

REPORT NUMBER: 3179893TOR-227 PVCSR
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EVALUATION CENTER
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6225 Kenway Drive
Mississauga, Ontario L5T 2L3

RENDERED TO

Artistic Skylight Domes Ltd.
2 Guided Court
Etobicoke, ON M9V 4K6

Attention: Nenzio Ferrazzo

PRODUCT EVALUATED: PVCSR Fixed Skylights
EVALUATION PROPERTY: Physical Tests

Report of Testing for Artistic Skylights Domes Ltd. on PVCSR deck-mounted fixed plastic skylight for compliance with the applicable requirements of the following criteria: AAMA/WDMA/CSA 101/I.S.2/A440-08 "NAFS North American Fenestration Standard/Specification for windows, doors, and skylights" and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, Canadian Supplement.

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Report of Testing for Artistic Skylights Domes Ltd. on PVCSR deck-mounted fixed plastic skylight for compliance with the applicable requirements of the following criteria: AAMA/WDMA/CSA 101/I.S.2/A440-08 “NAFS North American Fenestration Standard/Specification for windows, doors, and skylights” and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, Canadian Supplement.

2 Introduction

Intertek has conducted performance testing for Artistic Skylight Domes Ltd. on three G-PVCSR deck-mounted fixed glass skylights for the Intertek Certification Program.

- (A) 48"×48"
- (B) 67"×89-1/2"

The skylights were submitted to the Intertek laboratory in Mississauga, Ontario on August 17, 2009. Testing was conducted in accordance with the standard methods of AAMA/WDMA/CSA 101/I.S.2/A440-08 "NAFS North American Fenestration Standard/Specification for windows, doors, and skylights" and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement*. This evaluation began August 17, 2009 and was completed October 2, 2009.

3 Test Specimen

3.1. SPECIMEN AND ASSEMBLY DESCRIPTION

Designations:

- (CAN)
 - A - Class R-PG1200 (metric)-Size Tested 1346×1346 mm - SKP/RW
 - B - Class R-PG720 (metric)-Size Tested 1826×2400 mm - SKP/RW
- (US)
 - A - Class R-PG25-Size Tested 53.0×53.0 in - SKP/RW
 - B - Class R-PG15-Size Tested 71.9×94.5 in - SKP/RW

Model: • PVCSR Skylight

Type: • Deck-mounted, aluminum capped, plastic frame fixed plastic glass skylight

Manufacturer: • Artistic Skylight Domes Ltd., 2 Guided Court, Etobicoke ON M9V 4K6

Condition: • New and undamaged

Overall Size:

Skylight No.	Overall (incl. Nailing Fin) mm (in)	
	Width	Height
A	1464 (57-5/8)	1464 (57-5/8)
B	1943 (76-1/2)	2518 (99-1/8)

Frame: • Extruded vinyl main frame members (Extrusion Profiles Die No. 329C) with mitred and welded corners. The frame was complete with an integral nailing fin.

Frame (cont'd):

- Aluminum Cap- Extruded aluminum cap members (Spectra Aluminum Products Die No. SS-1880) having mitred corners fastened with one #6×1-1/4" pan head screw and a chevron corner key. The corners were liberally sealed with silicone on the backside.
- Aluminum Head Flashing- Brake-formed 'Z'-shaped 0.46 mm (0.018") thick aluminum flashing having a 267 mm (10-1/2") long to 337 mm (13-1/4") long leg (fastened to the roof deck), a 60 mm (2-3/8") outward return, and a 45 mm (1-3/4") long drip edge leg. The top edge of the flashing also had a 13 mm (1/2") wide inward return. For samples B and C, the ends of the large leg were cut at an angle, and the ends of the return folded at an angle so that the drip-edge leg was the dimension listed below. For sample A, the ends of the flashing were not folded, leaving the drip edge the same length as the rest of the flashing section.

Skylight No.	Length of Head Flashing
A	1803 mm (71)
B	2286 mm (90")

- Installation: The unit was installed onto a 2×6 wood support frame with 1/2" plywood sheathing secured to one face, simulating an inclined roof surface, the frame measuring 2438 mm (96") wide by 2743 mm (108") high overall. The skylight was installed over an opening, centred width-wise, the edge of the sill nailing fin corresponding with the bottom edge of the plywood sheathing. The perimeter of the opening was lined with 2×6 wood members.

Skylight No.	Size of Rough Opening	
	Width mm (in.)	Height mm (in.)
A	1226 (48-1/4)	1226 (48-1/4)
B	1727 (68)	2216 (87-1/4)

- The order of installation was as follows:
The exterior of the plywood, from the bottom edge of the support frame up to the bottom edge of the opening and extending up the sides of the opening by 76 mm (3"), was faced with self-adhering peel-and-stick waterproofing membrane. A nominally 102 mm (4") wide bed of silicone was applied to the exposed membrane along the bottom edge of the opening, this silicone bed continued up each side of the opening for approximately 178 mm (7") for Sample A and 1702 mm (67") for Sample B, applied to the membrane surface near the bottom of the opening continuing along the exposed plywood above the membrane (the bed of silicone varying from 63 mm (2-1/2") to 102 mm (4") wide along the sides of the opening).

- Frame (cont'd):**
- The skylight was then placed over the opening and fastened to the plywood along the head and jambs with 1-1/4" long roofing nails installed in the pre-punched holes along the head and jamb nailing fins, the holes on 122 mm (4-13/16") centres. There were no fasteners used along the exposed sill nailing fin. Strips of waterproofing membrane measuring approximately 457 mm (18") wide were then applied along each side and along the top of the unit, covering the exposed nailing fin and adjacent plywood surface. Conventional three-tab asphalt shingles were then installed over the membrane (butting up against the side of the skylight frame) along each side of the unit using 1-1/4" long roofing nails. The membrane was also applied over the nailing fin and adjacent plywood along the top of the unit, the membrane continuous to the top edge of the plywood, and lapping over the membrane along the sides of the unit.

Skylight No.	Number of Installation Fasteners (Roofing Nails)	
	Head Nailing Fin	Jamb Nailing Fin
A	12	11
B	8	20

- A brake-formed aluminum flashing was then installed over the head of the skylight using the roofing nails, two per end. The top edge of the flashing had a 13 mm (1/2") wide inward return which wrapped over the top edge of the plywood sheathing.

Note: For air tightness testing only, the inside perimeter of the skylight support frame opening was sealed with red air barrier tape to the inside perimeter of the PVC skylight frame such that the plywood sheathing-to-PVC skylight frame joint was sealed as well as the joint between the plywood sheathing and 2x6 wood support members lining the opening. The tape was removed for water tightness testing.

Drainage: • None (original slots along sill sealed with silicone).

Glazing:

- A- Two domed layers of nominally 3.2 mm (0.125") thick acrylic plastic (Plaskolite) with a 6.4 mm (1/4") air space, the two layers separated about the perimeter with double sided adhesive backed closed cell foam tape (continuous at three corners) measuring 9.5 mm wide by 6.4 mm thick (3/8"x1/4") sandwiched between the layers The tape joint at the fourth corner was sealed with silicone.
- B- Two domed layers of nominally 5 mm thick acrylic plastic (Plaskolite) with a 6.4 mm (1/4") air space, the two layers separated about the perimeter with double sided adhesive backed closed cell foam tape (continuous at three corners) measuring 9.5 mm wide by 6.4 mm thick (3/8"x1/4") sandwiched between the layers The tape joint at the fourth corner was sealed with silicone.

Glazing Method: • Laid in glazed on the interior on a bed of silicone measuring nominally 13 mm (1/2") wide applied on a co-extruded flexible vinyl glazing gasket, and retained with the extruded aluminum capping on the exterior, double-sided adhesive backed closed cell foam tape measuring 6.4 mm wide by 3.2 mm thick (1/4"x1/8") being sandwiched between the exterior of the glazing unit and the back side of the aluminum capping. The corners of the sealed unit were also sealed to the back-side of the capping with silicone. The aluminum cap was fastened to the skylight frame using #8x3/4" self-drilling tek screws installed through the side of the capping.

Skylight No.	Number of Aluminum Cap Fasteners	
	Head/Sill	Jambs
A	6	6
B	8	10

Drawings:

- Plan and Cross-Section Drawing:
Artistic Skylight Domes drawing PVCSR, undated
- Component Drawings:
Extrusion Profiles Inc. Die No. 329c, titled "Self Flashing Frame", dated Jan 09, 2004
Spectra Aluminum Products Die No. SS-1880, titled "Retaining Frame", dated Nov/30/2000

Drawings are enclosed with this report in Appendix A.

4 Testing and Evaluation Methods

The Unit Skylight (glazed with plastic) (SKP/RW) as described in this report was tested to the Residential (R) Performance Class as follows: (The skylight met the Gateway Performance Requirements, by virtue of meeting the higher (optional) performance grades to which they was tested):

- Minimum Gateway Test Size: 500 mm × 1100 mm
- Maximum Allowable Air Leakage: 1.5 L/s•m² (0.3 cfm/ft²) (US)
- Maximum Allowable Air Leakage: 0.2 L/s•m² (0.04 cfm/ft²) (FIXED Canadian)
- Minimum Water Pressure: 140 Pa (2.9 psf)
- Minimum Design Pressure: 720 Pa (15 psf)
- Minimum Structural Pressure: 1440 Pa (30 psf)

The skylights were tested for compliance to the above test criteria in order to achieve the Gateway Performance Designation of Class R-PG15 / R-PG720. The skylights tested had an overall size as follows:

- A- 1346 mm wide by 1346 mm high (53" × 53")
- B - 1826 mm wide by 2400 mm high (71-7/8" × 94-1/2")

Performance testing was conducted in order to meet the overall Optional Performance requirements as follows:

A- 30-1/4" × 89-1/2"

- Optional Water Pressure: 580 Pa (12 psf)
- Optional Water Pressure (Canada): 730 Pa (15 psf)
- Optional Positive Design Pressure: 3360 Pa (70 psf)
- Optional Negative Design Pressure: 1440 Pa (30 psf)
- Optional Positive Structural Test Pressure: 6720 Pa (140 psf)
- Gateway Negative Structural Test Pressure: 2880 Pa (60 psf)
- Canada (only) Air Infiltration/Exfiltration Level: Fixed

B- 46-1/4" × 69-1/2"

- Optional Water Pressure: 580 Pa (12 psf)
- Optional Water Pressure (Canada): 730 Pa (15 psf)
- Optional Positive Design Pressure: 2400 Pa (50 psf)
- Optional Negative Design Pressure: 1920 Pa (40 psf)
- Optional Positive Structural Test Pressure: 4800Pa (100 psf)
- Optional Negative Structural Test Pressure: 3840 Pa (80 psf)
- Canadian (only) Air Infiltration/Exfiltration Level: Fixed

DEVIATION FROM THE TEST STANDARD

Testing was not initiated at the minimum Gateway grade levels for the SKP/RW-R class of skylights in all incidences of testing. As testing was performed in conjunction with other skylight test standards, the skylight was tested to the Optional Performance Grades of AAMA/WDMA/CSA 101/I.S.2/A440-08. By default, the minimum Gateway requirements were met by virtue of meeting the requirements at higher test levels.

4.1. AIR LEAKAGE RESISTANCE TEST (Clause 5.3.2)

The Air Leakage Resistance test was performed in accordance with ASTM E283-04, "*Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen.*"

Air infiltration and exfiltration tests were performed using test pressures of 75 Pa (1.57 psf). The maximum air leakage rate was calculated and compared to the allowable air leakage.

4.2. WATER PENETRATION RESISTANCE TEST (Clause 5.3.3)

The Water Tightness test was conducted and evaluated in accordance AAMA/WDMA/CSA 101/I.S.2/A440-08, Section 5.3.3.4, in conjunction with ASTM E331-00, "*Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference.*"

The Water Tightness test was performed with the skylight installed into a make-shift roof opening as installed by the client, the installation details contained herein. For the water penetration test, the roof was placed at a 15° incline from horizontal at the specified pressure differential and a water spray rate of at least 204 L/m² per hour (5.0 US gal/ft² per hour). The test duration was 15 minutes.

4.3. UNIFORM LOAD TEST (Clause 5.3.4)

4.3.1 Uniform Load Deflection Test (Clause 5.3.4.2)

The Uniform Load Deflection test was conducted in accordance with ASTM E330-02, "*Standard Test Method for Structural Performance of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference,*" Procedure A.

The Deflection test was performed in both the positive and negative directions. A load equal to one-half the anticipated allowable load was applied and held for one minute. Deflection measurements were taken at the mid-span and ends of a jamb. The load was then released and deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for permanent damage. The anticipated allowable load was then be applied and held for one minute. Deflection readings were taken. The load was then released; deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for failure or permanent deformation of any part of the skylight that would cause any operational malfunction.

4.3.2 Uniform Load Structural Test (Clause 5.3.4.3)

The Uniform Load Structural Test was conducted in accordance with ASTM E330-02, "*Standard Test Method for Structural Performance of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference*," Procedure A.

The Structural test was performed in both the positive and negative directions. A load equal to one-half the structural test pressure was applied and held for one minute. Permanent deflection measurements were taken at the mid-span and ends of a jamb. The load was then released and deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for permanent damage. The structural test pressure was then be applied and held for one minute. Deflection readings were taken. The load was then released; Permanent deflection readings were taken after a recovery period of not less than one minute nor more than five minutes at zero load. The test specimen was evaluated for failure or permanent deformation of any part of the skylight that would cause any operational malfunction.

4.4 THERMOPLASTIC CORNER WELD TEST (Clause 5.3.6.2)

Corner weld tests were conducted in accordance with Clause 5.3.6.2 of the AAMA/WDMA/CSA 101/I.S.2/A440-08. Each corner sample was mounted in a test fixture as per Figure 12 of the standard. The frame corners were loaded as per Figure 12 with a gradually increasing load until breakage of the corner occurred. When loaded to failure, the break shall not extend along the entire weld line.

5 Testing and Evaluation Results

5.1 Air Leakage Resistance Test (Clause 5.3.2)

A- PVCSR 48x48	
Air Leakage – 75 Pa (1.57 psf)	
Net infiltration:	0.28 L/s (0.59 cfm)
Total Skylight Area	1.812 m ² (19.51 ft ²)
Air Leakage Rate:	0.15 L/s·m ² (0.030 cfm/ft ²)
Air Exfiltration – 75 Pa (1.57 psf)	
Net exfiltration:	0.28 L/s (0.59 cfm)
Total Skylight Area	1.812 m ² (19.51 ft ²)
Exfiltration rate:	0.15 L/s·m ² (0.030 cfm/ft ²)
B- PVCSR 67x89-1/2	
Air Leakage – 75 Pa (1.57 psf)	
Net infiltration:	0.28 L/s (0.59 cfm)
Total Skylight Area	4.382 m ² (47.17 ft ²)
Air Leakage Rate:	0.06 L/s·m ² (0.013 cfm/ft ²)
Air Exfiltration – 75 Pa (1.57 psf)	
Net exfiltration:	0.19 L/s (0.40 cfm)
Total Skylight Area	4.382 m ² (47.17 ft ²)
Exfiltration rate:	0.04 L/s·m ² (0.013 cfm/ft ²)
Maximum allowable air leakage rate:	1.5 L/s·m ² (0.3 cfm/ft ²)
Maximum allowable air leakage rate (Canadian Fixed):	0.2 L/s·m ² (0.04 cfm/ft ²)

The PVCSR skylights **MET** the performance levels (as well as FIXED Canadian Infiltration/Exfiltration Levels) specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 for Air Leakage Resistance.

5.2 Water Penetration Resistance Test (Clause 5.3.2)

A- PVCSR 48x48		
Pressure Differential		730 Pa (15 psf)
Skylight Inclination Angle		15°
Results:		No water leakage observed.
B- PVCSR 67x89-1/2		
Pressure Differential		730 Pa (15 psf)
Skylight Inclination Angle		15°
Results:		No water leakage observed.

The PVCSR skylights **MET** the minimum Gateway Water Penetration Resistance requirement at 140 Pa (2.9 psf), and the Optional Performance requirement for Residential class at 580 Pa (12 psf) in AAMA/WDMA/CSA 101/I.S.2/A440-08. Additionally, the skylights met the maximum water penetration resistance requirements for Canadian applications at 730 Pa (15 psf).

5.3 Uniform Load Test (Clause 5.3.3)

Uniform Load Deflection Test - A- PVCSR 48x48		
Member	Jamb	
Span Length	1295 mm (51")	
Allowable Deflection	Report only	
Test Pressure*	Positive Load	Negative Load
	+1440 Pa (+30 psf)*	-1440 Pa (-30 psf)*
Maximum Net Deflection	-0.03 mm (-0.001")	-1.32 mm (-0.052")
Note:	* Deflection measurements were taken at ±1400 Pa instead of ±1200 Pa	
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

Uniform Load Deflection Test - B- PVCSR 67x89-1/2		
Member	Jamb	
Span Length	2369 mm (93-1/4")	
Allowable Deflection	Report only	
Test Pressure	Positive Load	Negative Load
	+1200 Pa (+25 psf)	-720 Pa (-15 psf)
Maximum Net Deflection	-1.35 mm (-0.053")	-1.00 mm (-0.039")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

4.4 Uniform Load Tests (cont'd)

Uniform Load Structural Test - A- PVCSR 48x48		
Member	Jamb	
Span Length	1295 mm (51")	
Allowable Residual Deflection (0.4% × span)	5.18 mm (0.204")	
Test Pressure	Positive Load	Negative Load
	+2400 Pa (+50 psf)	-2400 Pa (-50 psf)
Residual Net Deflection	0.00 mm (0.000")	0.07 mm (0.003")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

Uniform Load Structural Test - B- PVCSR 67x89-1/2		
Member	Jamb	
Span Length	2369 mm (93-1/4")	
Allowable Residual Deflection (0.4% × span)	9.48 mm (0.373")	
Test Pressure	Positive Load	Negative Load
	+2400 Pa (+50 psf)	-1440 Pa (-30 psf)
Residual Net Deflection	-0.12 mm (-0.005")	-2.17 mm (-0.086")
Post-test Details	After the test loads were released, the skylight was inspected and there was found to be no failure or permanent deformation of any part of the skylight that would cause any operational malfunction.	

The PVCSR skylights met the minimum Gateway Uniform Load Structural Test (200% of Design Pressure) performance requirements at ±1440 Pa (±30 psf). The skylights met the performance requirements as specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 as follows:

Skylight No.	Structural Load Achieved	
	Positive Load	Negative Load
A	+2400 Pa (+50 psf)	-2400 Pa (-50 psf)
B	+2400 Pa (+50 psf)	-1440 Pa (-30 psf)

The PVCSR skylights qualify for the design loads as follows:

Skylight No.	Design Load	
	Positive Load	Negative Load
A	+1200 Pa (+25 psf)	-1200 Pa (-25 psf)
B	+1200 Pa (+25 psf)	-720 Pa (-15 psf)

5.4 Thermoplastic Corner Weld Test (Clause 5.3.6.2)

Frame- Break did not extend along entire weld line.

The skylights met the performance requirements specified in AAMA/WDMA/CSA 101/I.S.2/A440-08 for thermoplastic corner weld test.

6 Conclusion

When tested to the requirements in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-08 "NAFS North American Fenestration Standard/Specification for windows, doors, and skylights" and AAMA/WDMA/CSA 101/I.S.2/A440S1-09, *Canadian Supplement*, the PVCSR skylights described and tested herein achieved the following Performance Designations:

Primary Designator

- (CAN)
- A - Class R-PG1200 (metric)-Size Tested 1346×1346 mm - SKP/RW
 - B - Class R-PG720 (metric)-Size Tested 1826×2400 mm - SKP/RW
- (US)
- A - Class R-PG25-Size Tested 53.0×53.0 in - SKP/RW
 - B - Class R-PG15-Size Tested 71.9×94.5 in - SKP/RW

Secondary Designator

- A
- Positive Design Pressure = +1200 Pa (+25 psf)
 - Negative Design Pressure = -1200 Pa (-25 psf)
 - Water Penetration Resistance (US only) = 580 Pa (12 psf)
 - Water Penetration Resistance (Canada only) = 730 Pa (15.2 psf)
 - Canadian Air Leakage Resistance (Infiltration/Exfiltration) = Fixed
- B
- Positive Design Pressure = +1200 Pa (+25 psf)
 - Negative Design Pressure = -720 Pa (-15 psf)
 - Water Penetration Resistance (US only) = 580 Pa (12 psf)
 - Water Penetration Resistance (Canada only) = 730 Pa (15.2 psf)
 - Canadian Air Leakage Resistance (Infiltration/Exfiltration) = Fixed

INTERTEK

Tested by Mustafa Swalah, Ryan Huynh and Claudio Sacilotto

Reported by:



Claudio Sacilotto
Physical Testing Services

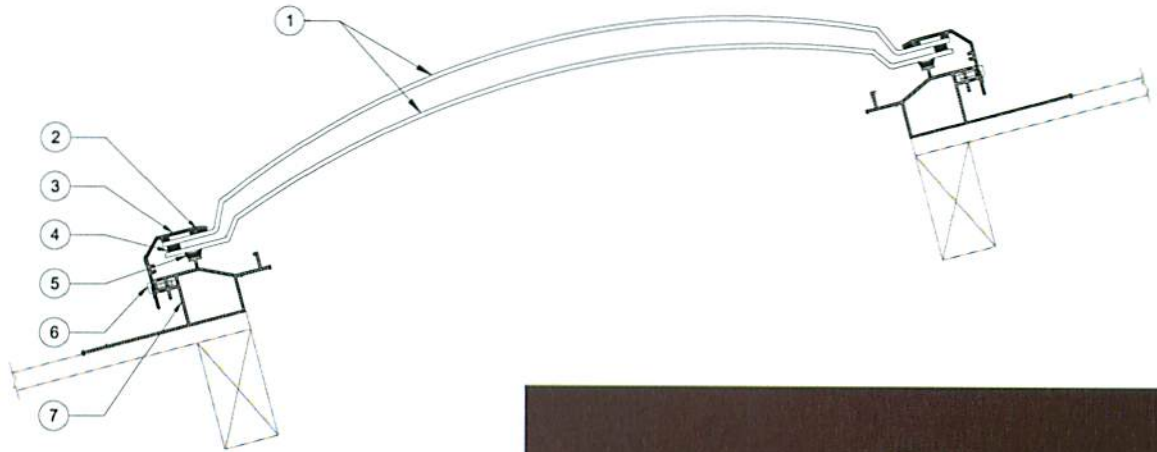
Reviewed by:



Ryan Huynh
Physical Testing Services

Appendix A – Parts List / Drawings

(Parts List / Drawings – 3 pages)



MODEL PVCSR (SELF FLASHING FIXED - ACRYLIC DOME GLAZING)

	DETAIL
UNIT 1: DOUBLE DOME	1 - CLEAR 1/8" THK. 2 - CLEAR 1/8" THK.
UNIT 2: DOUBLE DOME	1 - TRANSPARENT BRONZE 1/8" THK. 2 - CLEAR 1/8" THK.
UNIT 3: DOUBLE DOME	1 - CLEAR 1/8" THK. 2 - TRANSLUCENT WHITE 1/8" THK.
UNIT 4: TRIPLE DOME	1 - CLEAR 1/8" THK. 2 - CLEAR 1/8" THK. 3 - CLEAR 1/8" THK.
UNIT 5: TRIPLE DOME	1 - TRANSPARENT BRONZE 1/8" THK. 2 - CLEAR 1/8" THK. 3 - CLEAR 1/8" THK.
UNIT 6: TRIPLE DOME	1 - CLEAR 1/8" THK. 2 - CLEAR 1/8" THK. 3 - TRANSLUCENT WHITE 1/8" THK.

PARTS LIST

MODEL PVCSR (SELF FLASHING FIXED - ACRYLIC DOME GLAZING)

PARTICULAR	MANUFACTURER
1. ACRYLIC GLAZING	PLASKOLITE INC., U.S.A.
2. 1/8" x 1/4" DOUBLE FACE VINYL FOAM GLAZING TAPE	GASKA TAPE INC., PART # 623012020
3. EXTRUDED ALUMINUM RETAINING FRAME (6063-T5 ALLOY)	SPECTRA DIE # SS-1880 & AFP DIE # 228
4. 1/4" x 1/8" DOUBLE FACE VINYL GLAZING TAPE	GASKA TAPE INC., PART # 623025022
5. CO-EXTRUDED RUBBER DRAFT SEAL	EXTRUSION PROFILES INC.
6. #8 - 18 X 1/4" ASSEMBLY SCREW	ROBERTSON, CANADA
7. EXTRUDED RIGID THERMAL PVC CURB MOUNT FRAME	EXTRUSION PROFILES INC., DIE # 328

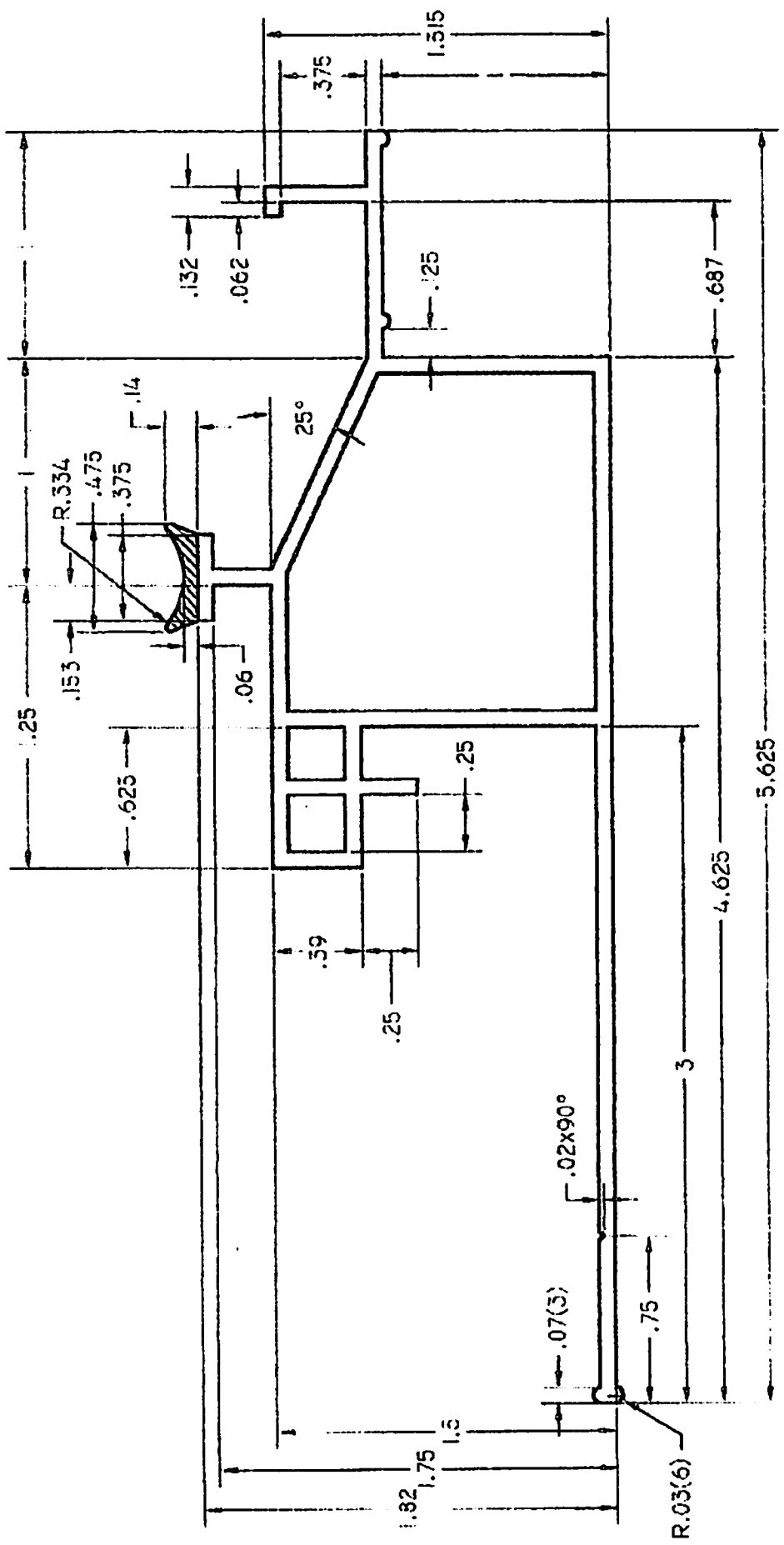
SKYLIGHT MODEL:

PVCSR



2 Guided Court
 Etobicoke, Ontario, Canada M9V 4K6
 E-mail: artistic@istar.ca
 Web: www.artisticskylight.com

DATE	APPROVED



9833 Meridian Rd. #17
 Meridian, MS 39301
 Tel. 601-471-3488
 Fax: 601-471-6104

EXTRUSION PROFILES INC.

TITLE **SELF FLASHING FRAME**

SIZE	DWG BY	DWG DATE	REV
	<i>Mimmy</i>	JAN.09.2004	

SCALE DWG NO DIE #: 329C SHEET

DESCRIPTION: **RETAINING FRAME**

PROPOSAL#: **SP-12291**

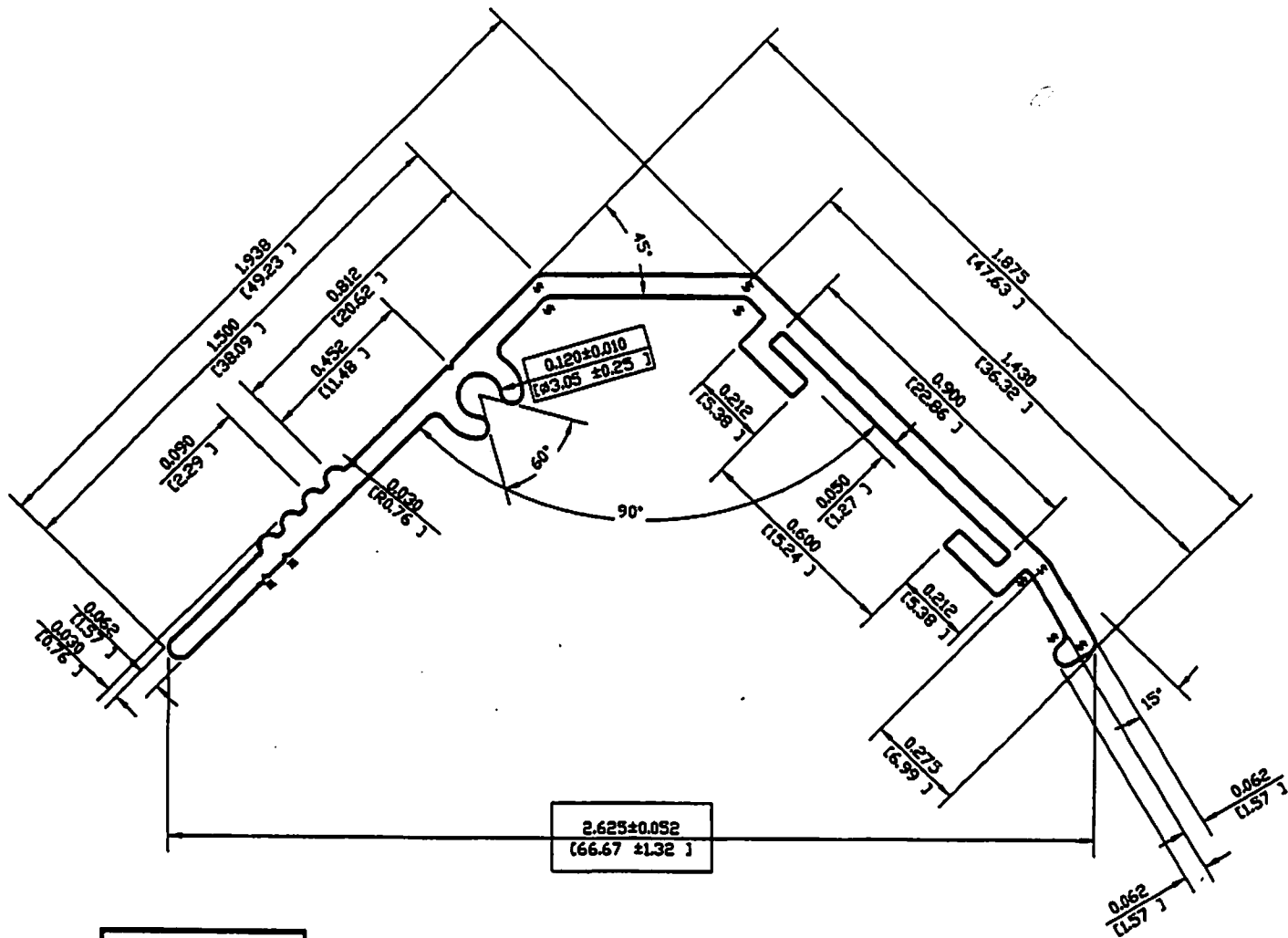
CUSTOMER #
01187233

CUSTOMER: **ARTISTIC SKYLIGHTS**

DIE NO. **SS-1880**

DATE: LET: REVISION: BY:

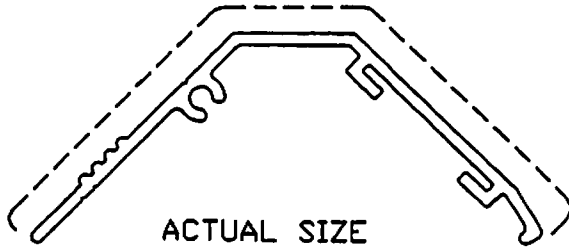
SPECTRA ALUMINUM PRODUCTS INC.
UNCONTROLLED
Date: **FEB 20 2007**



2.625±0.052
(66.67 ±1.32)

CAVITY I.D.

EXPOSED SURFACES

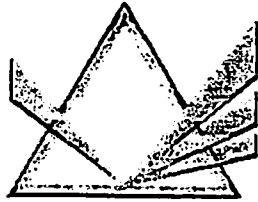


ACTUAL SIZE

NOTE: WALL THICKNESS IS 0.062" (1.57mm) UNLESS OTHERWISE SHOWN
NOTE: BREAK ALL CORNERS AT 0.010" (0.25mm) UNLESS OTHERWISE SHOWN
NOTE: * INDICATES A 0.031" (0.79mm) RADIUS

X.XXX = CRITICAL DIM.
* = 0.010 (0.25) X 90° (SPECTRA ALUMINUM ID MARK)

NOTE:
STANDARD ALUMINUM ASSOCIATION TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED.



SPECTRA
ALUMINUM PRODUCTS INC.

PRICING: WEIGHT <input checked="" type="checkbox"/>	PIECE: <input type="checkbox"/>	ALLOY: CHECK P.O.	TEMPER: TS
SS NO.: 1	CONTR: 6'	PKT: 3/4"	EXT. RATIO 50.66
PACKER NO.: BA-1632-1	DIE SIZE: 8' x 1'		
BOLSTER NO.: 80-2B	BACKER SIZE: 8' x 3'		
GUAGE:		NITROGEN: <input type="checkbox"/>	CAV: 2
DWN. BY: S.B.	SCALE: 2:1	DATE: NOV/30/2000	EST. VT: 0.329 lbs/ft. 0.489 kg/m
EST. AREA: 0.279 sq.in 180.00 sq.mm		DWS. PER: in mm	
OUT. PER: 8.811 in 223.80 mm		FACTOR: 26.78	
EST. VT: 0.329 lbs/ft. 0.489 kg/m		CCD: 2.625 in 66.66 mm	