.8 L/s/m <sup>2</sup> (0.35 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
137 Pa (2.86 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)	Pass	No Damage
-2777 Pa (-58.0 psf)	Pass	No Damage

*Note #4: All loads were held for 10 seconds.*

*Note #5: 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.*

This report is reissued in the name of Pocahontas Aluminum Company through written authorization from Veka, Inc. to whom the original report was rendered. The original Report Number is 2519.01-109-12. 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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Joseph E. Allison  
Regional Project Manager



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Michael D. Stremmel, P.E.  
Senior Project Engineer

JEA:dro

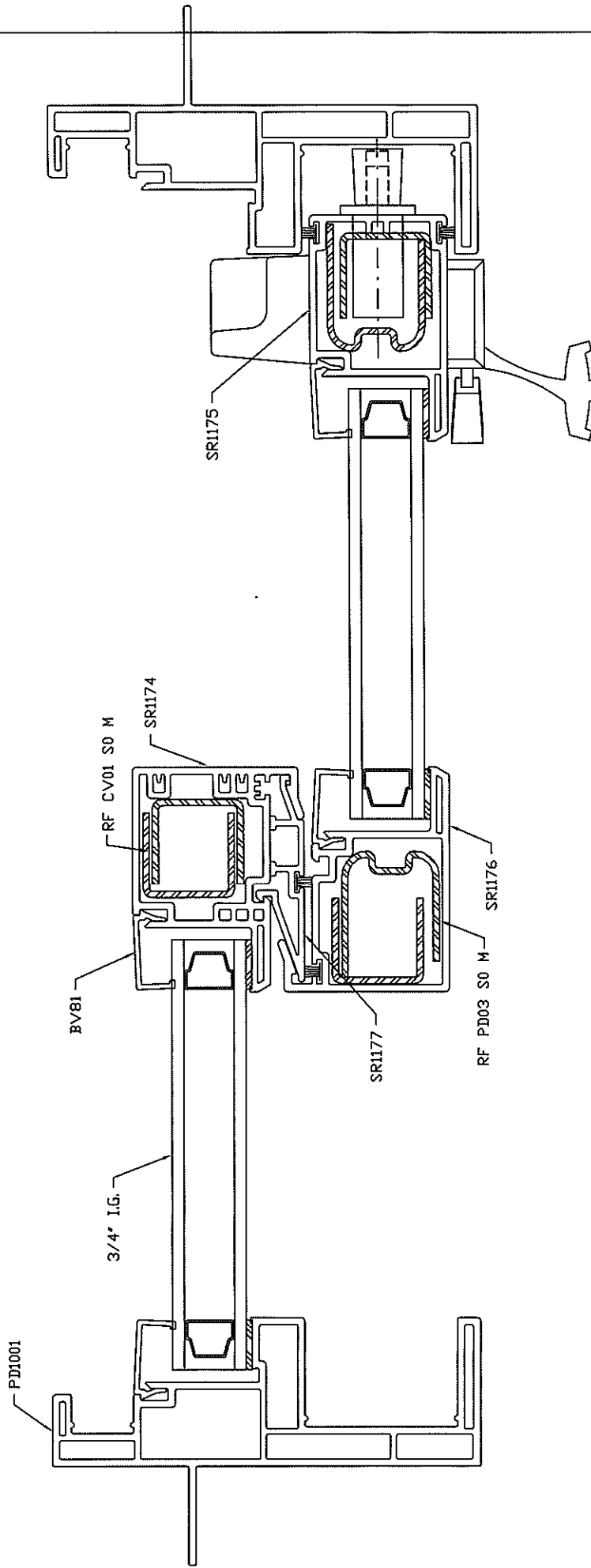
Attachments (pages): This report is complete only when all attachments listed are included.  
Appendix-A: Drawings (2)

### Revision Log

<b>Rev. #</b>	<b>Date</b>	<b>Page(s)</b>	<b>Revision(s)</b>
1	9/15/2020	4	Corrected reinforcement description

## **Appendix A**

### **Drawings**



VEKA INC.  
 100 VEKA DRIVE  
 FOMBELL, PA 16123

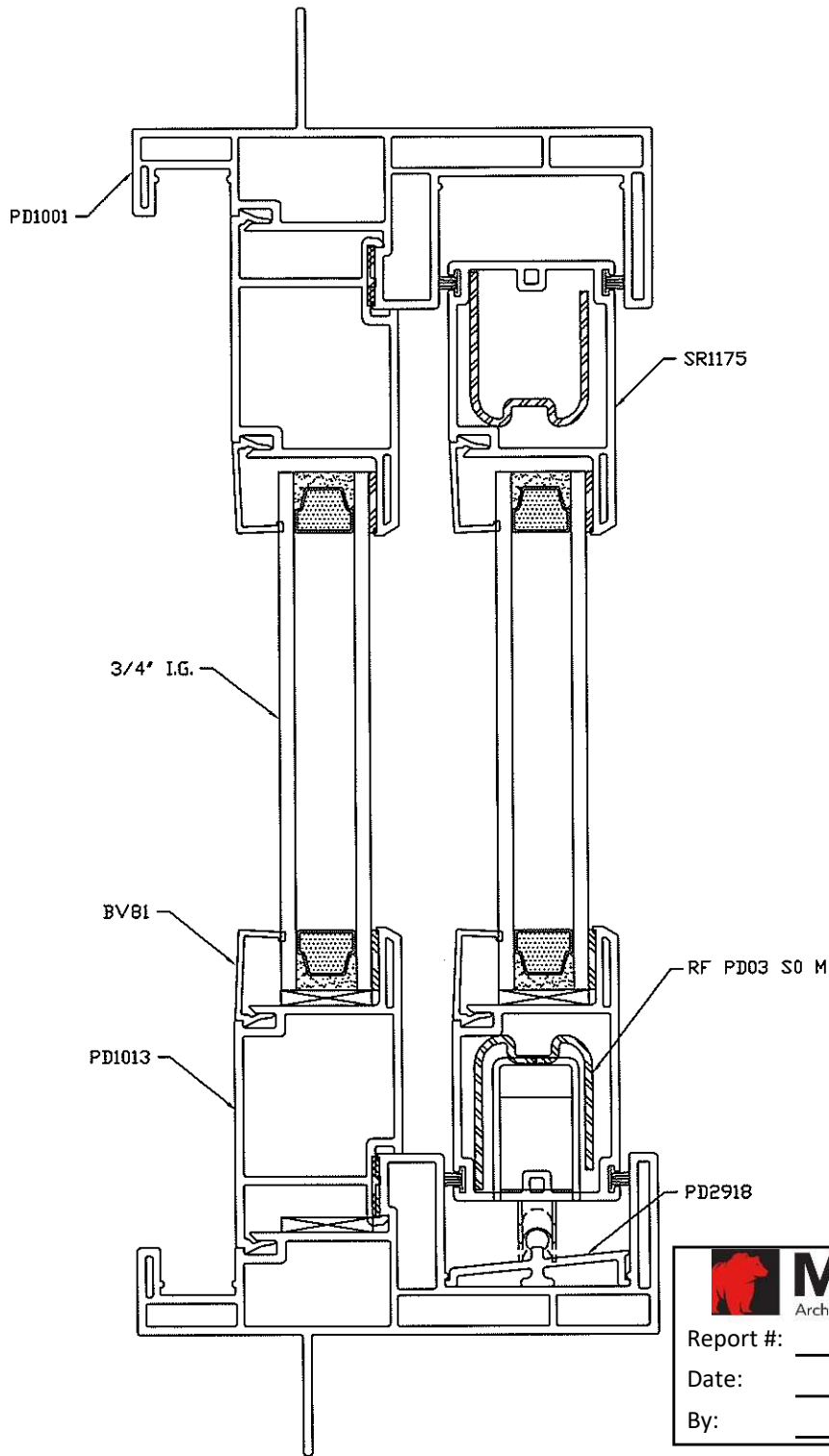
DRAWN: BUF	DATE: 24 AUG 20	SCALE: FULL
CHK'D:	DATE:	APPV'D:
TITLE PATIO DOOR PD10WW HORIZONTAL ASSEMBLY		
DWG. # PD10WW-H POCAHONTAS		


REVISIONS	DATE

**Molimo**<sup>®</sup>  
 Architectural Product Testing

Report #: 2519.02-109-12  
 Date: 9/11/2020  
 By: J. Allison

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 **Molimo**<sup>TM</sup>  
Architectural Product Testing

Report #: 2519.02-109-12

Date: 9/11/2020

By: J. Allison

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

REVISIONS		DATE	
		DRAWN: BJF	DATE: 24 AUG 20
		CHK'D:	DATE:
		TITLE	SCALE: FULL
		PATIO DOOR PD10WW VERTICAL ASSEMBLY	APPVD:
			DWG. #PD10WW-V POCAHONTAS