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EVALUATION REPORT

W517-1 ED4

APPENDIX A

Client: Uni-Tech Windows Manufacturer Inc.
260 Jevlan Drive
Woodbridge, ON
L4L 8B1
Canada

Date: April 26, 2019

Contents: APPENDIX A (Pages A1 through A39)

Prepared By

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Project Manager

Reviewed By

Matt Lansdowne, P.Eng.
Director of Engineering

Signed for and on behalf of QAI Laboratories, Ltd.

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APPENDIX A

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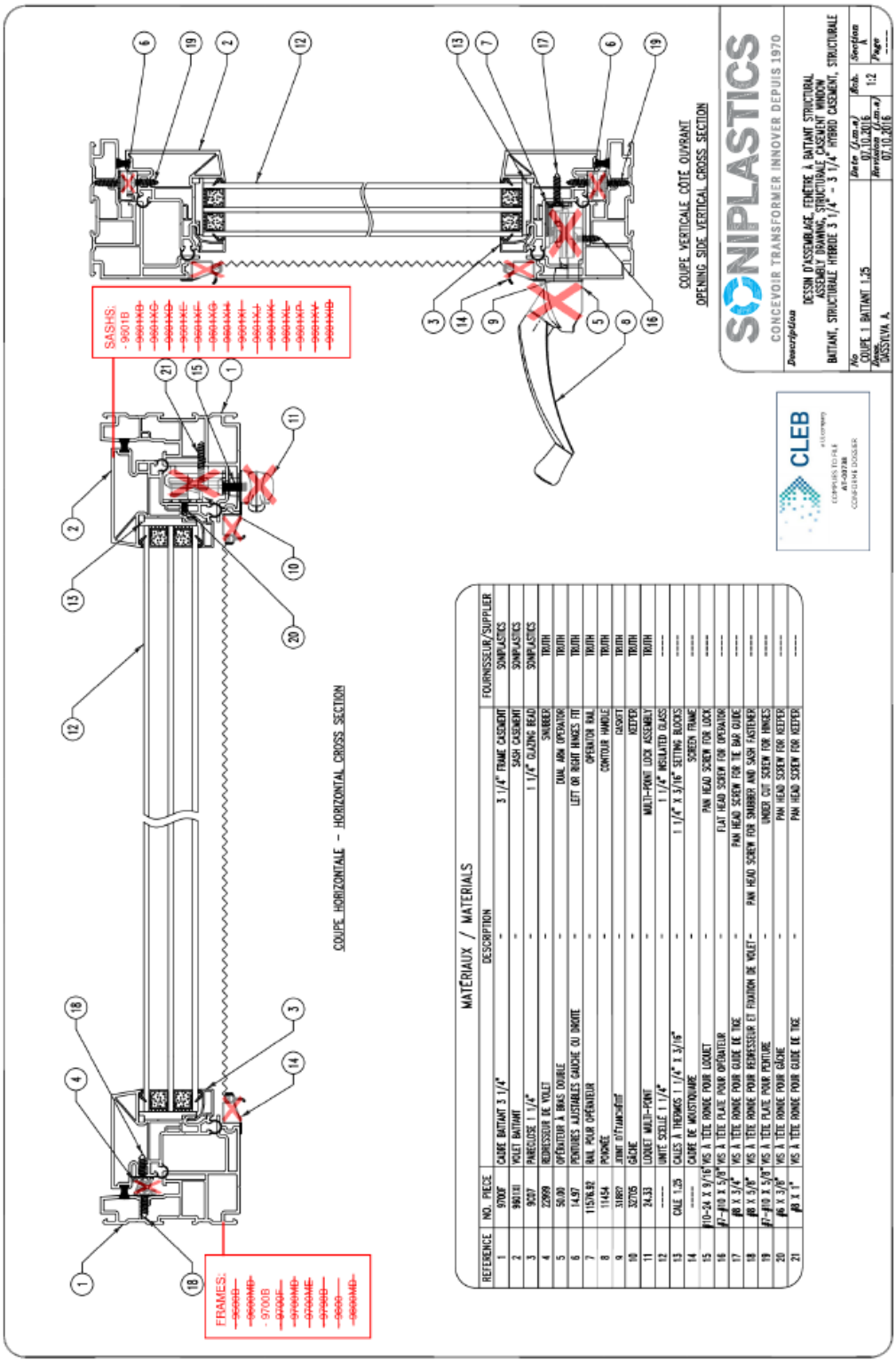

Casement Window - Assembly Cross-Sections

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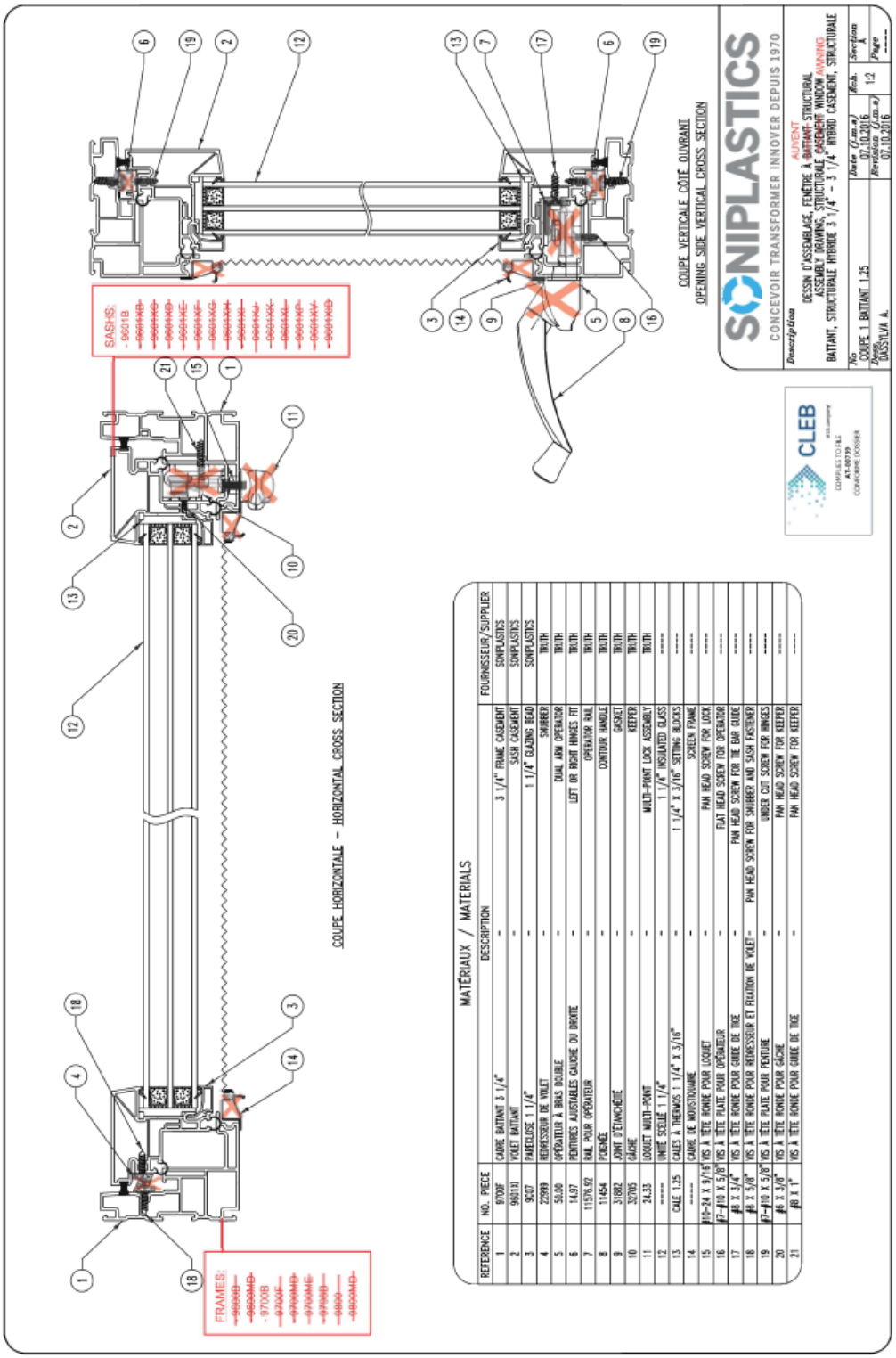

Awning Window - Assembly Cross-Sections

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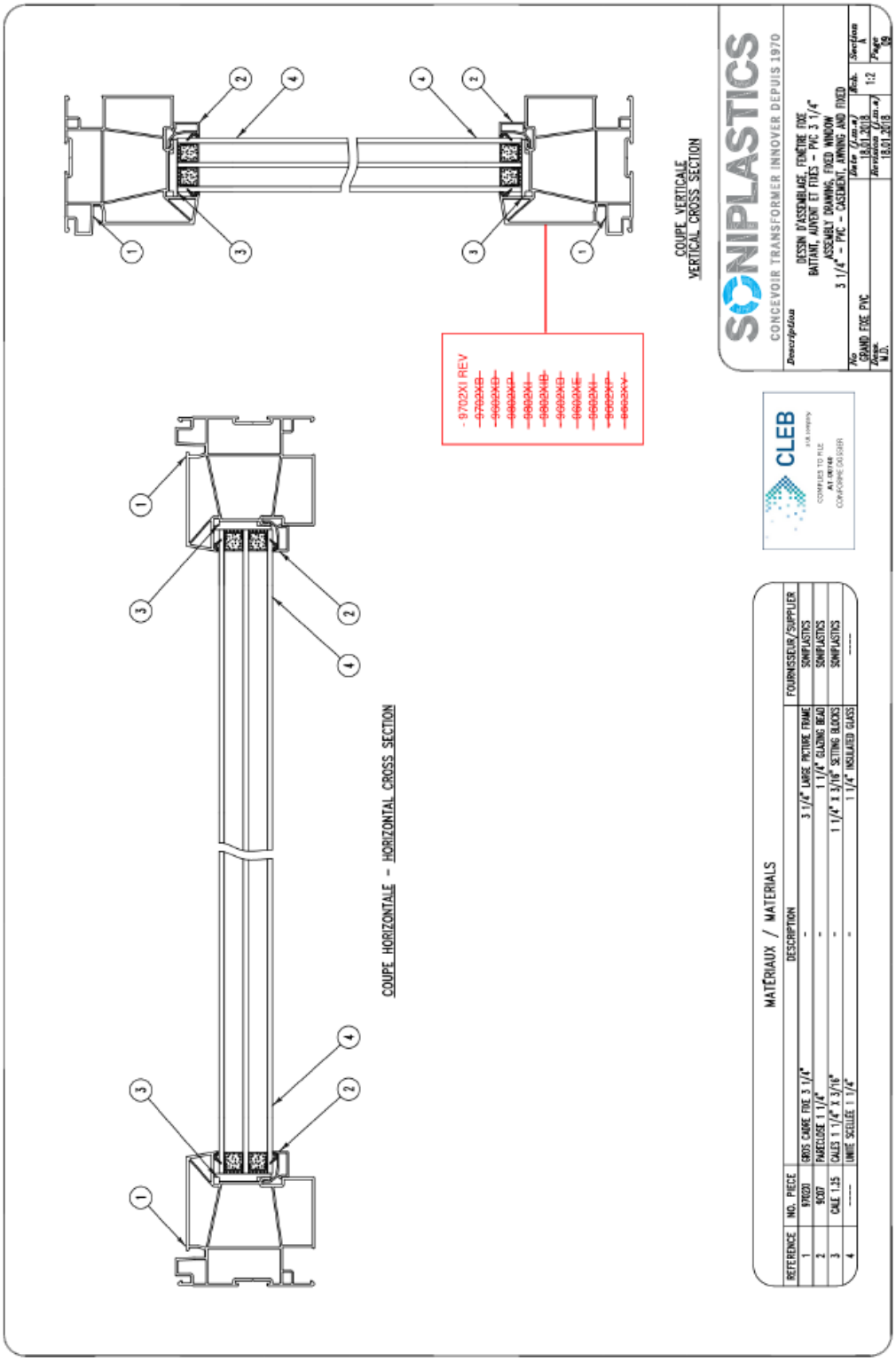

Large Fixed Window - Assembly Cross-Sections

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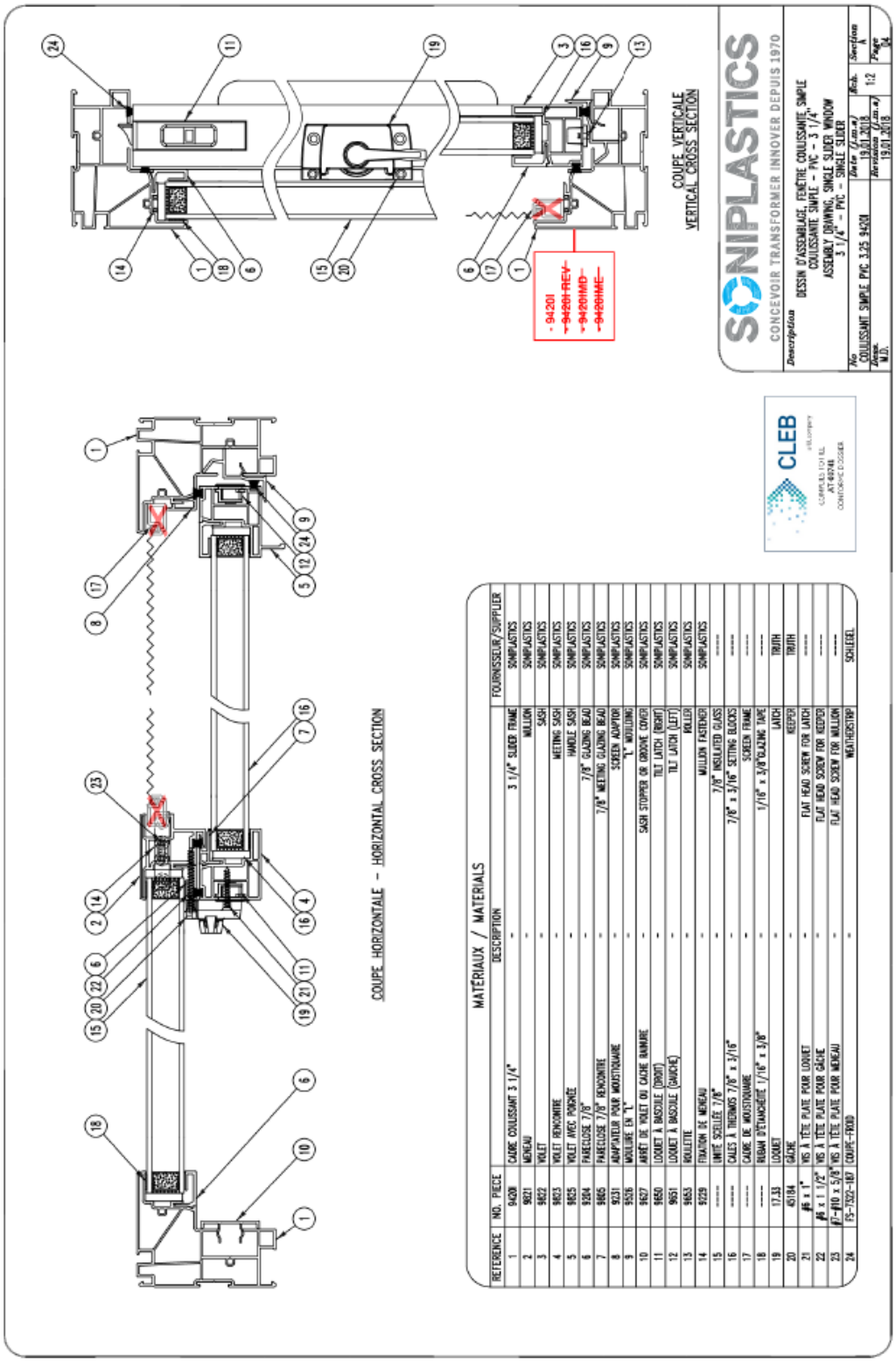

Horizontal Sliding Window - Assembly Cross-Sections

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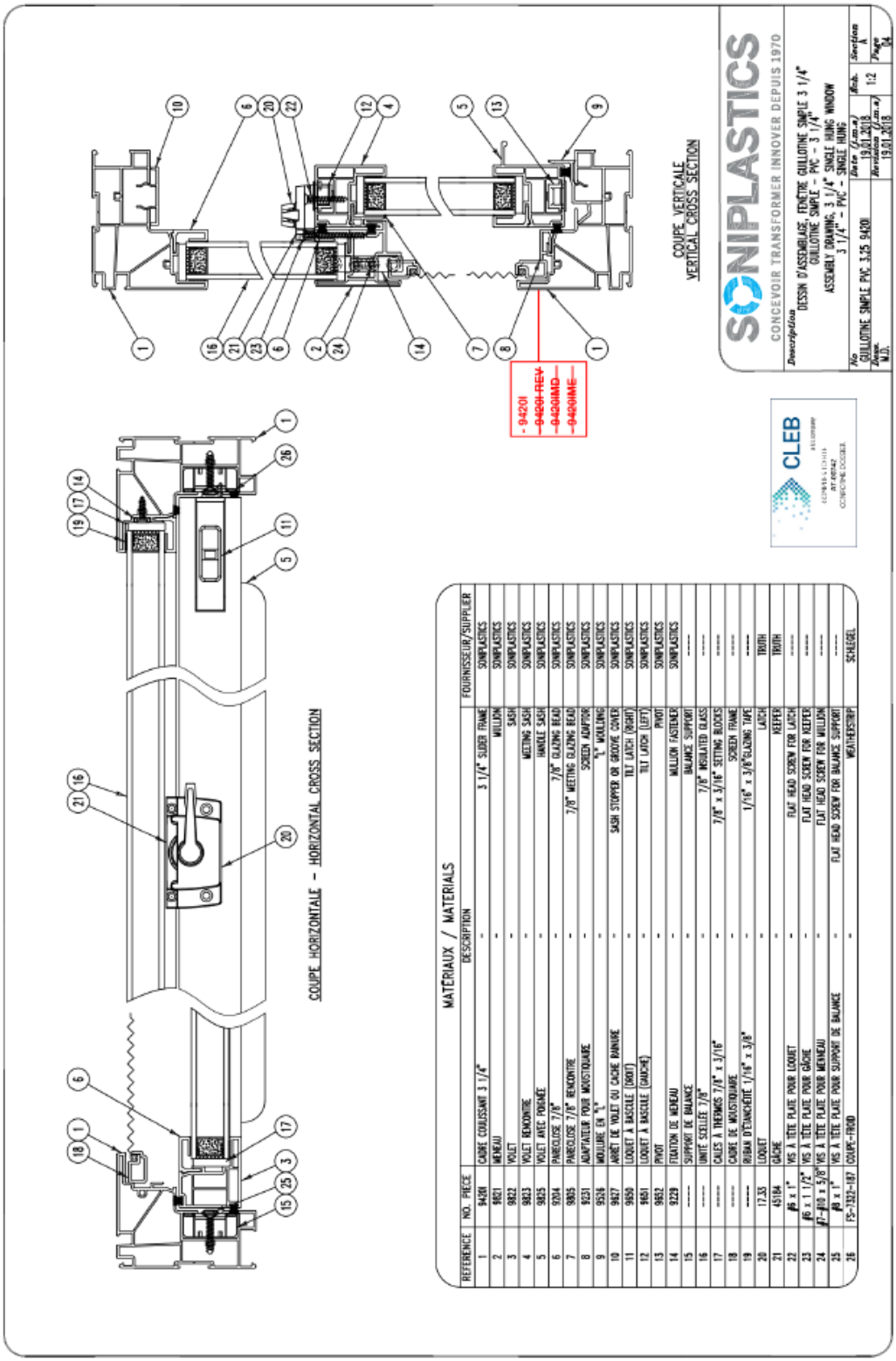

Vertical Sliding Window - Assembly Cross-Sections

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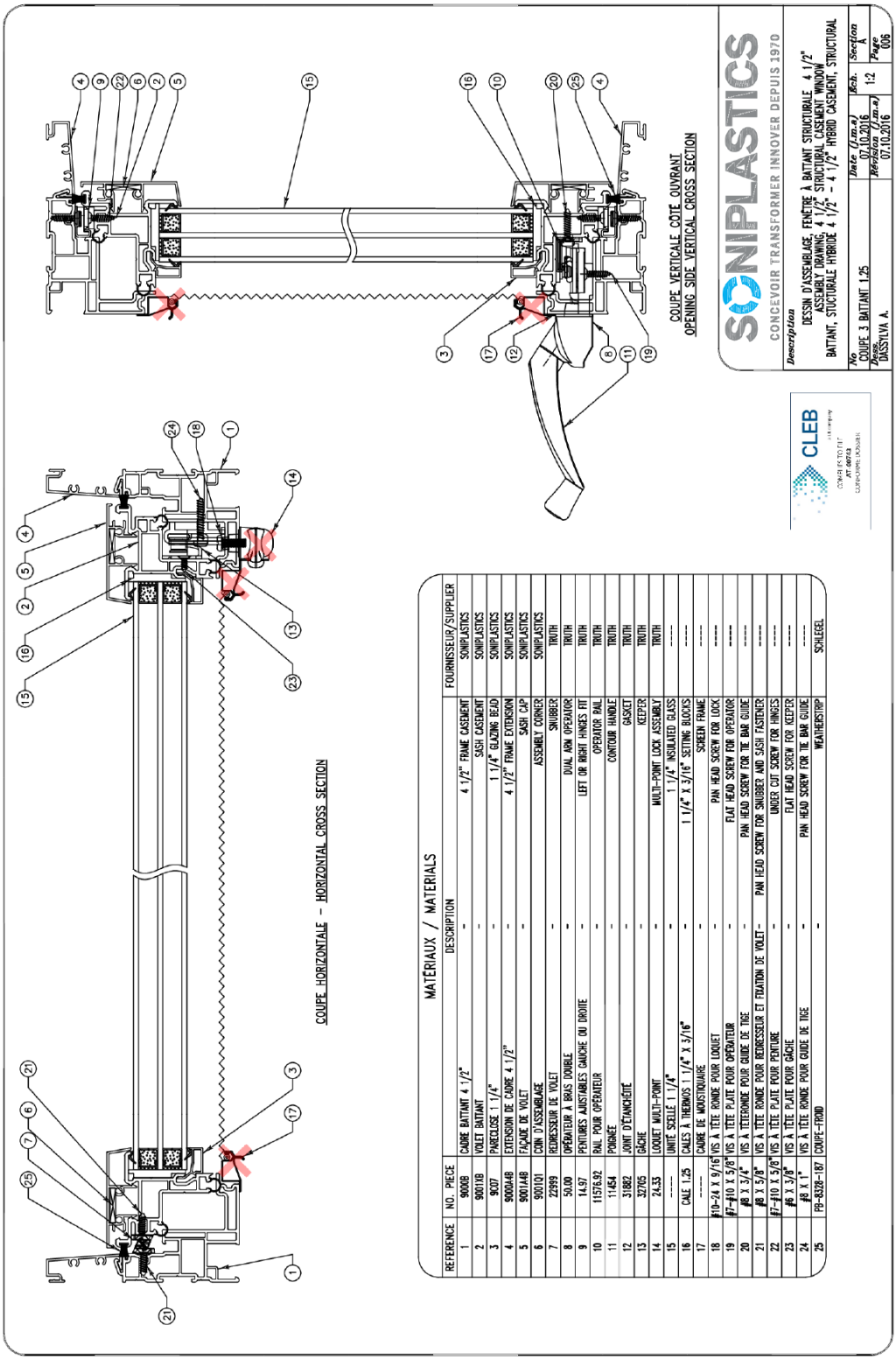

Hybrid Casement Window - Assembly Cross-Sections

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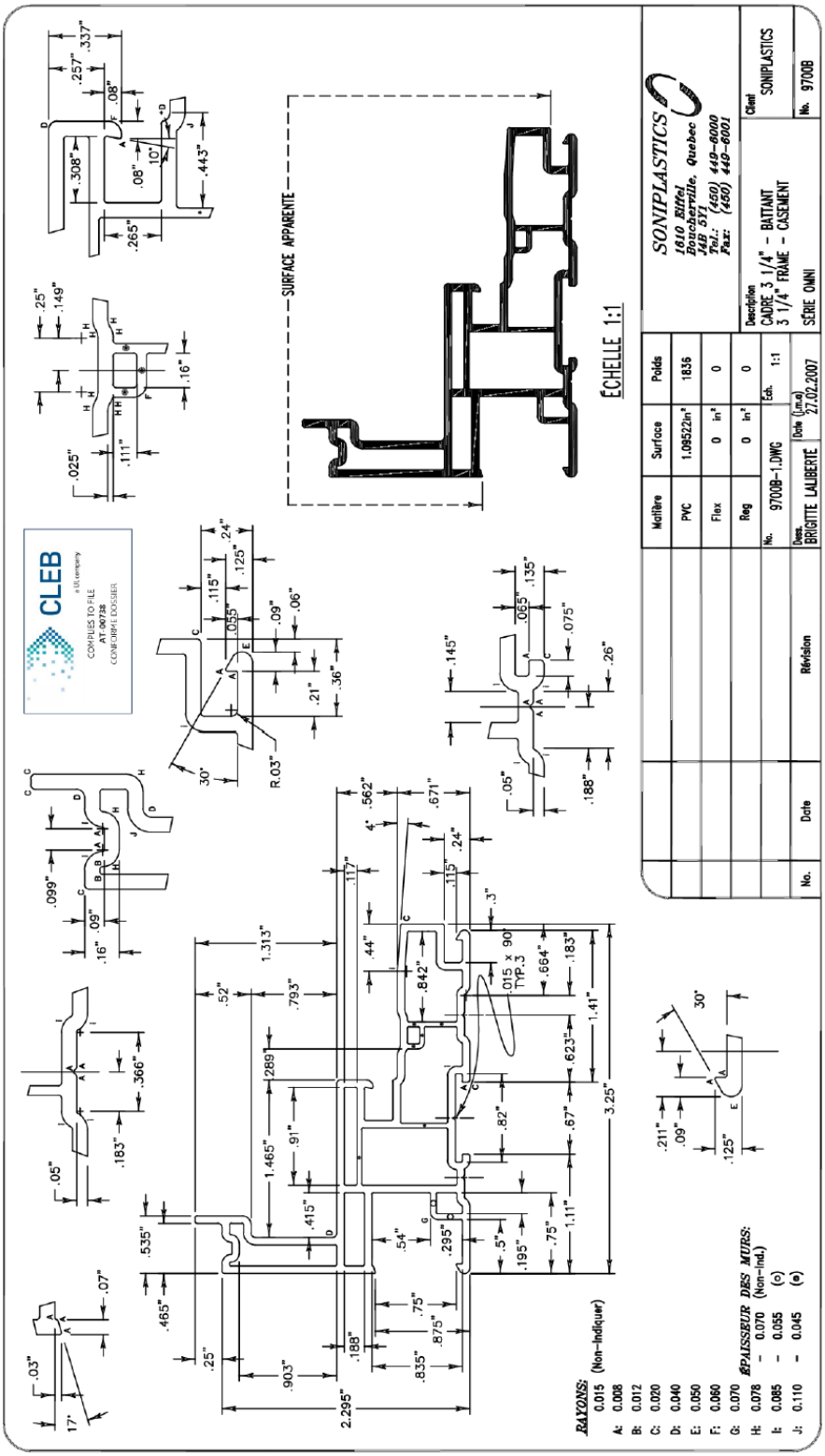

Casement and Awning Window Frame

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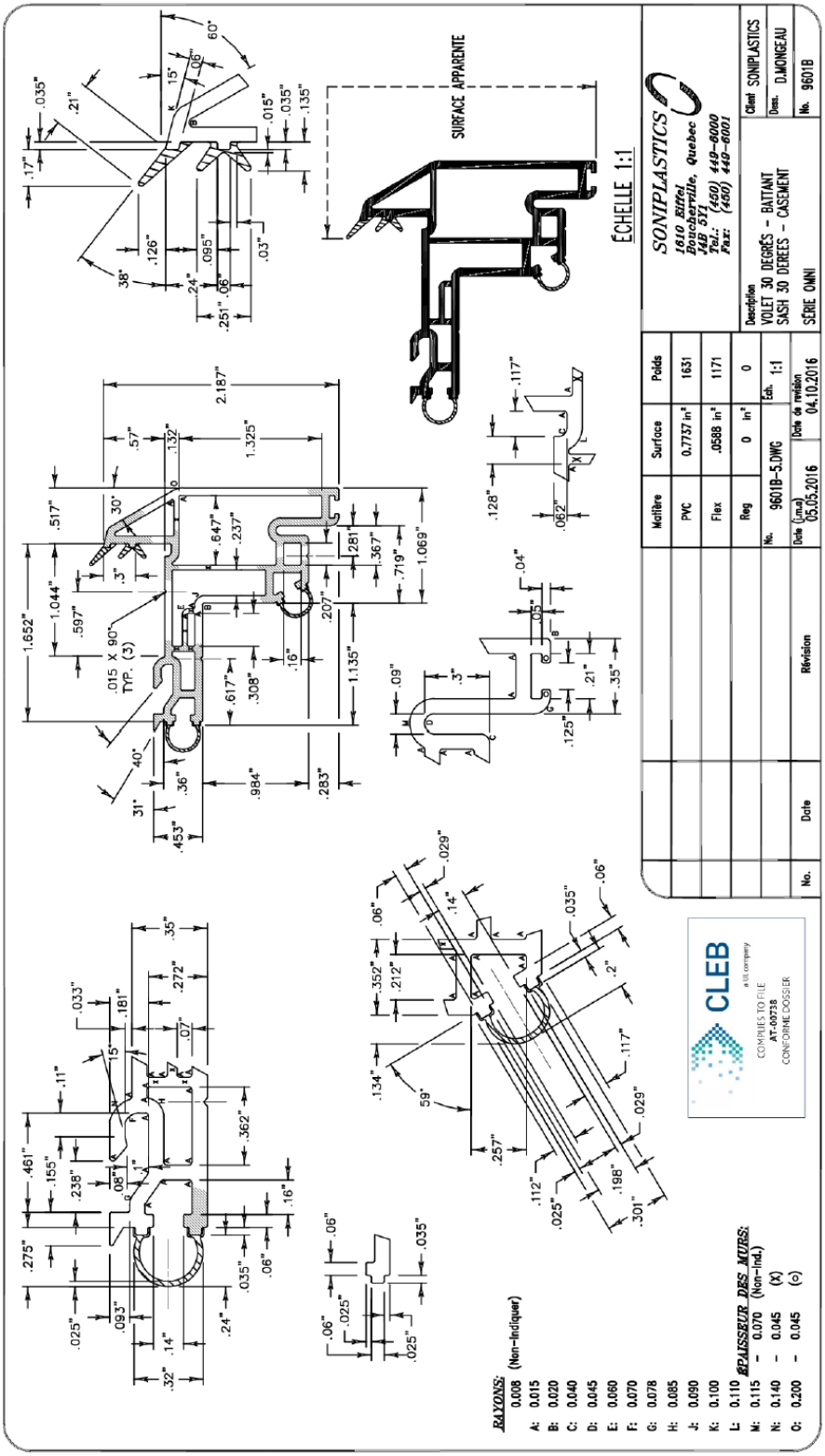

Casement and Awning Window Sash

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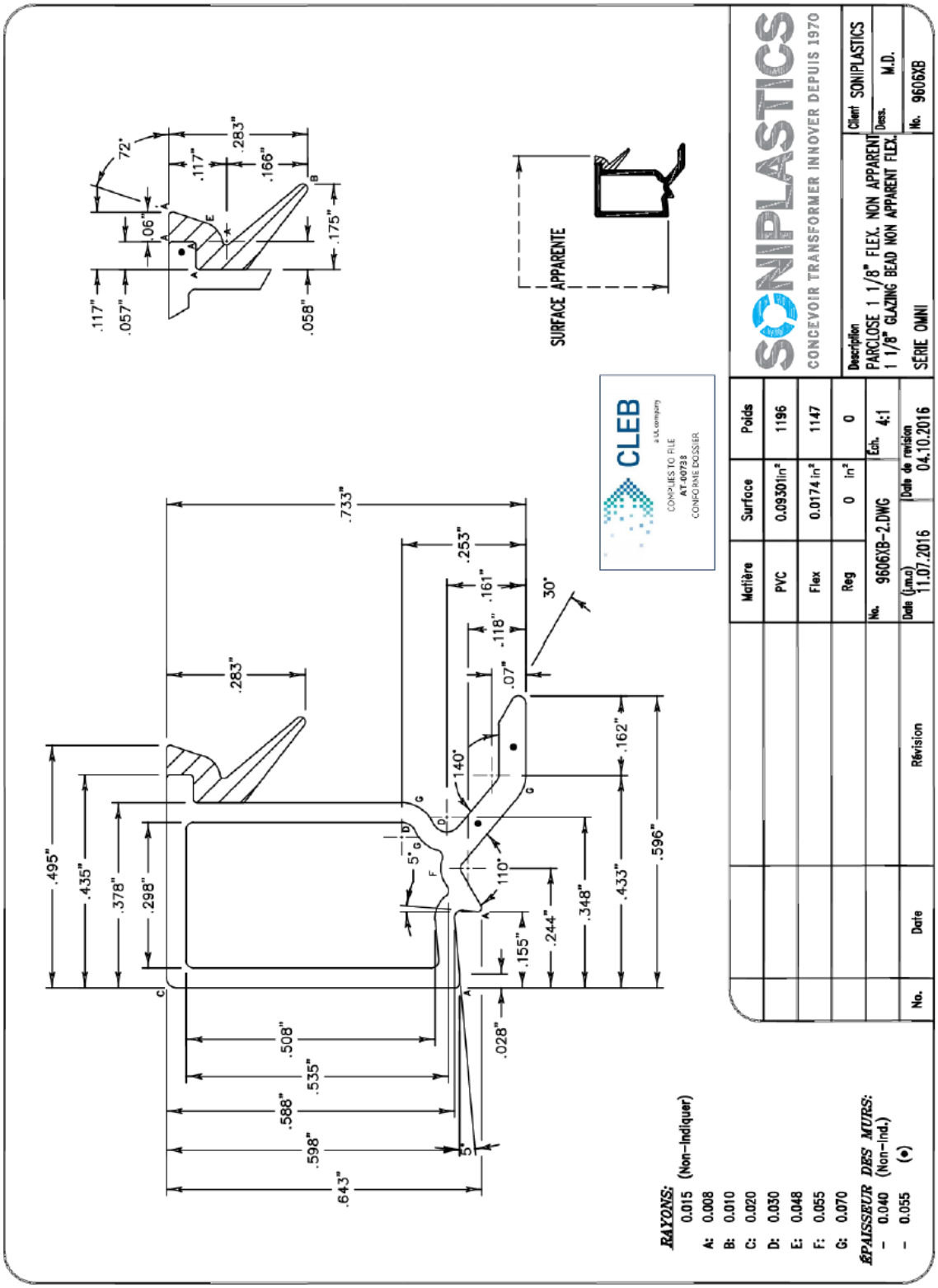

Casement and Awning Window Glazing Bead (Triple Glazing)

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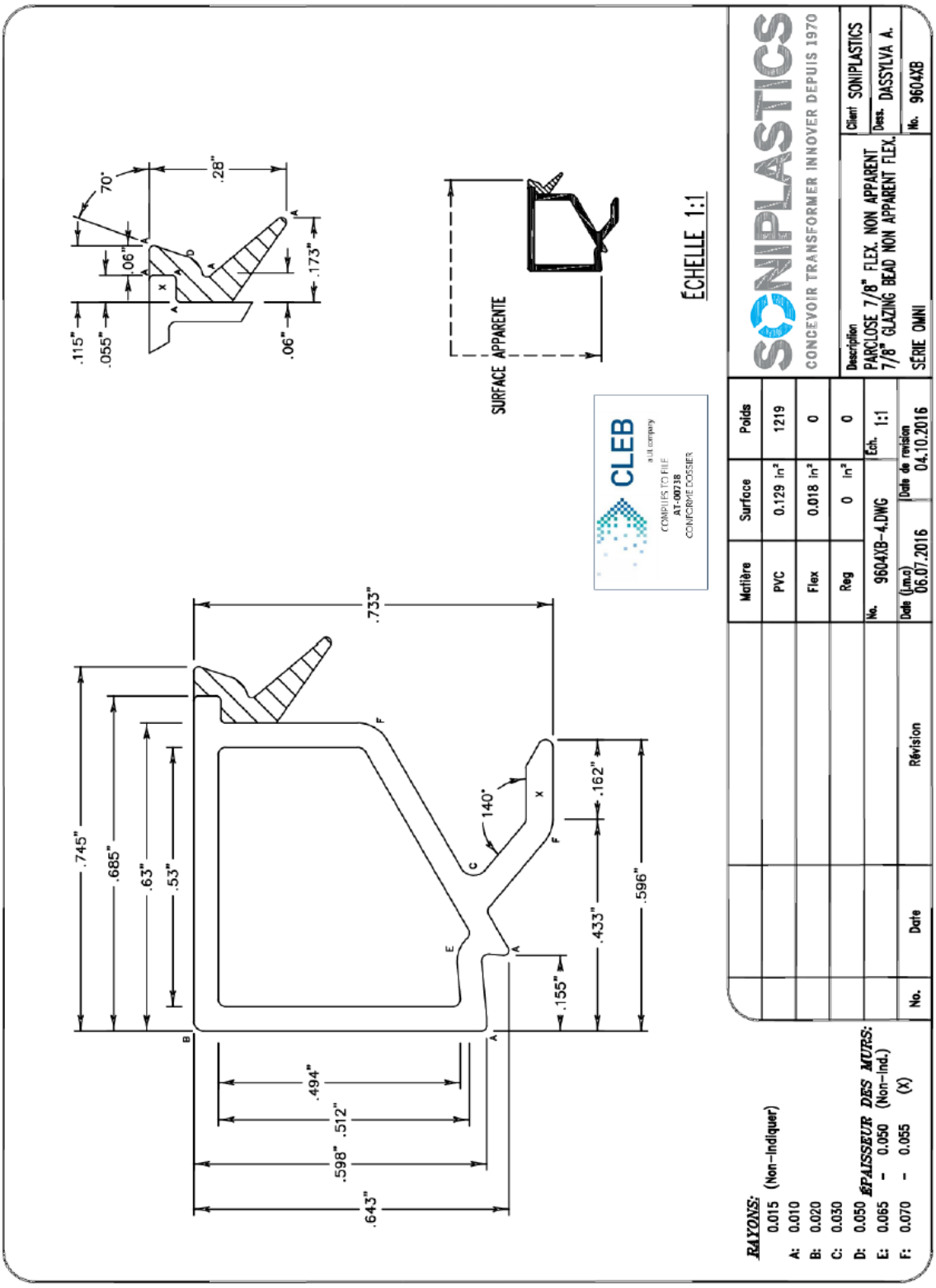

Casement and Awning Window Glazing Bead (Dual Glazing)

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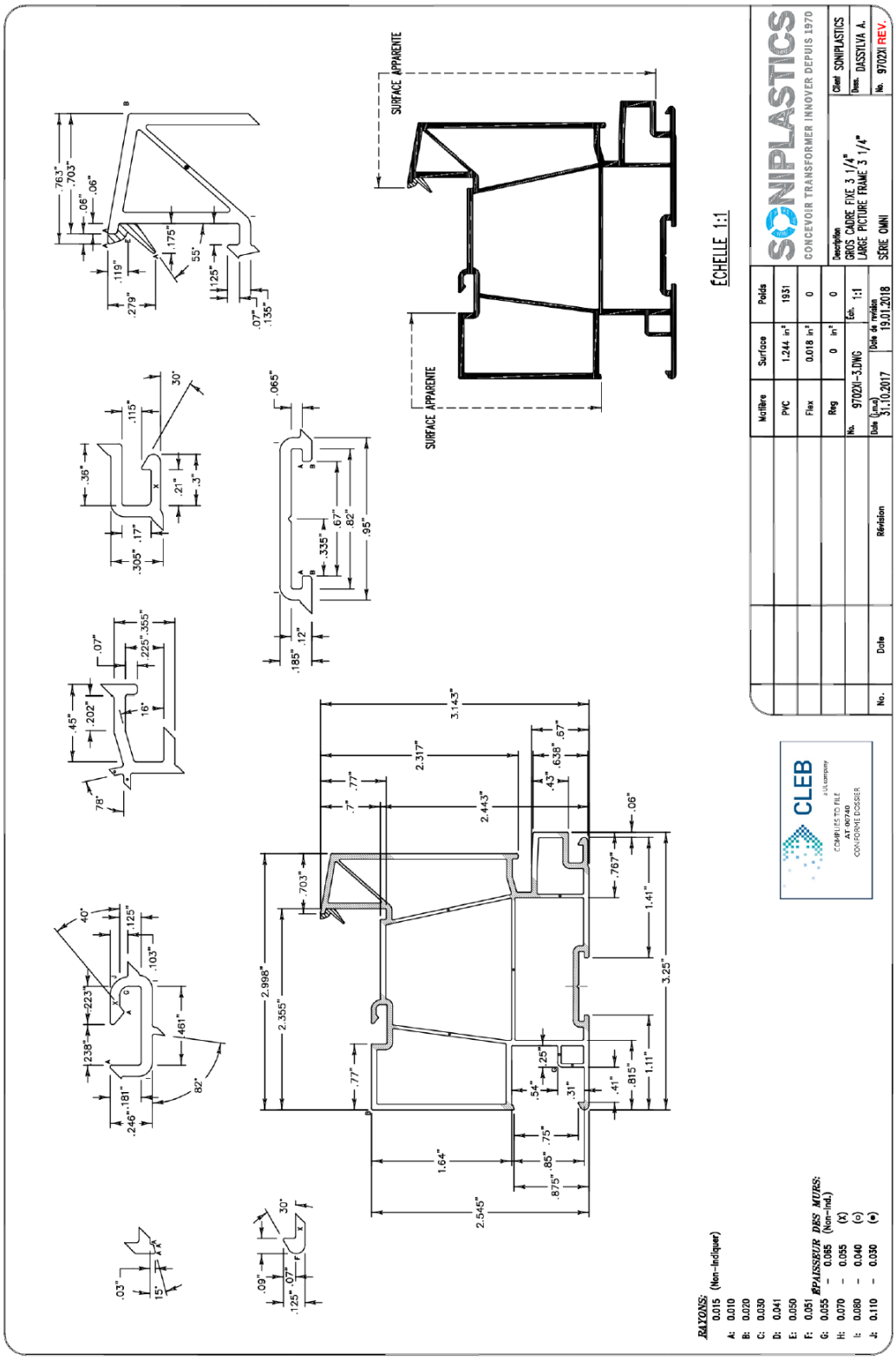

Large Fixed Window Frame

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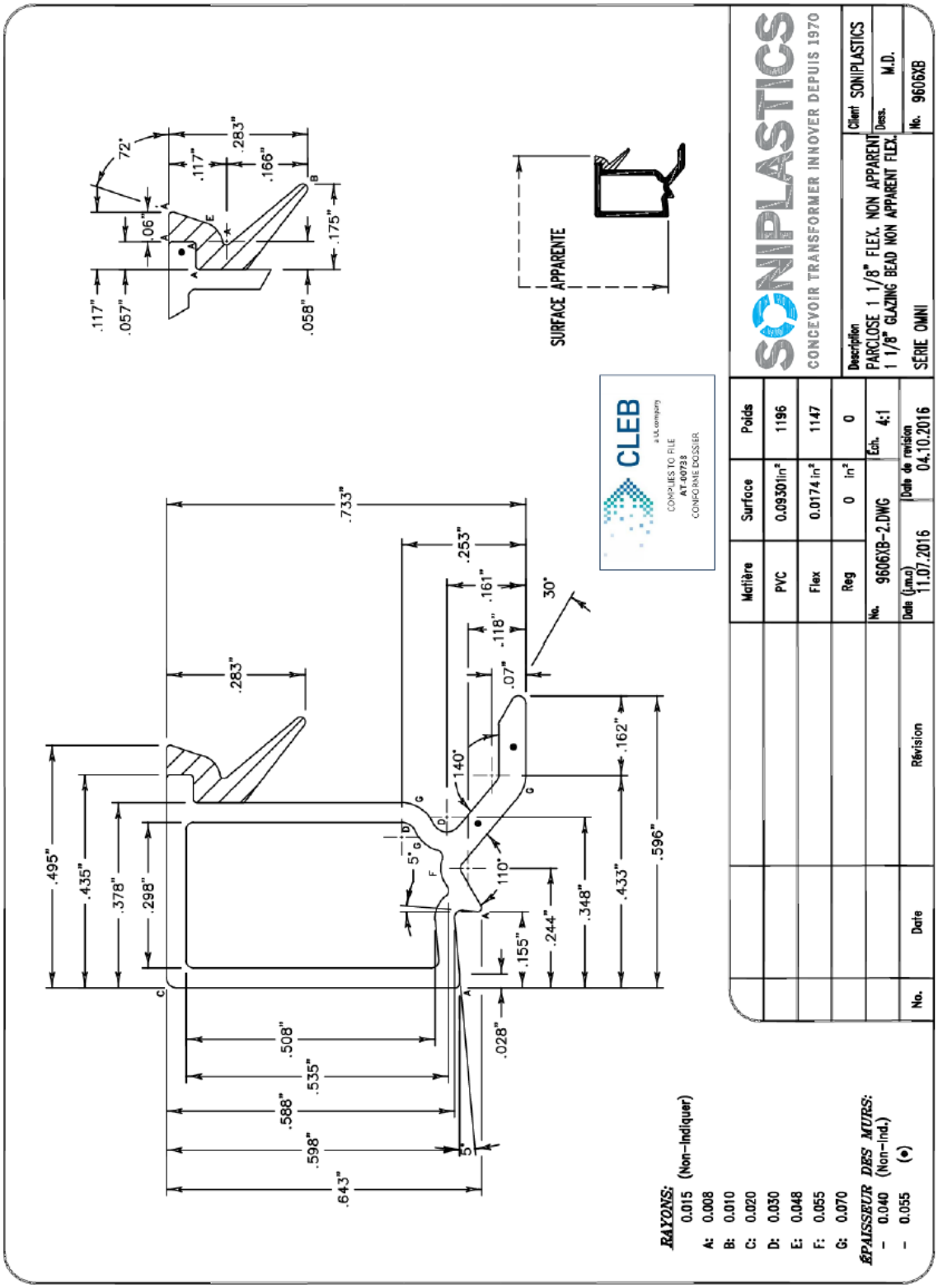

Large Fixed Window Glazing Bead (Triple Glazing)

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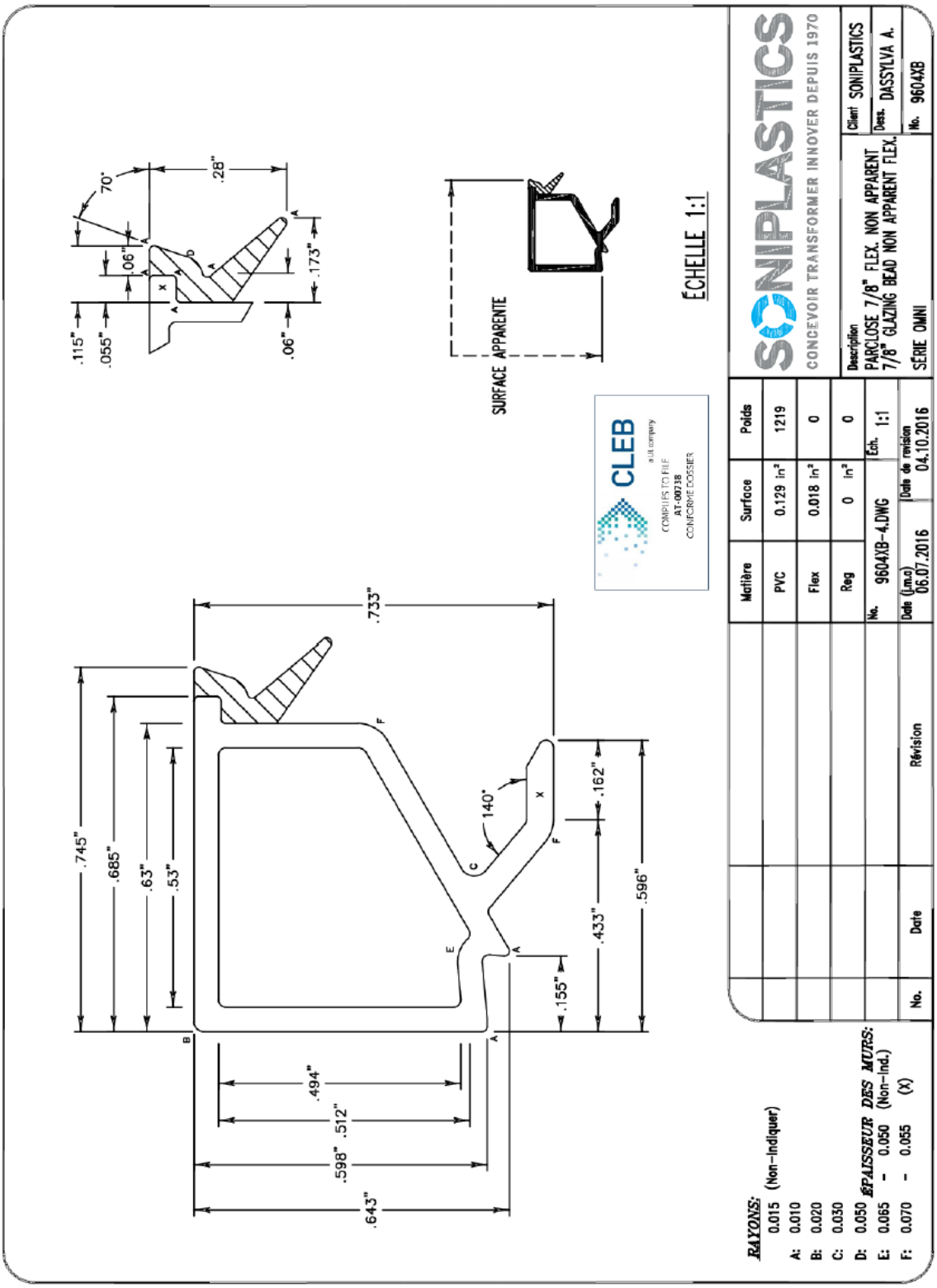

Large Fixed Window Glazing Bead (Dual Glazing)

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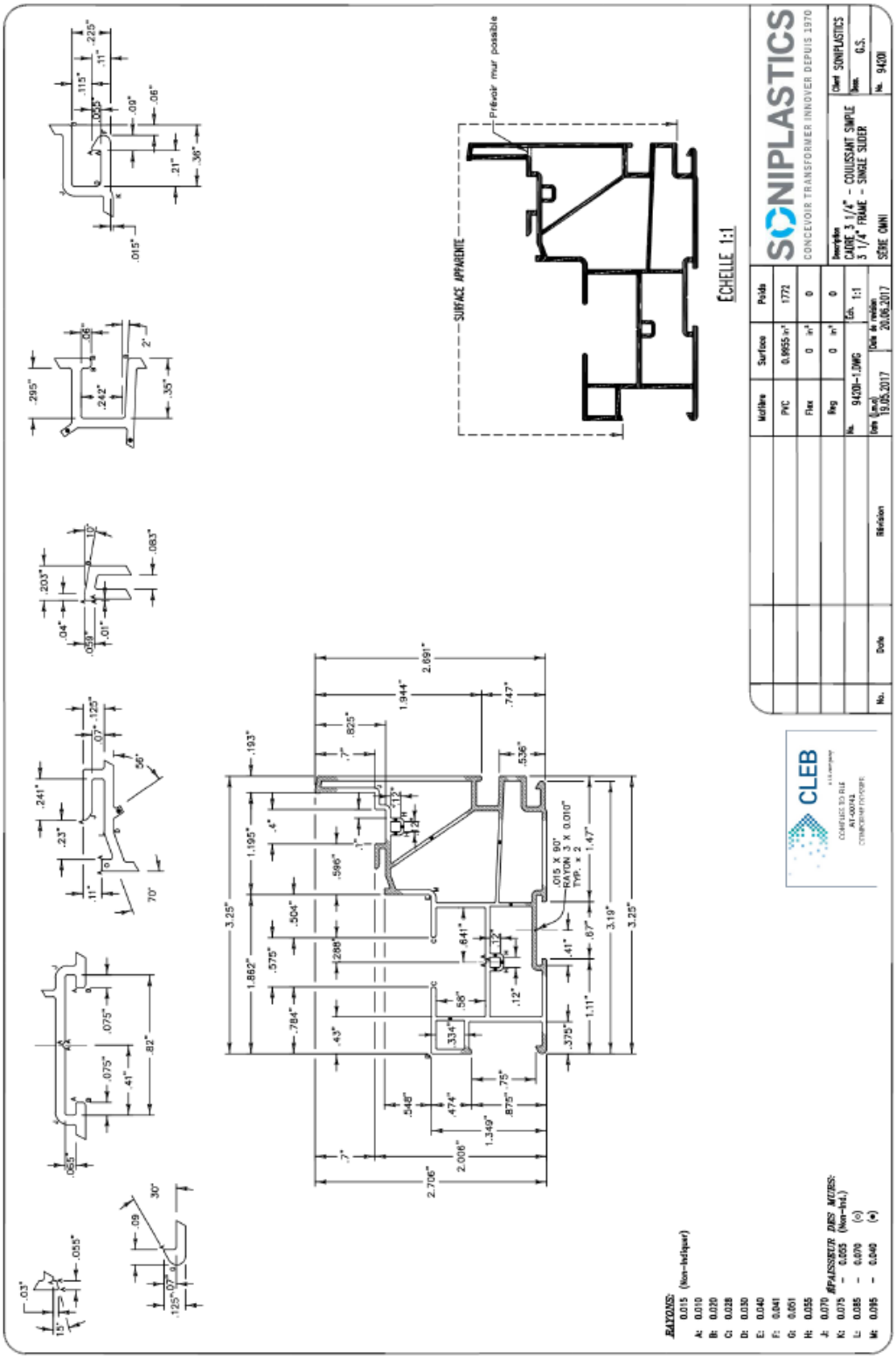

Horizontal and Vertical Sliding Window Frame

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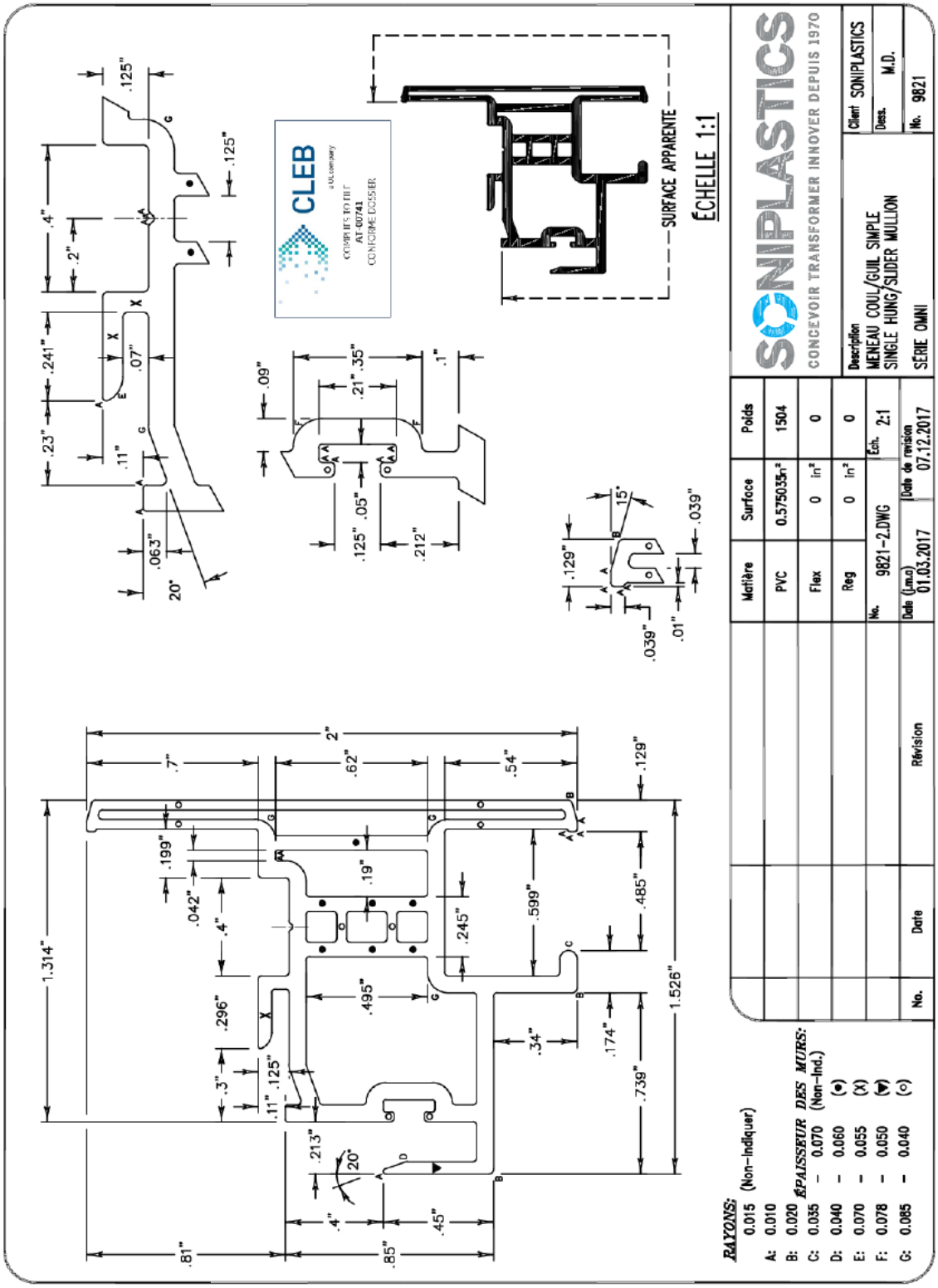

Horizontal and Vertical Sliding Window Mullion

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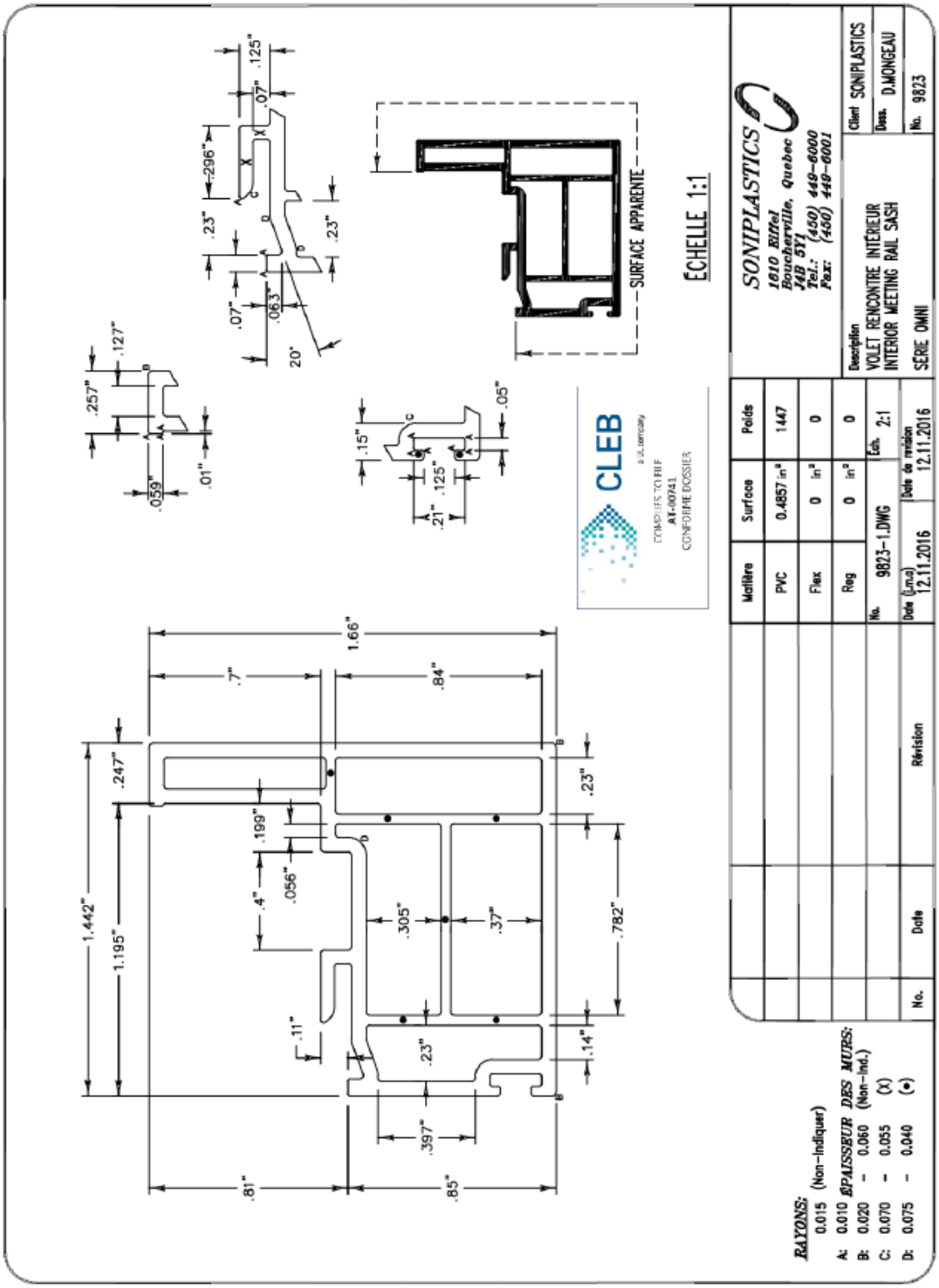

Horizontal and Vertical Sliding Window Sash

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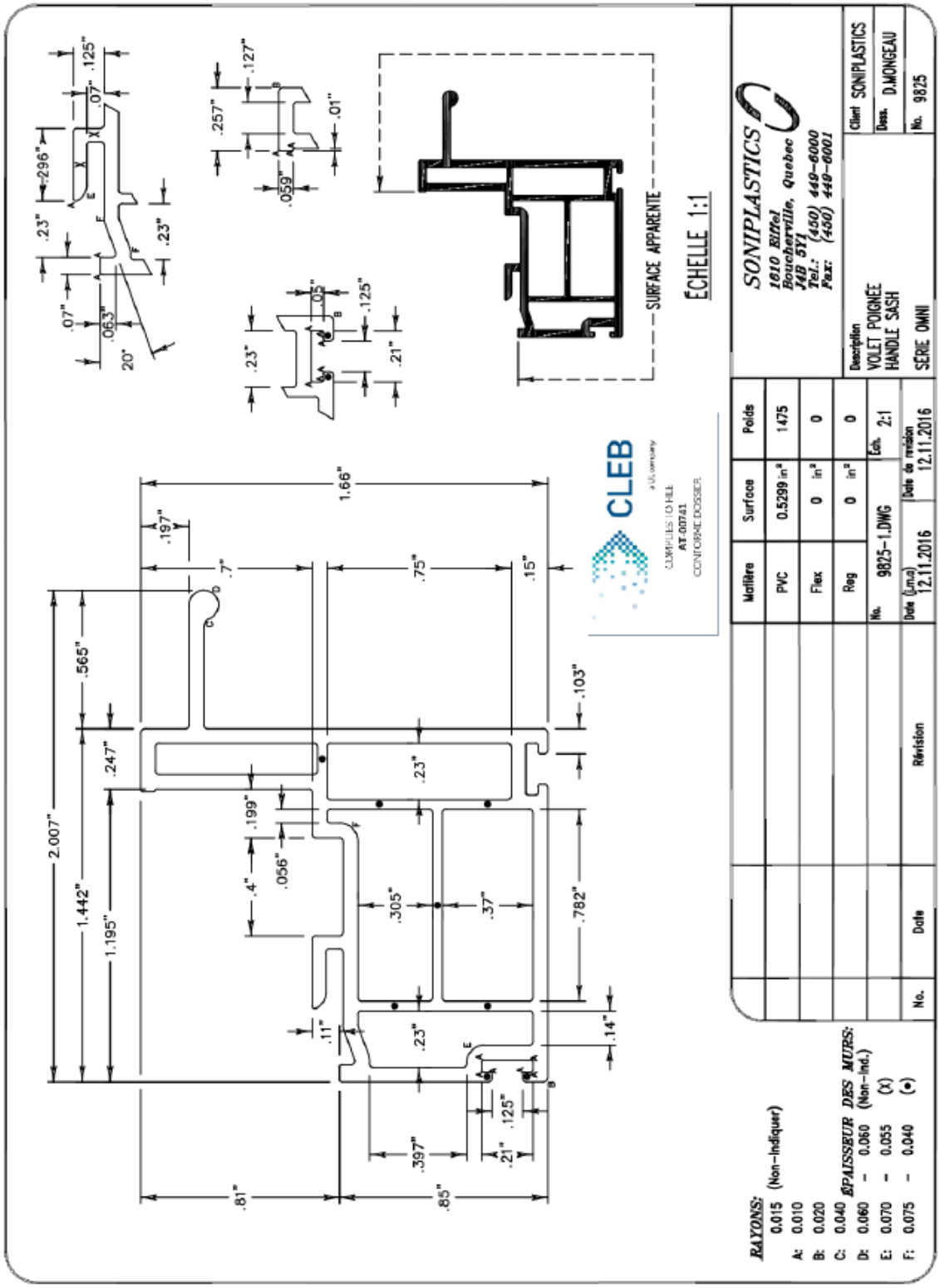

Horizontal and Vertical Sliding Window Sash Interlock

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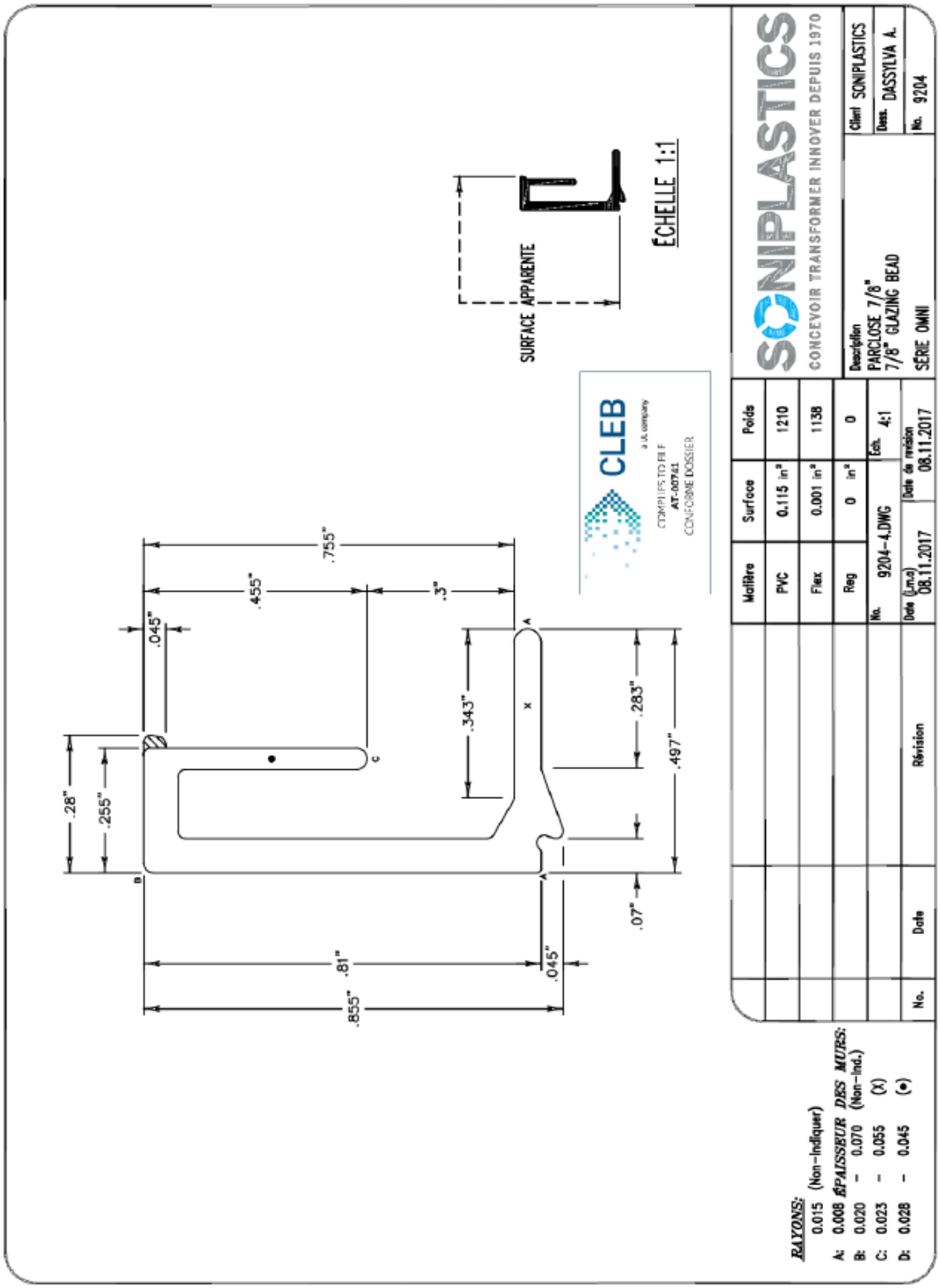

Horizontal and Vertical Sliding Window Glazing Bead

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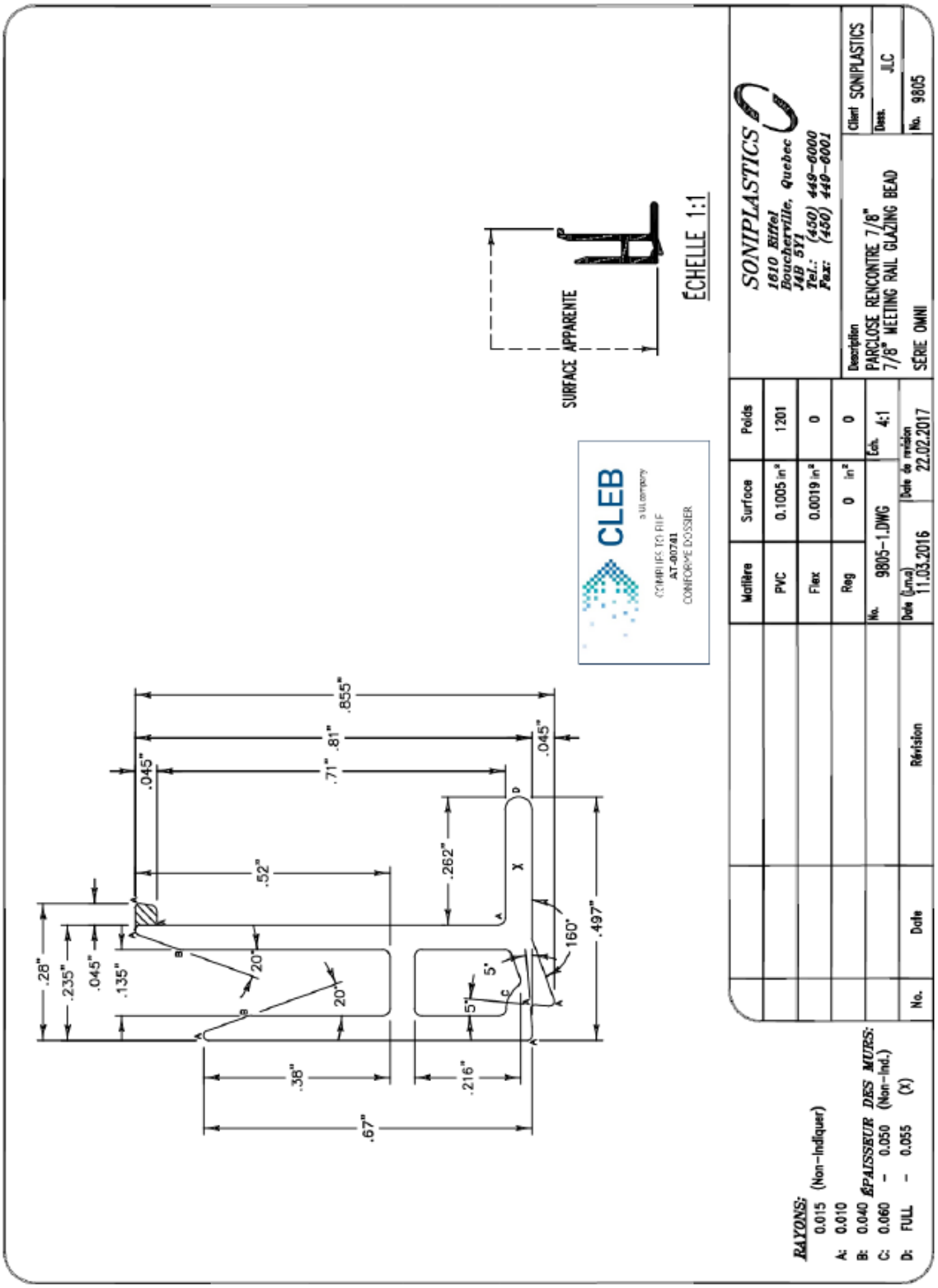

Horizontal and Vertical Sliding Window Interlock Glazing Bead

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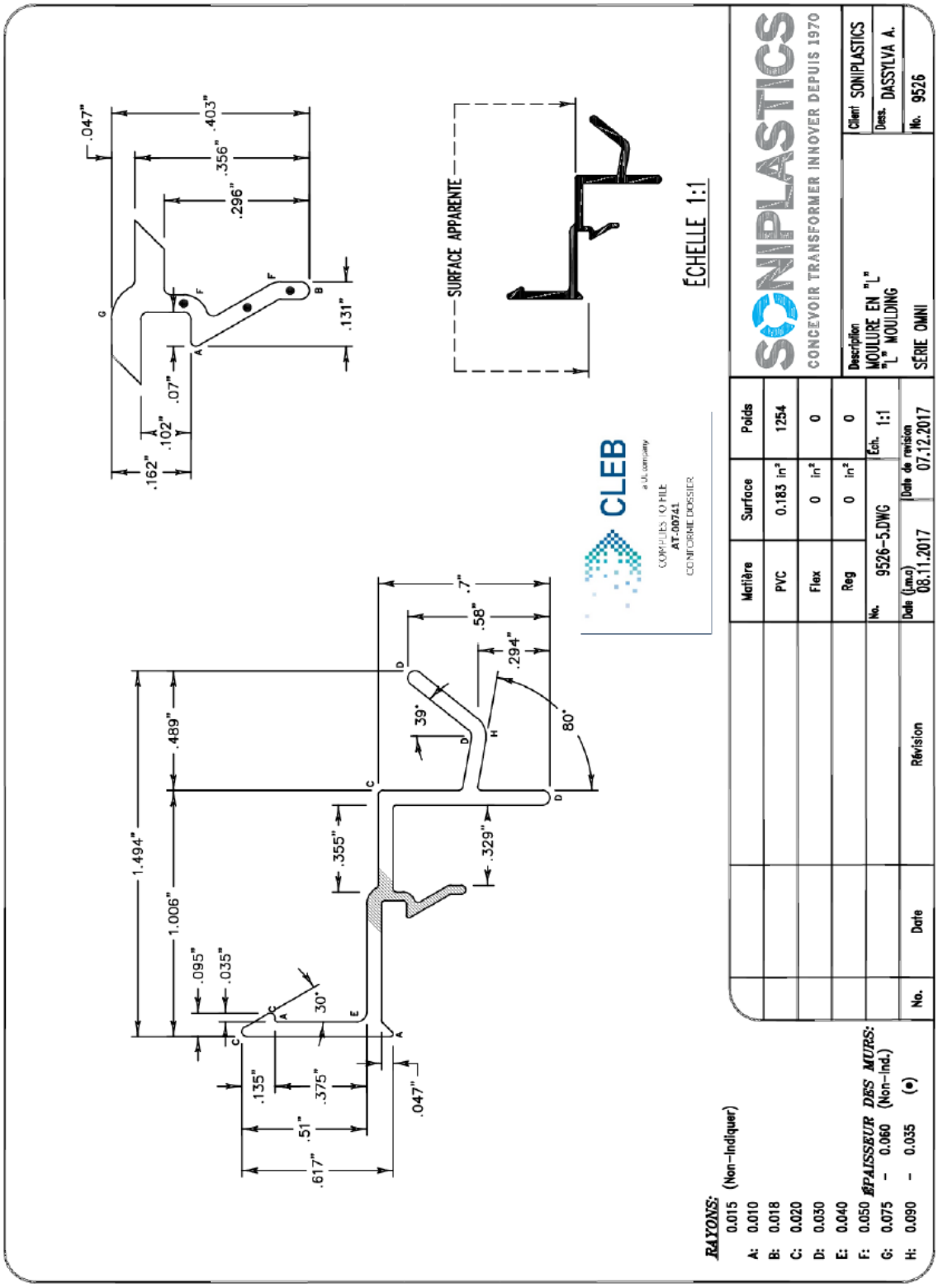

Horizontal and Vertical Sliding Window L Moulding

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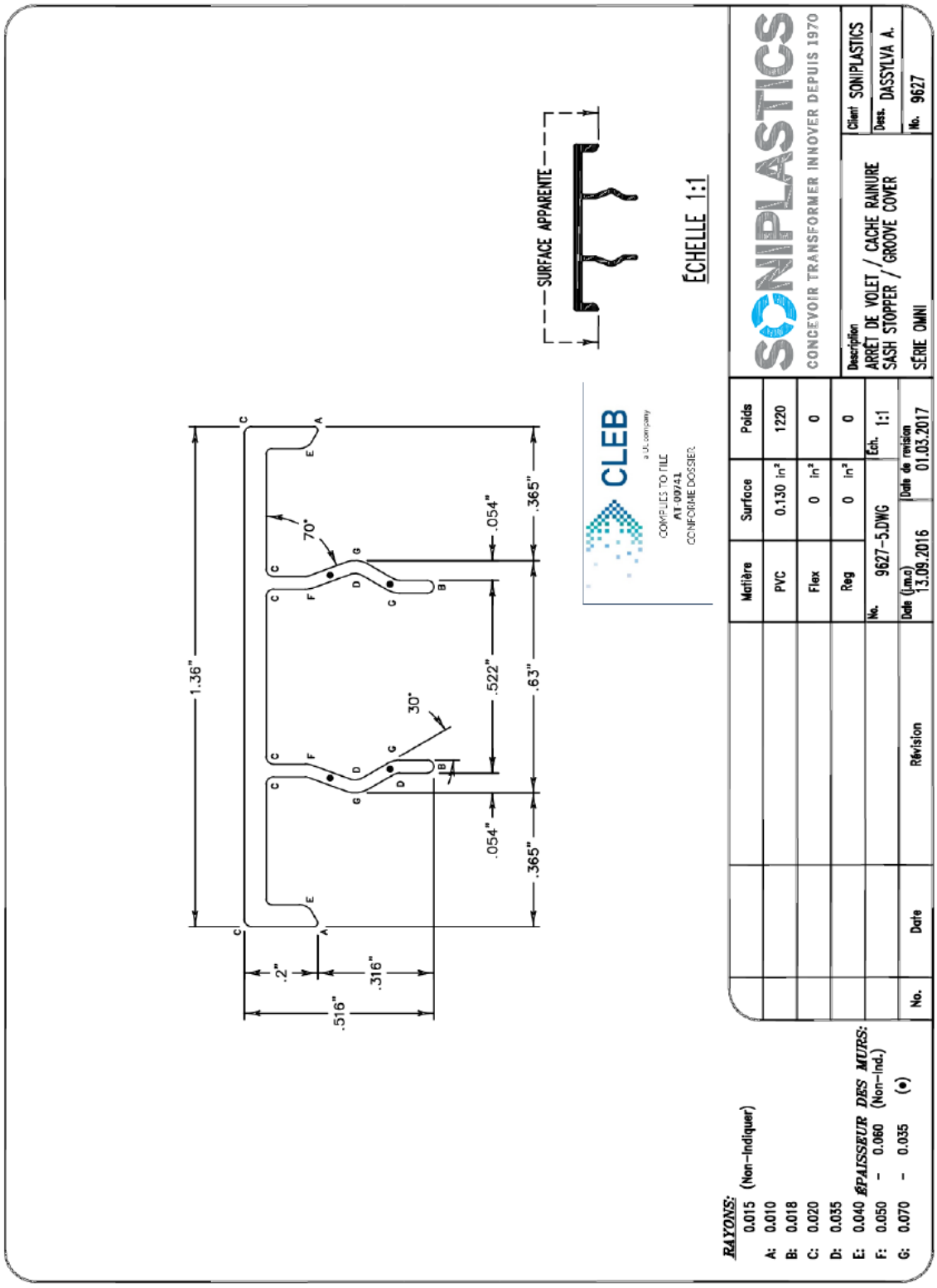

Horizontal and Vertical Sliding Window Sash Stopper

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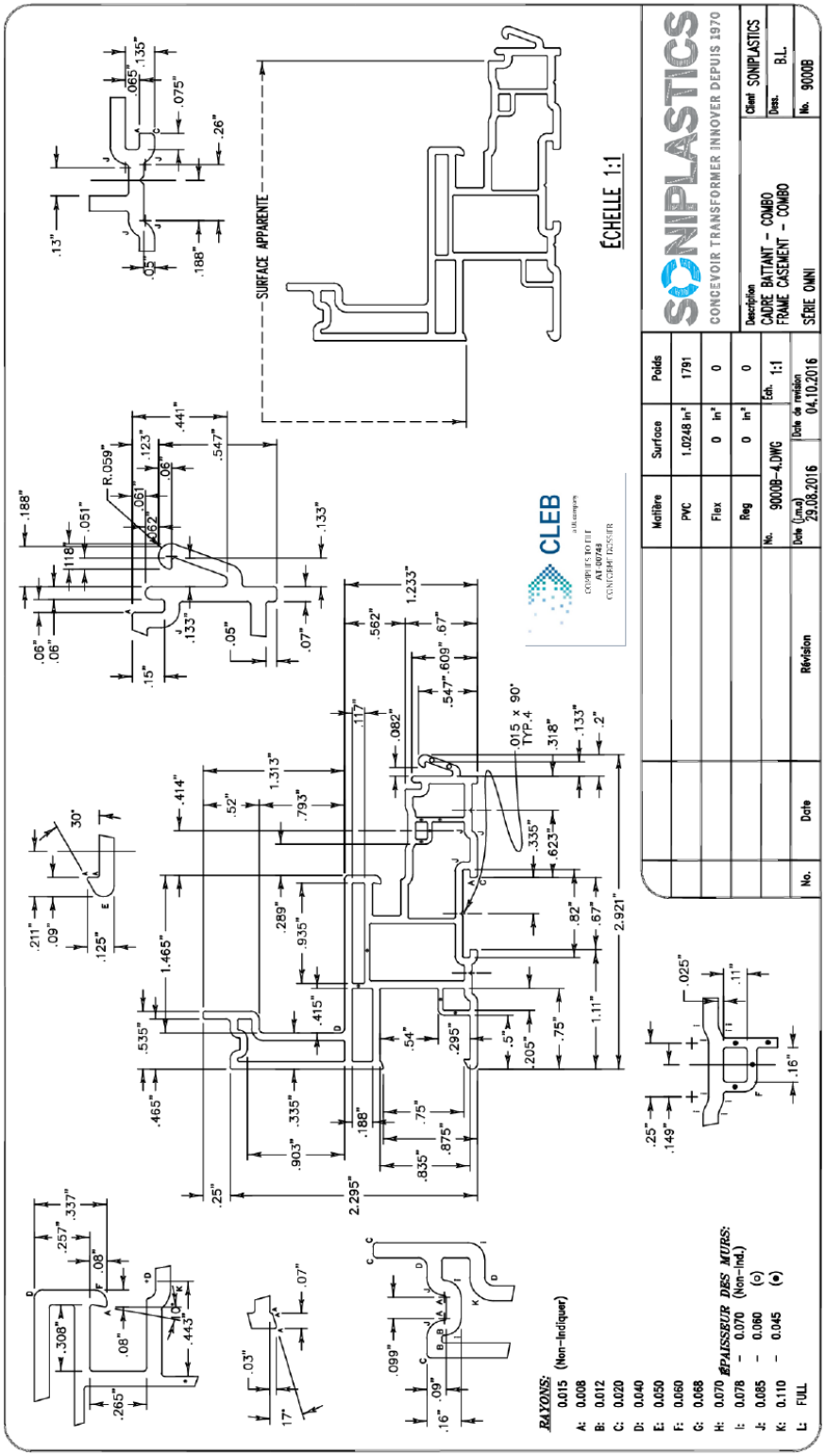

Hybrid Casement Window Frame

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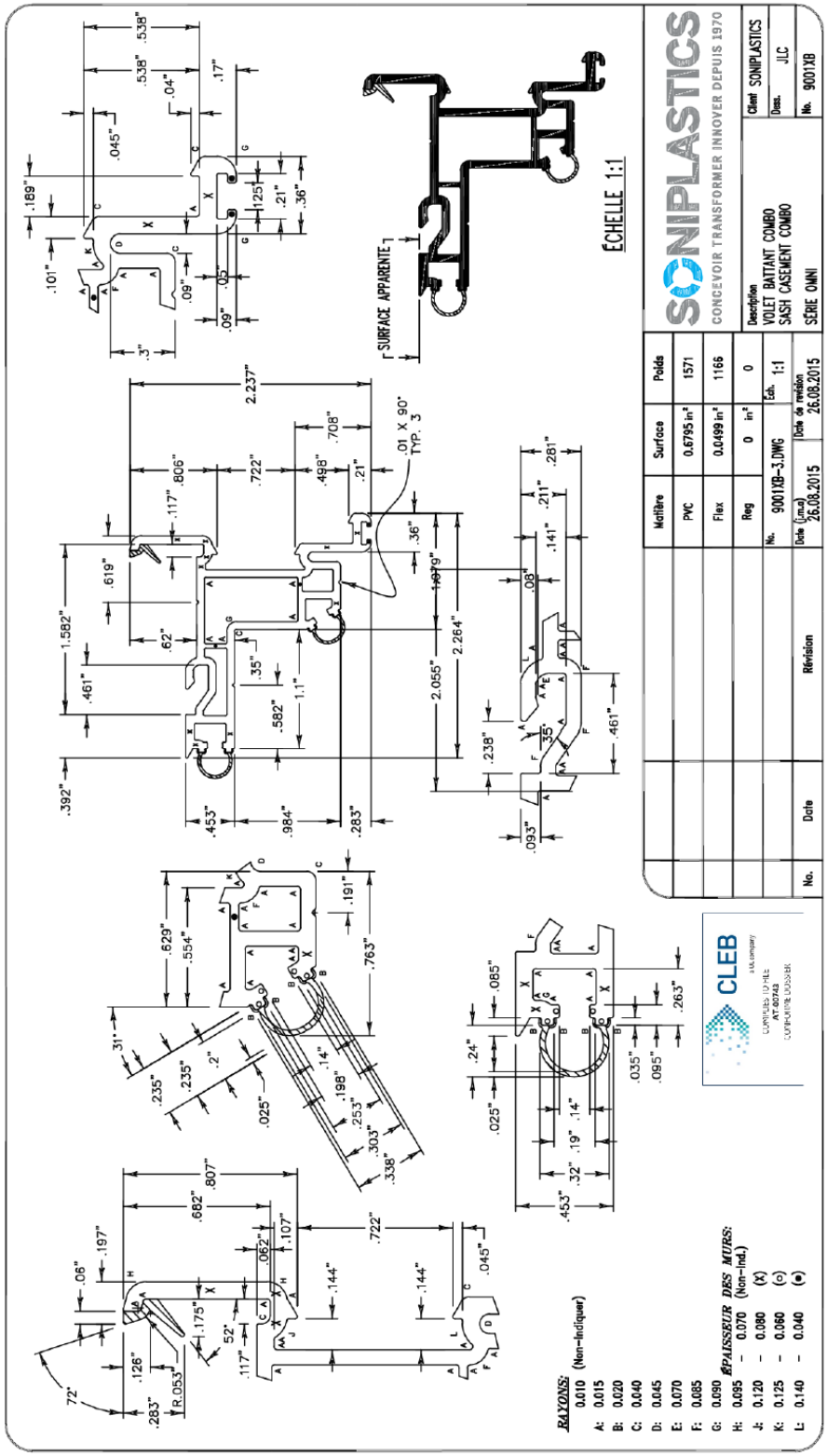

Hybrid Casement Window Sash

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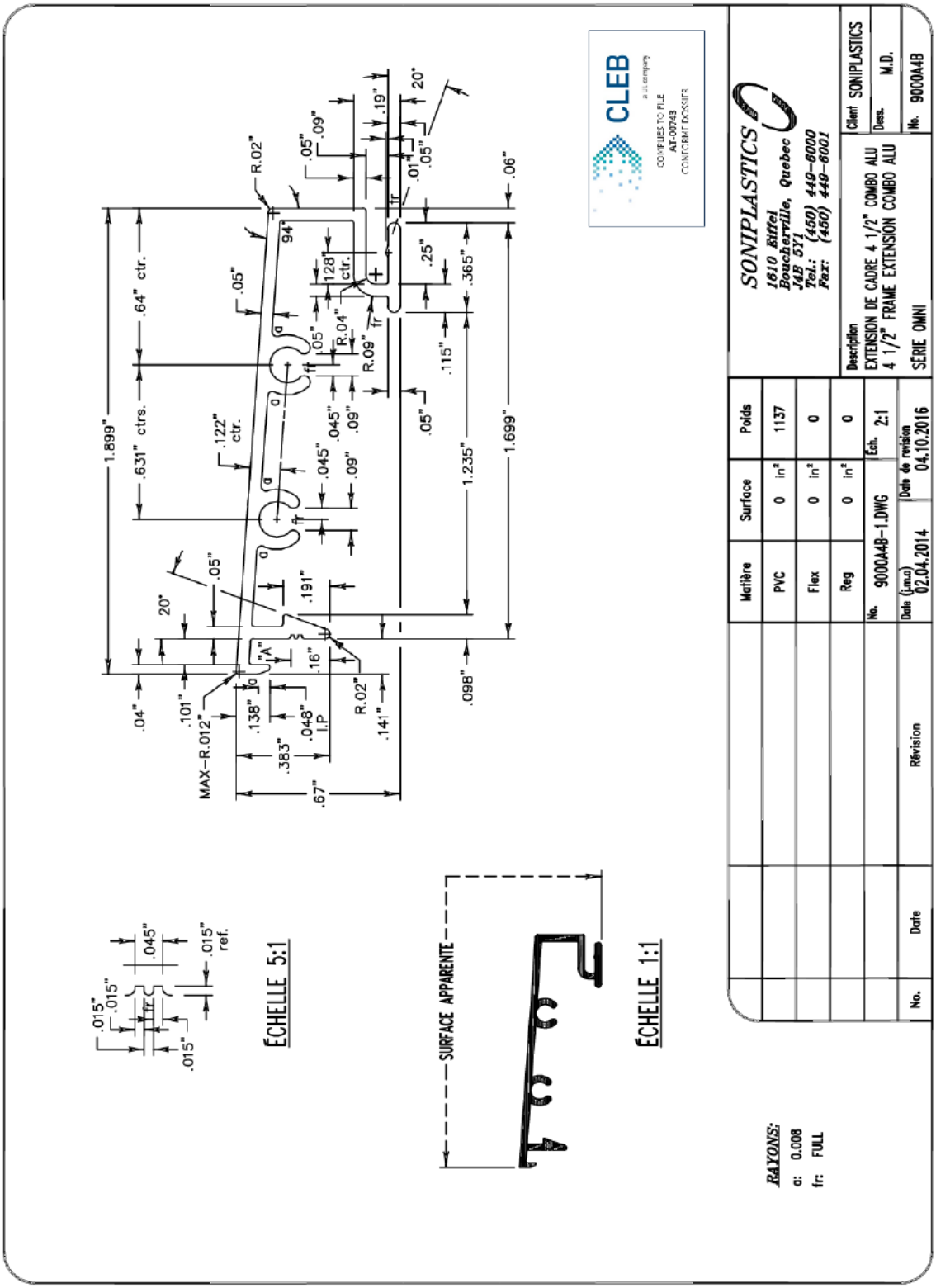

Hybrid Casement Window Aluminum Extension 4-1/2"

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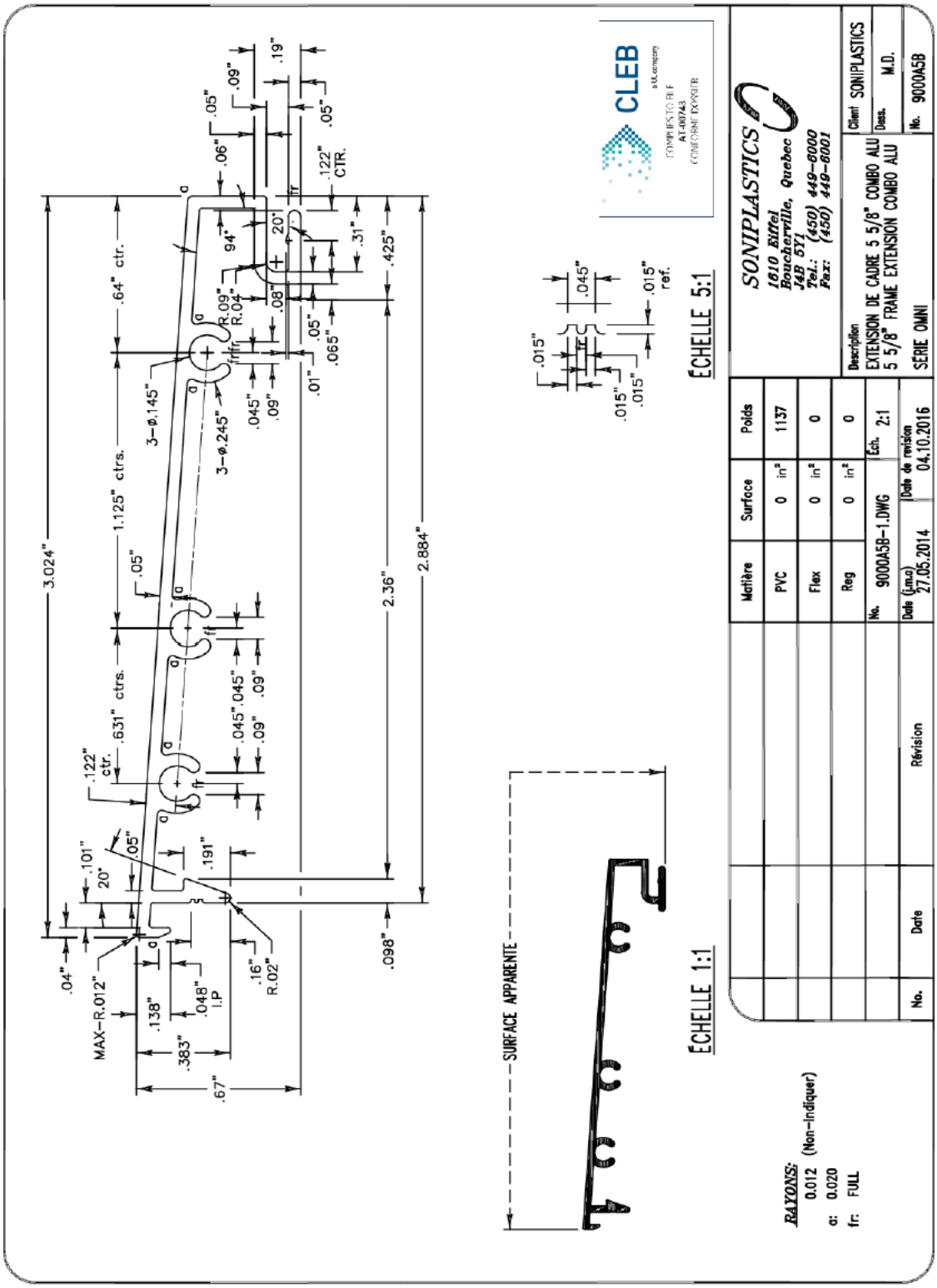

Hybrid Casement Window Aluminum Extension 5-5/8"

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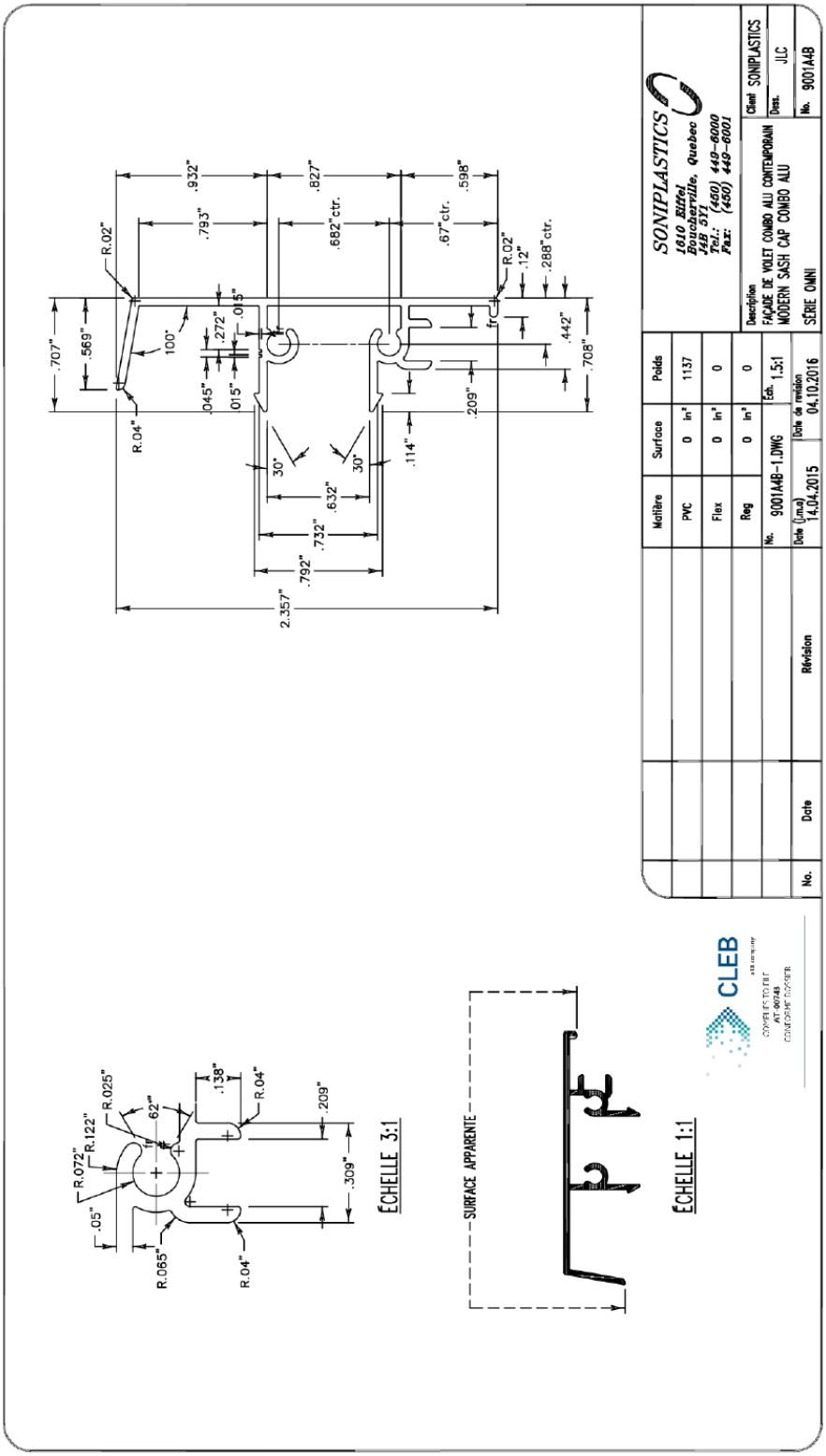

Hybrid Casement Window Aluminum Sash Cap

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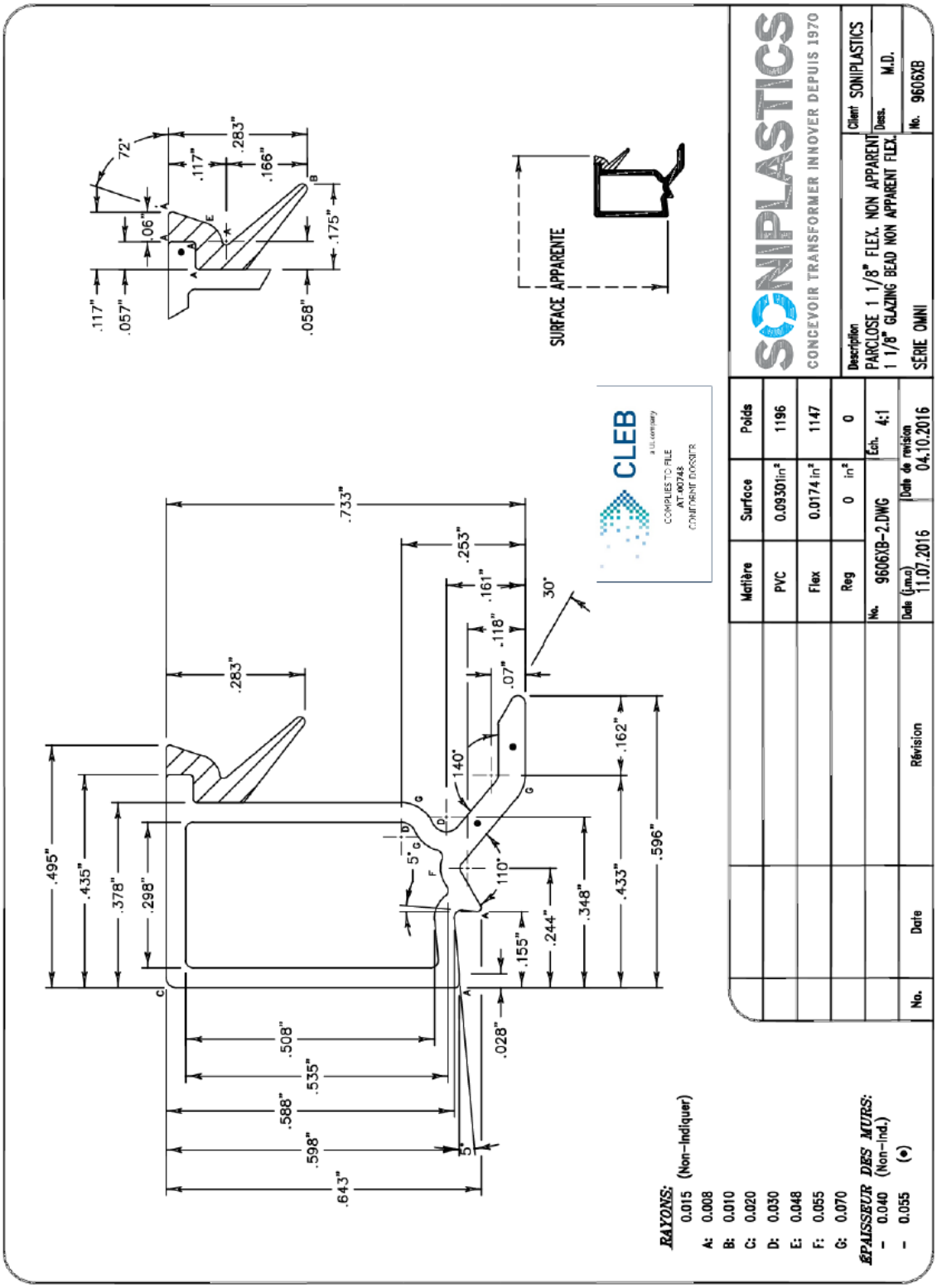

Hybrid Casement Window Glazing Bead (Triple Glazed)

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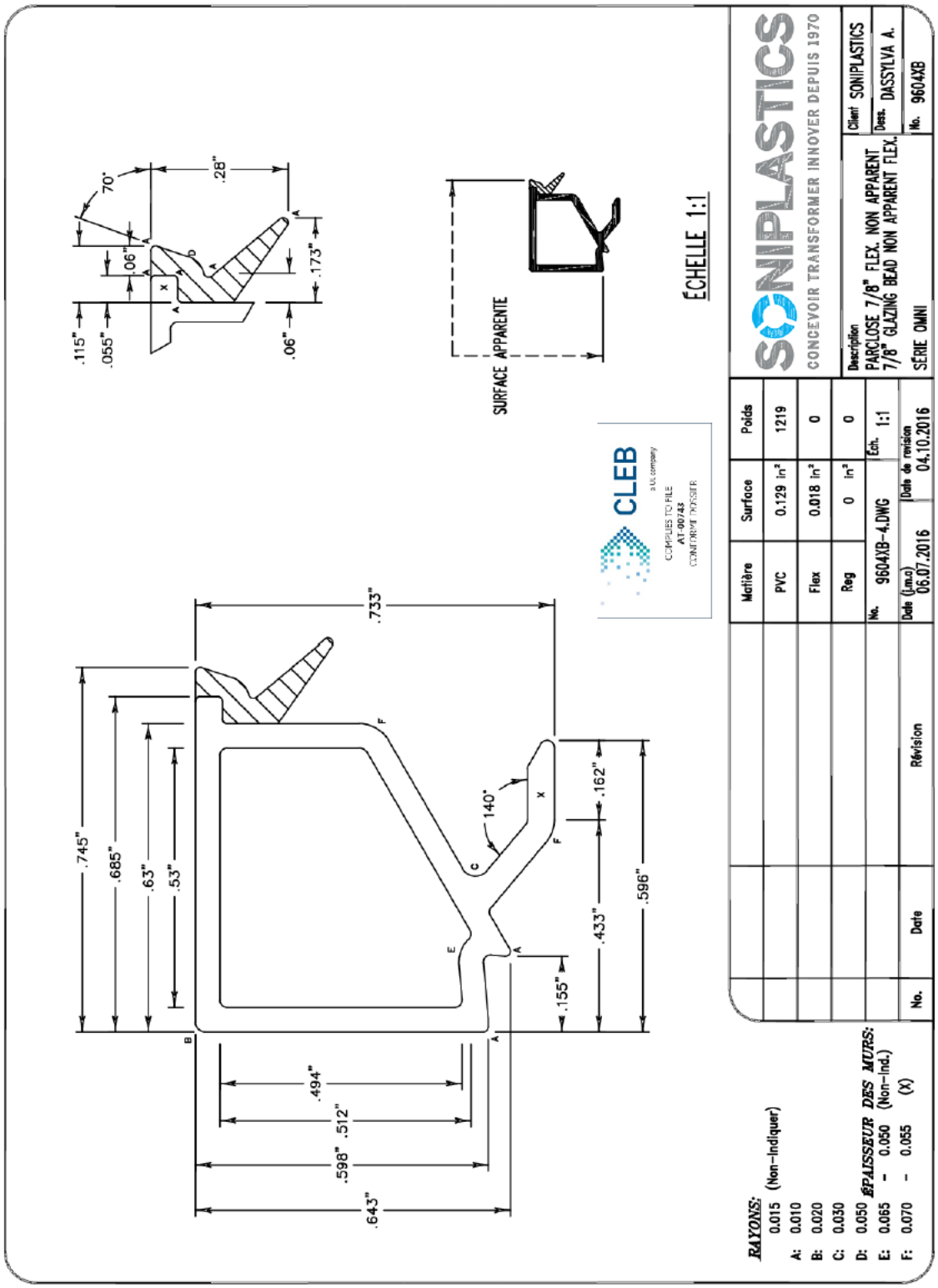

Hybrid Casement Window Glazing Bead (Dual Glazed)

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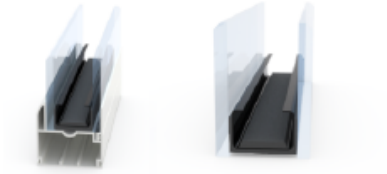
Spacer Bar Details

Blackline

Intercept Spacer System



Blackline Spacer System was originally introduced as a Warm Edge Stainless Steel Spacer. However, with the increasing popularity of this attractive spacer, Leading Edge has added this for all the current Intercept spacer systems. Blackline Spacers are designed to eliminate the view of the spacer making a beautiful finished window. The spacer disappears in the sash, which improves aesthetics of windows.

Blackline Intercept spacer provides the option of less expensive carbon steel material where the performance and additional cost of stainless is unnecessary. GED and LED have worked together to develop this unique alloy resulting in this value added product.

Blackline Intercept Spacer is available for both Intercept and ULTRA machines. Differentiate yourself from the market by using Blackline Spacers.

User Benefits

- Interchangeable with .0078 Ultra Stainless Steel Coil
- Half the cost of Stainless Steel
- Premium product aesthetics at Intercept cost.
- Approved by major sealant / matrix suppliers
- Peace of mind with GED's extensive testing and support

Leading Edge Benefits

- GED's "Approved Supplier"
- System Matched for Intercept & Ultra Systems
- Multiple products from single supply source
- Stocked Sizes across N. America
- Only supplier providing coil products specifically to W&D manufacturers

Technical Specifications Blackline ULTRA

Compliances:	Energy Star	H.B. Fuller TMHM-067
	GED Intercept®	NFRC
Material Thickness:	0.0078" +/- 0.0004	
Cut Slit Width Tolerance:	+.000" /-.005" Burr-Free Edge	
Coil Core Size I.D.:	16"	
Coil O.D.:	36" Maximum	
Coil Weight of 1" wide:	225# (approximately)	
Linear feet/coil:	8500 ft (approximately)	

** Proper tooling is required to run Blackline on GED Ultra Spacer System

Common Spacer / Coil Sizes

Spacer Size	Air Space	Slit Width	Lbs. Per Ft	34" OD Coil Weight
7/32"	1/4"	0.882	0.0239	180
1/4"	9/32"	0.913	0.0247	187
11/32"	3/8"	1.006	0.0273	206
13/32"	7/16"	1.069	0.0290	219
15/32"	1/2"	1.131	0.0307	232
17/32"	9/16"	1.193	0.0323	246
19/32"	5/8"	1.257	0.0341	258
11/16"	23/32"	1.351	0.0366	277
23/32"	3/4"	1.383	0.0375	283
25/32"	13/16"	1.445	0.0392	296

Technical Specifications Blackline Intercept

Compliances:	GED Intercept®	H.B. Fuller
	PPG	Bostik
Architectural Testing	ASTM E2188 / E2190 IG Durability	
Material Thickness:	0.0105" ± 0.0005	
Weight:	95# per base box (.0105") thickness	
Temper:	T-4 (AIM 58-64 RW 30-t)	
Finish:	#5 Finish (AIM 45±15 Micro-Inches)	
Cut Slit Width Tolerance:	+.000" /-.005" Burr-Free Edge	
Coil Core Size I.D.:	16"	
Coil O.D.:	36" Maximum	
Coil Weight of 1" wide:	225# (approximately)	
Linear feet/coil:	6400 ft (approximately)	

Common Spacer / Coil Sizes

Spacer Size	Air Space	Slit Width	Lbs Per Ft.	34" OD Coil Weight
7/32"	1/4"	0.862	0.0306	171
1/4"	9/32"	0.893	0.0317	177
11/32"	3/8"	0.986	0.0350	196
13/32"	7/16"	1.049	0.0372	208
15/32"	1/2"	1.111	0.0394	220
17/32"	9/16"	1.173	0.0416	233
19/32"	5/8"	1.237	0.0439	245
11/16"	23/32"	1.300	0.0473	264
23/32"	3/4"	1.363	0.0484	270
25/32"	13/16"	1.425	0.0506	283

CLEB

Stocked in our convenient locations throughout N.America

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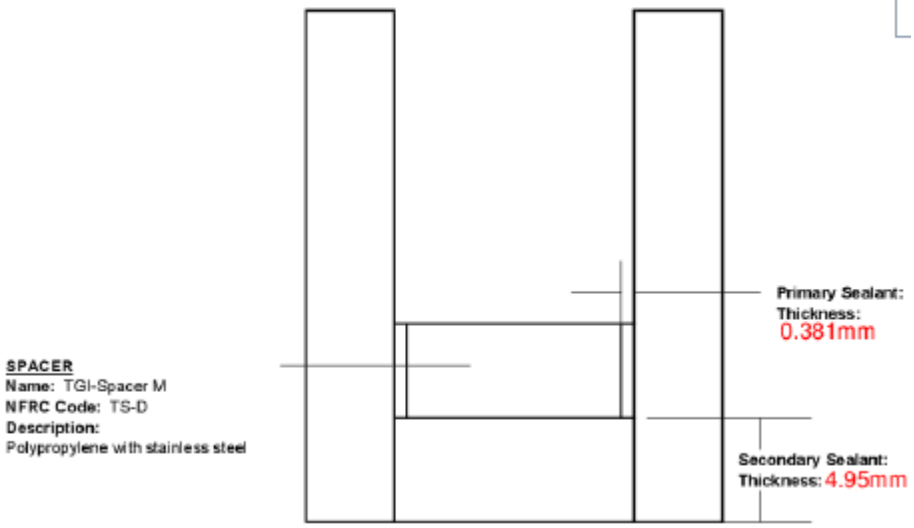
Edge of Glass Detail



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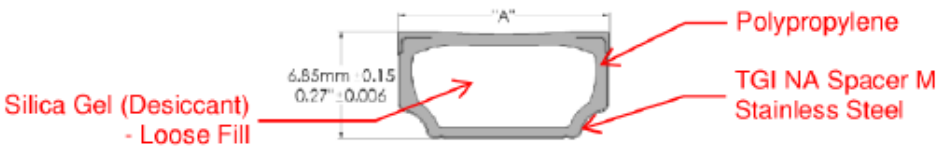
TECHNOFORM **GLASSINSULATION**

MASTER PART CHART

Spacer width is the actual width measured across the top of the thermoplastic as indicated in each drawing below

TGI®-SPACER M NO WIRE™ SPACER WIDTH MEASUREMENT



TGI-SPACER M (No Wire) WIDTHS, PART NUMBERS AND PACKAGING

Size (Inches/MM)	Inches "A" Width decimal Tolerance: ±0.006"	Millimeters "A" Width decimal Tolerance: ±0.15mm	TGI Spacer Part Number	Spacer Pieces/Box	13' (156") Feet/Box	16.42' (197") Feet/Box	19' (228") Feet/Box
13/32"	0.4004	10.17	TM1332	204	2,652	3,349	3,876
7/16"	0.4315	10.96	TM0716	170	2,210	2,791	3,230
12MM	0.4508	11.45	TM115MM	153	1,989	2,512	2,907
15/32"	0.4669	11.86	TM1532	153	1,989	2,512	2,907
1/2"	0.4941	12.55	TM0102	153	1,989	2,512	2,907
17/32"	0.5291	13.44	TM1732	153	1,989	2,512	2,907
9/16"	0.5567	14.14	TM0916	136	1,768	2,233	2,584
19/32"	0.5937	15.08	TM1932	136	1,768	2,233	2,584
16MM	0.6083	15.45	TM155MM	119	1,547	1,953	2,261
5/8"	0.6228	15.82	TM0508	119	1,547	1,953	2,261
17/25"	0.6740	17.12	TM1725	119	1,547	1,953	2,261
23/32"	0.7169	18.21	TM2332	102	1,326	1,674	1,938
3/4"	0.7441	18.90	TM0304	102	1,326	1,674	1,938
24MM	0.9232	23.45	TM235MM	85	1,105	1,396	1,615
1"	1.0020	25.45	TM255MM	85	1,105	1,396	1,615

CLEB
a UL company
COMPLIES TO NIL
AT-00741
CONFORME DOSSIER

Technoform Glass Insulation North America Inc. Master Part Chart Revision 12/21/2017

1755 Enterprise Parkway, Suite 300, Twinsburg, Ohio 44087, Phone 330-487-6600, Fax 330-487-6680, www.technoform.us

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Quality Control Forms and Checklists

Page	Title
A35	Incoming Raw Material QC Form
A36	Corner Weld Test Form
A37	Window Inspection Checklist
A38	Manufacturing Record

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INCOMING RAW MATERIALS QC FORM

- Incoming raw materials are to be checked in accordance with the below Quality Check Form.
- This form must be filled out for every shipment of incoming raw material.

PVC, Steel and Aluminum Profiles			Glazing Tape			Hardware		
Dimensional Check Against Drawings	Visual Inspection for Damage and Corrosion	Inspection of CoA / CoC from the supplier	Visual Inspection for Rips, Tears or Deformations	Meets Required Dimensions		Confirmation of Correct Part Number	Visual Inspection for Damage	
Date	**Technician's Initials**	**Shipment Number**	**Date**	**Technician's Initials**	**Shipment Number**	**Date**	**Technician's Initials**	**Shipment Number**

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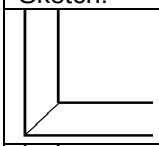
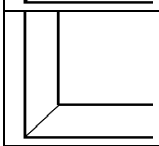
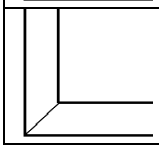
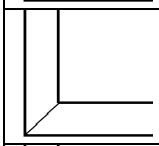
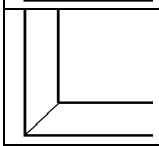
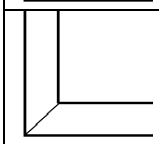
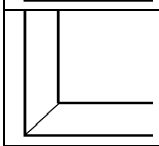
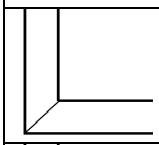
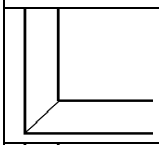
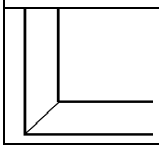
CORNER WELD TEST FORM

- When loaded to failure, the break shall not extend along the entire weld line.

Sketch:	Profile:	Date/Shift:	Pass/Fail	Comments:	Initials:
					
					
					
					
					
					
					
					
					
					

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WINDOW INSPECTION CHECKLIST

1	**General Info**	
	Window Product Model Code	
	Date of Manufacture	
	Inspector's Name	

	REQUIREMENTS	YES	NO	COMMENT
2	**Cutting / Welding**			
	Frame and Sash dimensions are within tolerance.			
	Welds are solid all the way through.			
	Corners cleaned for proper fit and appearance.			
3	**Drainage**			
	Drain holes are the correct size and located in the correct position (as stipulated in the QAI evaluation report).			
	Water passages are clean and free from debris.			
4	**Hardware**			
	Correct hardware part number is installed.			
	Correct number and size of fasteners are used.			
	Hardware is installed in the correct location. Locks aligned and engaged with keepers.			
5	**Glazing**			
	Correct type of IGU is used.			
	Correct size and type of glazing tape applied.			
	Silicone sealant is placed at corners of glazing tape.			
6	**Storage and Packaging**			
	Windows are stored in a vertical position and placed in an area where they are protected from damage.			
	Windows are correctly labeled in accordance with QAI and ENERGY STAR requirements.			
	Windows are packaged to sufficiently protect them from damage during transportation.			

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MANUFACTURING RECORD

Date	Purchase Order	Product Model Code	Dimensional Check Against Drawings and PO	Visual Inspection for Damage to Window	Operability Check for Operable Windows	Window is Labeled with Correct Permanent and Temporary Label

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**********<END OF APPENDIX A>********

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