QAI LABORATORIES
CERTIFICATION TESTING INSPECTION

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CLIENT: Siber Façade Group
230 – 7270 Market Crossing
Burnaby, British Columbia
V5J 0A2
Canada

Test Report No: BUR0069-DW	Issue Date: September 1, 2023

SAMPLE ID: Siber Façade Group LS-800 Series Sliding Door.

SAMPLE DESCRIPTION: Width: 2299 mm; Height: 2286 mm. See pages 6-10 for full description.

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

DATE OF RECEIPT: Test sample was received on June 19, 2023

TESTING PERIOD: Testing was conducted June 19 – September 1, 2023

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

AUTHORIZATION: Proposal #23MT04281, signed by Andrew Pushka, dated May 1, 2023.

TEST PROCEDURE: Testing was performed following the methods and requirements outlined in the following standards:

AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS – North American Fenestration Standard/Specification for windows, doors, and skylights.

CSA A440S1-19 – Canadian Supplement to NAFS.

TEST RESULTS:

LS-800 Series Sliding Door Class LC - PG50: Size tested 2299 x 2286 mm (~91 x 90 in) – Type SD

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

CONTENTS: Test Report pages 1 through 36.

Prepared By

Daniel Silva Zuleta
Project Manager

Signed for and on behalf of
QAI Laboratories, Ltd

Neil Dumont
Fenestration Reviewer

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TEST CONDITIONS:

AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS and CSA A440S1-19

QAI Laboratories Ltd. (QAI) was retained by Siber Façade Group to perform testing in accordance with the mandatory test requirements of AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS and CSA A440S1-19 on a representative sample of a 2299 mm x 2286 mm LS-800 Series Sliding Door.

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 Façade Group
Installation details:

- The door sill was fastened to the wooden test buck with an installation angle.
  - 14 Ga 1-3/4” x 7/8” mild steel installation angle was sealed with silicone and fastened to the sill with eight evenly spaced #10 x 1-1/4” panhead self-driving screws. The screws head are sealed with silicone.
  - The installation angle was sealed to the wooden test buck with silicone and fastened with five #8 x 2” countersunk self-tapping screws. The screws head are sealed with silicone.
- The head and the jambs are installed with fifteen #10 x 2” panhead screws penetrating through part LSF 03A. The screws head are sealed with silicone. See location below:
  - Head: Five screws centered at 6-1/2”, 26”, 45-5/8”, 77-5/8”, and 87-1/8” from the outer edge of the left side jamb, looking from the interior.
  - Jambs: Five screws each, centered at 4-5/8”, 24-5/8”, 45-1/4”, 66-1/8”, and 88-5/8” from the outer edge of the head.
- One backer-rod length was placed on the interior perimeter of each frame member.
- One backer-rod length was placed on the exterior perimeter of each frame member, not including the sill for drainage purposes.
- A silicone bead was applied to the interior perimeter between the door frame and the test buck, sealing the rough opening.
- A silicone bead was applied to the exterior perimeter between the door frame and the test buck, not including the sill for drainage purposes.

Wooden test buck details:

- Inner frame:
  - Perimeter: nominal 2” x 6” stud framing.
  - Support: 2-ply nominal 2” x 6” built-up beam along the sill.
- Outer frame: nominal 2” x 12” stud framing.
- Rough opening: 5/8” larger in width and height than the test specimen.
- Shims: Twenty evenly spaced 3-3/4” x 1-7/8” x 5/16” shims placed underneath the door frame. Five shims along each member.

PRODUCT RATINGS:

Table 1: Summary of Test Results

Test Name	*AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS* and *CSA A440S1-19* Results:
Operating Force Test (Clause 9.3.1)	Opening Direction: Force to Initiate Motion = 109.9 N (24.7 lb) Force to Maintain Motion = 32.0 N (7.2 lb) Closing Direction: Force to Initiate Motion = 77.1 N (17.3 lb) Force to Maintain Motion = 30.0 N (7.4 lb) Latch Open Force = 69.9 N (15.7 lb) Latch Closed Force = 31.8 N (7.1 lb) Pass
Air Leakage Resistance Test (ASTM E283)	Pressure differential = 75 Pa Infiltration result = 0.129 L/s/m² (0.025 cfm/ft²) Exfiltration result = 0.373 L/s/m² (0.073 cfm/ft²) Overall result – A3 Level Pressure differential = 300 Pa Infiltration result = 0.409 L/s/m² (0.081 cfm/ft²) Exfiltration result = 0.466 L/s/m² (0.092 cfm/ft²) Reported only
Water Penetration Resistance Test (ASTM E547 – Cyclic Static Air Pressure)	Maximum pressure differential = 720 Pa (DP 100 – 15.04 psf)
Water Penetration Resistance Test (ASTM E331 – Uniform Static Air Pressure)	Maximum pressure differential = 720 Pa (DP 100 – 15.04 psf)
Uniform Load Deflection Test (ASTM E330 – Procedure A)	Design pressure = 2400 Pa (DP 50) Maximum pressure differential = 2400 Pa (50.13 psf) Maximum deflection at design pressure = 12.0 mm (0.474”) Maximum L/175 deflection limit for CW class = 13.1 mm (0.514”) The deflection measurement was taken along the interlocking stile
Uniform Load Structural Test (ASTM E330 – Procedure A)	Design pressure = 2400 Pa (DP 50) Maximum pressure differential = 3600 Pa (75.19 psf)
Forced Entry Resistance Test (ASTM F842)	Grade 10 - Pass
Deglazing Test (Clause 9.3.6.3)	Pass

Table 2. Product Classification

LS-800 Series Sliding Door	
Maximum Size Tested:	2299 mm wide x 2286 mm tall (~91 x 90 in)
Performance Classification:	LC
Performance Grade:	PG50
Product Type:	SD
Primary Designator: Class LC - PG50: Size tested 2299 x 2286 mm (~91 x 90 in) – Type SD	
Secondary Designator: Positive Design Pressure (DP) = 2400 Pa (50.13 psf) Negative Design Pressure (DP) = -2400 Pa (-50.13 psf) Water Penetration Resistance Test Pressure = 720 Pa (15.04 psf) Canadian Air Infiltration / Exfiltration = Pass	

Notes:

- *AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS*, Clause 9.2.5: 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

LS-800 Series Sliding Door (continued)		
Frame:	Description:	Thermally broken aluminum frame profile, part LSF-TYP01 from Siber Façade. One 3-7/8" x 2-7/8" slot cut out of the GA-879 profile along the sill, centered at 44-3/16" from the inner face of the side jamb for a drainage box purpose. The box is composed of parts DBOX-T and DBOX-B. DBOX-T is fastened to the D-BOX-B with one 1/16" diameter x 3/16" length countersunk self-tapping screw. Refer to Appendix A for profiles used in the frame. Frame dimensions: Width: 2299 mm; Height: 2286 mm.
	Joints:	Mitre cut corners. Door frame cavities are sealed with Otto Coll P861, and the door slab surfaces are sealed with silicone. Corners are joined with three keys each. • One LSC 01 corner keys with a length of 43.5 mm along each leg. Friction fitted and crimped into the interior-most frame cavity. • One LSC 01 corner keys with a length of 24.0 mm along each leg. Friction fitted and crimped into the middle frame cavity. • One LSC 01 corner keys with a length of 10.5 mm along each leg. Friction fitted and crimped into the exterior-most frame cavity.
	Insulation:	None.
	Sill Track:	Stainless steel sill track inserted in the interior-most T-slot of the frame profile. Refer to Appendix A for drawings and photographs.
Operable Door Slab:	Description:	Thermally broken aluminum common sash profile, part LSV TYP01 from Siber Façade. The door slab is located on the left side looking from the interior. One thermally broken aluminum support inserted into the locking stile. Interlocking stile is composed of the common sash profile along with profiles LSV 04, PAG-876, and LSV 03. • LSV 04 = Fastened to the common sash profile with fifteen #8 x 3/4" pan head self-tapping screws evenly spaced. • PAG-876 = Sealed to the common sash profile with silicone and then clipped to the common sash profile as well as the LSV 04 profile. • LSV 03 = Interlocking stile cover, clipped to the common sash profile and the PAG-876 profile. Refer to Appendix A for profiles. Door slab dimensions: Width: 1160 mm; Height: 2207 mm.
	Joints:	Mitre cut corners. Door slabs cavities are sealed with Otto Coll P861, and the door slab surfaces are sealed with silicone. Corners are joined with four corner keys each. • Two LSC 02 corner keys with a length of 7mm along each leg. Friction fitted and crimped into the sash cavities. • Two STS corner keys stamped on the inside face of the exterior and interior frame components.
	Insulation:	None.

LS-800 Series Sliding Door (continued)		
Fixed Door Slab	Description:	Thermally broken aluminum common sash profile, part LSV TYP01 from Siber Façade. The door slab is located on the right side looking from the interior. One thermally broken aluminum support inserted into the locking stile. Interlocking stile is composed of the common sash profile along with profiles LSV 04, PAG-876, and LSV 03. • LSV 04 = Fastened to the common sash profile with fifteen #8 x 3/4" pan head self-tapping screws evenly spaced. • PAG-876 = Sealed to the common sash profile with silicone and then clipped to the common sash profile as well as the LSV 04 profile. • LSV 03 = Interlocking stile cover, clipped to the common sash profile and the PAG-876 profile. Eight 3” x 2-1/8” x 1-3/4” door slab spacers blocks (FX-BL) placed underneath the door slab. Each FX-BL is fastened to the door slab from the outer-most cavity with two #8 x 2” pan head self-tapping screws. The FX-BL along the top rail is not fastened. The FX-BLs are aligned with the door slab fastening screws. See details below. The door slab is fastened to the door frame with eight #12 x 3” panhead self-tapping screws through the glazing pocket face and the FX-BLs. See locations below: • Top and bottom rail: Two screws each centered at 7-13/16” and 37-1/2” from the outer edge of the fixed stile. • Fixed stile: Four screws centered at 8-1/8”, 31-5/8”, 55-1/4”, and 79” from the outer edge of the top rail. • Interlocking stile: No screws and no FX-BLs were found. Refer to Appendix A for more details. Door slab dimensions: Width: 1160 mm; Height: 2207 mm.
	Joints:	Mitre cut corners. Door slabs cavities are sealed with Otto Coll P861, and the door slab surfaces are sealed with silicone. Corners are joined with four corner keys. • Two LSC 02 corner keys with a length of 7mm along each leg. Friction fitted into the sash cavities. • Two STS corner keys stamped on the inside face of the exterior and interior frame components.
	Insulation:	None.
Weather-stripping:	Frame:	• One 5-1/8” x 2-1/16” x 5/8” foam block fastened to the head with one #8 x 3/8” pan head self-tapping screw. • One 3-7/8” x 1-7/8” x 1/4” foam block adhered with silicone to the top of the drainage box, part DBOX-T. • Four finless 10mm height mohair strips inserted on the interior-most T-slot of the frame perimeter. • Three bulb seal gasket lengths, part GA-946F, inserted inserted in the interior-most T-slot of the frame profile. One length along the head and one along each jamb. • Four bulb seal gasket lengths, part GA-946F, inserted inserted in the interior-most T-slot of the frame profile. One length along the head, one along each jamb and one 42-1/4” long strip along the sill (started from the left side jamb).

LS-800 Series Sliding Door (continued)		
Weather-stripping: Cont'd	Operable Door Slab:	Interlocking stile: • One 2" x 1" x 1" foam block inserted into the block house RT. The block house RT is inserted at the top rail-to-interlocking stile joint and fastened to the LSV 03 profile with two #8 x 3/8" countersunk machine screws. • One 2" x 1" x 1" silicone block inserted into the block house LT. The block house LT is inserted at the bottom rail-to-interlocking stile joint and fastened to the LSV 03 profile with two #8 x 3/8" countersunk machine screws. • Two double-fin 7mm height mohair strips inserted on the two T-slots of the exterior-most face of the interlocking stile, profile PAG-876, running parallel with the glass plane. Parallel joints. • One weather-stripping gasket inserted in the interior-most T-slot of the interlocking stile, part PAG-876, running parallel with the glass plane. Locking side stile: • Two bulb-seal with triple-fin style gasket lengths inserted in either of the outer-most T-slot of the locking side stile. Miter cut joints. Top rail: • Two bulb-seal with single-fin style gasket lengths inserted in either of the outer-most T-slot of the top rail. Miter cut corners, only joined at the top rail-to-locking side stile. Eight 1-3/8" x 7/8" custom plastic clips added along the top rail, four fastening each bulb seal, centered at 4-3/4", 15-3/8", 31-5/8", and 42" from the outer edge of the locking side stile. Bottom rail: • Two bulb-seal with triple-fin style gasket lengths inserted in either of the outer-most T-slot of the bottom rail. Miter corners, only joined at the bottom rail-to-locking side stile.
	Fixed Door Slab:	Interlocking stile: • One 2" x 1" x 1" silicone block inserted into the block house RT. The block house RT is inserted at the top rail-to-interlocking stile joint and fastened to the LSV 03 profile with two #8 x 3/8" countersunk machine screws. • One 2" x 1" x 1" silicone block inserted into the block house LT. The block house LT is inserted at the bottom rail-to-interlocking stile joint and fastened to the LSV 03 profile with two #8 x 3/8" countersunk machine screws. • Two double-fin mohair strips inserted on the exterior-most face of the interlocking stile, profile PAG-876, running parallel with the glass plane. Parallel joints. • One weather-stripping gasket inserted in the interior-most T-slot of the interlocking stile, part PAG-876, running parallel with the glass plane. Locking side stile, top rail, and bottom rail: • Two bulb-seal with triple-fin style gasket lengths inserted in either of the outer-most T-slot of the common sash profile. Miter joints.

LS-800 Series Sliding Door (continued)		
Glazing Method: (2x)	Interior Seal: (Glazing bead and Glazing Gasket)	Four strips of aluminum glazing bead clipped to the sash perimeter. Four glazing gasket strips rolled between the glazing bead and the IGU. Miter joints.
	Full bead and backer-rod:	Full silicone bead applied between the IGU and the sash-to-IGU pocket face. Four lengths of backer-rod placed between the exterior seal and the full bead.
	Exterior Seal: (Glazing Gasket):	Four glazing gasket strips inserted in the exterior-most T-slot of the sash perimeter. Miter joints.
	Setting Chairs & Setting Blocks:	Six 3-1/4" x 1-1/4" x 5/16" setting chairs used in pairs with six 3-1/8" x 1/8" x 1-1/4" setting blocks. The setting blocks are placed on top of the setting chairs. See location of each pair below: • Top rail: None. • Bottom rail: Two pairs centered at 10-1/2" and 33-1/2" from the outer edge of the locking side stile. • Stiles: Two pairs along each stile centered at 20-1/2" and 71" from the outer edge of the bottom rail.
Glazing: (2x)	Description:	Triple tempered glass panes with a thickness of 6 mm each. Overall IGU thickness of 42 mm.
Drainage:	Frame:	<u>Into the frame:</u> • Four 3/4" x 1/4" drainage slots machined into the sill, part GA-879, centered at 4-3/4", 15-7/8", 27", and 38-1/8" from the inner face of the left side jamb, looking from the interior. • One 1/2" diameter drainage hole with a check valve machined into the sill, part GA-879, centered at 4-3/4" from the inner face of the right-side jamb, looking from the interior. • One 1/2" diameter drainage hole with a check valve machined into the sill, part LSF 03A, centered at 44-3/16" from the inner face of the right-side jamb, looking from the interior. • One 2" x 5/8" drainage slot machined into the drainage box, part DBOX-T which only allows for drainage to the operable sliding door. The drainage box is centered at 44-3/16" from the inner face of the left side jamb, looking from the interior. <u>Out of the frame:</u> • Seven 3/16" diameter drainage holes machined out of the sill from the rough opening, part C-17, centered at 5-3/4", 29-1/4", 40-7/8", 49-5/8", 61-1/4", 72-1/8", and 84-7/8" from the outer edge of the right-side jamb, looking from the exterior. • Seven 1-1/16" x 1/4" drainage slots machined out of the sill from the rough opening, part LSF 02, centered at 5-3/4", 29-1/4", 40-7/8", 49-5/8", 61-1/4", 72-1/8", and 84-7/8" from the outer edge of the right-side jamb, looking from the exterior. <u>Through the frame cavities:</u> • Seven 2-3/8" drainage holes through connecting cavities between part LSF 02 and C-17, the holes are evenly spaced. **No photograph was taken since the holes were pre-drilled before crimping. Refer to Appendix A for more details.

LS-800 Series Sliding Door (continued)		
Drainage: Cont'd	Operable Door Slab:	Into the door slab: Two 7/16" x 1/4" drainage slots machined into the glazing pocket face of the bottom rail, centered at 3" from the inner face of either stile. Out of the door slab: Two 7/16" x 1/4" drainage slots machined out of the outer face of the bottom rail, centered at 6" from the outer edge of either stile.
	Fixed Door Slab:	Into the door slab: Two 7/16" x 1/4" drainage slots machined into the glazing pocket face of the bottom rail, centered at 3" from the inner face of either stile. Out of the door slab: Two 7/16" x 1/4" drainage slots machined out of the outer face of the bottom rail, centered at 6" from the outer edge of either stile.
Hardware:	Locks:	Sliding door multi-point locking hardware. The locking system mechanism is installed along the locking side stile, with keepers installed along the locking side jamb. Five gear spacers used underneath the locking system mechanism. Refer to Appendix A for positioning. The multi-point system was fastened to the door slab with seven #10 x 2-1/8" countersunk self-tapping screws. Each locking point was aligned to the keeper (see keepers' section below for locations).
	Keepers:	Part #6-22648-01 from GU – Gretsch Unitas. The keepers were secured to the locking side jamb using two #8 x 1-3/8" countersunk self-tapping screws per keeper. The keepers were centered at 8-1/2" and 65-1/4" from the inner face of the sill track.
	Rollers:	Part #K-16488-00-0-1 from GU – Gretsch Unitas. One roller assembly composed of one 23" long connecting rod, one front and rear two-wheel rollers. One 4-1/2" x 7/8" x 5/8" gear spacer underneath the front roller along the locking side stile. The roller assembly was fastened as follows: • Locking side jamb: Two #11 x 1-1/2" countersunk self-tapping screws and one # 10 x 2-1/8" countersunk self-taping screw (This screw penetrates from the locking system mechanism). • Sill: Two #11 x 1-7/8" countersunk self-tapping screws per roller. The connecting rod is fastened to the rollers with four 5/16" x 5/8" knurl grip cup set screw, two screws at each end.
	Lever Operator Handle:	• One interior lever operator fastened to the door slab with two #12 x 3" countersunk machine screws centered at 39-11/16" from the outer face of the bottom rail. Two screws fastened from the interior face of the door slab. • One exterior recessed handle clipped to the exterior face of the door slab. It is aligned with the interior lever operator and fastened with the same screws. Refer to photographs in Appendix A.

CONCLUSION / FINDINGS:

QAI Laboratories Ltd. has performed testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-17 NAFS and CSA A440S1-19 requirements, on a representative sample of a Siber Façade Group. LS-800 Series Sliding Door. Testing was performed at the Burnaby, BC location.

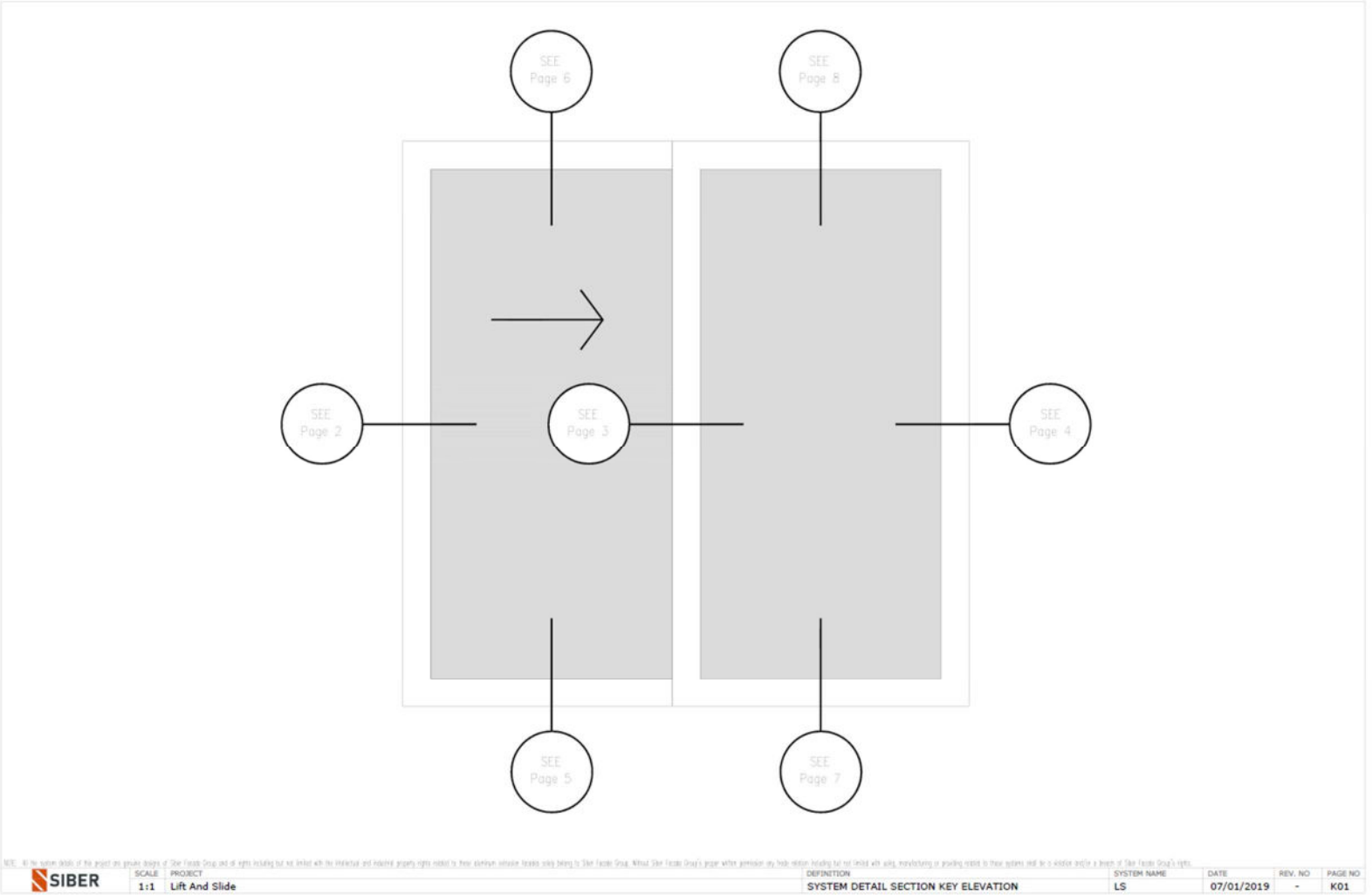
Test results in this report may not be reproducible in the field. Test results relate only to those products tested.

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.

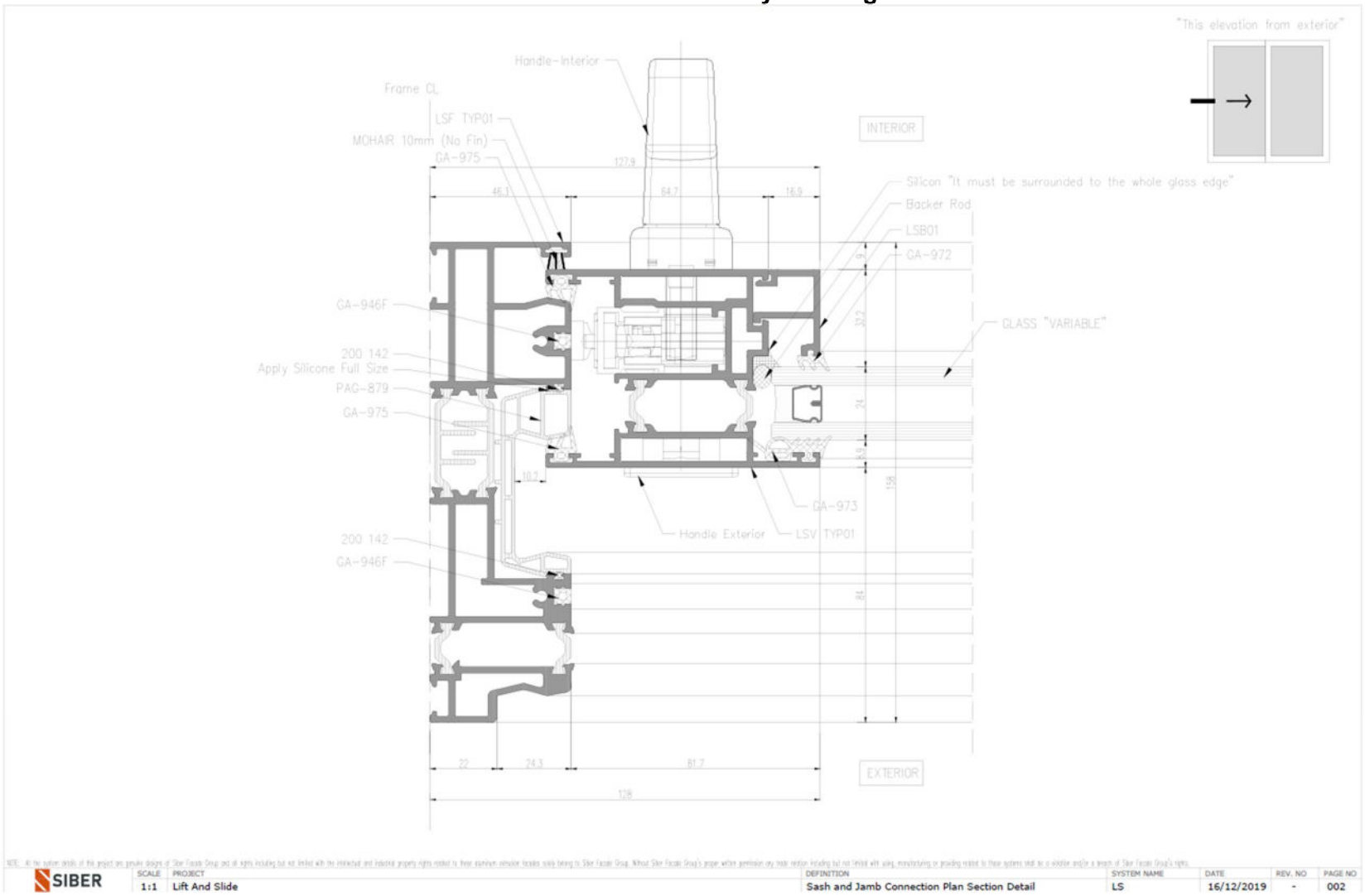
APPENDIX A

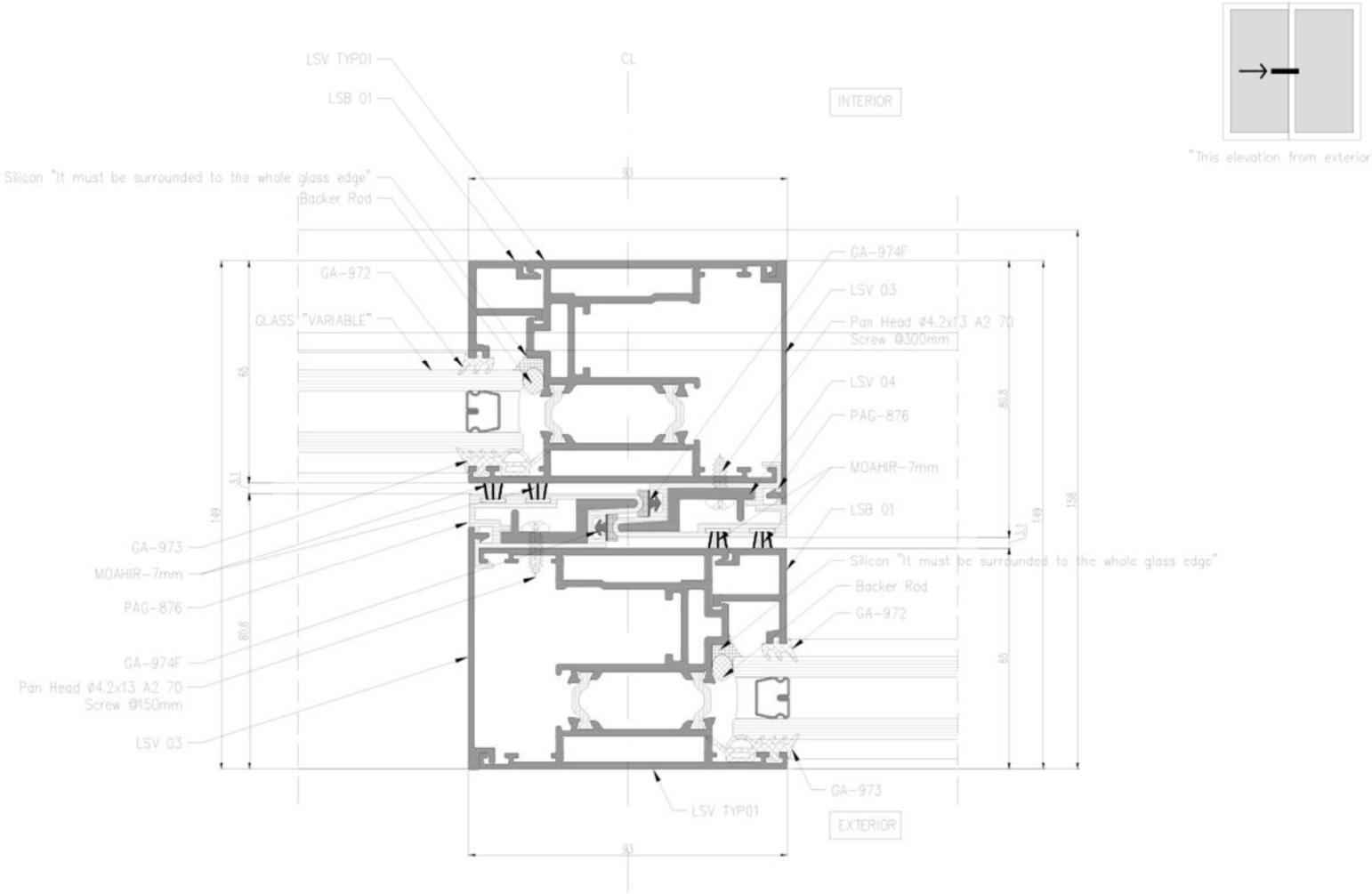
(Drawings and photographs specifications)

Elevation Drawing



Cross-Section Assembly Drawing





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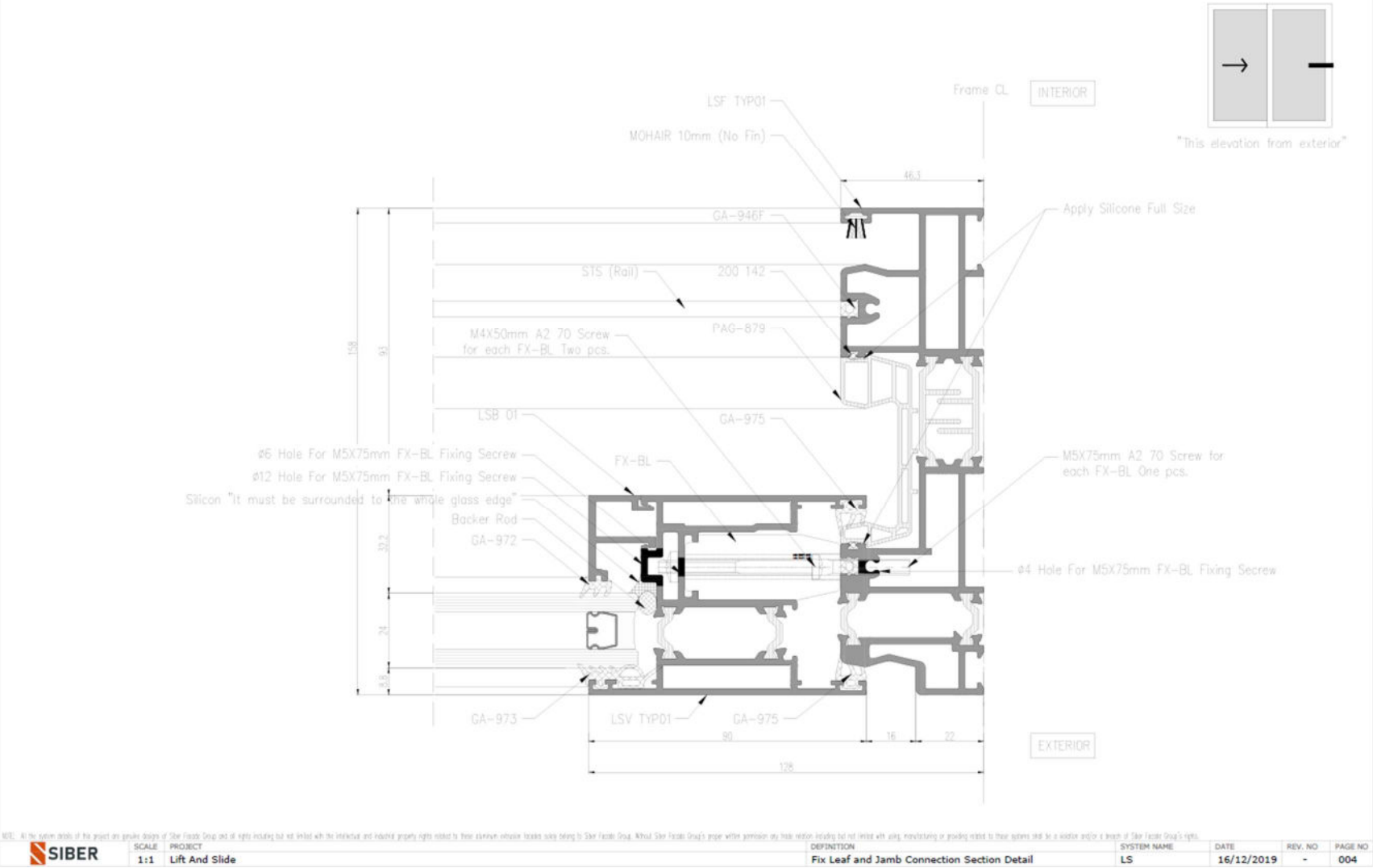

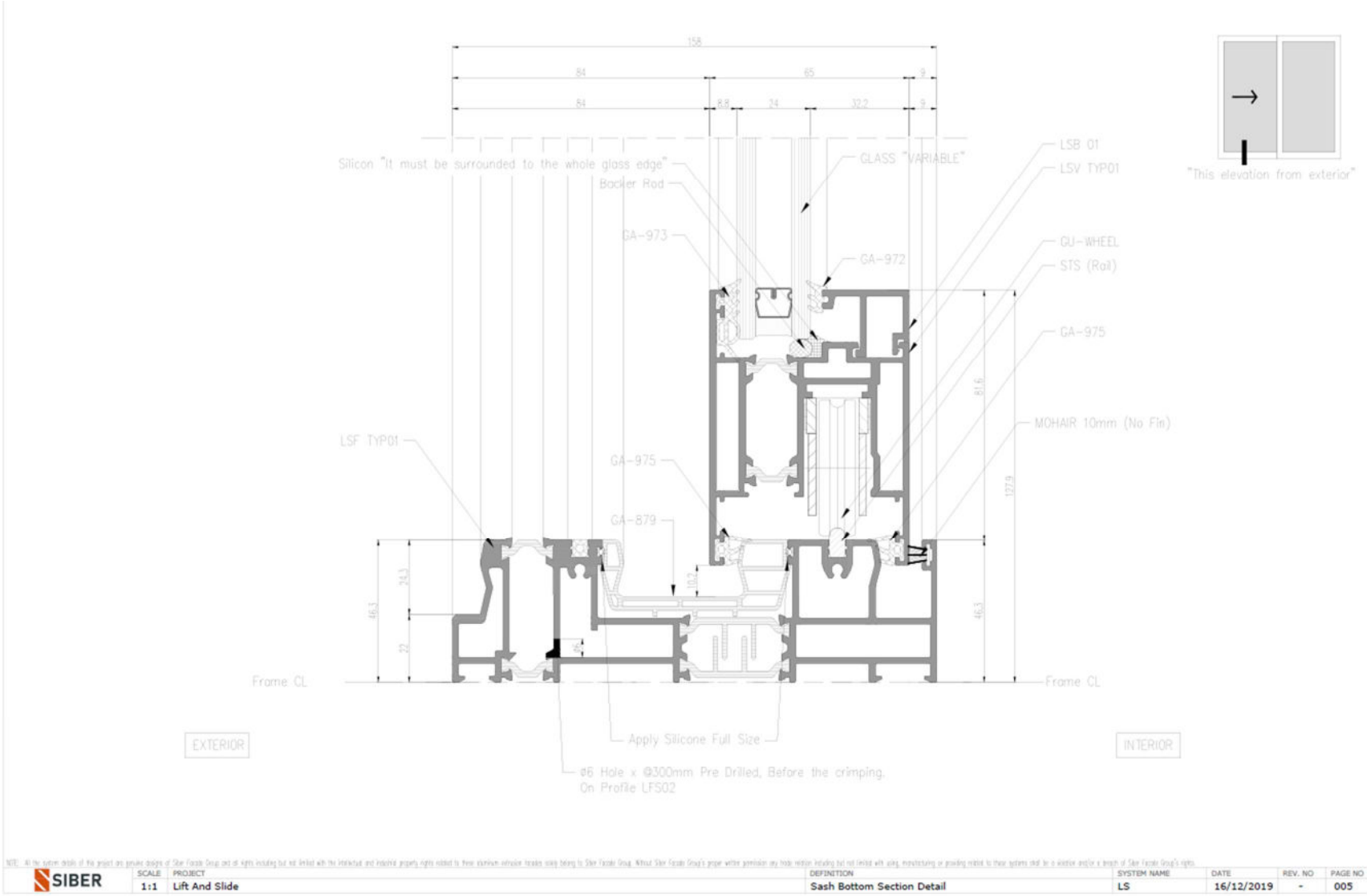

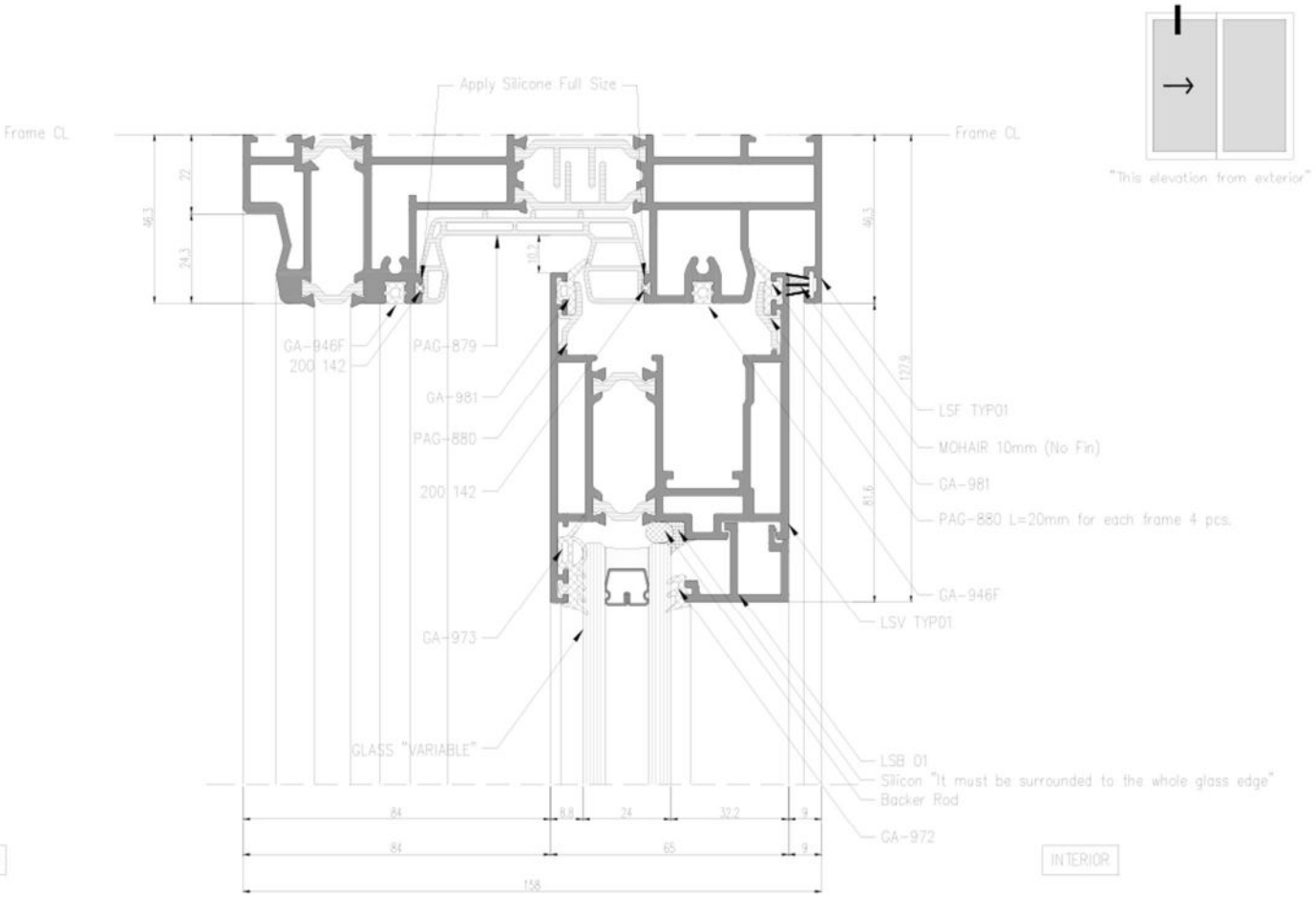

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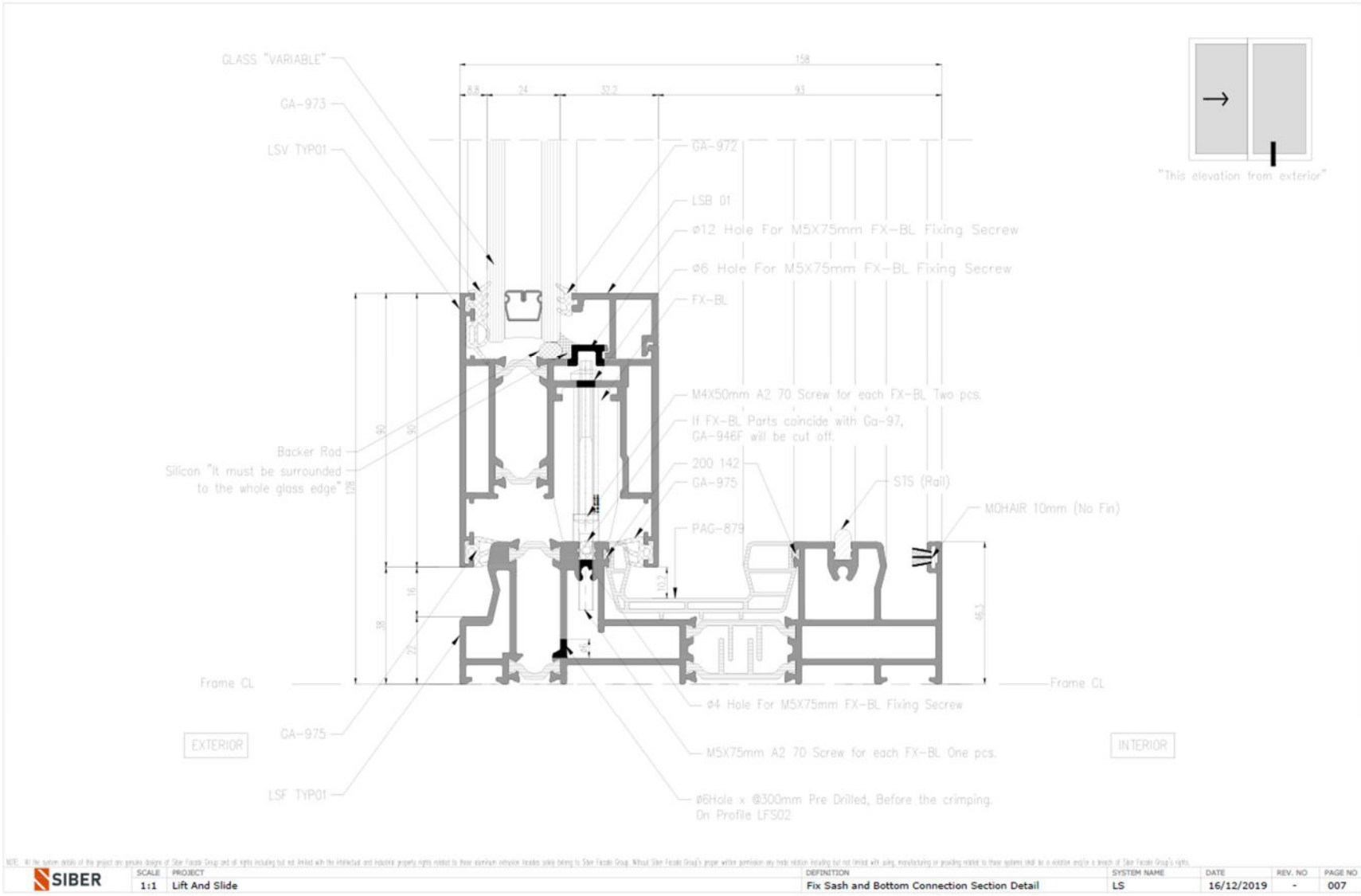

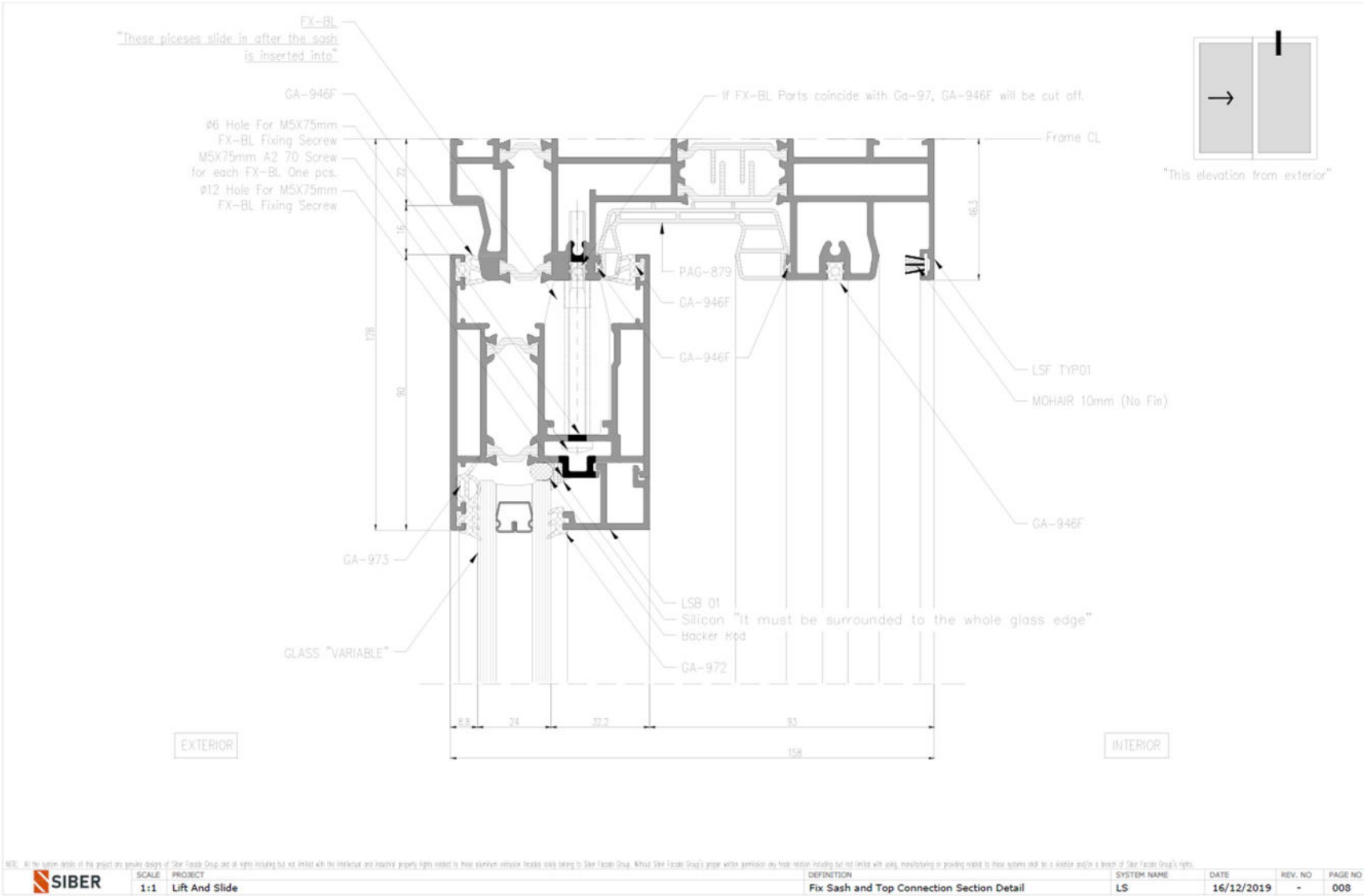

SIBER	SCALE	PROJECT	DEFINITION	SYSTEM NAME	DATE	REV. NO	PAGE NO
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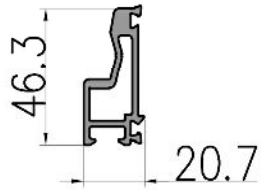
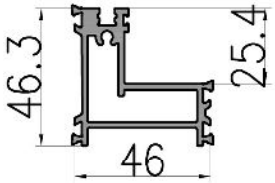
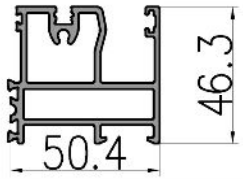
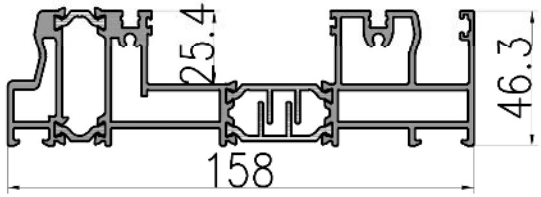
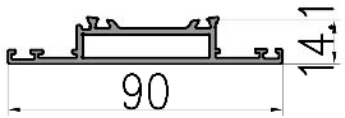
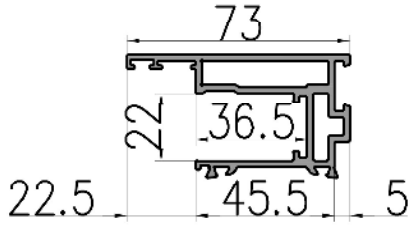
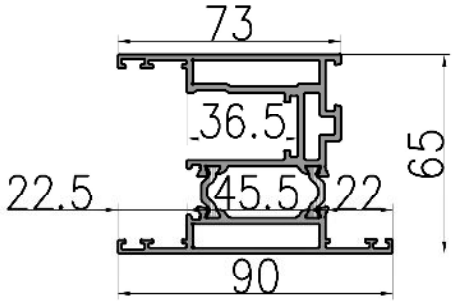
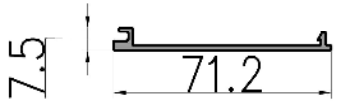
Dimensioned Die Drawings

Dimensions are in millimeters.

	R&D CODE	DIE CODE
	LSF 01	HMU-7529
	LSF 02	HMU-7700
	LSF 03A	HMU-7701
	LSF TYP01 (LSF 01-02-03)	HMU-7529 HMU-7700 HMU-7701

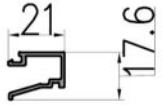
Frame profile.

Dimensions are in millimeters.

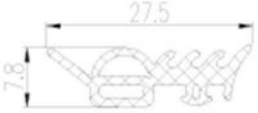
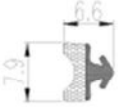
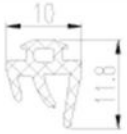
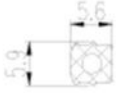
	LSV 01	HMU-7532
	LSV 02	HMU-7533
	LSV TYP01 (LSV 01-02)	HMU-7532 HMU-7533
	LSV 03	HMU-7702
	LSV 04	HMU-7535

Sash profile.

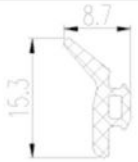
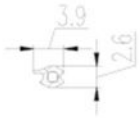
Dimensions are in millimeters.

	LSB 05	HMU-8873

Glazing bead profile.

	SILICONE (SHORE A 60 ±5)	GA-972
	SILICONE (SHORE A 60 ±5)	GA-973
	SILICONE (SHORE A 60 ±5)	GA-974F
	SILICONE (SHORE A 60 ±5)	GA-975
	SILICONE (SHORE A 60 ±5)	GA-946F

Gasket profiles.

	SILICONE (SHORE A 60 ±5)	GA-981
	SILICONE (SHORE A 60 ±5)	200 142

Gasket profiles.

Sample Photographs

Figure 1: Frame profile.

Figure 2: Door slab profile.

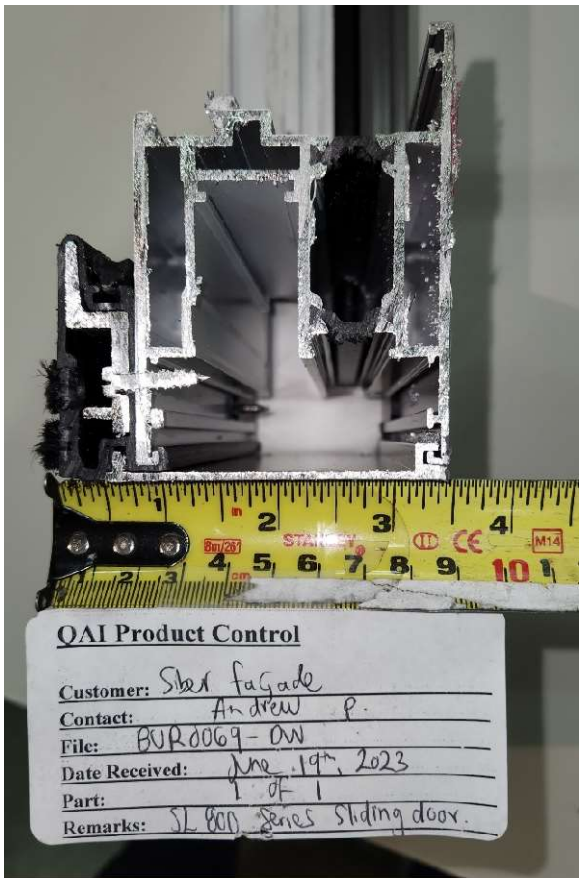


Figure 3: Interlocking stile profile.

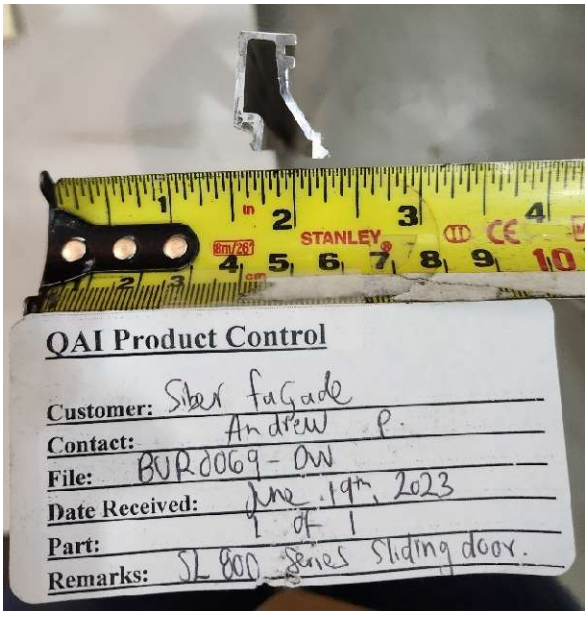


Figure 4: Glazing bead profile.

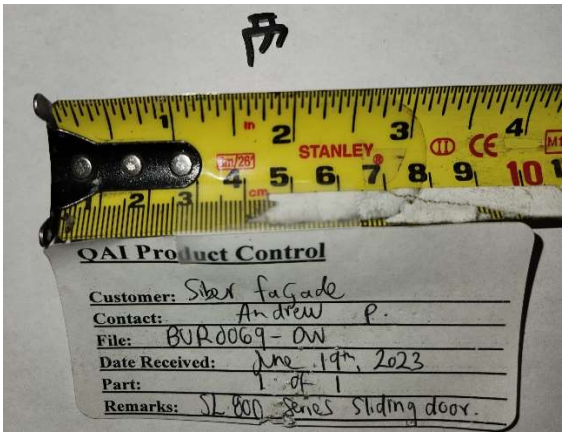


Figure 5: Bulb seal triple-fin style gasket.

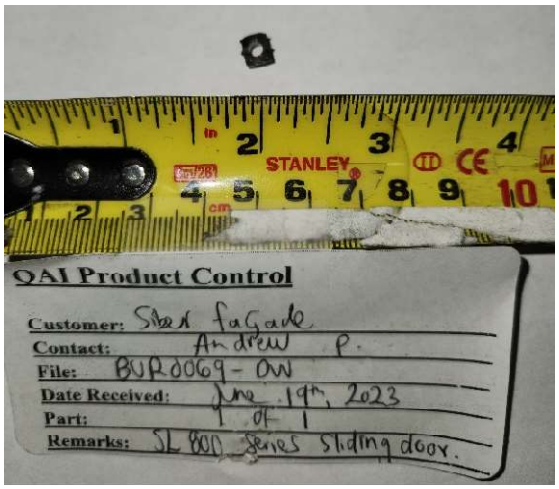


Figure 6: Bulb seal gasket.

Figure 7: Foam block at the head.

Figure 8: Exterior glazing gasket.

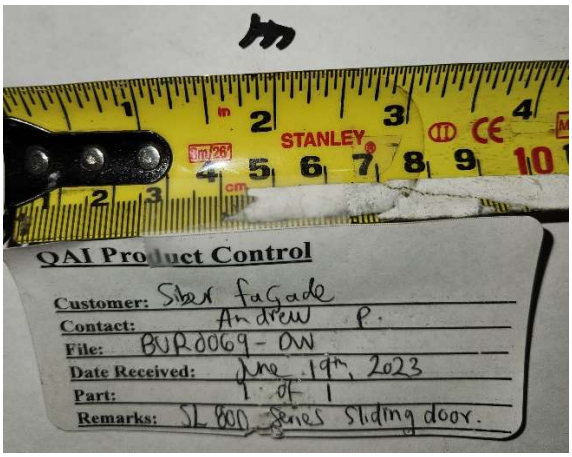


Figure 9: Interior glazing gasket.

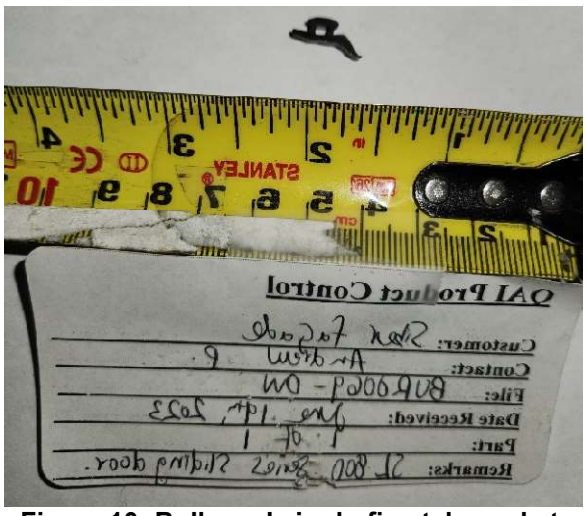


Figure 10: Bulb seal single-fin style gasket.

Figure 11: Foam block on the operable door slab.

Figure 12: Silicone block on the operable and fixed door slab.

Figure 13: Setting chair and setting block.

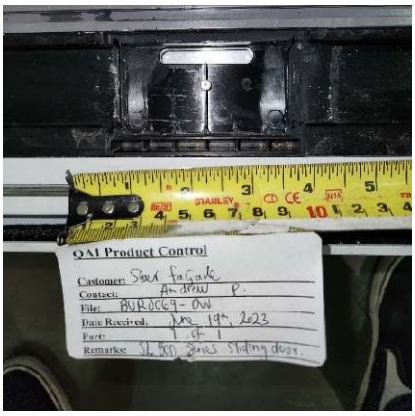


Figure 14: Drainage box into the sill.

Figure 15: Foam block on the sill.

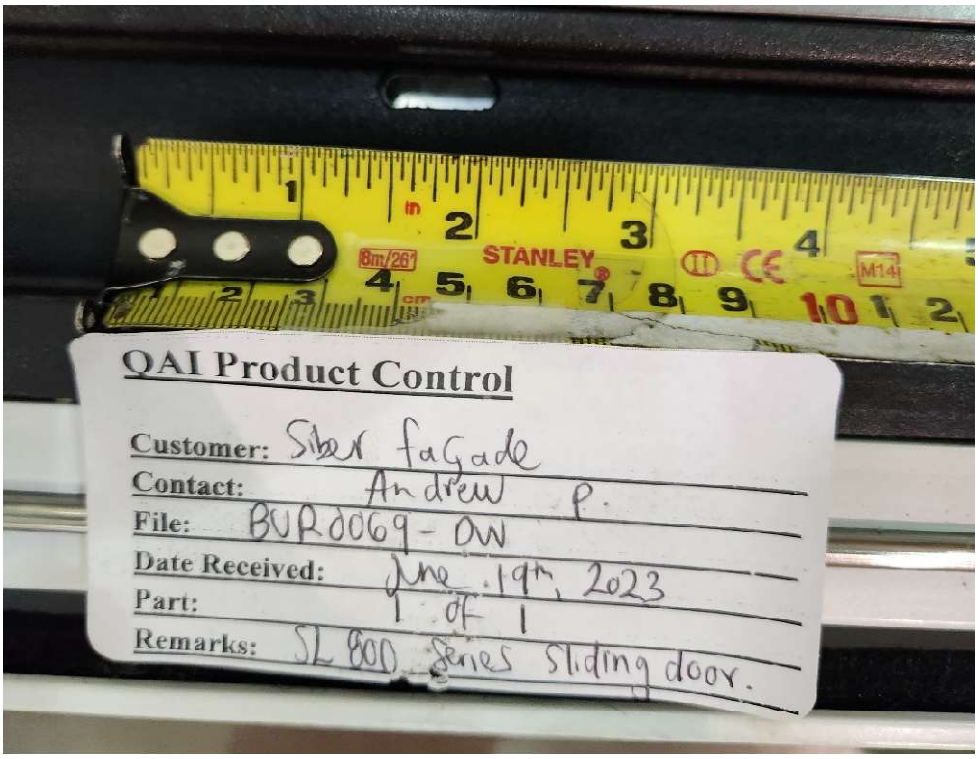


Figure 16: Drainage slot into the sill.

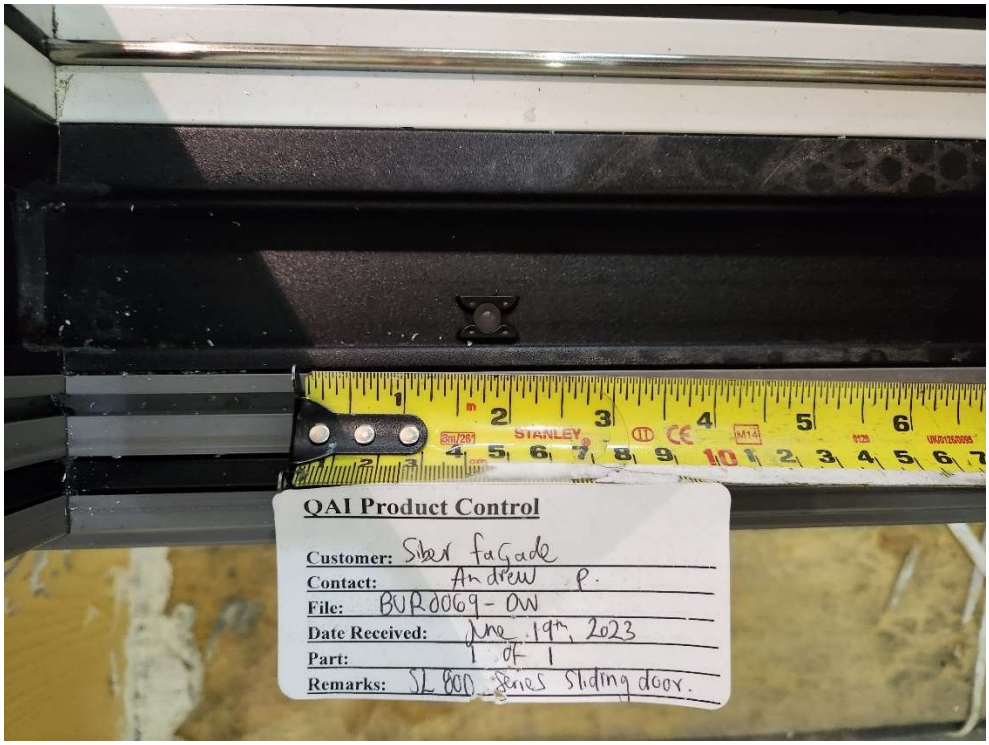


Figure 17: Drainage hole into the sill with a check valve.

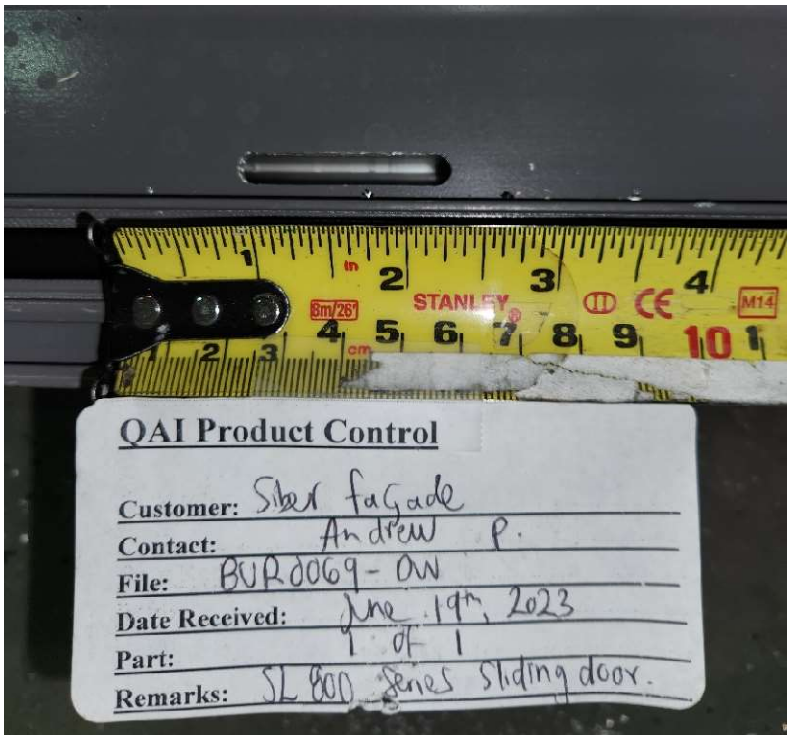


Figure 18: Drainage slot out of the sill.

Figure 19: Drainage slot into the bottom rail.

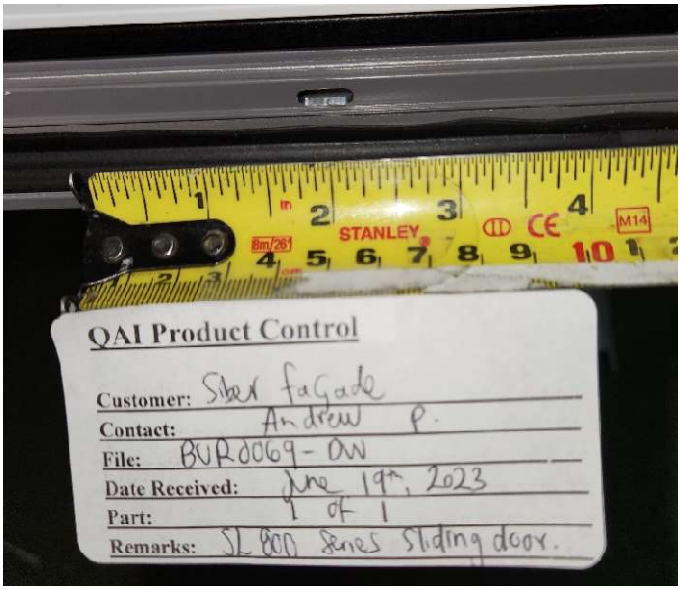


Figure 20: Drainage slot out of the bottom rail.

Figure 21: Supporting block for the fixed door slab.

Figure 22: Locking point.

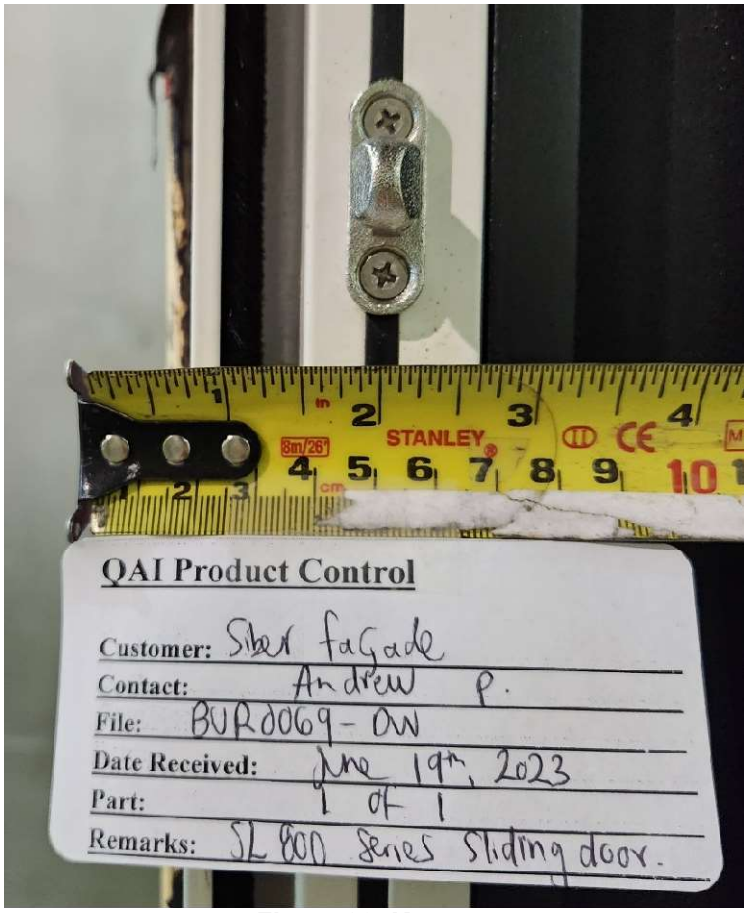


Figure 23: Keeper.

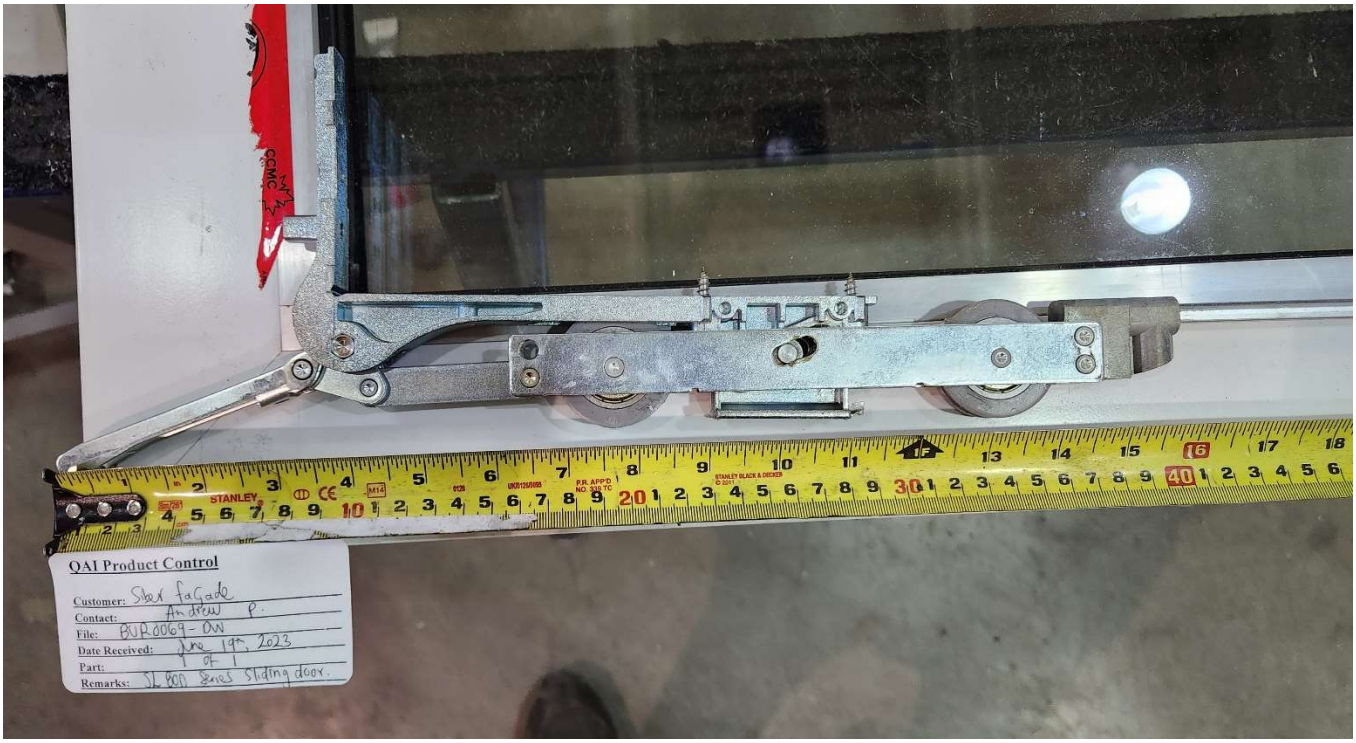


Figure 24: Front roller.

Figure 25: Rear roller.

Figure 26: Roller connecting rod.

Figure 27: Lever operator handle.

REPORT REVISION HISTORY

Date	Revision	Change Description	Initials
September 1, 2023	0	Original Report: Siber Façade Group. LS-800 Series Sliding Door	DSZ

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