

**AAMA 1503-09 THERMAL PERFORMANCE
TEST REPORT**

Rendered to:

UNITED STATES ALUMINUM

SERIES/MODEL: 7400

TYPE: Fixed

Summary of Results	
Thermal Transmittance (U-Factor)	0.39
Condensation Resistance Factor - Frame (CRF _f)	63
Condensation Resistance Factor - Glass (CRF _g)	69
Unit Size	47-1/4" x 59-1/8" (1200 mm x 1502 mm)
Layer 1	1/4" AFG Comfort Ti-AC36 (e=0.034*, #2)
Gap	0.50" Gap, Super Spacer Premium (ZF-D), 100% Air-Filled*
Layer 2	1/4" Clear

Reference must be made to Report No. A3935.02-301-46, dated 10/29/10 for complete test specimen description and data.

AAMA 1503-09 THERMAL PERFORMANCE TEST REPORT

Rendered to:

UNITED STATES ALUMINUM
200 Singleton Drive
Waxahachie, Texas 75165

Report Number: A3935.02-301-46
Test Date: 10/21/10
Report Date: 10/29/10
Test Record Retention Date: 10/21/14

Test Sample Identification:

Series/Model: 7400

Type: Fixed

Test Sample Submitted by: Client

Test Procedure: The condensation resistance factor (CRF) and thermal transmittance (U) were determined in accordance with AAMA 1503-09, *Voluntary Test Method for Thermal Transmittance and Condensation Resistance of Windows, Doors and Glazed Wall Sections*

- | | |
|---|---------|
| 1. Average warm side ambient temperature | 69.79 F |
| 2. Average cold side ambient temperature | -0.65 F |
| 3. 15 mph dynamic wind applied to test specimen exterior. | |
| 4. 0.0" \pm 0.04" static pressure drop across specimen. | |

Test Results Summary:

- | | |
|---|------|
| 1. Condensation resistance factor - Frame (CRF _f) | 63 |
| Condensation resistance factor - Glass (CRF _g) | 69 |
| 2. Thermal transmittance due to conduction (U) | 0.39 |
| (U-factors expressed in Btu/hr·ft ² ·F) | |

Test Sample Description:

CONSTRUCTION	Frame
Size (in.) Non-Standard	47-1/4 x 59-1/8
Daylight Opening (in.)	43-5/8 x 55-1/2
CORNERS	Coped
Fasteners	Screws
Sealant	Yes
MATERIAL	AT (0.36")
Color Exterior	Gray
Finish Exterior	Paint
Color Interior	Gray
Finish Interior	Paint
GLAZING METHOD	Interior

Glazing Information:

Layer 1	1/4" AFG Comfort Ti-AC36 (e=0.034*, #2)
Gap	0.50" Gap, Super Spacer Premium (ZF-D), 100% Air-Filled*
Layer 2	1/4" Clear
Gas Fill Method	N/A*
Desiccant	Yes - Contained within the Spacer

**Stated per Client/Manufacturer*

NA Non-Applicable

See Description Table Abbreviations

Test Sample Description: (Continued)

COMPONENTS			
	Type	Quantity	Location
WEATHERSTRIP			
	None		
HARDWARE			
	None		
DRAINAGE			
	None		

Test Duration:

1. The environmental systems were started at 10:23 hours, 10/20/10.
2. The thermal performance test results were derived from 04:10 hours, 10/21/10 to 08:10 hours, 10/21/10.

Condensation Resistance Factor (CRF):

The following information, condensed from the test data, was used to determine the condensation resistance factor:

T_h	=	Warm side ambient air temperature	69.79 F
T_c	=	Cold side ambient air temperature	-0.65 F
FT_p	=	Average of pre-specified frame temperatures (14)	43.65 F
FT_r	=	Average of roving thermocouples (4)	38.96 F
W	=	$[(FT_p - FT_r) / (FT_p - (T_c + 10))]$ x 0.40	0.055
FT	=	$FT_p(1-W) + W (FT_r)$ = Frame Temperature	43.40 F
GT	=	Glass Temperature	47.67 F
CRF_g	=	Condensation resistance factor – Glass	69
		$CRF_g = (GT - T_c) / (T_h - T_c)$ x 100	
CRF_f	=	Condensation resistance factor – Frame	63
		$CRF_f = (FT - T_c) / (T_h - T_c)$ x 100	

The CRF number was determined to be 63 (on the size as reported). When reviewing this test data, it should be noted that the frame temperature (FT) was colder than the glass temperature (GT) therefore controlling the CRF number. Refer to the 'CRF Report' page and the 'Thermocouple Location Diagram' page of this report.

Thermal Transmittance (U_c):

T_h	=	Average warm side ambient temperature	69.79 F
T_c	=	Average cold side ambient temperature	-0.65 F
P	=	Static pressure difference across test specimen 15 mph dynamic perpendicular wind at exterior	0.00 psf
Nominal sample area			19.40 ft ²
Total measured input to calorimeter			614.37 Btu/hr
Calorimeter correction			87.60 Btu/hr
Net specimen heat loss			526.77 Btu/hr
U	=	Thermal Transmittance	0.39 Btu/hr·ft ² ·F

Glazing Deflection (in.):

	Glazing
Edge Gap Width	0.50
Estimated center gap width upon receipt of specimen in laboratory (after stabilization)	0.25
Center gap width at laboratory ambient conditions on day of testing	0.50
Center gap width at test conditions	0.32

The sample was inspected for the formation of frost or condensation, which may influence the surface temperature measurements. The sample showed no evidence of condensation/frost at the conclusion of the test.

A full calibration of the Architectural Testing Inc. 'thermal test chamber' (ICN 004287) in Fresno, California was conducted in April 2010 in accordance with Architectural Testing Inc. calibration procedure. A calibration check was performed September 2010.

Prior to testing the specimen was sealed with silicone on the interior side and checked for air infiltration per Section 9.3.4.

CRF Report

Time: 06:10 06:40 07:10 07:40 08:10 AVERAGE

Pre-specified Thermocouples - Frame

1	39.41	39.45	39.49	39.46	39.48	39.46
2	41.35	41.35	41.41	41.47	41.42	41.40
3	39.57	39.50	39.59	39.59	39.63	39.57
4	48.06	48.05	48.08	48.07	48.10	48.07
5	48.04	48.06	48.06	48.04	48.05	48.05
6	48.21	48.22	48.27	48.21	48.25	48.23
7	47.35	47.31	47.33	47.33	47.33	47.33
8	47.00	47.01	46.97	47.02	47.02	47.01
9	45.03	45.07	45.04	45.01	45.03	45.04
10	45.20	45.19	45.22	45.23	45.20	45.21
11	41.82	41.86	41.87	41.84	41.84	41.85
12	41.99	42.06	42.05	42.07	42.05	42.04
13	38.57	38.60	38.63	38.62	38.62	38.61
14	39.28	39.27	39.29	39.31	39.28	39.29
FT _p	43.63	43.64	43.66	43.66	43.66	43.65

Pre-specified Thermocouples - Glass

15	32.69	32.71	32.66	32.72	32.69	32.70
16	51.48	51.46	51.49	51.51	51.45	51.48
17	43.54	43.52	43.55	43.56	43.53	43.54
18	56.51	55.67	55.51	57.71	57.93	56.67
19	54.36	54.34	54.38	54.38	54.39	54.37
20	47.26	47.34	47.29	47.27	47.28	47.29
GT	47.64	47.51	47.48	47.86	47.88	47.67

Cold Point (Roving) Thermocouples

21	39.41	39.45	39.49	39.46	39.48	39.46
22	38.49	38.33	38.46	38.54	38.53	38.47
23	39.28	39.27	39.29	39.31	39.28	39.29
24	38.57	38.60	38.63	38.62	38.62	38.61
FT _R	38.94	38.91	38.97	38.98	38.98	38.96
W	0.05	0.06	0.05	0.05	0.05	0.05
FT	43.38	43.38	43.41	43.41	43.41	43.40

Warm Side - Room Ambient Air Temperature

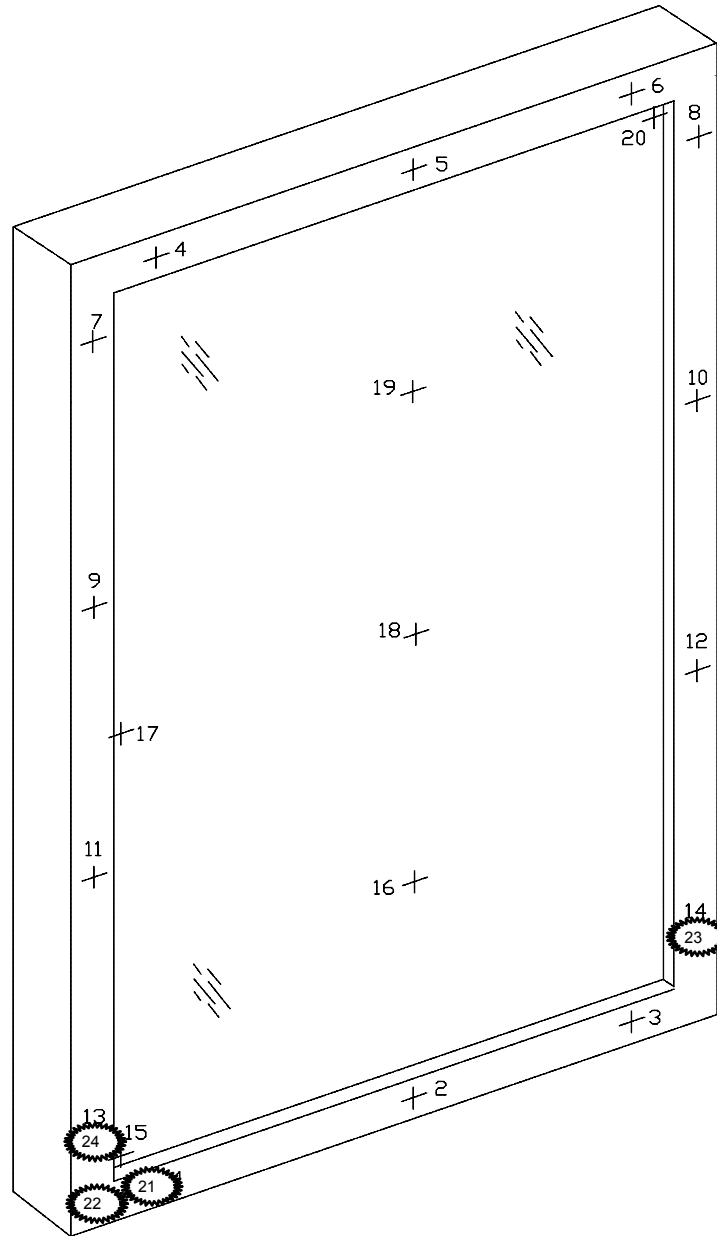
	69.78	69.78	69.79	69.83	69.83	69.80
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Cold Side - Room Ambient Air Temperature

	-0.65	-0.65	-0.65	-0.65	-0.65	-0.65
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CRF _f	63	63	63	63	63	63
CRF _g	69	68	68	69	69	69

Thermocouple Location Diagram



Cold Point Locations

21	21. 39.46
22	22. 38.47
23	23. 39.29
24	24. 38.61

Detailed drawings, data sheets, representative samples of test specimens, a copy of this report, or other pertinent project documentation will be retained by Architectural Testing, Inc. for a period of four years from the original test date. At the end of this retention period such materials shall be discarded without notice and the service life of this report by Architectural Testing will expire. Results obtained are tested 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 specimen(s) tested. This report may not be reproduced, except in full, without the written approval of Architectural Testing, Inc.

For ARCHITECTURAL TESTING, INC.



Digitally Signed by: William Smeds

Simon Smeds
Technician



Digitally Signed by: Kenny C. White

Kenny C. White
Laboratory Manager
Individual-In-Responsible-Charge

WSS:ss
A3935.02-301-46

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

Appendix-A: Description Table Abbreviations (1)

Appendix-B: Drawings (11)

Revision Log

<u>Rev. #</u>	<u>Date</u>	<u>Page(s)</u>	<u>Revision(s)</u>
0	10/29/10	All	Original Report Issue. Work requested by Mr. Don Willard of United States Aluminum

Appendix A: Description Table Abbreviations

CODE	Frame / Sash Types
AI	Aluminum w/ Vinyl Inserts (Caps)
AL	Aluminum
AP	Aluminum w/ Thermal Breaks - Partial
AS	Aluminum w/ Steel Reinforcement
AT	Aluminum w/ Thermal Breaks - All Members ($\geq 0.21"$)
AU	Aluminum Thermally Improved - All Members (0.062" - 0.209")
AV	Aluminum / Vinyl Composite
AW	Aluminum-clad Wood
FG	Fiberglass
PA	ABS Plastic w/ All Members Reinforced
PC	ABS Plastic-clad Aluminum
PF	ABS Plastic w/ Foam-filled Insulation
PH	ABS Plastic w/ Horizontal Members Reinforced
PI	ABS Plastic w/ Reinforcement - Interlock
PL	ABS Plastic
PP	ABS Plastic w/ Reinforcement - Partial
PV	ABS Plastic w/ Vertical Members Reinforced
PW	ABS Plastic-clad Wood
ST	Steel
VA	Vinyl w/ All Members Reinforced
VC	Vinyl-clad Aluminum
VF	Vinyl w/ Foam-filled Insulation
VH	Vinyl w/ Horizontal Members Reinforced
VI	Vinyl w/ Reinforcement - Interlock
VP	Vinyl w/ Reinforcement - Partial
VV	Vinyl w/ Vertical Members Reinforced
VW	Vinyl-clad Wood
VY	Vinyl
WA	Aluminum / Wood composite
WD	Wood
WV	Vinyl / Wood composite
WF	Fiberglass/Wood Combination
WC	Composite/Wood Composite (Shaped vinyl/wood composite members)
CW	Copper Clad Wood
CO	Vinyl/Wood Composite Material

CODE	Spacer Types (See sealant)
A1	Aluminum
A2	Aluminum (Thermally-broken)
A3	Aluminum-reinforced Polymer
A4	Aluminum / Wood
A5	Aluminum-reinforced Butyl (Swiggle)
A6	Aluminum / Foam / Aluminum
A7	Aluminum U-shaped
A8	Aluminum-Butyl (Corrugated) (Duraseal)
ER	EPDM Reinforced Butyl
FG	Fiberglass
GL	Glass
OF	Organic Foam
P1	Duralite
PU	Polyurethane Foam
SU	Stainless Steel, U-shaped
CU	Coated Steel, U-shaped (Intercept)
S2	Steel (Thermally-broken)
S3	Steel / Foam / Steel
S5	Steel-reinforced Butyl
S6	Steel U-channel w/ Thermal Cap
SS	Stainless Steel
CS	Coated Steel
TP	Thermo-plastic
WD	Wood
ZE	Elastomeric Silicone Foam
ZF	Silicone Foam
ZS	Silicone / Steel
N	Not Applicable
TS	Thermo-plastic w/ stainless steel substrate

CODE	Tint Codes
AZ	Azurlite
BL	Blue
BZ	Bronze
CL	Clear
EV	Evergreen
GD	Gold
GR	Green
GY	Gray
LE	Low 'e' Coating
OT	Other (use comment field)
RC	Solar or Reflective Coating
RG	Roller Shades between glazing
RS	Silver (reflective coating)
SF	Suspended Polyester Film
SR	Silver
BG	Blinds between the Glazing
DV	Dynamic Glazing-Variable
DY	Dynamic Glazing-NonVariable

CODE	Gap Fill Codes
AIR	Air
AR2	Argon/Krypton Mixture
AR3	Argon / Krypton / Air
ARG	Argon/Air
CO2	Carbon Dioxide
KRY	Krypton/Air
SF6	Sulfur Hexafluoride
XE2	Xenon/Krypton/Air
XE3	Xenon/Argon/Air
XEN	Xenon/Air
N	Not Applicable

DOOR DETAILS	
N	Not Applicable
CODE	Door Type
EM	Embossed
FL	Flush
LF	Full Lite
LH	1/2 - Lite
LQ	1/4 - Lite
LT	3/4 - Lite
RP	Raised Panel
CODE	Skin
AL	Aluminum
FG	Fiberglass
GS	Galvanized Steel
ST	Steel
WD	Wood
VY	Vinyl
CODE	Panel
FG	Fiberglass
PL	Plastic
WP	Wood - Plywood
WS	Wood - Solid
CODE	Sub-Structure
GS	Galvanized Steel
ST	Steel
WD	Wood
VY	Vinyl
CODE	Core Fill
CH	Cellular - Honeycomb
EP	Expanded Polystyrene
PI	Polyisocyanurate
PU	Polyurethane
WP	Wood - Plywood
WS	Wood - Solid
XP	Extruded Polystyrene

CODE	Spacer Sealant
D	Dual Seal Spacer System
S	Single Seal Spacer System

CODE	Grid Description
N	No Muntins
G	Grids between glass
S	Simulated Divided Lites
T	True Muntins

CODE	Grid Size Codes
	Blank for no grids
0.75	Grids < 1"
1.5	Grids $\geq 1"$

CODE	Thermal Breaks
F	Foam
U	Urethane
V	Vinyl
FB	Fiberglass
O	Other
AB	ABS
NE	Neoprene
AI	Air
N	Not Applicable
P	Polamide

Appendix B: Drawings

BILL OF MATERIALS

ITEM	I.E.C. PART NO.	PART NO.	DESCRIPTION	QTY.	SUPPLIER	PART NO.	COMMENTS	UNITS
1	T-60929	WN 414	FRAME HEAD/SILL INSIDE	2	INTEX-TX			LBS.
2	T-60928	WN 413	FRAME HEAD/SILL OUTSIDE	2	INTEX-TX			LBS.
3	T-60930	WN 416	FRAME JAMB INSIDE	2	INTEX-TX			LBS.
4	T-60960	WN 415	FRAME JAMB OUTSIDE	2	INTEX-TX			LBS.
5	T-60939	WN 429	ONE INCH GLASS STOP	4	INTEX-TX			LBS.
6		(B)TB146	14.6 mm THERMOBAR	8	ENSINGER	2280		LBS.
7		(B)ST252	#10 AB x 1" PH PAN HD SMS S.S.	8			FRAME SCREWS	PCS.
8			1" GLASS	1				SQ. FT.
9		(C)GT416	1/8" x 1/2" PRES-HIM TAPE	A/R				FT.
10			SILICONE CAP BEAD	A/R	TREMO	SPEC 11		FT.
11		SB-222	SETTING BLOCK (.250 x 1" x 4")	2	RYKO			FT.
12		(C)						FT.
13		WH 344	WEDGE GASKET	A/R				FT.

Architectural Testing, Inc.
Test sample complies with these details
deviations are noted



A 3 9 3 5 OCT 28 2010

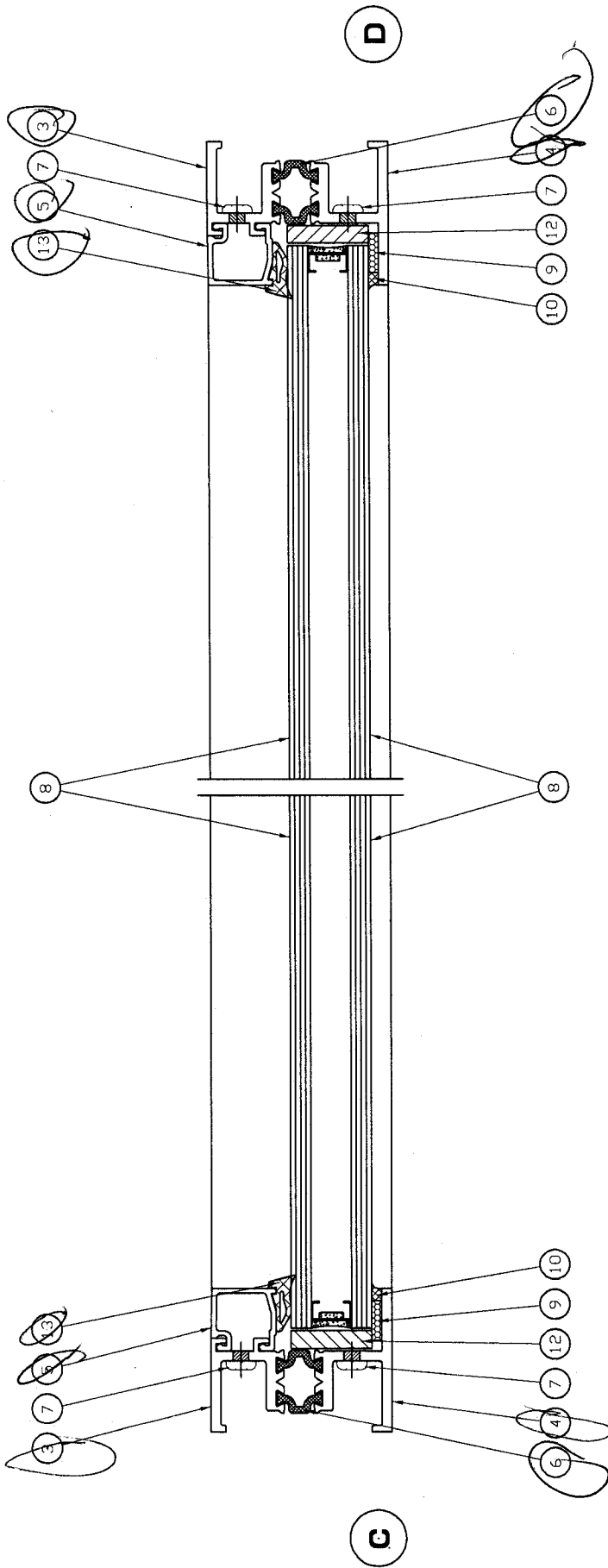
Report #  Date

Tech

UNITED STATES ALUMINUM

BILL OF MATERIALS
FOR FIXED WINDOW
(SERIES 7400)

7400-004C
1 of 3



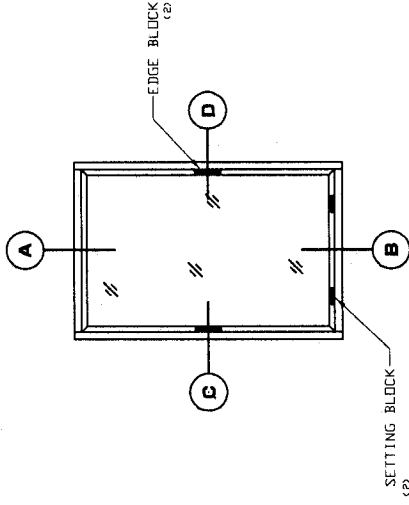
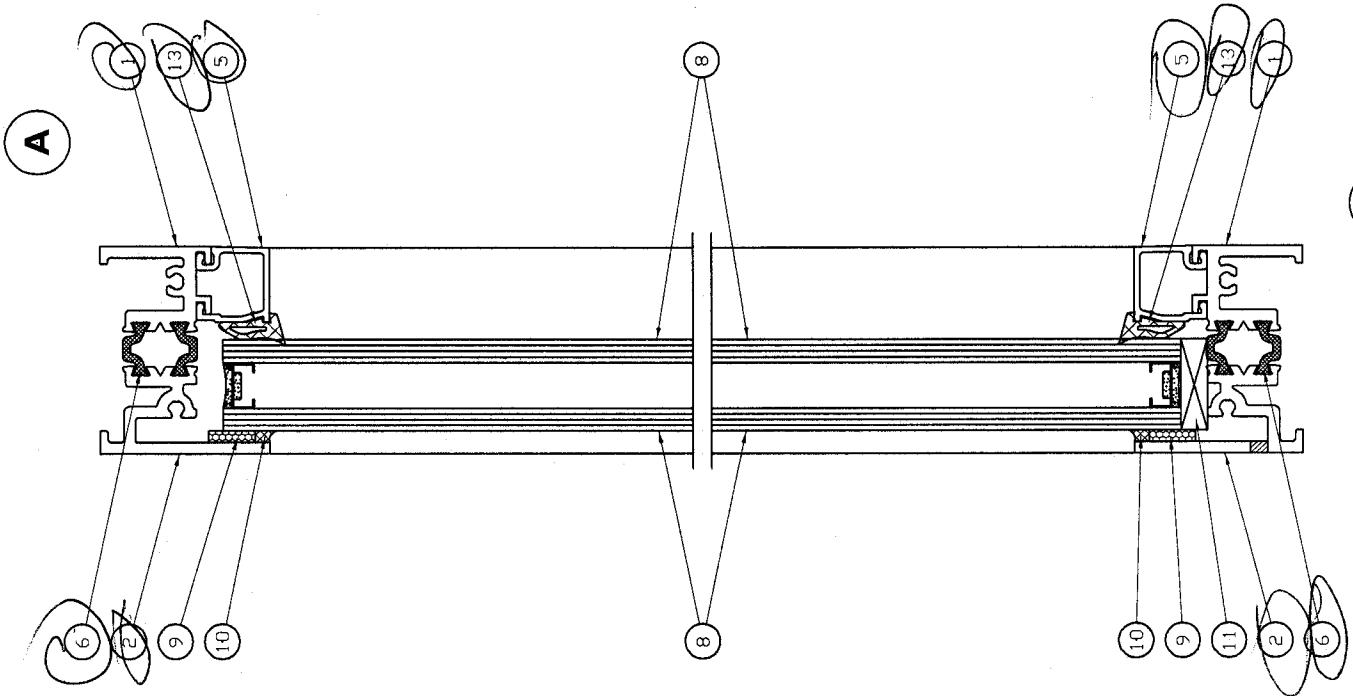
Architectural Testing, Inc.
Test sample complies with these details
deviations are noted



A 3 9 3 5 OCT 28 2010

Report # Date
Tech *[Signature]*

UNITED STATES ALUMINUM			
REVISED AS NOTED	DB/27/10	DCW	FULL SIZE
	DB/19	MCC	
REVISED AS NOTED	05/13/02		
FIXED WINDOW LAYOUT			
7400-004C			
3 of 3			



ELEVATION
NO SCALE



Architectural Testing, Inc.
Test sample complies with these details
deviations are noted

A 3 9 3 5 OCT 28 2010

Report # Tech *[Signature]* Date

UNITED STATES ALUMINUM			
REVISED AS NOTED		REVISED AS NOTED	DATE
C		DCW	05/13/02
B		WCE	05/13/02
FULL SIZE		FULL SIZE	
FIXED WINDOW LAYOUT		7400-004C	
(SERIES 7400)		2 of 3	