

**CLIENT:** Siber Facade Group  
230-7270 Market Crossing  
Burnaby, British Columbia  
V5J 0A2  
Canada

<b>Test Report No: BUR0125-DW-c</b>	<b>Issue Date: January 23, 2024</b>
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**SAMPLE ID:** Siber Facade Group Alpine HD Aluminum Fixed Window.

**SAMPLE DESCRIPTION:** Width: 1500 mm; Height: 2000 mm. See page 6 for full description.

**SAMPLING DETAIL:** Test sample from Siber Facade Group was submitted directly to QAI.

**DATE OF RECEIPT:** Test sample was received on November 8, 2023.

**TESTING PERIOD:** Testing was conducted November 9, 2023 – January 23, 2024.

**TESTING LOCATION:** QAI Laboratories Ltd., Burnaby, BC, Canada.

**AUTHORIZATION:** Proposal #23MT07263, signed by Andrew Pushka dated July 26, 2023.

**TEST PROCEDURE:** Testing was performed following the methods and requirements outlined in the following standards:  
**AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS – North American Fenestration Standard/Specification for windows, doors, and skylights.**  
**CSA A440S1-19 – Canadian Supplement to NAFS 2017.**

**TEST RESULTS:** Alpine HD Aluminum Fixed Window  
Class CW - PG100: Size tested 1500 x 2000 mm (~59 x 79 in) – Type FW

Detailed test results and product ratings are available on pages 4-5.

**CONTENTS:** Test Report pages 1 through 19.

**Prepared By** Signed for and on behalf of  
QAI Laboratories, Ltd

*Robbie Manuel*

**Robbie Manuel**  
Project Manager



**Neil Dumont**  
Fenestration Reviewer

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## TEST CONDITIONS:

### **AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS and CSA A440S1-19**

QAI Laboratories Ltd. (QAI) was retained by Siber Facade Group to perform testing in accordance with the mandatory test requirements of AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS and CSA A440S1-19 on a representative sample of a 1500 mm x 2000 mm Alpine HD Aluminum Fixed Window.

This report includes tests performed on a specimen of specific dimensions. Actual product performance may be affected by variations in the windows dimensions, assembly details and installation method. The drawings supplied by the client were verified by QAI for the window unit tested and are shown in Appendix A.

Installed by: Siber Facade Group

Installation details:

- Three aluminum L-angles are inserted into the outermost T-slot of the exterior aluminum frame component. A 1300 mm length is used along the head and an 1800 mm length is used along each jamb.
- The L-angles are fastened to the test buck with #10 x 2" self-tapping panhead screws through pre-punched holes spaced 155 mm apart along the head and 174 mm apart along each jamb.
- Four lengths of 1/4" foam backing rod were used around the perimeter of the window frame.
- Silicone was applied between the window frame and test buck on the interior side.

Wooden test buck details:

- Inner frame: nominal 2" x 6" stud framing.
- Outer frame: nominal 2" x 12" stud framing.
- Rough opening: The rough opening is 1" larger in width and 1/4" larger in height than the test specimen.
- Shims: None used.

**PRODUCT RATINGS:**

**Table 1: Summary of Test Results**

Test Name	<b>AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS and CSA A440S1-19 Results:</b>
<b>Air Leakage (ASTM E283)</b>	Test pressure = 75 Pa Infiltration = 0.121 L/s/m <sup>2</sup> (0.024 cfm/ft <sup>2</sup> ) Exfiltration = 0.131 L/s/m <sup>2</sup> (0.026 cfm/ft <sup>2</sup> ) Overall result – Pass CW class requirements  Test pressure = 300 Pa Infiltration = 0.113 L/s/m <sup>2</sup> (0.022 cfm/ft <sup>2</sup> ) Exfiltration = 0.274 L/s/m <sup>2</sup> (0.054 cfm/ft <sup>2</sup> ) Reported only
<b>Water Penetration (ASTM E547)</b>	Maximum pressure differential = 720 Pa (DP 100 – 15.04 psf) <sup>1</sup>
<b>Uniform Load Deflection (ASTM E330 – Procedure A)</b>	Design Pressure = 4800 Pa (DP 100) Maximum pressure differential = 5760 Pa (120.30 psf) L/175 Deflection limit for CW class = 11.2 mm (0.442") Deflection at pressure = 4.0 mm (0.159") Deflection measured along the left jamb looking from the interior.
<b>Uniform Load Structural (ASTM E330 – Procedure A)</b>	Design pressure = 4800 Pa (DP 100) Maximum pressure differential = 7200 Pa (150.38 psf)
<b>Forced Entry Resistance Test (ASTM F588-17)</b>	Grade 10 – Pass

<sup>1</sup> The window frame was sealed to the test buck along the entire perimeter on the interior side and was not evaluated for water penetration at the frame corner joints and their fastening screws.

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**Table 2. Product Classification**

<b>Alpine HD Aluminum Fixed Window</b>	
<b>Maximum Size Tested:</b>	1500 mm wide x 2000 mm tall (~59 x 79 in)
<b>Performance Classification:</b>	CW
<b>Performance Grade:</b>	PG100
<b>Product Type:</b>	FW
<b>Primary Designator:</b> Class CW - PG100: Size tested 1500 x 2000 mm (~59 x 79 in) – Type FW	
<b>Secondary Designator:</b> Positive ASD Design Pressure (DP) = 4800 Pa (100.25 psf) Negative ASD Design Pressure (DP) = -4800 Pa (-100.25 psf) Water Penetration Resistance Test Pressure = 720 Pa (15.04 psf) Air Infiltration / Exfiltration = Pass	

**Notes:**

- AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS, Clause 8.2.4: The air, water, and structural tests required by this Standard/Specification are performed on test specimens installed in a fixture that permits installation in accordance with the manufacturer’s documented instructions. These tests are used to evaluate the performance of the fenestration product only and are not intended to test the performance of the installation, particularly the perimeter sealants between the fixture and the test specimen and the anchoring of the test assembly to the test fixture.
- Products not installed according to the installation method described in this report may not perform to an equivalent performance level.

**Table 3. Product Description**

<b>Alpine HD Aluminum Fixed Window</b>		
<b>Frame:</b>	Description:	Thermally broken insulated aluminum frame profile. Frame dimensions: Width: 1500 mm; Height: 2000 mm.
	Joints:	Mitre cut and sealed with silicone at the joining faces. Two aluminum corner keys per corner joint. One corner key inserted into both the interior and exterior aluminum frame components and sealed in place with silicone.
	Insulation:	Rigid insulation used in the thermal break cavity and on the rough opening side of the thermal break.
<b>Glazing Method:</b>	Interior Seal: (Glazing Bead and Gasket)	Aluminum glazing bead profile. Four strips of glazing bead used around the window perimeter; butt joined at corners. Four lengths of rubber glazing gasket (Gasket Code 200 162) inserted between the glazing bead and IGU; butt joined at corners.
	Glazing Foam Insulation:	Four lengths of glazing foam insulation around the perimeter of the window frame inserted between the frame and IGU.
	Heel Bead:	A silicone heel bead was applied on the interior side of the IGU, extending the entire length up each jamb.
	Exterior Seal: (Glazing Gasket)	Four lengths of rubber glazing gasket (Gasket Code 200 158) inserted between the exterior aluminum frame component and IGU; butt joined and sealed with silicone at corners.
	Setting Blocks:	Three 3-1/2" x 1" x 1/4" plastic setting blocks were used. <ul style="list-style-type: none"> <li>• Sill: One setting block each centered 2" from the inside face of either jamb.</li> <li>• Left jamb, looking from the interior: One setting block centered 4" from the inside face of the head.</li> </ul>
<b>Glazing:</b>	Description:	Three tempered glass panes with a thickness of 6 mm each. Overall IGU thickness: 42 mm.
<b>Drainage:</b>	Frame:	<u>Into the frame:</u> Three 1/2" x 1/4" drainage slots machined into the sill, centered 8", 29-1/2" and 51" from the outer edge of the left jamb, looking from the interior. <u>Out of the frame:</u> Seven 1/2" x 1/4" drainage slots machined out of the sill and spaced 8" apart.

**CONCLUSION / FINDINGS:**

QAI Laboratories Ltd. has performed testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS and CSA A440S1-19 requirements, on a representative sample of a Siber Facade Group. Alpine HD Aluminum Fixed Window. Testing was performed at the Burnaby, BC location.

Test results in this report may not be reproducible in the field. Test results relate only to those products tested.

See Table 1 for a summary of test results and window ratings. The sample tested was found to comply with the applicable requirements and obtained test results as reported in Table 1 of this report.

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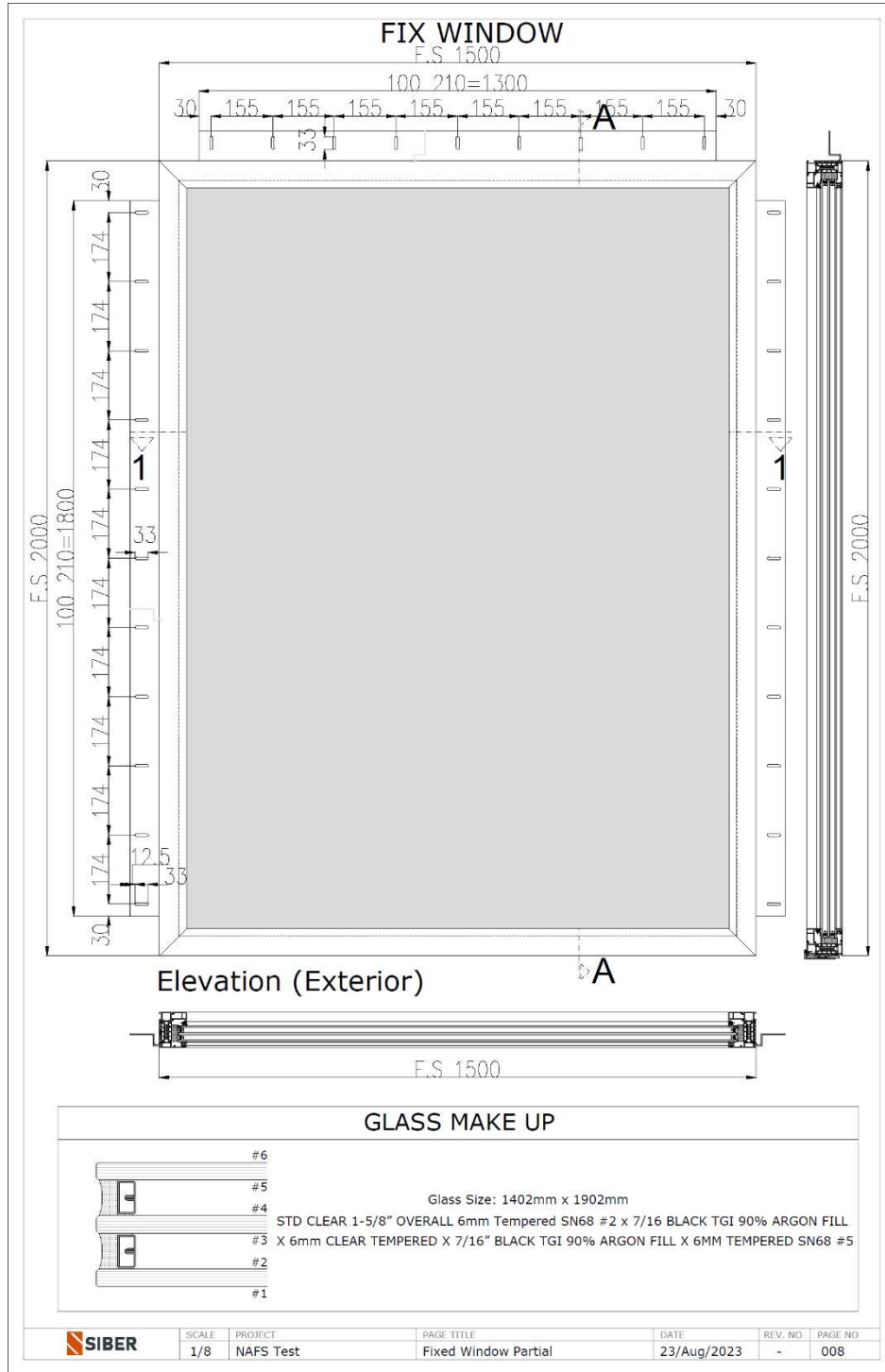
**APPENDIX A**  
(Drawings and photographs specifications)

<b>Page</b>	<b>Title</b>
8	Elevation Drawing
9-11	Cross-Section Assembly Drawings
12-15	Dimensioned Die/Profile Drawings
16-18	Sample Photographs

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**Elevation Drawing**

Dimensions are in mm.

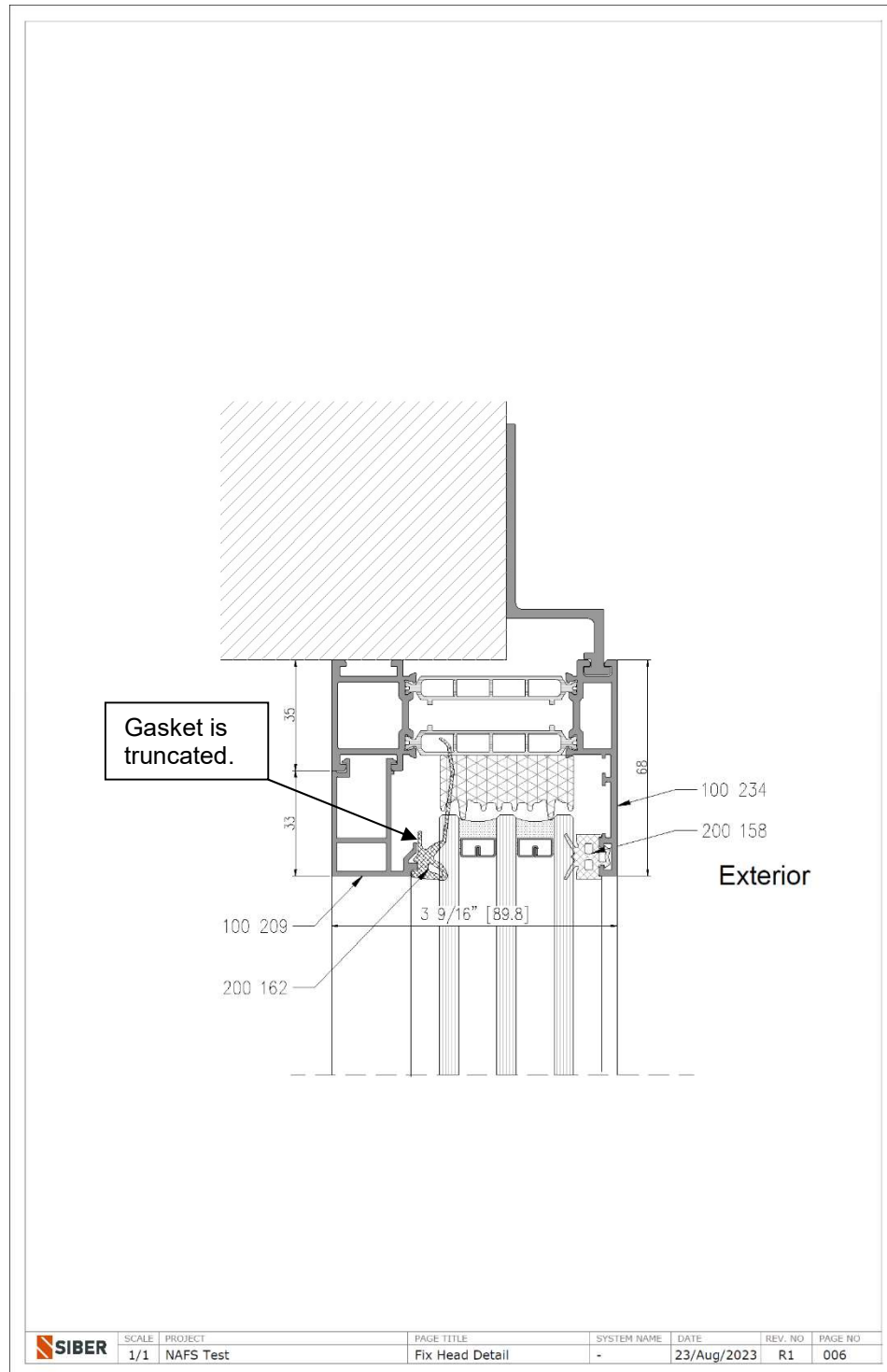


**Alpine HD Aluminum Fixed Window – Elevation**

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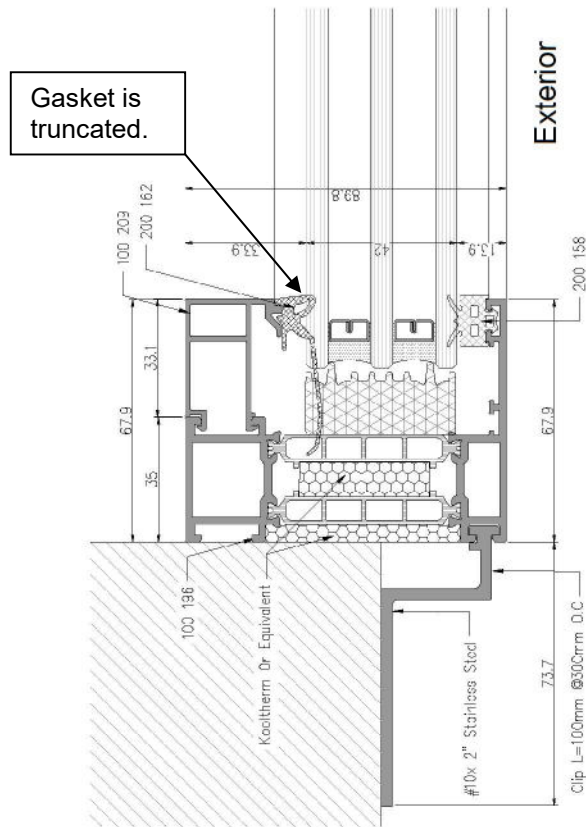
**Cross-Section Assembly Drawings**



**Alpine HD Aluminum Fixed Window – Assembly Cross-Section – Head**

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Dimensions are in mm.

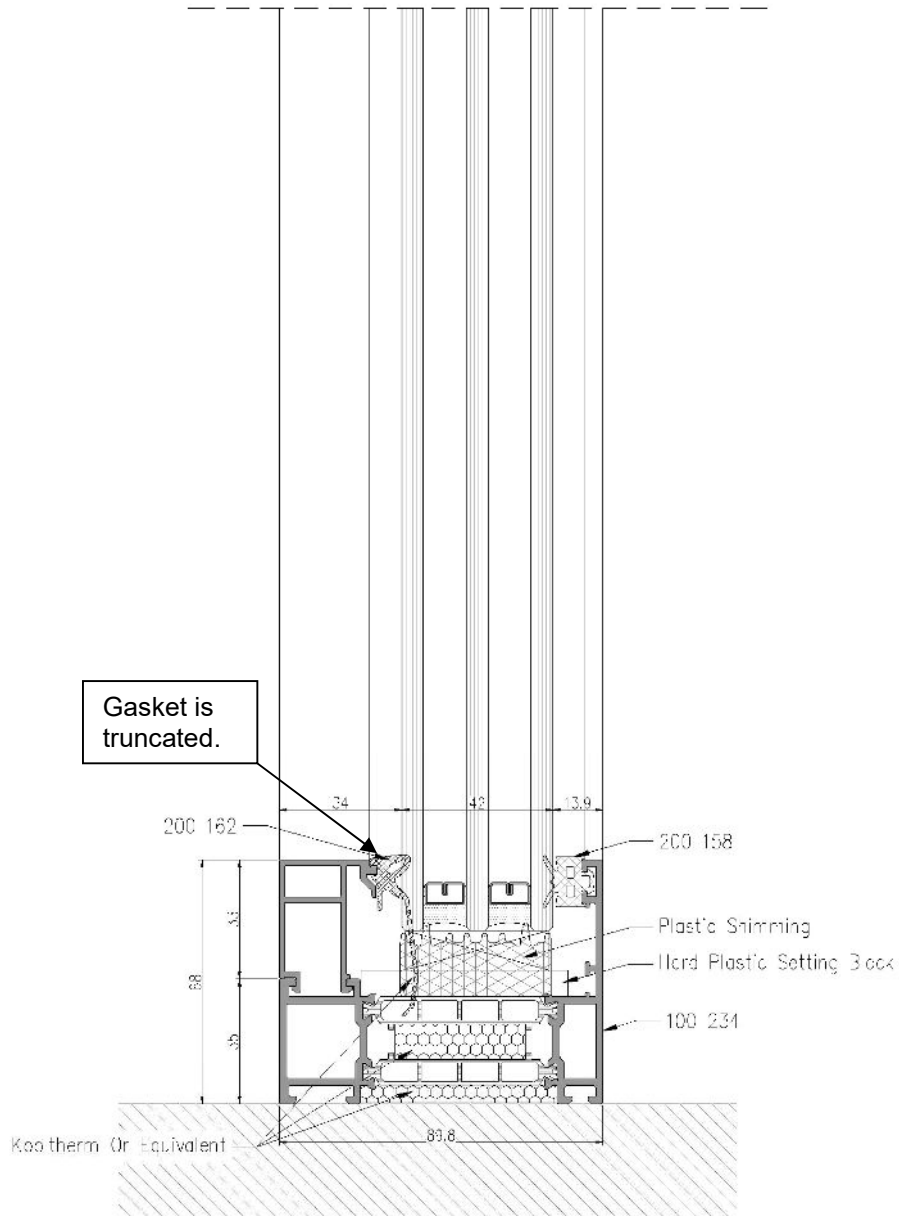


SCALE	PROJECT	PAGE TITLE	DATE	REV. NO.	PAGE NO.
1/1	NAFS Test	Fix Window Plan Detail	23/Aug/2023	R1	005

**Alpine HD Aluminum Fixed Window – Assembly Cross-Section – Jamb**

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Dimensions are in mm.



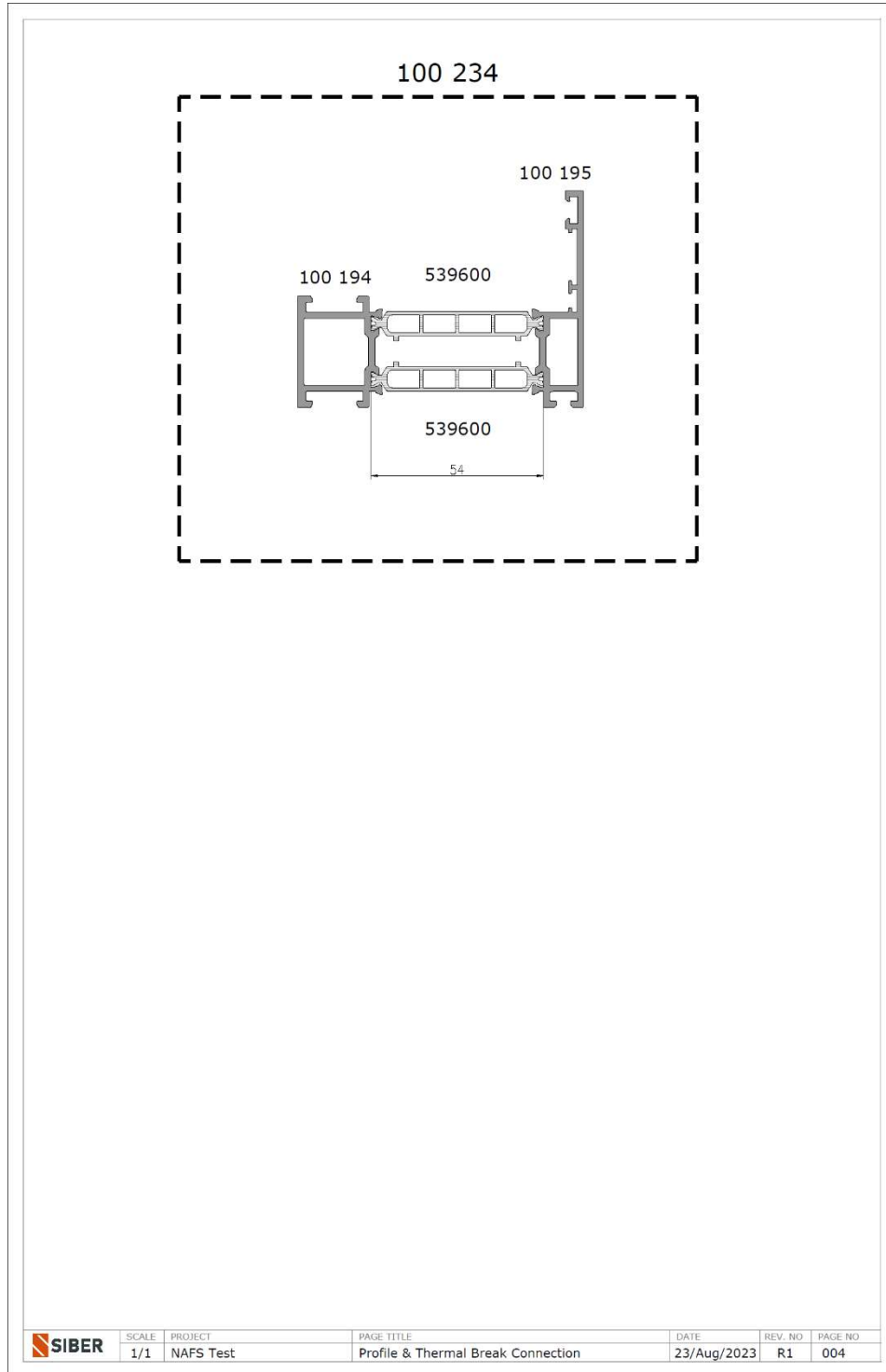
SIBER	SCALE	PROJECT	PAGE TITLE	SYSTEM NAME	DATE	REV. NO.	PAGE NO.
	1/1	NAFS Test	Fix Sill Detail	-	23/Aug/2023	R1	007

**Alpine HD Aluminum Fixed Window – Assembly Cross-Section – Sill**

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**Dimensioned Die Drawings**


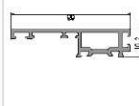

Dimensions are in mm.



**Alpine HD Aluminum Fixed Window – Frame Profile**

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
Dimensions are in mm.

Profile No	Profile Type	Material	Weight
Siber 100 194		EN AW 6063 - T5	0.703 Kg/m
JJTech 23-099-01			0.768 Kg/m
Siber 100 195			
JJTech 23-100-01			
Siber 100 234			
JJTech 23-099-01			
Siber 100 209			0.532Kg/m
JJTech 23 109 01			
Siber 100 210			0.930Kg/m
JJTech 23-110-01			
Siber 100 215			4.899 Kg/m
JJTech 23-114-01			


RESU. NO. | TRACE NO. | R.1 | 001  
 SYSTEM NAME | DATE | 23/Aug/2023  
 PAGE TITLE | Fixed Window Profile List

**Alpine HD Aluminum Fixed Window – Aluminum Component Profiles**

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Gasket Number	Gasket Shape	Material	
200 158		SILICONE (SHORE A 60 ±5)	
200 162		SILICONE (SHORE A 60 ±5)	
			<div style="border: 1px solid black; padding: 5px; display: inline-block;">           Truncated glazing gasket.         </div>

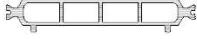

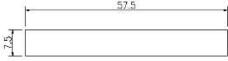
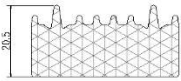
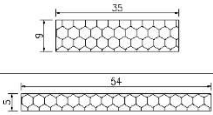

  

	<small>PROJECT</small> NAFS Test	<small>PAGE TITLE</small> Fixed Window Gasket List	<small>DATE</small> 23/Aug/2023	<small>REV. NO</small> --	<small>PAGE NO</small> 002
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**Alpine HD Aluminum Tilt and Turn Window – Gasket Profiles**

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Dimensions are in mm.

T.B Number	Thermal Break Shape	Material	
539 600		POLYAMIDE	
Accessories List			
Monticelli		2401/250 (Will provide From Siber)	
Glazing Chair		Hard Plastic Or Polyamide	
Isolation Sizes			
Isolation		Foam Weather Stripping	
Isolation Sizes			
Isolation		Kooltherm Or Equivalent	
	PROJECT NAFS Test	PAGE TITLE Fixed Window Thermal Break & Accessories List	DATE 23/Aug/2023    REV. NO R1    PAGE NO 003

**Alpine HD Aluminum Fixed Window – Thermal Break and Accessory Profiles**

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### Sample Photographs

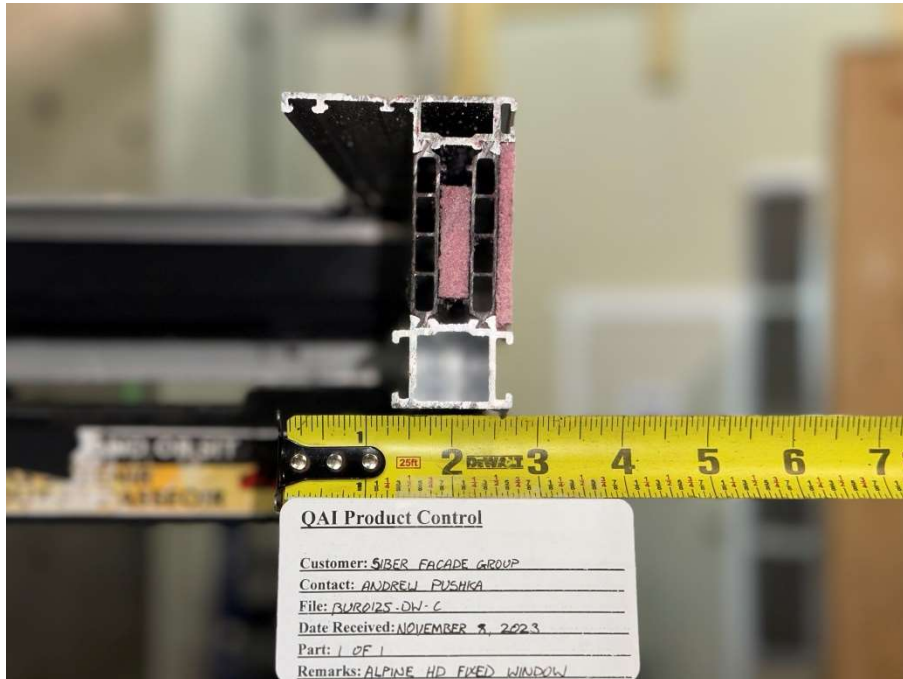


Figure 1: Frame.



Figure 2: Glazing bead.

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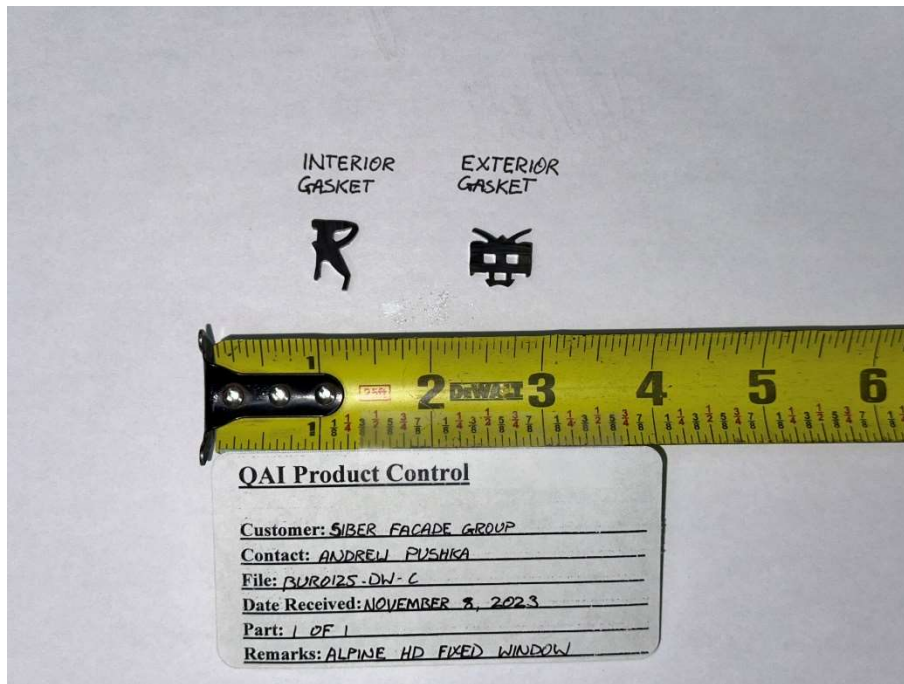


Figure 3: Glazing gaskets.

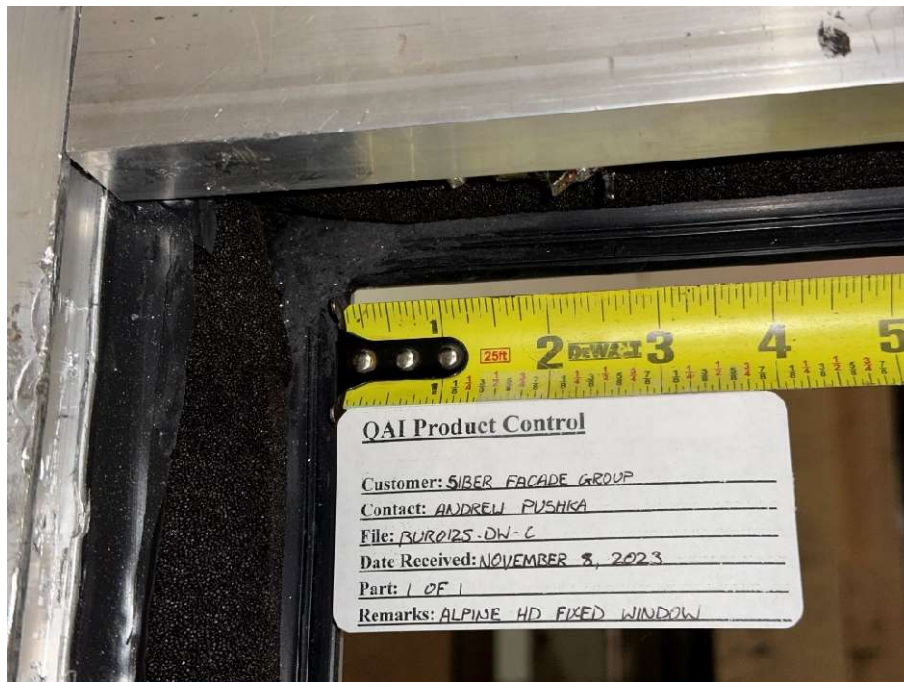


Figure 4: Silicone heel bead, glazing foam insulation, and exterior glazing gasket corner joint.



Figure 5: Drainage into the frame.



Figure 6: Drainage out of the frame.

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## REPORT REVISION HISTORY

Date	Revision	Change Description	Initials
January 23, 2024	0	Original Report: Siber Facade Group. Alpine HD Aluminum Fixed Window	RM

\*\*\*\*\*<END OF REPORT>\*\*\*\*\*

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