QAI LABORATORIES
CERTIFICATION TESTING INSPECTION

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

Test Report No: BUR0125-DW-a	Issue Date: December 5, 2023

SAMPLE ID: Siber Facade Group SW800 WWADA LHR Out-Swing Side Hinged Door.

SAMPLE DESCRIPTION: Width: 1117 mm; Height: 2362 mm. See pages 6-7 for full description.

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

DATE OF RECEIPT: Test sample was received on September 12, 2023.

TESTING PERIOD: Testing was conducted September 13 – December 5, 2023.

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:

SW800 WWADA LHR Out-Swing Side Hinged Door Class CW - PG60: Size tested 1117 x 2362 mm (~44 x 93 in) – Type SHD

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

CONTENTS: Test Report pages 1 through 31.

Prepared By

Robbie Manuel

Robbie Manuel
Project Manager

Signed for and on behalf of
QAI Laboratories, Ltd

Matt Lansdowne

Matt Lansdowne
Vice President

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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 1117 mm x 2362 mm SW800 WWADA LHR Out-Swing Side Hinged 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 Facade Group
Installation details:

- The door frame was fastened to the test buck with #12 x 2-1/2” self-tapping countersunk screws spaced approx. 12” apart along the head and both jambs. Each screw head is sealed with silicone.
- Four lengths of 1/4” foam backing rod were used around the perimeter of the door frame.
- Silicone was applied between the door frame and test buck on the interior and exterior 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 1/2” larger in width and 1/2” larger in height than the test specimen.
- Shims: 1/4” thick plastic Y-shaped shims were spaced approx. every 14” around the perimeter of the door frame.

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PRODUCT RATINGS:

Table 1: Summary of Test Results

Test Name	*AAMA/WDMA/CSA 101/I.S.2/A440-22 NAFS* and *CSA A440S1-19* Results:
Operating Force for Latching Devices (Clause 8.3.1.3)	Latch operator – 48.7 N (10.9 lbf) Thumb turn operator – 0.4 N (0.1 lbf)
Air Leakage (ASTM E283)	Test pressure = 75 Pa Infiltration = 0.112 L/s/m^2 (0.022 cfm/ft^2) Exfiltration = 0.144 L/s/m^2 (0.028 cfm/ft^2) Overall result – Pass CW class requirements Test pressure = 300 Pa Infiltration = 0.938 L/s/m^2 (0.185 cfm/ft^2) Exfiltration = 1.377 L/s/m^2 (0.271 cfm/ft^2) Reported only
Water Penetration (ASTM E547)	Maximum pressure differential = 440 Pa (DP 60 – 9.19 psf)[1]
Uniform Load Deflection (ASTM E330 – Procedure A)	Design Pressure = 3360 Pa (DP 70) Maximum pressure differential = 3360 Pa (70.18 psf) L/175 Deflection limit for CW class = 13.4 mm (0.531”) Deflection at pressure = 7.1 mm (0.279”) Deflection measured along the locking stile.
Uniform Load Structural (ASTM E330 – Procedure A)	Design pressure = 3360 Pa (DP 70) Maximum pressure differential = 5040 Pa (105.26 psf)
Forced Entry Resistance Test (AAMA 1304)	Grade 10 - Pass

[1] The door 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

SW800 WWADA LHR Out-Swing Side Hinged Door	
Maximum Size Tested: **Performance Classification:** **Performance Grade:** **Product Type:**	1117 mm wide x 2362 mm tall (~44 x 93 in) CW PG60 SHD
Primary Designator: Class CW - PG60: Size tested 1117 x 2362 mm (~44 x 93 in) – Type SHD	
Secondary Designator: Positive ASD Design Pressure (DP) = 3360 Pa (70.18 psf) Negative ASD Design Pressure (DP) = -3360 Pa (-70.18 psf) Water Penetration Resistance Test Pressure = 440 Pa (9.19 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.

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Table 3. Product Description

SW800 WWADA LHR Out-Swing Side Hinged Door		
Frame:	Description:	Thermally broken aluminum frame profile. Frame dimensions: Width: 1117 mm; Height: 2362 mm.
	Joints:	Head-to-jambs: 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. Sill-to-jambs: The sill has notched ends and is fastened to the jambs with two #8 x 2" self-tapping countersunk screws from the rough opening side and sealed with silicone.
	Reinforcement:	None.
Door Slab:	Description:	Thermally broken aluminum door slab profile. Door slab dimensions: Width: 1061 mm; Height: 2228 mm.
	Joints:	Mitre cut and sealed with silicone at the joining faces. Two aluminum corner keys per corner joint. • One corner key inserted into the interior aluminum door slab component and sealed in place with silicone. • One corner key inserted into the exterior aluminum door slab component and sealed in place with silicone.
	Reinforcement:	None.
Weather-stripping:	Frame:	One length of weather-stripping (Gasket Code 200 148) around the perimeter of the frame, inserted into the inner-most T-slot of the frame profile and wrapped around corners. Butt joined at the bottom left corner of the frame, looking from the interior, and sealed with silicone. Three lengths of weather-stripping (Gasket Code 200 147) used along the head and jambs, inserted into the middle T-slots of the frame profile. Corners are sealed with silicone.
	Door Slab:	One length of weather-stripping (Gasket Code SW .4002s) around the perimeter of the door slab, inserted into the outer-most T-slot of the door slab and wrapped around corners. Butt joint located 6-3/4" from the outer edge of the top rail, no silicone was used. One door sweep fastened to the bottom rail with #8 x 1" self-tapping buttonhead screws spaced approx. every 8-1/2". One length of weather-stripping (Gasket Code SW .4002s) inserted into the T-slot of the door sweep.
Glazing Method:	Interior Seal: (Glazing Bead and Gasket)	Aluminum glazing bead profile. Four strips of glazing bead used around the door slab perimeter; butt joined at corners. Four strips of rubber glazing gasket (Gasket Code SW .4005s) inserted between the glazing bead and IGU; butt joined at corners.
	Full Bead:	One continuous length of 1/2" diameter backer rod was inserted between the door slab and IGU. The butt joint was located at the top rail-to-locking stile connection. A full silicone bead was applied around the perimeter of the IGU on the interior side.
	Exterior Seal: (Glazing Gasket)	Four strips of rubber glazing gasket (Gasket Code SW .4004s) inserted between the door slab profile and IGU; butt joined and sealed with silicone at corners.
	Setting Blocks:	Four 3-1/2"x 1" x 1/4" rubber setting blocks were used. • Top rail: One setting block centered 4" from the inside face of the locking stile. • Bottom rail: One setting block centered 2" from the inside face of the hinge stile. • Locking stile: One setting block centered 4" from the inside face of the top rail. • Hinge stile: One setting block centered 2" from the inside face of the bottom rail.

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SW800 WWADA LHR Out-Swing Side Hinged Door (continued)		
Glazing:	Description:	Three tempered glass panes with a thickness of 6 mm each. Overall IGU thickness: 43 mm.
Drainage:	Frame:	None.
	Door Slab:	Into the slab: Two 1/2" x 1/4" drainage slots machined into the bottom rail, each centered 4" from the inner face of either stile. Out of the slab: Two 1/2" x 1/4" drainage slots machined out of the bottom rail, each centered 8" from the outer edge of either stile. Three 2" wide notches cut out of the weather-stripping for drainage purposes, centered at 5", 20-1/2" and 37" from the outer edge of the locking stile.
Hardware:	Locking System:	One multi-point locking system consisting of an I-bar, fastened to the locking side stile with fifteen #8 x 1/2" countersunk machine screws. Two hook-style locks located 11" and 79" from the top edge of the door slab. Two anti-slam devices located 10" and 78" from the top edge of the door slab. One latch operated by the lever handle located 47" from the top edge of the door slab. One deadbolt operated by the thumb turn located 51" from the top edge of the door slab.
	Lever Handle Operator:	The lever handle is located 48" from the top edge of the door slab and fastened with eight #6 x 3/4" self-drilling countersunk screws total: four through the interior side and four through the exterior side. The screws were sealed with silicone.
	Thumb Turn Operator:	The thumb turn is located 52" from the top edge of the door slab and is part of the multi-point locking system.
	Keeper System:	One multi-point keeper system consisting of an I-bar, fastened to the locking side jamb with fifteen #8 x 3/4" countersunk machine screws. All keepers are aligned with their corresponding locking hardware components.
	Hinges:	One stay arm hinge and three pivot hinges. The stay arm hinge track on the frame side moves freely along the head and the track on door slab side is secured at the top rail at 4" from the outer edge of the hinge side stile with two #12 x 3/8" set screw. The pivot hinges are located along the hinge side jamb at 9", 62", and 83" from the outer edge of the sill and fastened to a hinge backplate. Each hinge backplate is secured to the door frame/slab with one #12 x 3/8" set screw. Fastener information are as follows: • Frame side – Four #12 x 1/2" countersunk machine screws. • Door slab side – Two #12 x 1/2" countersunk machine screws.

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. SW800 WWADA LHR Out-Swing Side Hinged 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.

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APPENDIX A

(Drawings and photographs specifications)

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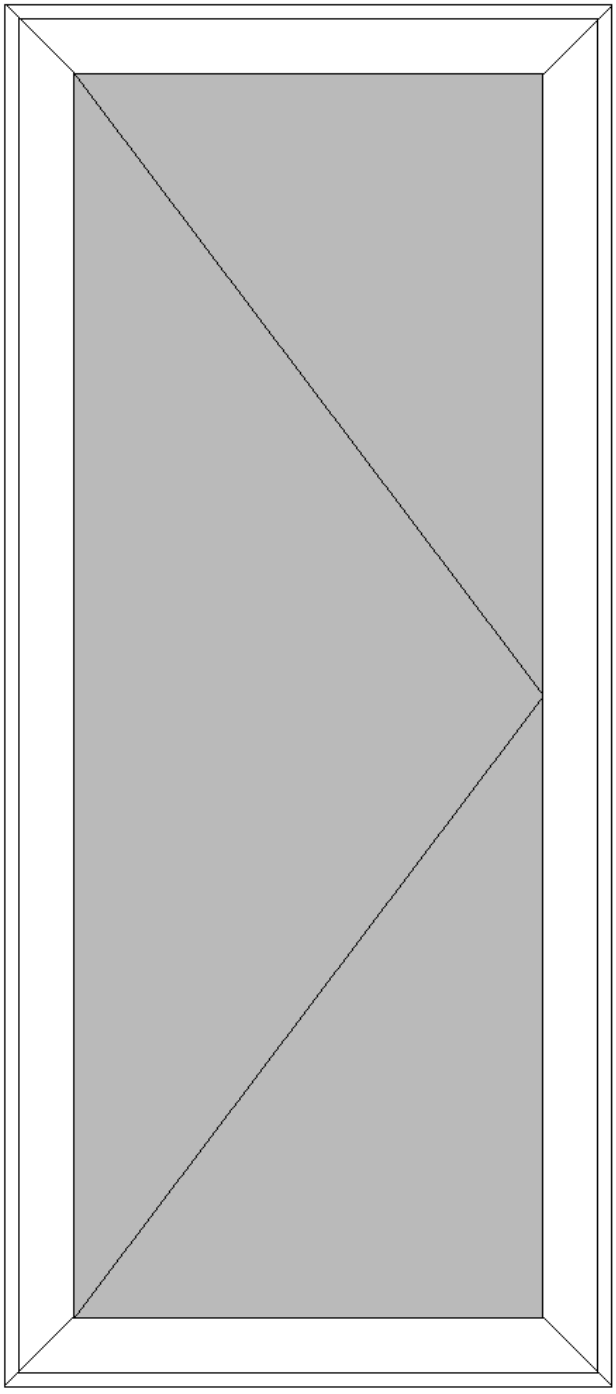
Elevation Drawing



SW800 WWADA LHR Out-Swing Side Hinged Door – Elevation

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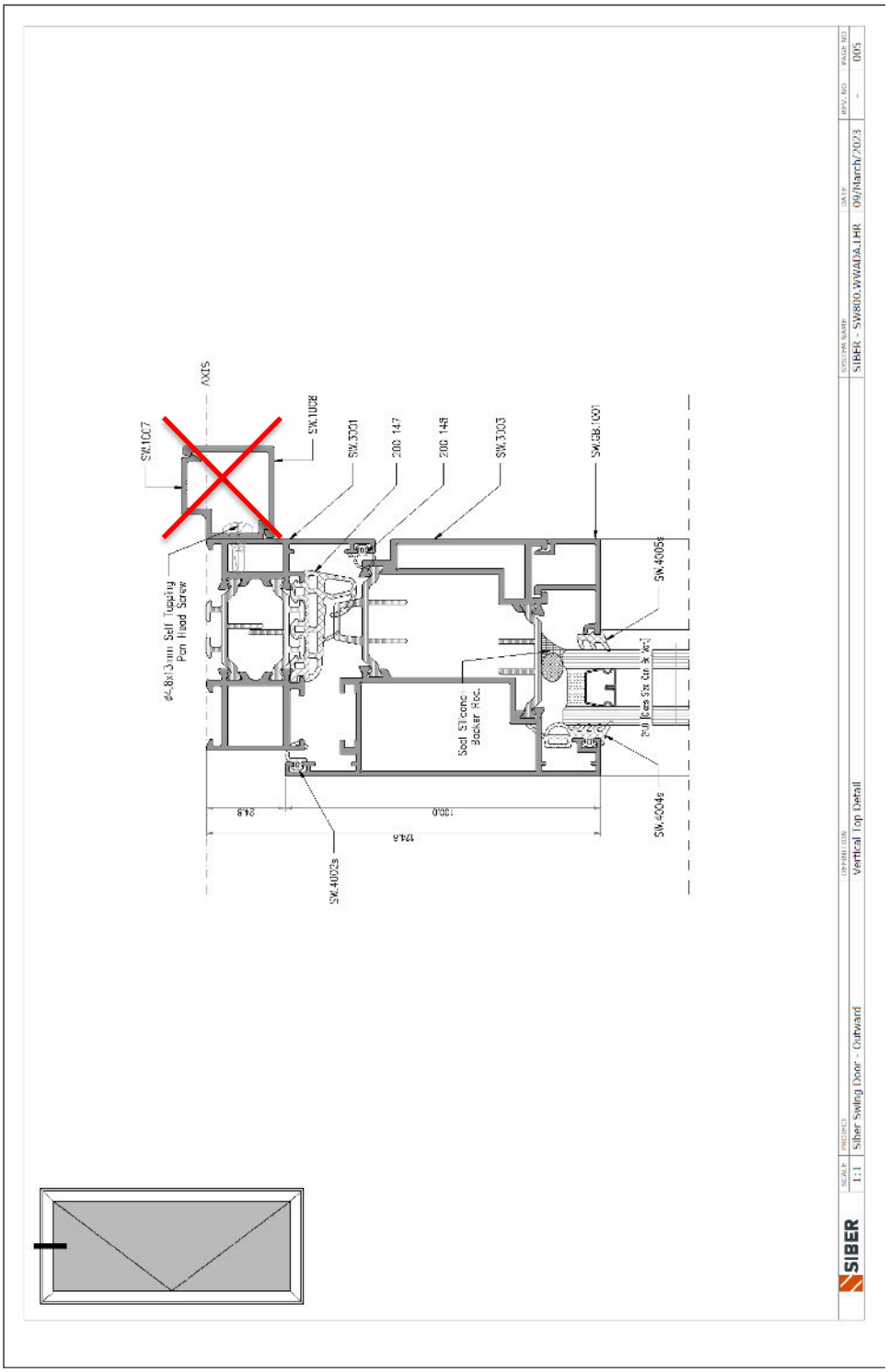
Cross-Section Assembly Drawing



SW800 WWADA LHR Out-Swing Side Hinged Door – Cross-Section Assembly – Head and Top Rail

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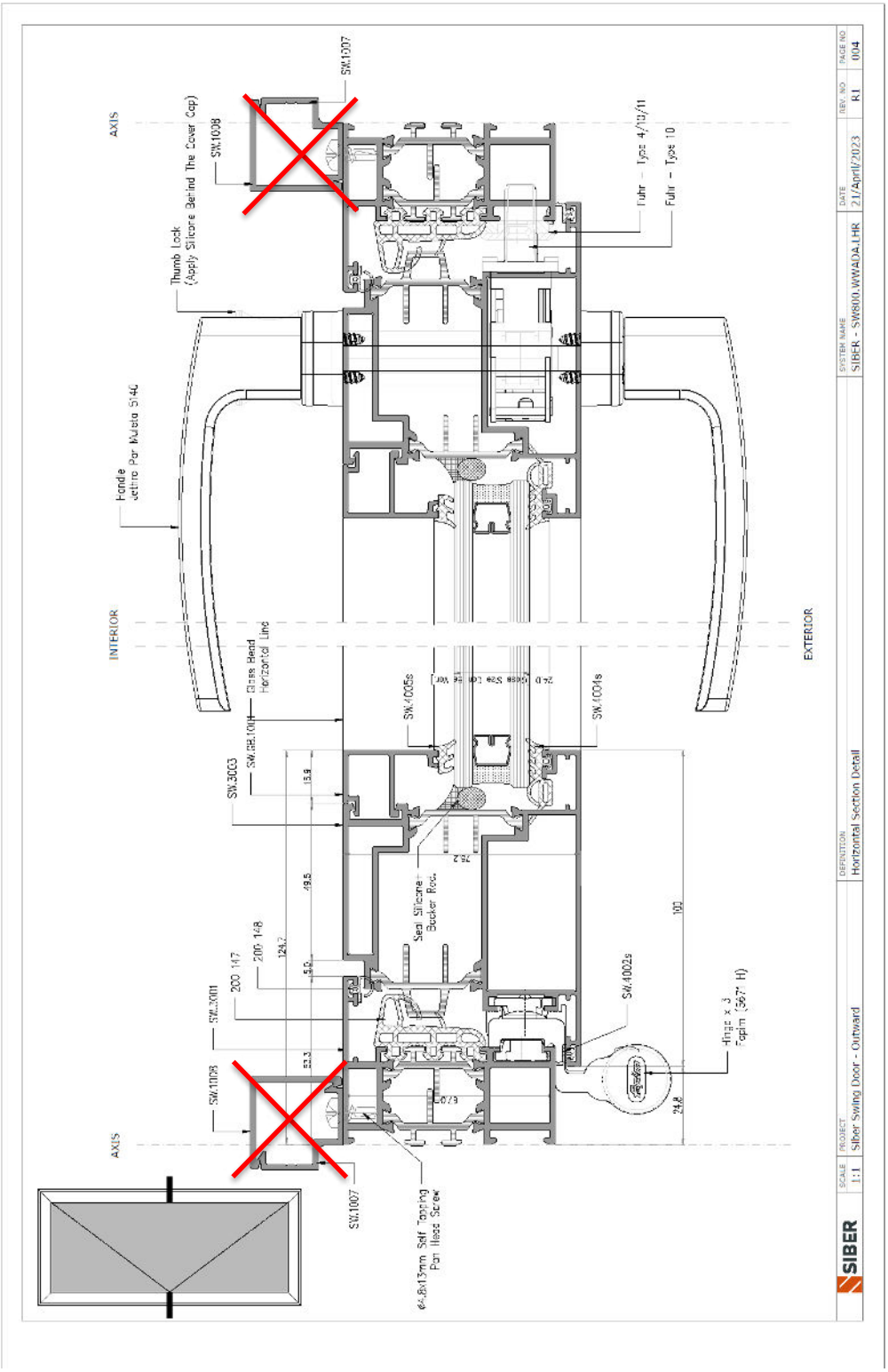

SW800 WWADA LHR Out-Swing Side Hinged Door – Cross-Section Assembly – Jambs and Stiles

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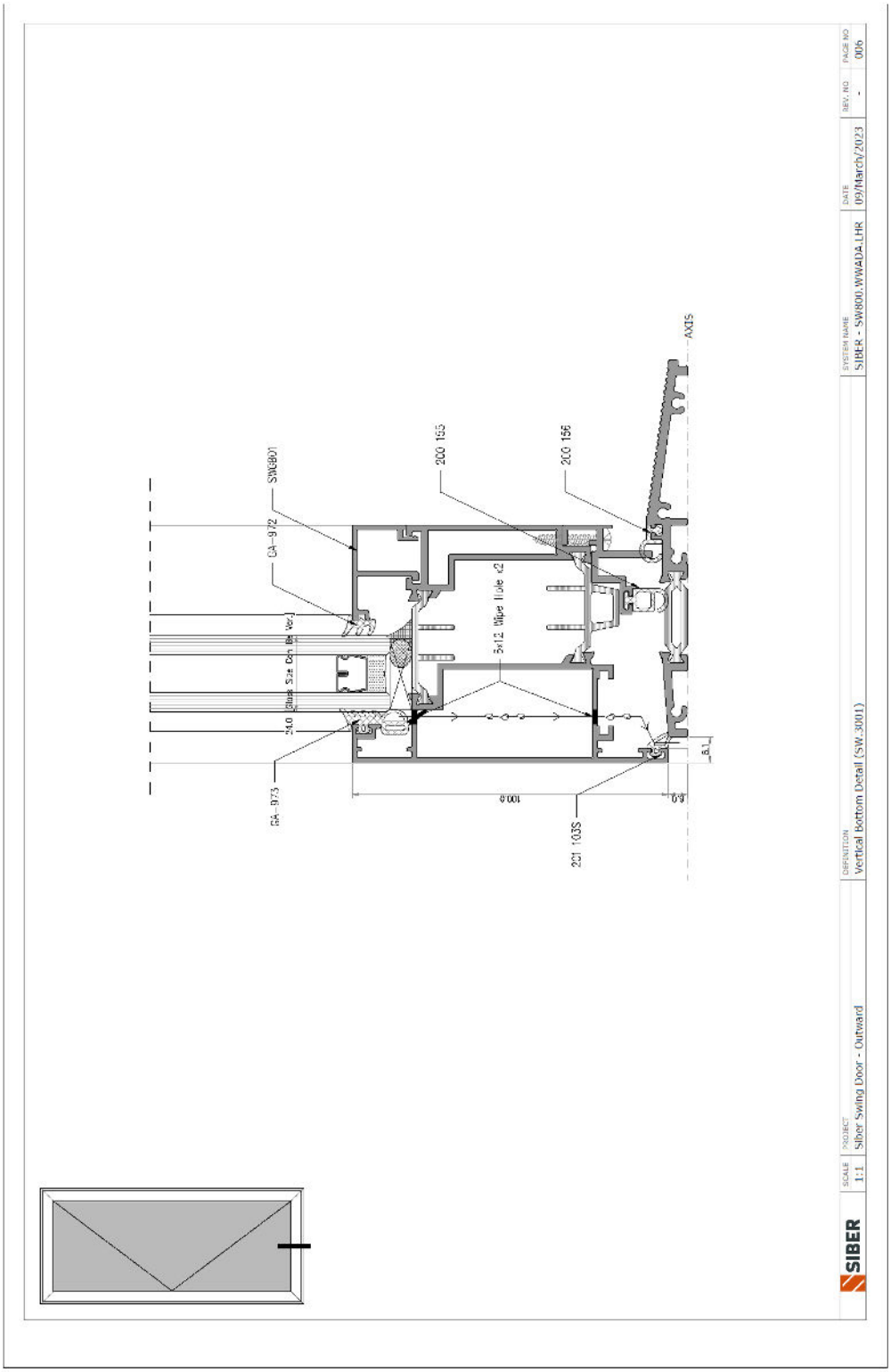

SW800 WWADA LHR Out-Swing Side Hinged Door – Cross-Section Assembly – Sill and Bottom Rail

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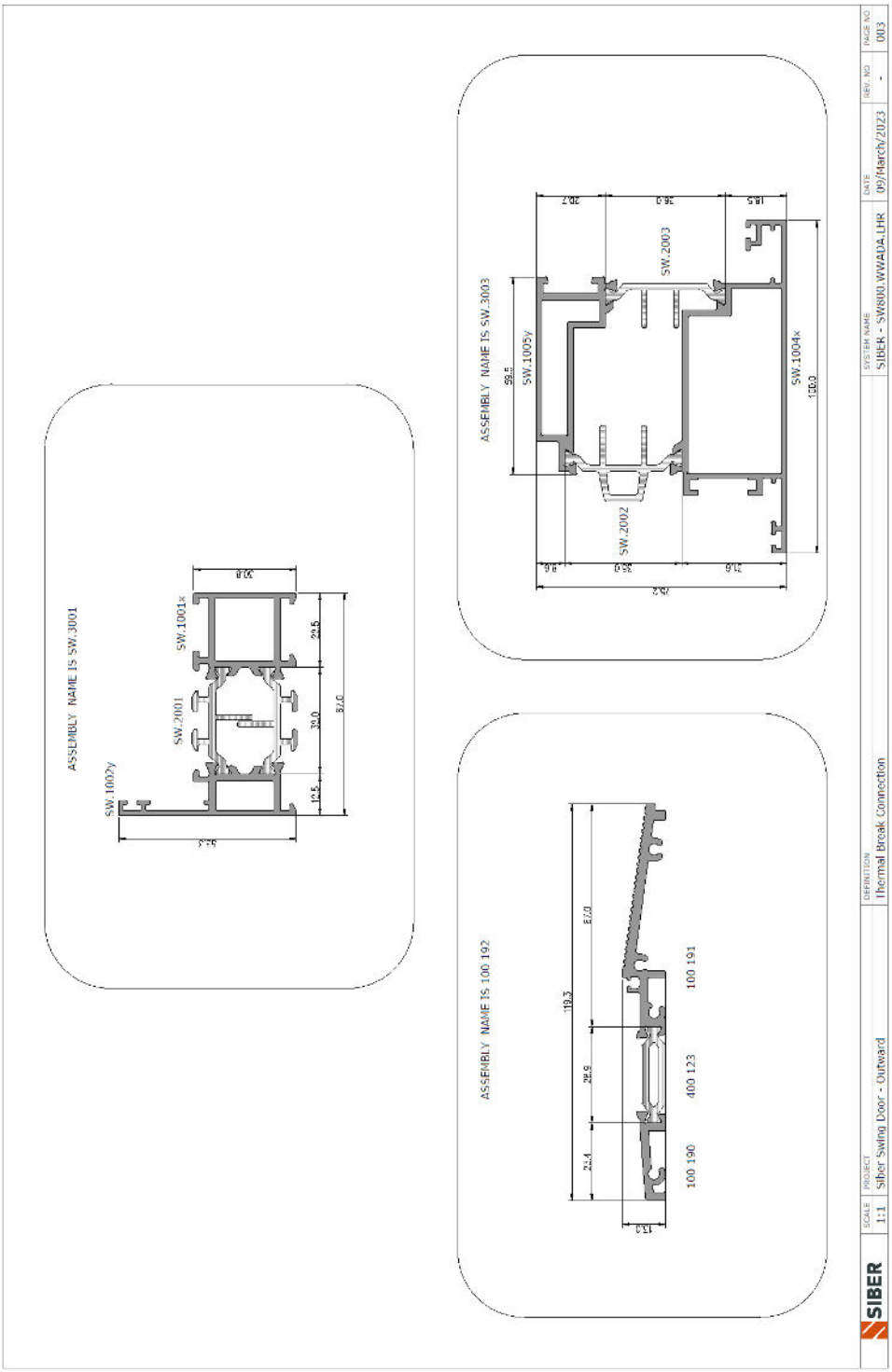
Dimensioned Die Drawings

Dimensions are in mm.



SW800 WWADA LHR Out-Swing Side Hinged Door – Frame and Door Slab Profiles

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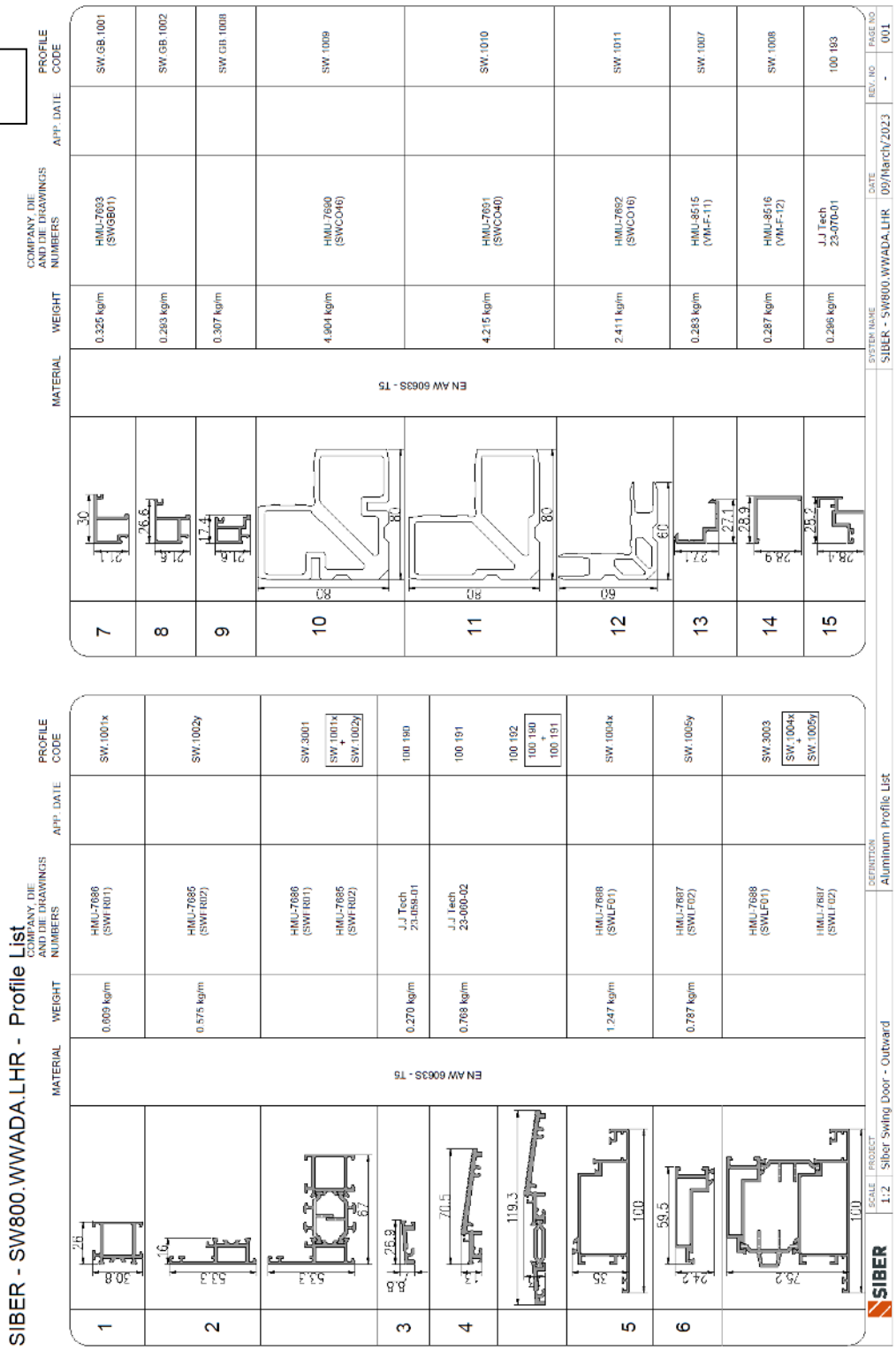
Dimensions are in mm.



SW800 WWADA LHR Out-Swing Side Hinged Door – Aluminum Component Profiles

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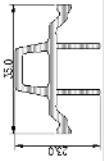
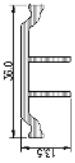
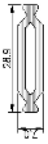
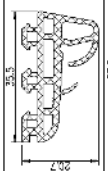
Dimensions are in mm.

SIBER - SW800.WWADA.LHR - Thermal Break List

		Material	Company Number	Thermal Break Code
1			SW.TH-01	SW.2001
2			SW.TH-02	SW.2002
3			PAG-878	SW.2003
4				400 123

SIBER - SW800.WWADA.LHR - Gasket List

		Material	Company Code	Gasket Code
1		SILICONE GASKET (SHORE A 50 ±5)	200 147	200 147
2		SILICONE GASKET (SHORE A 60 ±5)	GA-973	SW.4004s
3	On Sash	SILICONE GASKET (SHORE A 60 ±5)	SW.GA-02	SW.4002s
4	On Frame	SILICONE GASKET (SHORE A 50 ±5)	200 148	200 148
5		SILICONE GASKET (SHORE A 60 ±5)	SW.GA-04	SW.4005s
6		SILICONE GASKET (SHORE A 60 ±5)		200 155
7		SILICONE GASKET (SHORE A 60 ±5)		200 156
8		SWGACO01		
9		SWGACO02		

SIBER | SCALE 1:1 | PROJECT Siber Swing Door - Outward | DEFINITION Gasket - Thermal Break - Accessory List | SYSTEM NAME SIBER - SW800.WWADA.LHR | DATE 09/March/2023 | REV. NO R1 | PAGE NO 002

SW800 WWADA LHR Out-Swing Side Hinged Door – Gasket and Thermal Break Profiles

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Sample Photographs

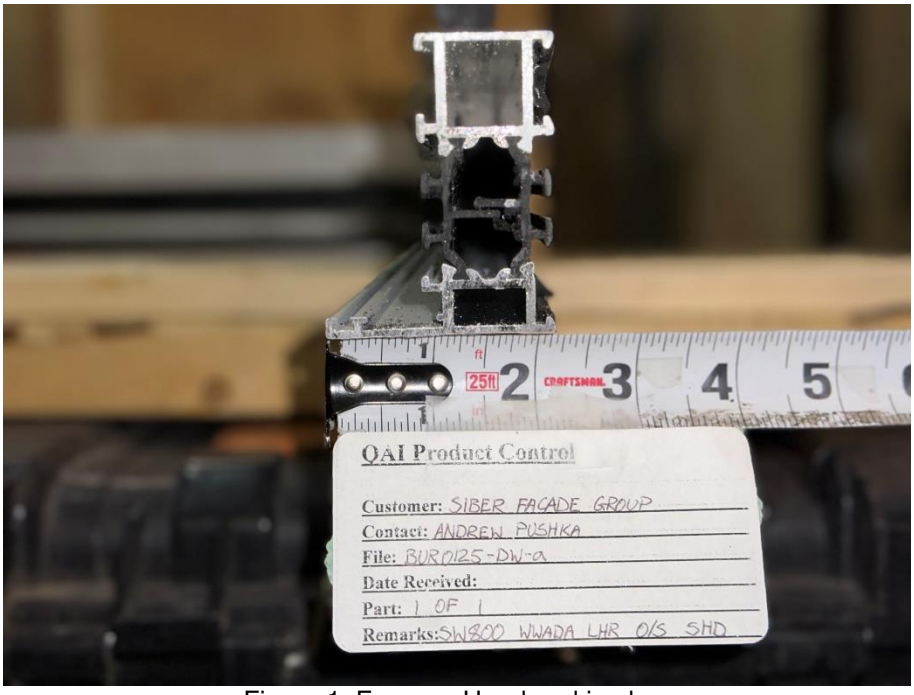

Figure 1: Frame – Head and jambs.

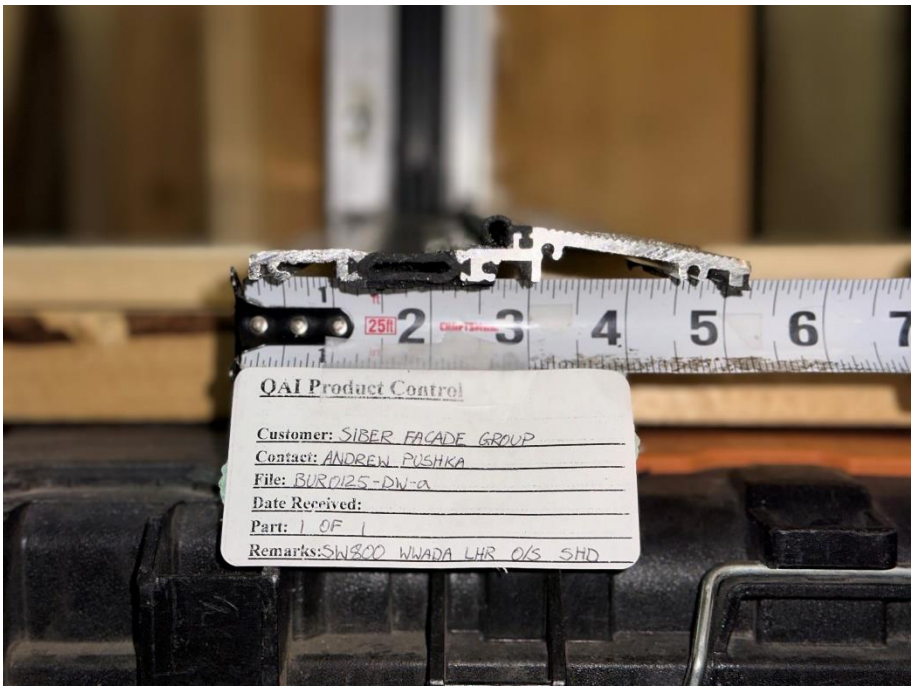

Figure 2: Frame – Sill.

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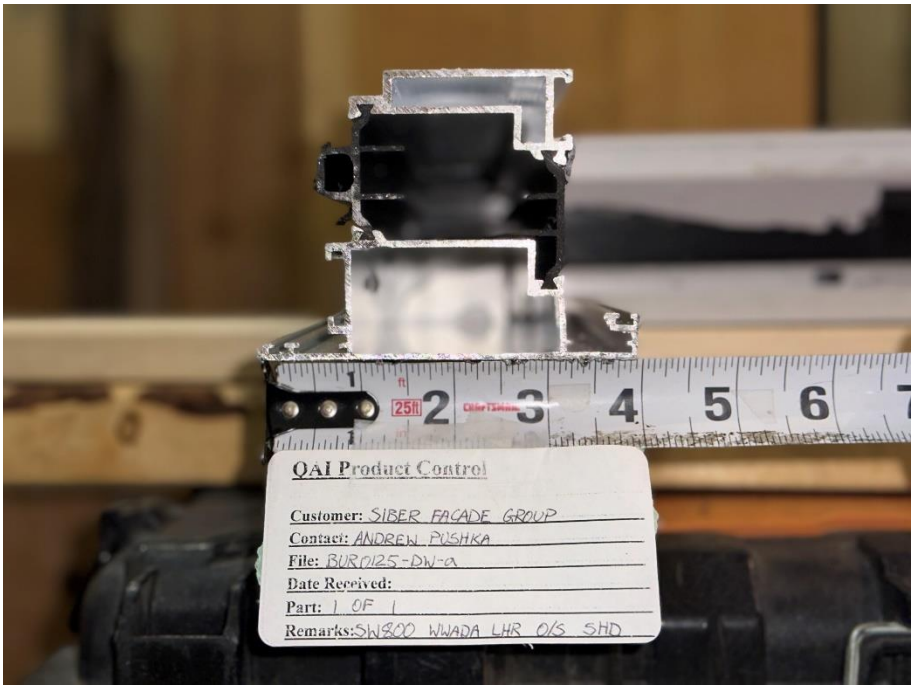

Figure 3: Door slab – Top rail and stiles.

Figure 4: Door slab – Bottom rail.

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Figure 5: Glazing bead.

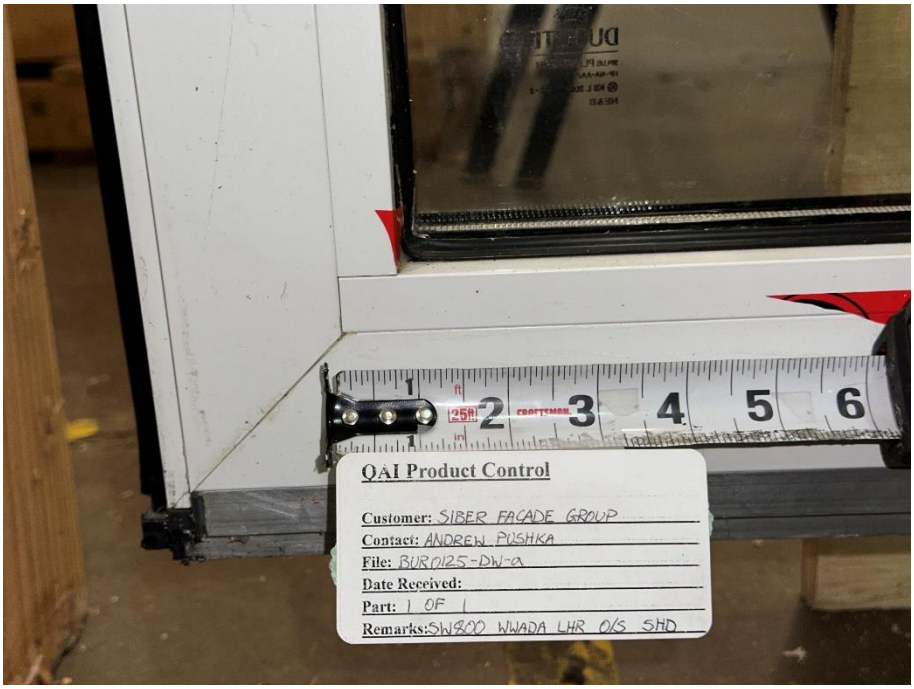

Figure 6: Glazing bead corner joint.

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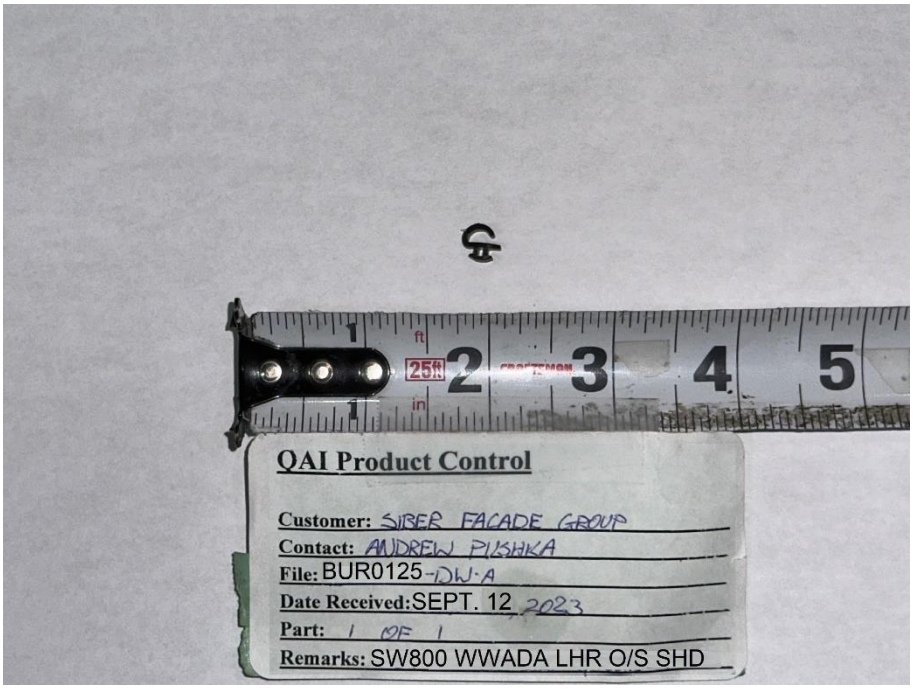

Figure 7: Weather-stripping (Gasket Code 200 148) - Frame.

Figure 8: Weather-stripping (Gasket Code 200 147) - Frame.

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Figure 9: Weather-stripping corner joint - Frame.

Figure 10: Weather-stripping gasket (Gasket Code SW .4002s) - Door Slab.

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Figure 11: Weather-stripping butt joint - Door slab.

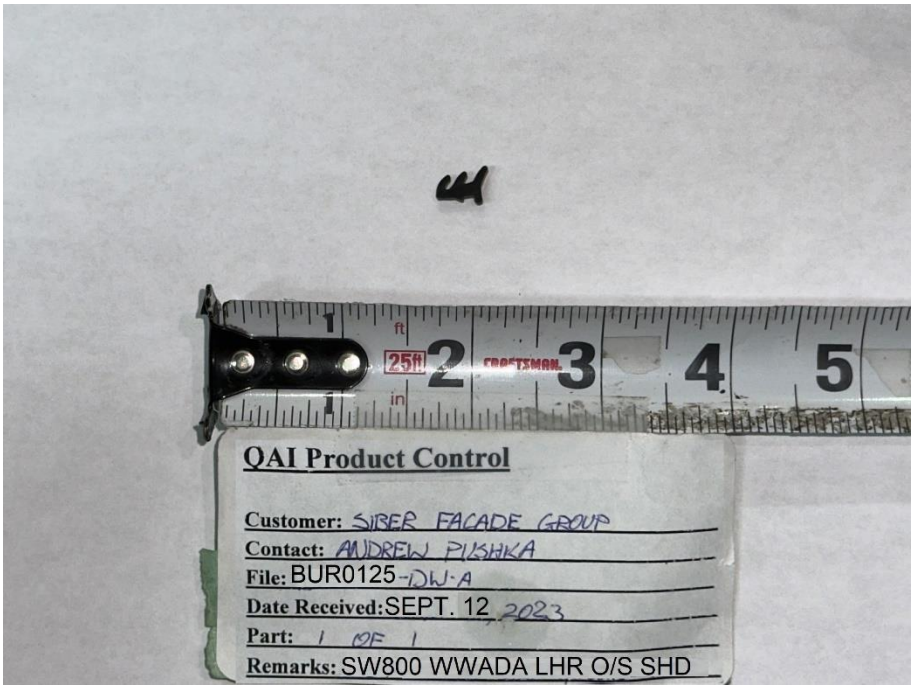

Figure 12: Interior glazing gasket (Gasket Code SW .4005s).

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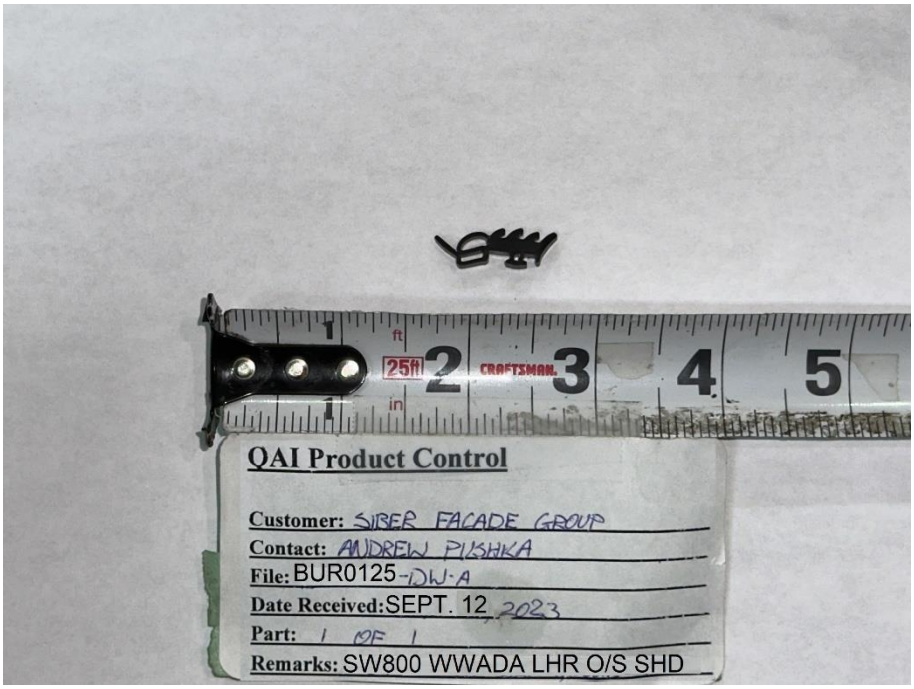

Figure 13: Exterior glazing gasket (Gasket Code SW .4004s).

Figure 14: Exterior glazing gasket corner joint.

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Figure 15: Drainage into the door slab.

Figure 16: Drainage out of the door slab.

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Figure 17: Notch in door slab weather-stripping for drainage.

Figure 18: I-bar locking system – Lower section.

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Figure 19: I-bar locking system – Lower Middle section.

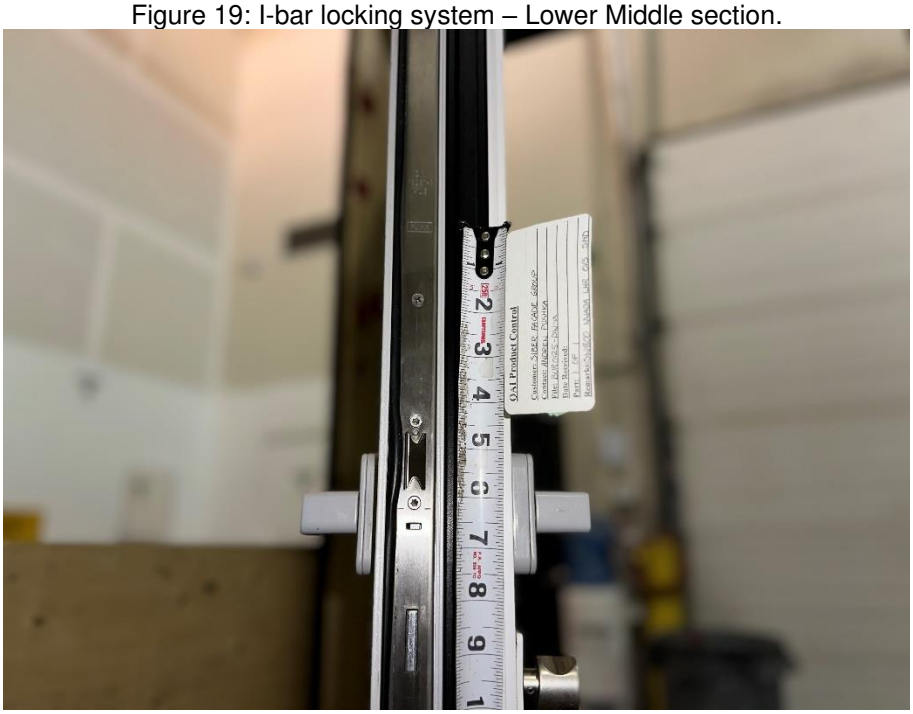

Figure 20: I-bar locking system – Upper middle section.

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Figure 21: I-bar locking system – Upper Section.

Figure 22: I-bar keeper system – Lower section.

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Figure 23: I-bar keeper system – Lower middle section.

Figure 24: I-bar keeper system – Upper middle section.

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Figure 25: I-bar keeper system – Upper section.

Figure 26: Lever handle and thumb turn operators.

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Figure 27: Hinge.

Figure 28: Stay arm hinge – Door slab side.

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Figure 29: Stay arm hinge – Frame side.

Figure 30: Hinge backplate.

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REPORT REVISION HISTORY

Date	Revision	Change Description	Initials
December 5, 2023	0	Original Report: Siber Facade Group. SW800 WWADA LHR Out-Swing Side Hinged Door	RM

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

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