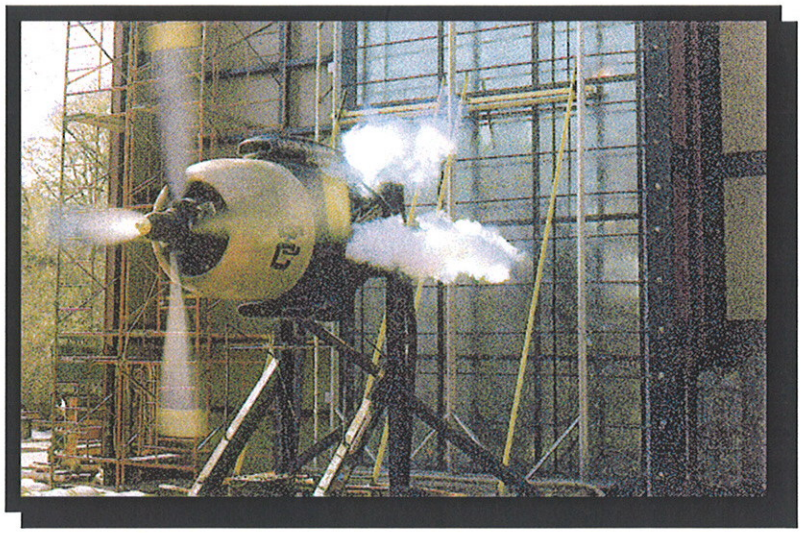
CONSTRUCTION CONSULTING LABORATORY, *INTERNATIONAL*



TEST REPORT:

DADE COUNTY TAS 201, 202 & 203
UNITED STATES ALUMINUM
SERIES 7600 ALUMINUM PROJECT OUT WINDOW
REPORT #CCLI-10-210

November 9, 2010

Prepared for:

US ALUMINUM CORPORATION
200 Singleton Drive
Waxahachie, TX 75165

1601 Luna Road
Carrollton, Texas 75006

S- UNITED, INC.
A Quality Control Company

Office: (972) 242-0556
FAX: (972) 245-6047

DADE COUNTY TAS 201, 202 & 203
UNITED STATES ALUMINUM
SERIES 7600 ALUMINUM PROJECT OUT WINDOW
REPORT CCLI #10-210

November 9, 2010

TABLE OF CONTENTS

APPENDICES:

APPENDIX A: UNITED STATES ALUMINUM SERIES 7600 PROJECT OUT WINDOW DRAWINGS. Refer to drawings in Appendix A. This report is not complete unless this drawing is stamped and initialed by CCLI as illustrated below.

DRAWING	PART NO.	DATE	STAMPED AS ILLUSTRATED
Bill of Materials and Elev.			CONSTRUCTION CONSULTING LABORATORY, INTERNATIONAL 1601 Luna Road Carrollton, Texas 75006 Phone (972) 242-0556 Report# 10-210 Date 11-9-10 Reviewed BY
Series C7600-23 Page 2 of 4		9/3/10	
Series C7600-23 Page 3 of 4		9/3/10	
Series C7600-23 Page 4 of 4		9/3/10	
Head, Jamb Deep Pocket Mullion	IG626	2/23/06	
Filler	IG100	2/22/06	
Sill	IG672	10/18/01	
Glass Stop	IG663	10/18/01	
Subsill	IG570	8/22/01	
Tube	J-175	11/25/64	

APPENDIX B: IMPACT DIAGRAM

APPENDIX C: DEFLECTION DIAGRAM

Report No.	CCLI-10-210
DC Notification Number:	CCLI-10-004
Date:	October 12, 2010
CCLI Certification Number:	06.0515.02
Test Start Date:	September 15, 2010
Test End Date:	September 17, 2010

1. PROJECT DATA

Project: Dade County TAS 201, 202 & 203

Date(s) of Testing: September 15-17, 2010

Tested For: United States Aluminum
200 Singleton Drive
Waxahachie, TX 75165

Witnessed By	**(All or Partial Viewing)**		
U.S. Aluminum	Terry Hopgood		
CCLI	Jeffrey Crump	Chevis Wilson	Abdol Rezadad, P.E.

2. SUMMARY

Tests were conducted in accordance with Testing Application Standard, Protocol 201, 202 & 203. Specimens were impacted with a 96", 9 lb. large missile in accordance with TAS 201, cycled at a Design load of 75 psf positive and 75 psf negative in accordance with TAS 203 and achieved a positive test load of 112.5 psf and a negative test load of 112.5 psf in accordance with TAS 202. Tests were conducted at Construction Consulting Laboratory, *International* (**CCLI**) in Carrollton, TX.

3. IMPACT ACCEPTANCE CRITERIA

The test specimen shall resist the large missile impact with no tear formed longer than 5" (130mm) and wider than 1mm ($^1/_{16}$") through which air can pass or no opening formed through which a 3" (76mm) diameter solid sphere can freely pass when evaluated upon completion of missile impacts and test loading program.

4. TEST SPECIMEN

Product Type: Aluminum Project Out Window, **Product Drawings, Appendix A**
Series Model: Series 7600
Specifications: TAS 201, 202 & 203 Large Type-D Missile
Design: ASTM E 1886-05 (+75 / -75)
Frame Size: 1524mm x 813mm (5'-0"x 2'-8")
Vent Size: 1514mm x 803mm (4'-11$^5/_8$" x 2'-7$^5/_8$")
Daylight Opening: 1413 x 702 (55.625 " x 27.625")
Configuration: X

Florida Registered Professional Engineers Review: Reg. #52849, February 28, 2011 – Abdol Rezadad, P.E.

Signature: 11/11/10

WEATHER-STRIP: 4.76mm ($^3/_{16}$") dual durometer bulb located at the exterior face of frame interior leg, full perimeter. Dual durometer bulb 4.76mm ($^3/_{16}$") located at interior face of vent, full perimeter. Continuous finger gasket (part #NP810) located at the exterior lateral face of vent perimeter.

HARDWARE: One (1) multi-point lock actuated handle located at center of vent bottom rail. Three (3) lock buttons located at lock slide bar, (unit #1 AMC aluminum slide bar, unit #2 AMC 6/6 nylon slide bar, unit #3 Intex aluminum slide bar). Lock keepers located 63.5mm (2½") from one jamb and 152.4mm (6") from the other jamb with one at center of sill. Keepers attached with two (2) #10–24 x $^3/_8$" screws. Three (3) snubber sets located 152.4mm (6") from each end and one at center at vent top rail and frame head. Snubbers at vent are attached with aluminum adapter and two (2) #10 x ½" PHL PH SMS and snubbers at frame are attached with two (2) #10 x ½" PHL PH SMS. Four bar friction hinge with hinge adapter (part #61585 or AMC #1402 L or R) located at frame jambs attached to each jamb with three (3) #10 x ½" screws.

GLASS: 1" overall thickness sealed insulating glass (SIG). Exterior, 1 pc 4.76mm ($^3/_{16}$") heat strengthened glass, 7.93mm ($^5/_{16}$") air space, Interior, 1 pc. 4.76mm ($^3/_{16}$") heat strengthened glass, 2.28 mm (.090") Sentry Glas® laminate and 1 pc. 4.76mm ($^3/_{16}$") heat strengthened glass. Air spacer consists of molded aluminum and desiccant.

GLAZING: Exterior glazed with GT 900 glazing tape and silicone at interior and lateral face of glass. Unit #1 and #2 used Tremco Proglaze SSG at the interior face of glass and Tremco Spectrum 2 at the lateral face of glass. Unit #3 used Dow 995 at the interior face of glass and Dow 795 at the lateral face of glass.

WEEP ARRANGEMENT: 9.52mm ($^3/_8$") diameter weep holes spaced 152.4mm (6") from each end of frame subsill.

SEALANT: Sealant at all frame corners and vent corners. Attachment screws sealed. Frame members sealed to sub-frame at the interior. Subsill sealed at interior and exterior at frame sill. Sub-frame filler sealed continuous at all sub-frame members.

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Signature: 11/11/10

INSTALLATION FEATURES: Frame sill attached to aluminum sub-frame with #12 x 19.05mm (¾") screws spaced 101.6mm (4") from each end and on 304.8mm (12") centers. Frame filler part # J-175 attached to sub-frame members at head, sill, and jambs with #10 x 44.45mm (1¾") screws spaced 152.4mm (6") from each end and on 308.8mm (12") centers. Sub-frame attached to SPF, nominal 50.8mm x 203.2mm (2" x 8") test buck with 9.52mm (⅜") x 114.3 (4½") lag bolt, 152.4mm (6") from each end and 304.8mm (12") on center.

OTHER FEATURES: Vent members are thermally broken with polyurethane. Vent corners are mitered and crimped with one aluminum corner key (part #WN524) per connection. Frame members are coped, butted, and attached with two (2) #8 x ¾" PHSMS per connection. Frame members attached to sub frame members with one (1) #14 x 1½" PHL PH SMS spaced 101.6mm (4") from each end and 304.8mm (12") on center. Frame sill attached to subsill with #12AB x ¾" screws, 101.6mm (4") from each end and 304.8mm (12") O.C. Filler (part #J-175) attached to sub-frame members with #10 x 44.45mm (1¾") PHL PH SMS, spaced 152.4mm (6") from each end and 304.8mm (12") on center

Specification: Testing Application Standard, Protocol 202.

5. PERFORMANCE RESULTS

Title of Test	Test Method	Measured	Allowed
Uniform Deflection @ 3600 Pa (75.0 psf) P.O. Stile	ASTM E 330-02		
-Positive		.508mm (.02")	4.57mm (0.180")
-Negative		1.27mm (.05")	4.57mm (0.180")
Uniform Deflection @ 3600 Pa (75.0 psf) P.O. Top Rail in between Snubbers	ASTM E 330-02		
-Positive		.762mm (.03")	3.40mm (0.134")
-Negative		2.03mm (.08")	3.40mm (0.134")
Air Infiltration @ 300 Pa (6.24 psf)	ASTM E 283-04	.10 l/s·m² (0.02 cfm/sf)	.5 l/s·m² (0.10 cfm/sf)
Water Resistance @ 580 Pa (12.00 psf)	ASTM E 547 & 331-00	No Leakage	No Leakage

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Signature: 11/11/10

Title of Test	Test Method	Measured	Allowed
Uniform Deflection @ 3600 Pa (75.0 psf) P.O. Stile	ASTM E 330-02		
-Positive		.762mm (.03")	4.57mm (0.180")
-Negative		1.77mm (.07")	4.57mm (0.180")
Uniform Deflection @ 3600 Pa (75.0 psf) P.O. Top Rail in between Snubbers	ASTM E 330-02		
-Positive		.762mm (.03")	3.40mm (0.134")
-Negative		2.28mm (.09")	3.40mm (0.134")
Uniform Structural	ASTM E 330-02		
-Positive			
-5400 Pa (112.5 psf)		No Damage	No Damage
-Negative			
-5400 Pa (112.5 psf)		No Damage	No Damage
-Permanent Set		3.81mm (.015")	4.53mm (.046")

Specification: Testing Application Standard, Protocol 201
Impact Diagrams, Appendix B

Test Specimen 1

Speed	Rotation	Title of Test	Measured	Allowable
50.6 fps	0°	Center of Glass	No Penetration	TAS 201
50.1 fps	0°	Lower Right Corner	No Penetration	TAS 201

Test Specimen 2

Speed	Rotation	Title of Test	Measured	Allowable
50.5 fps	0°	Upper Right Corner	No Penetration	1996-05b
49.8 fps	0°	Center of Glass	No Penetration	1996-05b

Test Specimen 3

Speed	Rotation	Title of Test	Measured	Allowable
50.9 fps	0°	Lower Left Corner	No Penetration	1996-05b
50.2 fps	0°	Center of Glass	No Penetration	1996-05b

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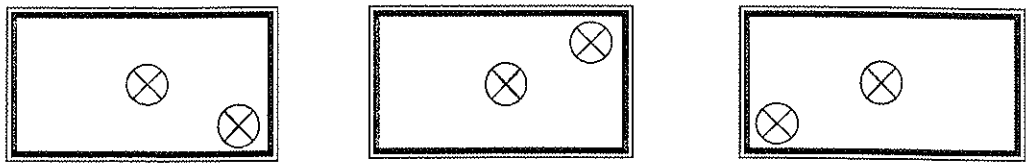
Signature: 11/11/10

TEST SPECIMEN 1 TEST SPECIMEN 2 TEST SPECIMEN 3



⊗ - Indicates 2nd impact to specimen.

The laboratory temperature was maintained at 81° F for the duration of testing. Test specimens were stored in the lab prior to testing and the skin temperature of the aluminum was recorded at 81° F.

Visual inspections performed on the test specimens revealed there were no penetrations through the laminate and no separation of vision-to-frame glazing at the conclusion of the large missile impact tests.

Specification: Testing Application Standard, Protocol 203

Test Specimens 1-3

Load Direction	Sequence	Range	Cycle Time	Cycles	Damage
75 psf Positive	Cycle 1	0.2 P to 0.5 P	< 3 seconds	3500	None
	Cycle 2	0 to 0.6 P	< 3 seconds	300	None
	Cycle 3	0.5 P to 0.8 P	< 3 seconds	600	None
	Cycle 4	0.3 P to 1.0 P	< 3 seconds	100	None
Load Direction	**Sequence**	**Range**	**Cycle Time**	**Cycles**	**Damage**
75 psf Negative	Cycle 1	0.3 P to 1.0 P	< 3 seconds	50	None
	Cycle 2	0.5 to 0.8 P	< 3 seconds	1050	None
	Cycle 3	0 to 0.6 P	< 3 seconds	50	None
	Cycle 4	0.2 P to 0.5 P	< 3 seconds	3350	None

Snubber Deflections

Load	Sequence	Range	Pos-Deflect.	Range	Neg-Deflect.
75 psf	Cycle 1	0.2 P to 0.5 P	.02"	0.3 P to 1.0 P	.090"
	Cycle 2	0 to 0.6 P	.025"	0.5 to 0.8 P	.070"
	Cycle 3	0.5 P to 0.8 P	.0275"	0 to 0.6 P	.070"
	Cycle 4	0.3 P to 1.0 P	.0310"	0.2 P to 0.5 P	.065"

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Signature: 11/11/10

Visual inspections performed on the test specimens revealed there were no penetrations through the laminate and no separation of vision-to-frame glazing at the conclusion of the cyclic pressure differentials.

Detailed extrusion and assembly drawings indicating measured wall thickness and corner construction are on file and have been compared to the test sample submitted. These records will be retained at **CCLI** for a period of four years.

6. DISCLAIMER

The above results were achieved by using the designated test methods and indicate compliance with the above specification. This report does not constitute certification of this product.

Respectfully submitted,
CONSTRUCTION CONSULTING LABORATORY, *INTERNATIONAL*

CHEVIS WILSON
TEST TECHNICIAN

JEFFREY CRUMP
TESTING MANAGER

Florida Registered Professional Engineers Review: Reg. # 52849, February 28, 2011 – Abdol Rezadad, P.E.
Signature: 11/1/10

APPENDICES

APPENDIX A

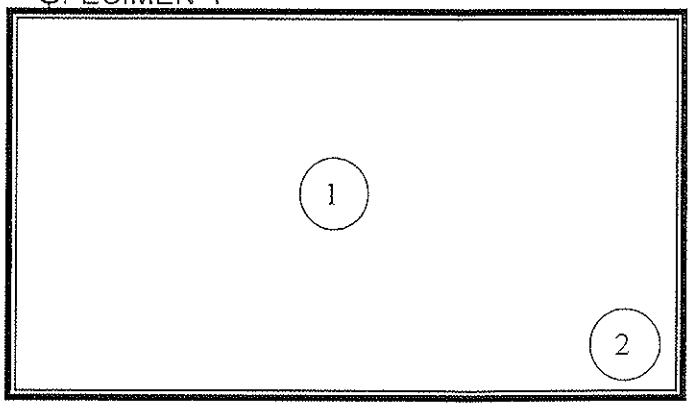
PRODUCT DRAWINGS

DRAWING	PART NO.	DATE
Bill of Materials and Elev.		
Series C7600-23 Page 2 of 4		9/3/10
Series C7600-23 Page 3 of 4		9/3/10
Series C7600-23 Page 4 of 4		9/3/10
Head, Jamb Deep Pocket Mullion	IG626	2/23/06
Filler	IG100	2/22/06
Sill	IG672	10/18/01
Glass Stop	IG663	10/18/01
Subsill	IG570	8/22/01
Tube	J-175	11/25/64

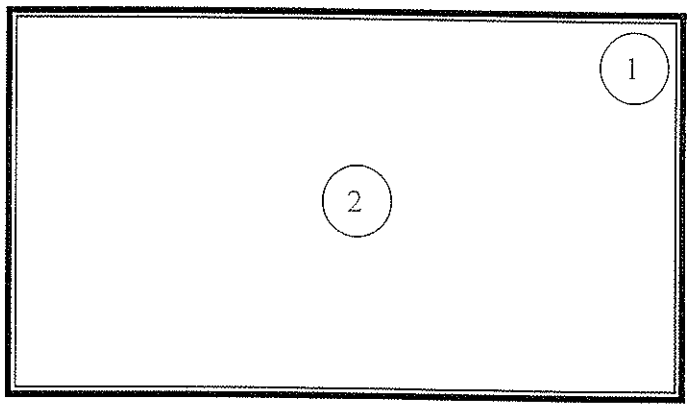
APPENDIX B

IMPACT DIAGRAM

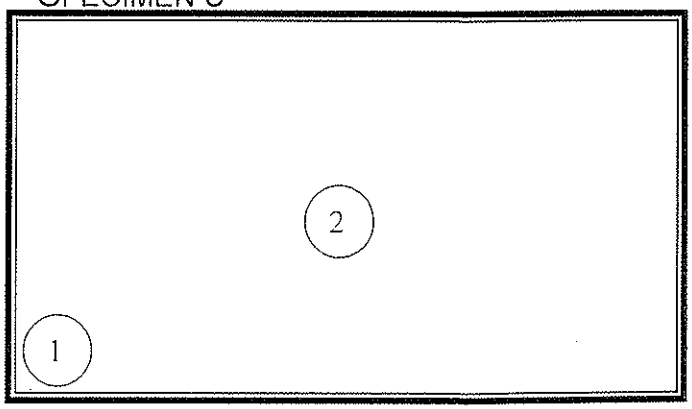
SPECIMEN 1



SPECIMEN 2

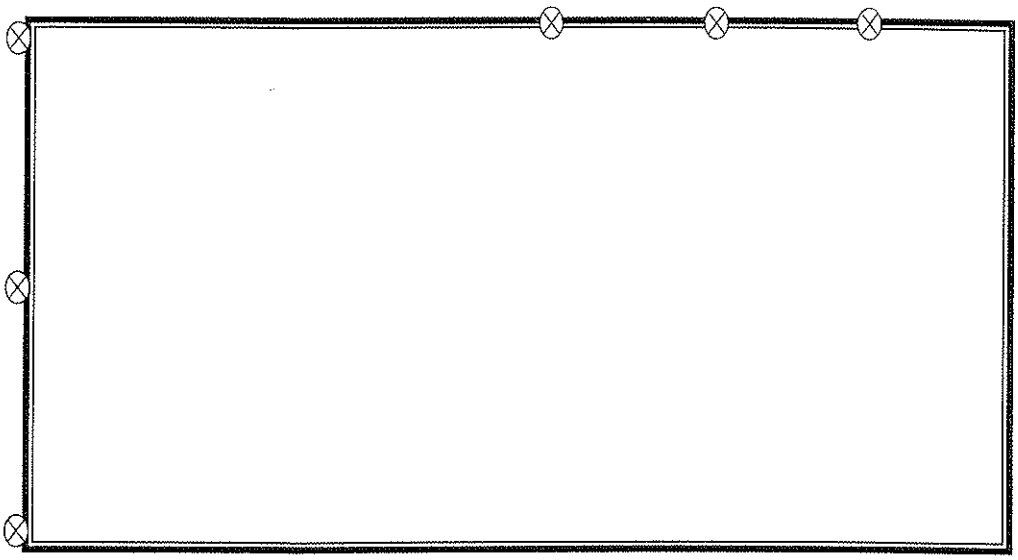


SPECIMEN 3



APPENDIX C

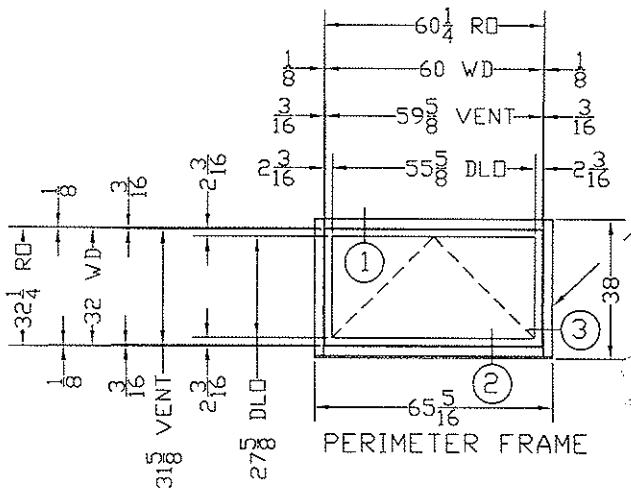
DEFLECTION DIAGRAM



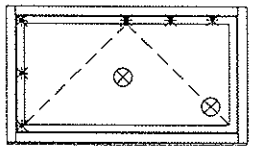
			CW7600	WINDOW		WINDOW				
QTY	MARK		TAS IMPACT	WIDTH	X	HEIGHT				
3	A			60.0000	X	32.0000				
				GLASS	X	GLASS				
			1" INSULATED	58.5000	X	30.5000				
			.187" HS CLEAR							
			.312" ALUMINUM SPACER							
			.187" HS CLEAR							
			.090" SAFGLAS							
			.187" HS CLEAR							
QTY	PART	DIE	DESCRIPTION	LENGTH						
			HORIZONTALS			OPERATION				
1	WN521	61582	HEAD	59.0000		CW7500-11				
1	WN521	61582	SILL	59.0000		CW7500-11	CW7500-18			
1	WN520	61581	VENT HEAD	59.6250		CW7500-10	CW7500-13			
1	WN520	61581	VENT SILL	59.6250		CW7500-10	CW7500-17			
			VERTICALS							
1	WN523	61583	RIGHT JAMB	32.0000		CW7500-12				
1	WN523	61583	LEFT JAMB	32.0000		CW7500-12				
1	WN520	61581	RIGHT VENT	31.6250		CW7500-13	CW7500-16			
1	WN520	61581	LEFT VENT	31.6250		CW7500-13	CW7500-16			
			ACCESSORIES							
4	WN524	61584	CORNER ANGLE	1.2300		CW7500-21				
2	WN526	61585	HINGE ADAPTER	8.0000		CW7500-16	<OR> NOTE: AMC PART# 1402-16 L or R			
3	WN526	61585	SNUBBER SHIM	4.0000						
1	WH342		WEATHERSTRIP	15.3333	FT	TREMCO				
1	NP810		WEATHER SWEEP	15.3333	FT	TREMCO				
10	RG750		TEMP GLAZING CLIPS							
1	GT900		SHIM TAPE	15.3333	FT	TREMCO				
			HARDWARE							
2	WH641		HYBRID HINGE	14"-16"		AMC				
1	1248		HANDLE			AMC				
1	8021 (OR) 8020		HANDLE CONNECTOR			AMC				
1	1326		DRIVE ARM			AMC				
1	1324		DRIVE PLATE			AMC				
3	1315		LOCK PLATE			AMC				
3	1355		KEEPER			AMC				
3	1356		KEEPER SHIM			AMC				
3	WH765		SNUBBER DRIVER			AMC				
3	WH766		SNUBBER RECEIVER			AMC				
2	WN526	61585	SLIDE BARS			<OR> AMC 6/6 OR ALUM				
			NOTE: THREE OPTIONS TESTED			UNIT #1	AMC ALUM			
						UNIT #2	AMC 6/6 NYLON			
						UNIT #3	INTEX ALUMINUM			
			FASTENERS							
2			SHCS @ HANDLE			AMC				
2	1336		SHFH @ HNDL CONC			AMC				
2			SH SET @ SHIM			AMC				
8	ST241		ASSEMBLY SCREWS			VARIES				
12	ST242		ARM SCREWS			VARIES				
10	ST361		TEMP CLIP SCREWS			VARIES				
6	ST242		SNUBBER SCREWS			VARIES				
			POLYURETHANE THERMAL FILL			AZON				
	PERIMETER FRAMING - SIMULATING APPROVED PERIMETER STOREFRONT OR CURTAINWALL									
2	IG626		REPRESENTING			INTEX				
2	IG626		IMPACT APPROVED			INTEX				
2	IG100		STOREFRONT			INTEX				
2	IG100		OR CURTAINWALL			INTEX				
2	J-175					INTEX				
2	J-175					INTEX				
1	IG570					INTEX				
1	IG663					INTEX				
1	IG672					INTEX				
			SEALANTS							
	UNIT #1		TREMCO PROGLAZE SSG / TREMCO SECTRUM2							
	UNIT #2		TREMCO PROGLAZE SSG / TREMCO SECTRUM2							
	UNIT #3		DOW 995 / DOW 795							

75096

SYM	REVISION	DATE	BY

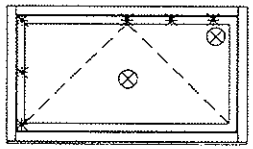


NOTE:
IG600 FRAME USED TO SIMULATE APPROVED IMPACT STOREFRONT OR CURTAINWALL PERIMETER SYSTEM. ANCHORED IN YELLOW PINE BUCK



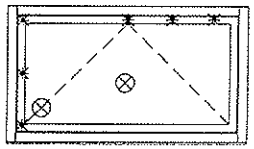
UNIT #1

AMC ALUMINUM
SLIDE BAR
USES TREMCO
SEALANTS



UNIT #2

AMC 5/6 NYLON
SLIDE BAR
USES TREMCO
SEALANTS



UNIT #3

INTEX
ALUMINUM
SLIDE BAR
USES DOW
SEALANTS

A

QTY = 3

SYMBOL KEY			
SYMBOL	DESCRIPTION	QTY	COMMENTS
A	58.625 X 30.625	3	1 INS= 3/16"HSCLR 5/16" Air 3/16"HSCLR .090 SG 3/16" HSCLR
*	INDICATOR LOCATIONS		
⊗	IMPACT LOCATIONS		

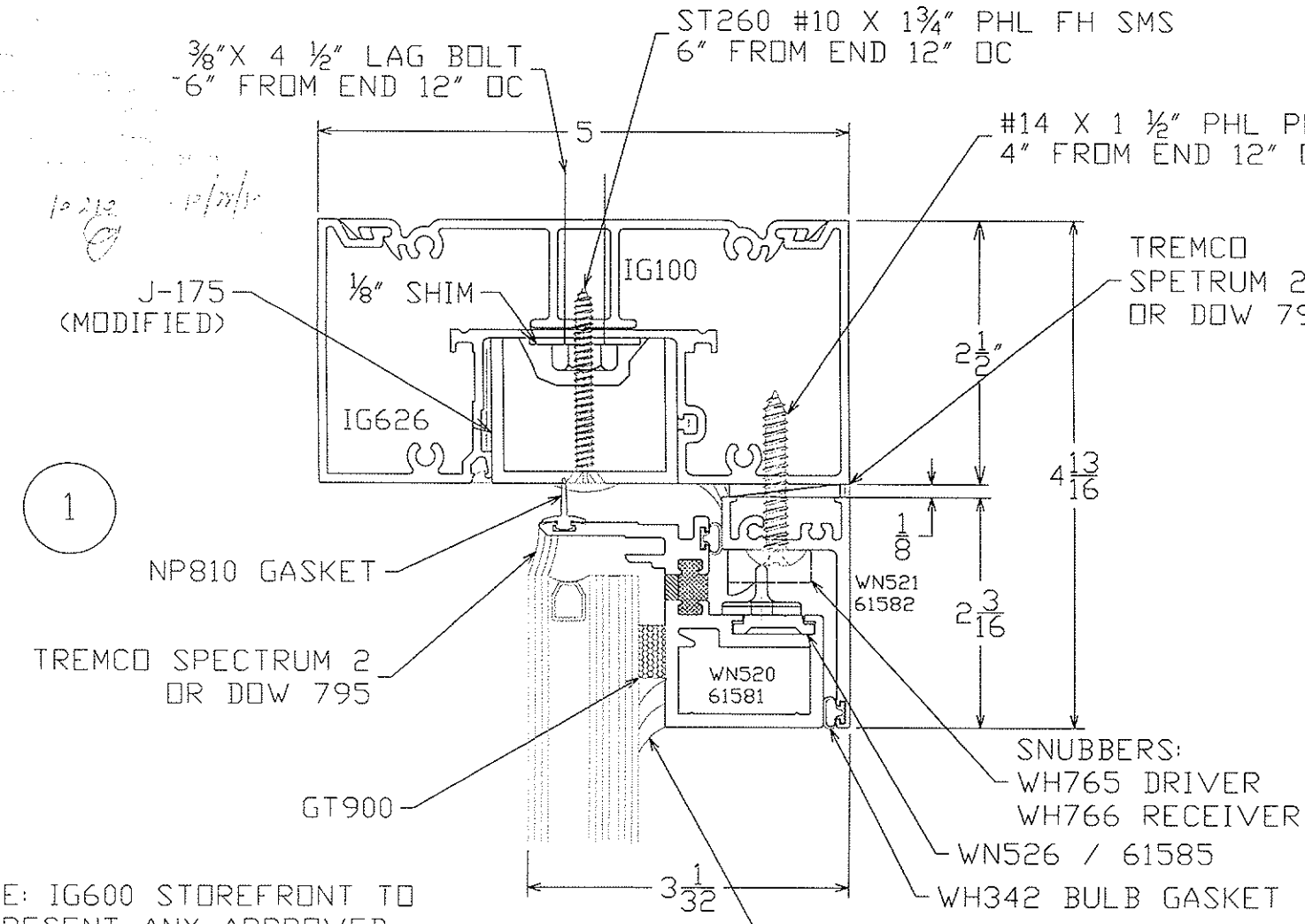
THIS SPACE RESERVED FOR STRUCTURAL ENGINEER

THIS SPACE RESERVED FOR METRO-DADE USE ONLY

United States Aluminum
- 720 Cel-River Road
Rock Hill, SC 29730
- 200 Singleton Drive
Waxahachie, TX 75165

DRAWN BY: DCW	SYSTEM: 7600 PROJECTED VENT
DATE: 09.03.10	
APPROVED BY:	DESCRIPTION: ELEVATIONS
SCALE: 3/4" = 1"	DRAWING NO: C7600-23
	SHEET: 1 OF 4

SYM	REVISION	DATE	BY



NOTE: IG600 STOREFRONT TO REPRESENT ANY APPROVED IMPACT STOREFRONT OR CURTAINWALL FRAMING.

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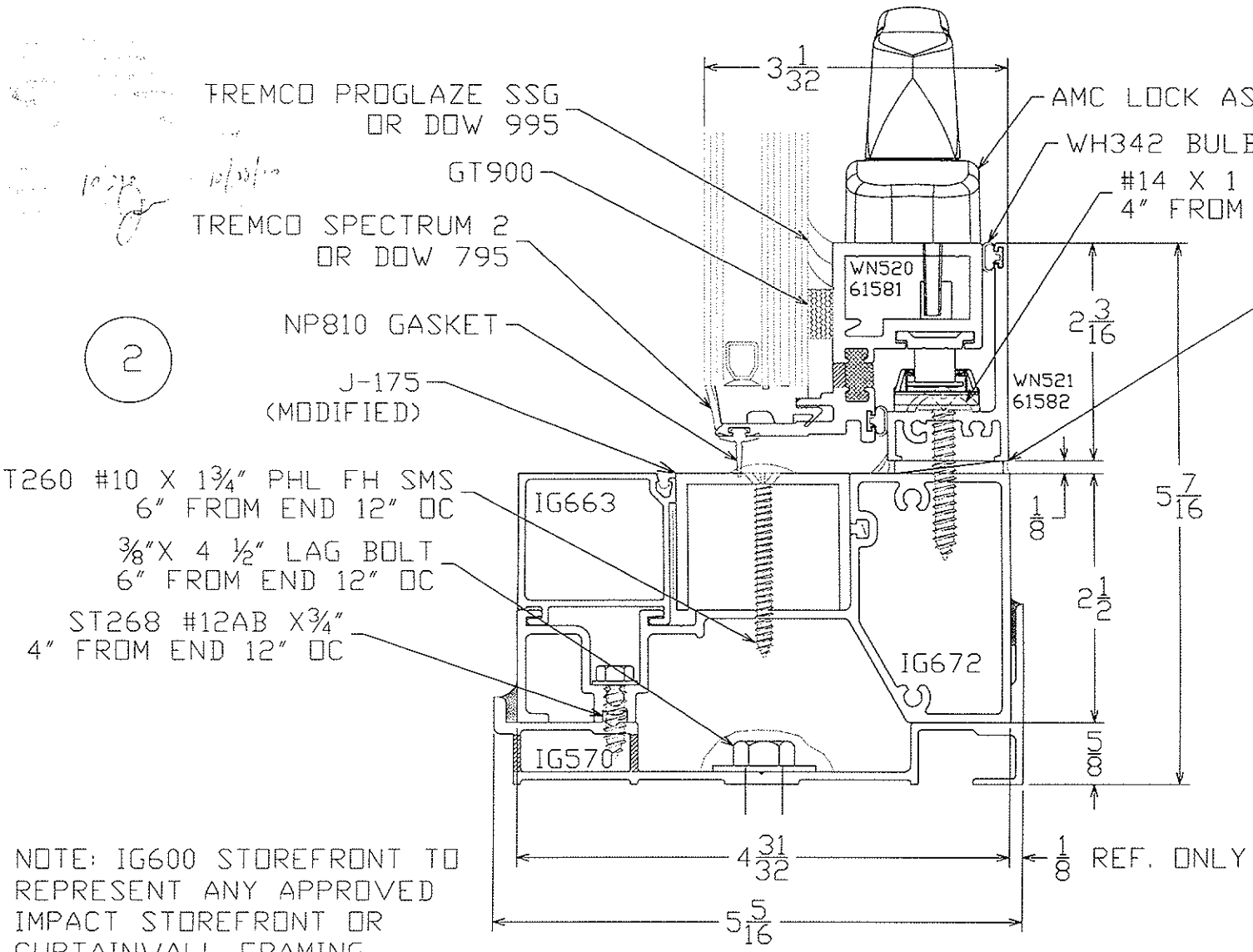
United States Aluminum
720 Cel-River Road
Rock Hill, SC 29730
200 Singleton Drive
Waxahachie, TX 75165

DRAWN BY: DCW	SYSTEM: 7600 PROJECTED VENT
DATE: 09.03.10	
APPVD BY:	DESCRIPTION: DETAILS
SCALE: FULL	DRAWING NO.: C7600-23
	SHEET: 2 OF 4

SYM	REVISION	DATE	BY



2

NOTE: IG600 STOREFRONT TO REPRESENT ANY APPROVED IMPACT STOREFRONT OR CURTAINWALL FRAMING.

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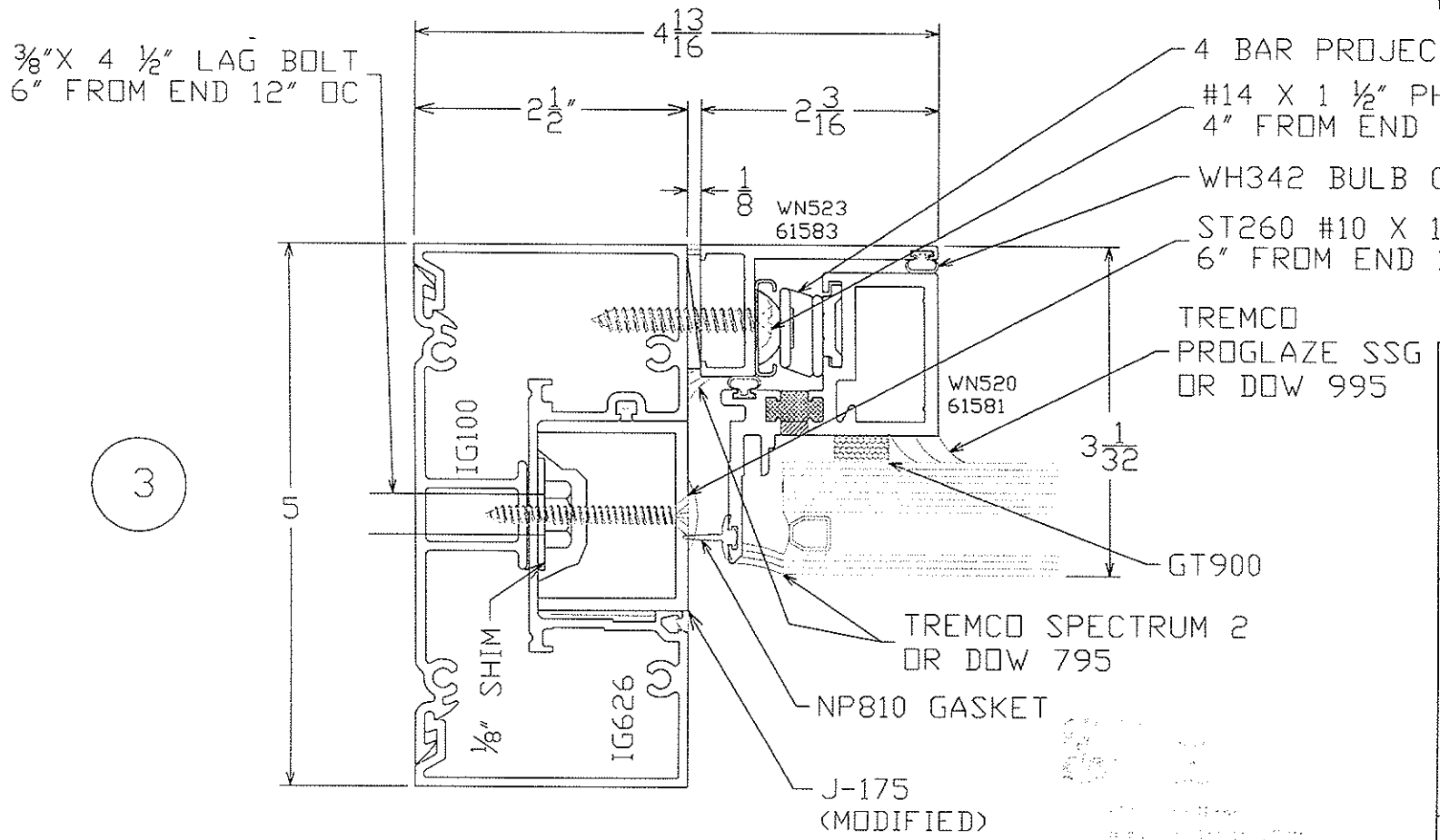
720 Col-River Road
Rock Hill, SC 29730
200 Singleton Drive
Waxahachie, TX 75165

DRAWN BY: DCW	SYSTEM: 7600 PROJECTED VENT
DATE: 09.03.10	
APPVD BY:	DESCRIPTION: DETAILS
SCALE: FULL	DRAWING NO.: C7600-23
	SHEET: 3 OF 4

SYM	REVISION	DATE	BY



3

NOTE: IG600 STOREFRONT TO REPRESENT ANY APPROVED IMPACT STOREFRONT OR CURTAINWALL FRAMING.

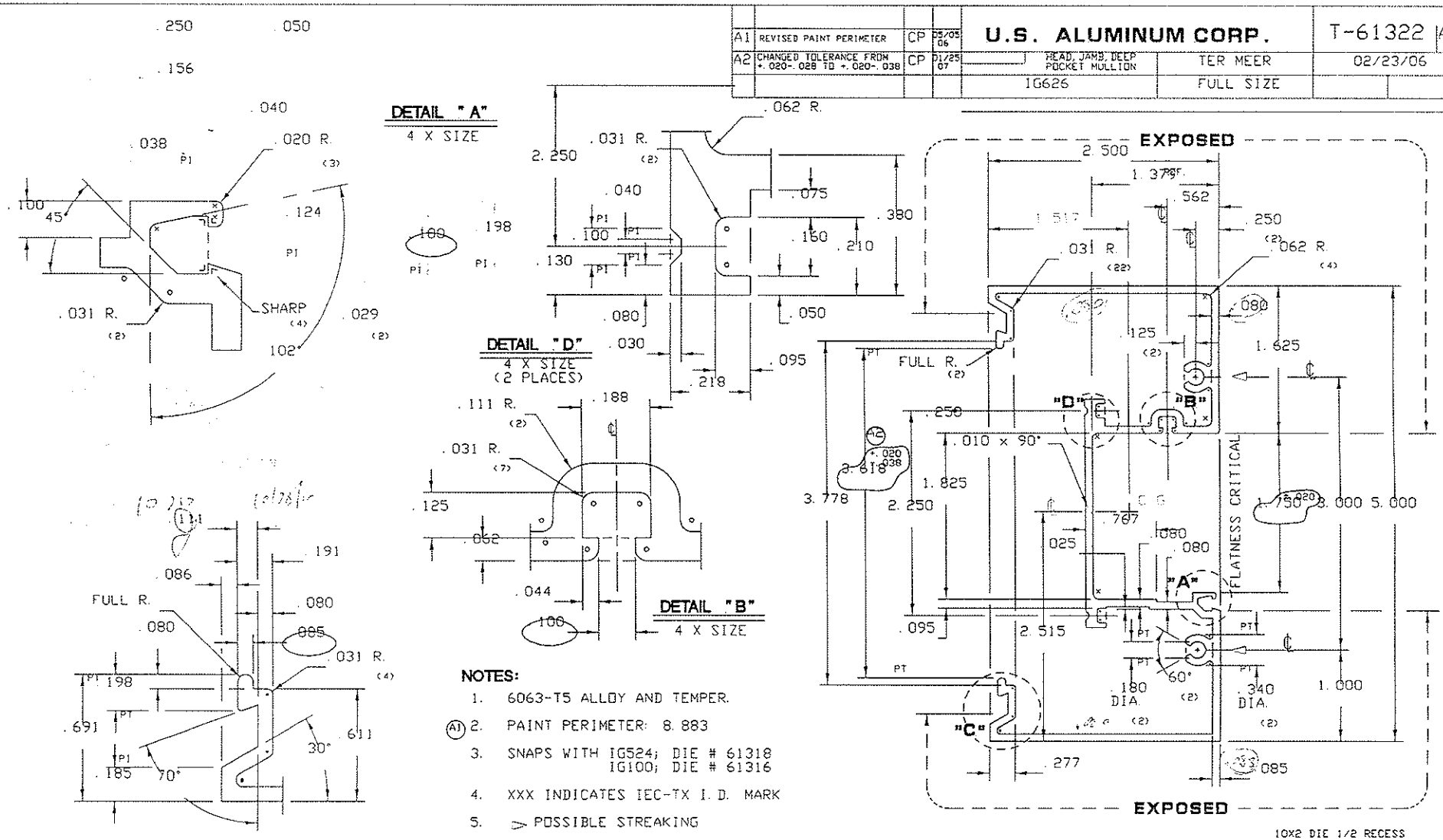
THIS SPACE RESERVED FOR STRUCTURAL ENGINEER

THIS SPACE RESERVED FOR METRO-DADE USE ONLY

United States Aluminum
720 Cel-River Road
Rock Hill, SC 29730
200 Singleton Drive
Waxahachie, TX 75165

DRAWN BY: DCW	SYSTEM: 7600 PROJECTED VENT
DATE: 09.03.10	
APPVD BY:	DESCRIPTION: DETAILS
SCALE: FULL	DRAWING NO.: C7600-23
	SHEET: 4 OF 4

A1	REVISED PAINT PERIMETER	CP	05/05/06	U.S. ALUMINUM CORP.		T-61322 A2
A2	CHANGED TOLERANCE FROM +.020-.028 TO +.020-.038	CP	01/25/07	HEAD JAMB, DEEP POCKET MULLION	TER MEER	02/23/06
				IG626	FULL SIZE	



NOTES:

1. 6063-T5 ALLOY AND TEMPER.
2. (A1) PAINT PERIMETER: 8.883
3. SNAPS WITH IG524; DIE # 61318
   IG100; DIE # 61316
4. XXX INDICATES IEC-TX I.D. MARK
5. ⊃ POSSIBLE STREAKING

4.436 IN⁴
1.764 IN³
0.875 IN⁴
0.577 IN³

10X2 DIE 1/2 RECESS

			.080
	1.393	C-1418	1
	1.672	5.590	10 X 61322
	33.309	SOLID	61319
	20	8' 38 / SUE	T-61322 A2

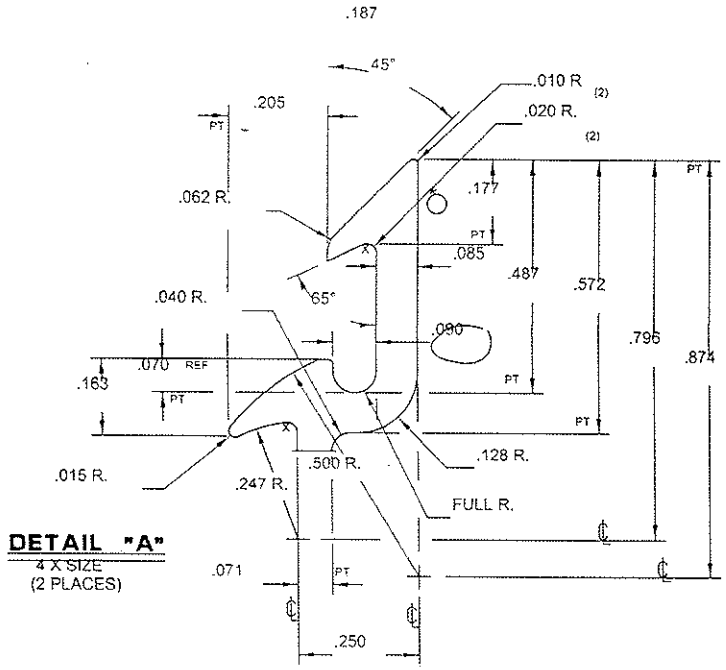
SYM	REVISION	BY	DATE

CUSTOMER: **U.S. ALUMINUM CORP.**

DIE NO.: H-61316

PART NAME: PERIMETER FILLER	DRAWN: TER MEER	DATE: 02/22/06	
PART NO.: IG100	SCALE: FULL SIZE	CHKD	APP.

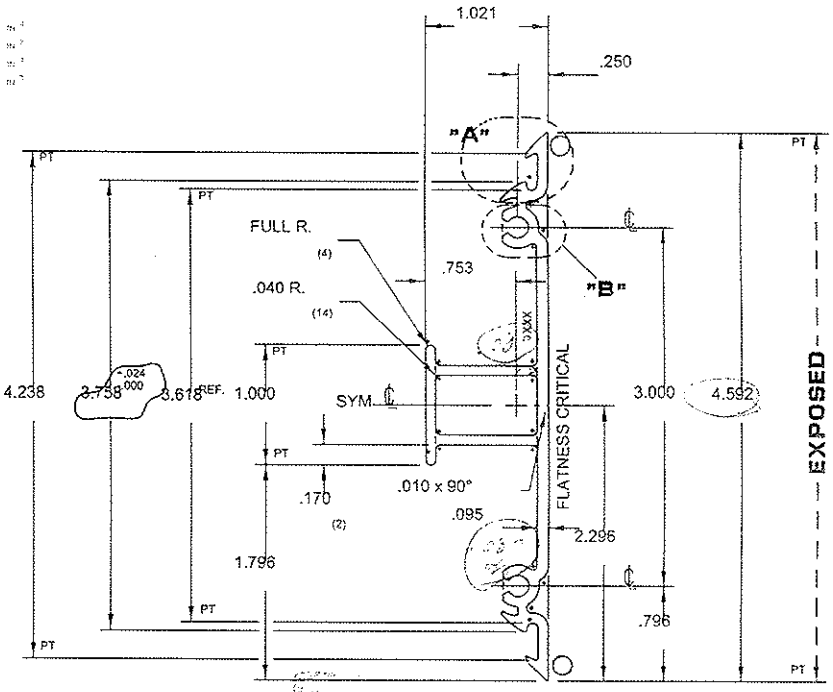
STANDARD TOLERANCES FOR EXTRUDED SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

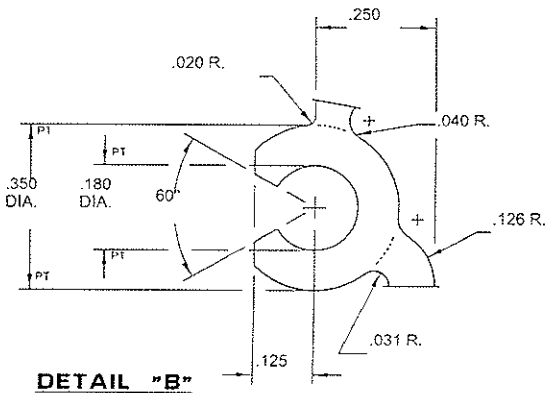


DETAIL "A"
4 X SIZE
(2 PLACES)

SECTION PROPERTIES

I_{xx} =	1.090	in^4
S_{xx} =	0.475	in^3
I_{yy} =	0.077	in^4
S_{yy} =	0.102	in^3





DETAIL "B"
4 X SIZE
(2 PLACES)

NOTES:

1. 6063-T5 ALLOY AND TEMPER.
2. PAINT PERIMETER: 4.961
3. SNAPS WITH IG526; DIE #
   IG626; DIE #
   IG525; DIE #
   IG625; DIE #
4. XXX INDICATED I.D. MARK FOR IEC-TX.
5. INDICATES POSSIBLE STREAKING.
6. OUTSIDE PERIMETER: 14.908

PRODUCT:
PROJECT:

☐ CA
☐ TX

UNLESS OTHERWISE NOTED,
ALL CORNERS ARE .015 R, AND TYPICAL WALL THICKNESS IS .080

International Extrusion Corporation
202 SINGLETON DRIVE (972) 937-7032
WAXAHACHIE TEXAS 75165

EST. AREA: .771	US-NO. C-1412	PORTS 1	
EST. WT/FT: .925	CIRCLE SIZE IN. 4.592	BACKER PORTHOLE 10 x 5.5	
EST. PERI: 17.539	CLASS	BOLSTER: 1-4	
FACTOR : 19	ER: - 7 53/LOIS	DIE NO. H-61316	

SYM	REVISION	BY	DATE

CUSTOMER: U. S. ALUMINUM CORP.

DIE NO: T-60845

PART NAME: SILL SF500 STORM-FRONT

DRAWN: TER MEER

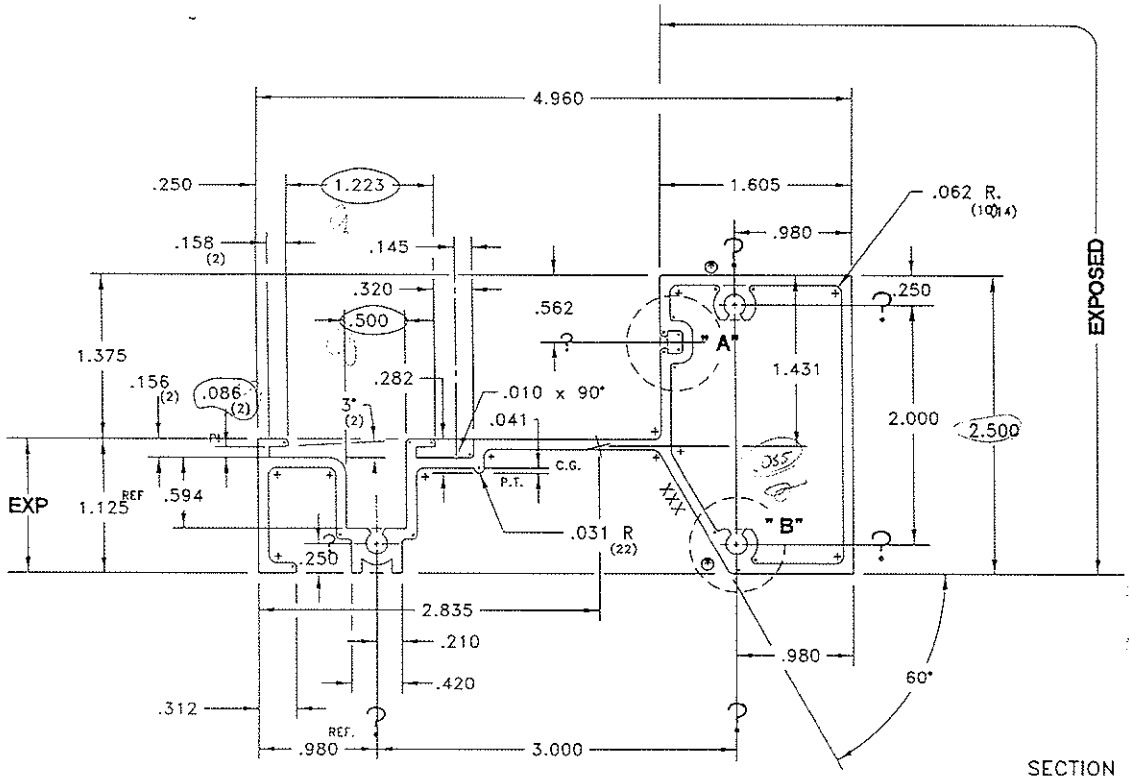
DATE: 10/18/01

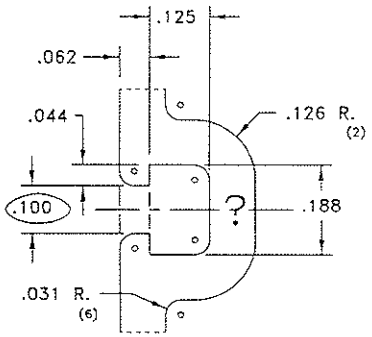
ALLOY: 6063

SCALE: FULL SIZE

DRAWN: CHK'D:

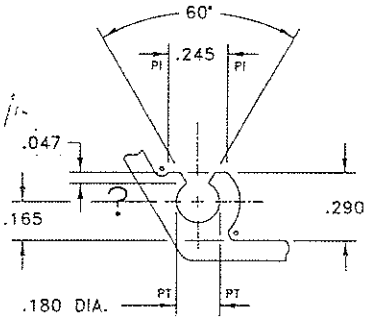
STANDARD TOLERANCES FOR EXTRUDED SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE





DETAIL "A"

4 X SIZE
2 PLACES



DETAIL "B"

2 X SIZE
SIM. 3 PLACES

NOTES:

1. 6063-T5 ALLOY AND TEMPER.
2. PAINT PERIMETER: 5.230
3. OUTSIDE PERIMETER: 22.100
4. XXX INDICATES IEC-TX I.D. MARK
5. PT INDICATES STREAKING POSSIBLE
6. ASSEMBLES WITH C-428; DIE #

SECTION PROPERTIES:

Ixx = 3.848 in^4
Sxx = 1.357 in^3
Iyy = 0.870 in^4
Syy = 0.608 in^3

☐ CA
☐ TX

UNLESS OTHERWISE NOTED ALL CORNERS ARE .062 R. AND TYPICAL WALL THICKNESS IS .085

International Extrusion Corporation

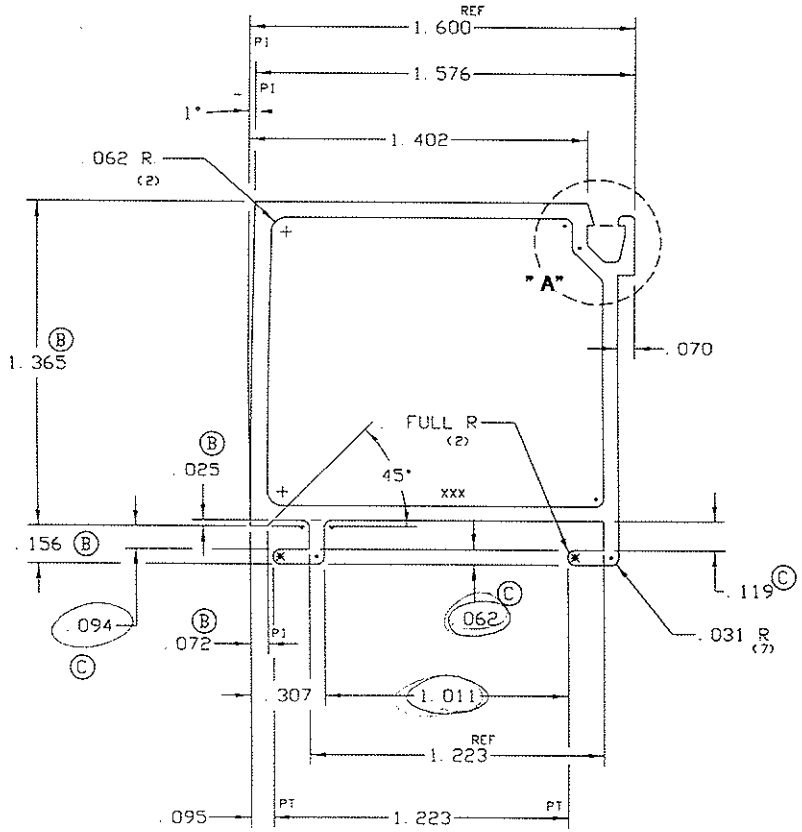
201 SINGLETON DRIVE (972) 637-7030 WAXAHACHIE, TEXAS 75165

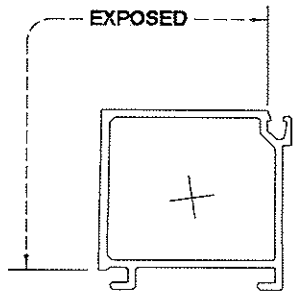
EXT. AREA	1.385	DIE NO.	C-427
EXT. WEIGHT	1.662	PRESS SIZE	5.554 "D"
EXT. PERI	31.022	SHAPE	HOLLOW III
FACTOR	19	PRESS	8" - 39/SHIRLEY

POINTS: 1
PRESS: PORTHOLE 12x6.5
BILLETS: 60776
DIE NO: T-60845

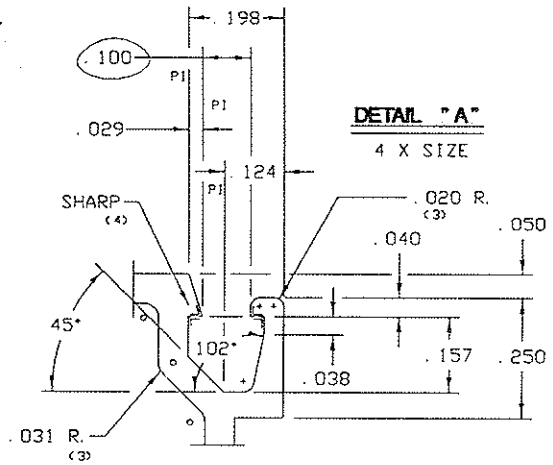
PROPOSED BY:
PROJECT:

B	REVISE HOOK DIMS	CP	11/13 02	U. S. ALUMINUM CORP.		T-60843 C
C	ELIM .038 R & HOOK; ADD PRS CHK. ECN USA03-033	GAH	05/16 03	GLASS STOP SF500 STORM-FRONT	R. TER MEER	10/18/01
				1G663	2 X SIZE	





ACTUAL SIZE



DETAIL "A"
4 X SIZE

NOTES:

1. 6063-T5 ALLOY AND TEMEPR.
2. OUTSIDE PERIMETER: 7.535
3. PAINT PERIMETER: 2.743
4. XXX INDICATES I.D. MARK FOR IEC-TX.

.062

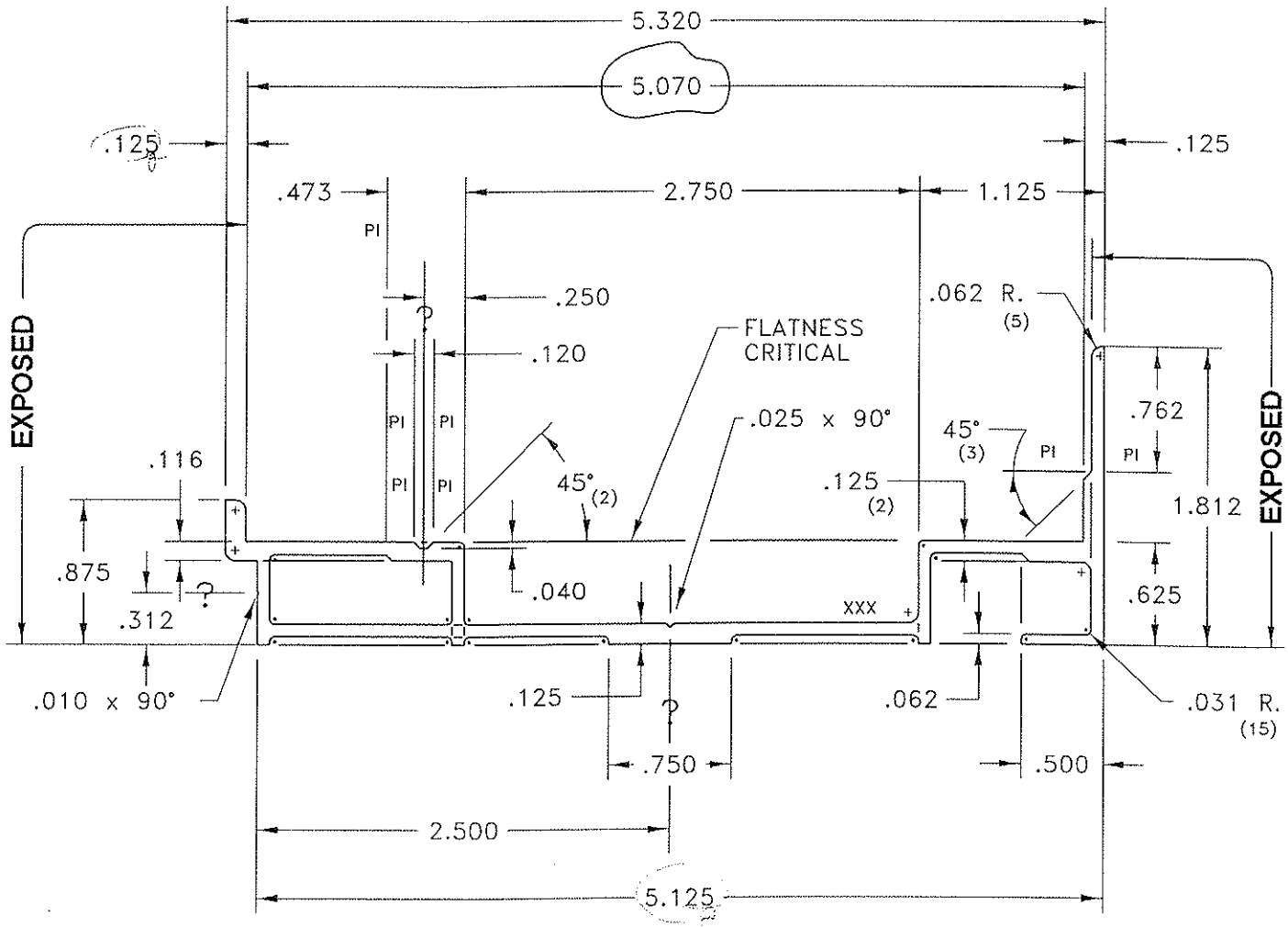
.405 C	C-428	1
.486 C	2.128	PORTHOLE 10x5.5
12.552 C	HOLLOW II	STD-2
26	7' 49/BARBARA	T-60843 C

CUSTOMER: U. S. ALUMINUM CORP.			DIE NO. H-60779
PART NAME: 16500 IMPACT SUBSILL	DRAWN: TER MEER		DATE: 08/22/01
ASS'Y NO: IG570	SCALE: FULL SIZE		CHK'D: APP'D:

STANDARD TOLERANCE PER EXTRUDED SHAPES APPLY UNLESS SPECIFICALLY SHOWN OTHERWISE

NOTES:

1. 6063– T5 ALLOY AND TEMPER
2. OUTSIDE PERIMETER: 17.725
3. PAINT PERIMETER: 1.182
4. XXX INDICATES IEC–TX I.D. MARK.



PRODUCT:
PROJECT:

UNLESS OTHERWISE NOTED,
ALL CORNERS ARE .015 R. AND TYPICAL WALL THICKNESS IS .075

International Extrusion Corporation
303 SHOLETON DRIVE WAXAHACHIE
(972) 937-9922 TEXAS 75165

EST. AREA: .894	US-NO. C-392	PORTS	
EST. WT/FT: 1.073	CIRCLE SIZE 5.494 IN.	BACKER	
EST. PERI: 20.704	CLASS. HOLLOW II	BOLSTER	
FACTOR: 19	ER–	DIE NO. H-60779	

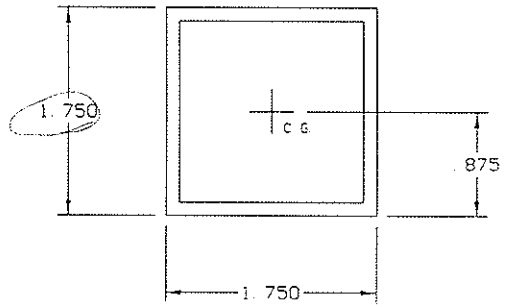
B	REVISED BOL CALLOUT	F	5/17 73	U.S.ALUMINUM CORP.		H-4571 C1
C	ADDED NOTE	IRC	3/10 75	1 3/4" x 1 3/4" SQ. TUBE	J. D.	11/25/64
C1	WT/FT CAL'D @ 1.176	DG	08-24 99	J-175	FULL SIZE	

NOTE:

1. **ALL OUTSIDE SURFACES EXPOSED**
2. OUTISDE PERIMETER= 7.000

SECTION PROPERTIES:

Ixx = 0.330 in^4
Sxx = 0.377 in^3
Iyy = 0.330 in^4
Syy = 0.377 in^3



.112

	.734		
	.863 (C1)	2.475	
	13.104	HOLLOW II	
	15	8' 74 / SUE	H-4571 C1

- END OF REPORT –