

CMI ARCHITECTURAL PRODUCTS, INC. COMPUTER SIMULATION REPORT

SCOPE OF WORK

351 MEDIUM STILE DOOR - AAMA 507

REPORT NUMBER

N8135.01-201-45 R0

TEST DATE

08/25/22

ISSUE DATE

08/25/22

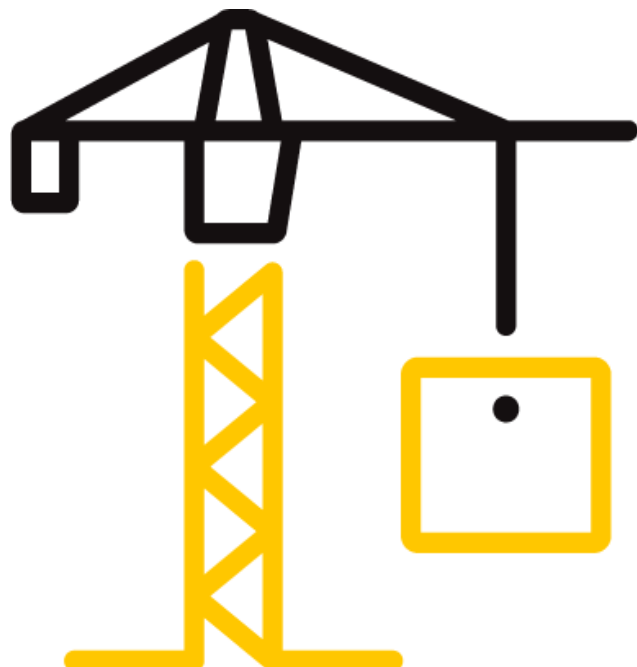
PAGES

27

DOCUMENT CONTROL NUMBER

RT-R-AMER-Test-3753 (02/20/18)

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TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

Report No.: N8135.01-201-45 R0

Date: 08/25/22

REPORT ISSUED TO

CMI ARCHITECTURAL PRODUCTS, INC.

1630 101st Avenue NE

Blaine, Minnesota 55449

SECTION 1

SUMMARY

SERIES/MODEL: 351 Medium Stile Door

Architectural Testing, Inc. (an Intertek company), dba Intertek Building & Construction (Intertek B&C) was contracted to perform AAMA 507 computer simulations utilizing thermal thermal modeling computer software developed by Lawrence Berkeley National Laboratory Laboratory (LBNL). Results obtained are simulated values and were secured using the designated test methods.

Intertek B&C is an NFRC accredited simulation laboratory and all simulations were conducted in full compliance with NFRC approved procedures and specifications.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. The record retention end date of this report is 08/25/27.

For INTERTEK B&C:

COMPLETED BY: Andrew C. Walczak
Simulation Project
TITLE: Manager, SIRC

SIGNATURE:

DATE: 08/25/22

ACW:emd/wma

REVIEWED BY: Eid M. Dushaishi
Project Engineer, NFRC
TITLE: Certified Simulator

SIGNATURE:

DATE: 08/25/22

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SECTION 2

TEST METHODS

The products were evaluated in accordance with the following:

***AAMA 507-15**, Standard Practice for Determining the Thermal Performance Characteristics of Fenestration Systems Installed in Commercial Buildings*

***ANSI/NFRC 100-2020**, Procedure for Determining Fenestration Product U-Factors*

***ANSI/NFRC 200-2020**, Procedure for Determining Fenestration Product Solar Heat Gain Coefficient and Visible Transmittance at Normal Incidence*

SECTION 3

TEST PROCEDURE

The total product, including specific frame, spacer, and glass details, was modeled using NFRC approved software.

FRAME AND EDGE MODELING	THERM 7.4.4
CENTER-OF-GLASS MODELING	WINDOW 7.4.14
TOTAL PRODUCT CALCULATIONS	WINDOW 7.4.14
SPECTRAL DATA LIBRARY	IGDB 87.0

Modeling Assumptions / Technical Interpretations

Any modeling assumptions and technical interpretations required to model this product are listed below.

- 1) To prevent air infiltration, tape was applied to all interior sash crack locations.
- 2) Non-continuous hardware was not modeled.

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SECTION 4
SIMULATION SPECIMEN DESCRIPTION

SERIES/MODEL	351 Medium Stile Door
PRODUCT TYPE	Swinging Door - Single
FRAME MATERIAL	AT - Aluminum w/ Thermal Breaks - All Members
SASH MATERIAL	AL - Aluminum (Non-thermally Broken)

GLAZING OPTIONS					
	OUTER PANE	MIDDLE PANE	INNER PANE	GAP SIZES	IG OVERALL
GL1	1/4"	N/A	1/4"	0.500"	1"
GL2	1/4"	Heat Mirror	1/4"	0.250"	1"

GL1: Dual glazed IG unit (COG=0.48 - COG=0.20)

GL2: Dual glazed IG unit w/ heat mirror (COG=0.18 - COG=0.10)

SPACER OPTIONS			
TYPE	PRIMARY SEAL	SECONDARY SEAL	CODE
Generic Aluminum Dual Seal Spacer	Butyl Rubber	Butyl Rubber	A1-D

SECTION 5
MEASURED SIMULATION DATA

U-FACTOR CALCULATIONS	
Exterior Air Temperature	-0.4°F
Exterior Wind Velocity	12.3 mph (Perpendicular Flow)
Interior Air Temperature	69.8°F

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

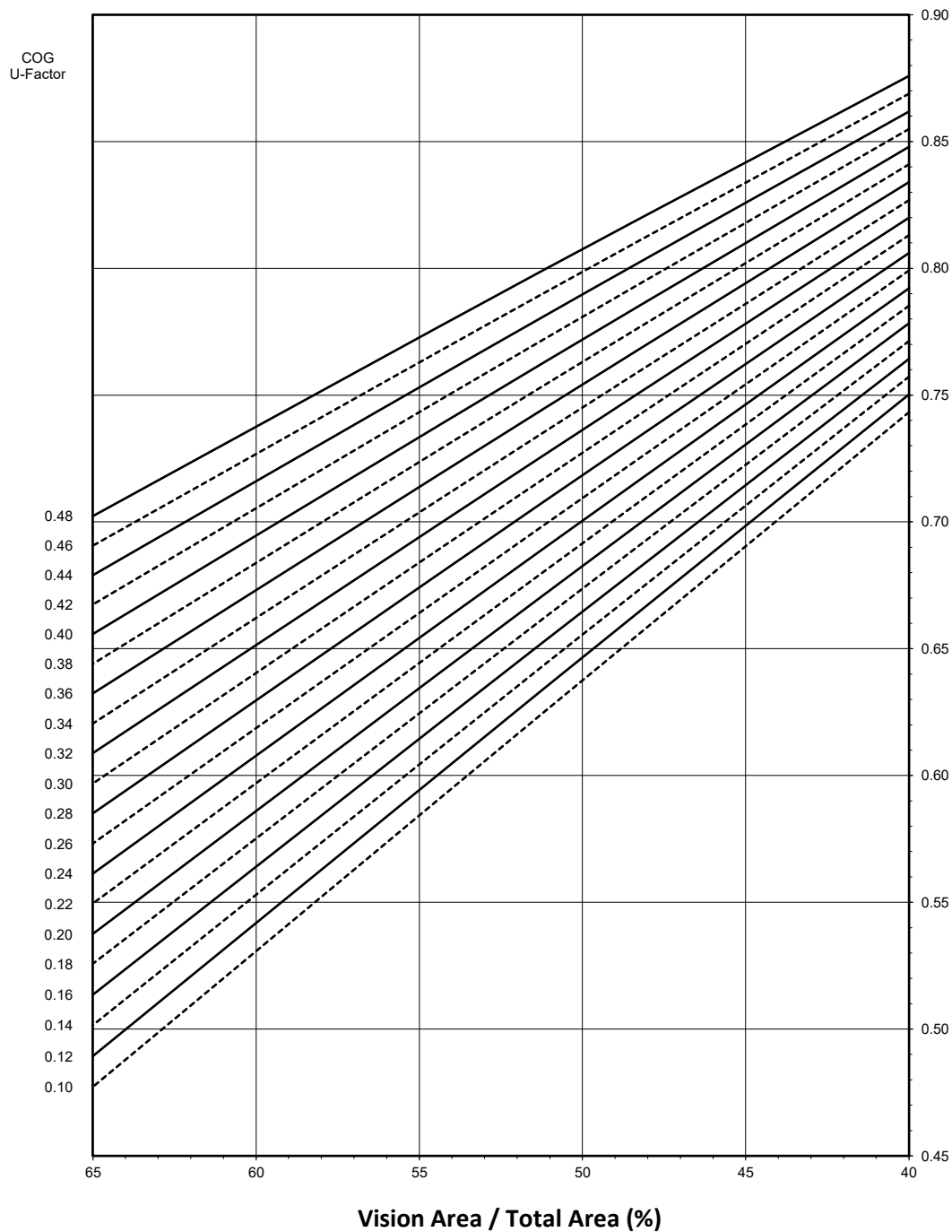
Report No.: N8135.01-201-45 R0

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SECTION 6

SIMULATION RESULTS

U-FACTOR CALCULATIONS: System U-Factor vs. Percentage of Vision Area



TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

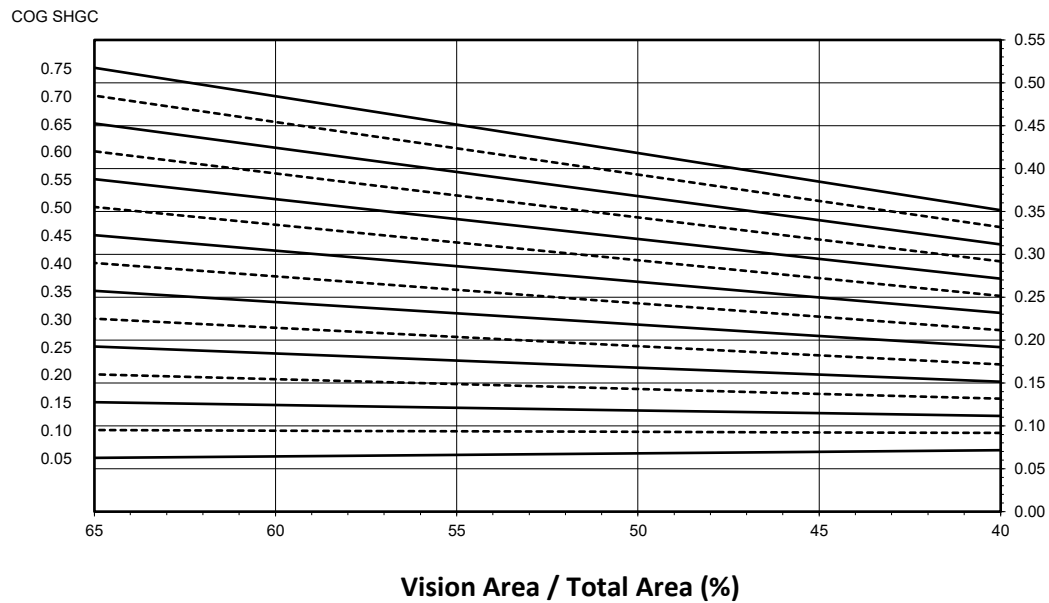
Report No.: N8135.01-201-45 R0

Date: 08/25/22

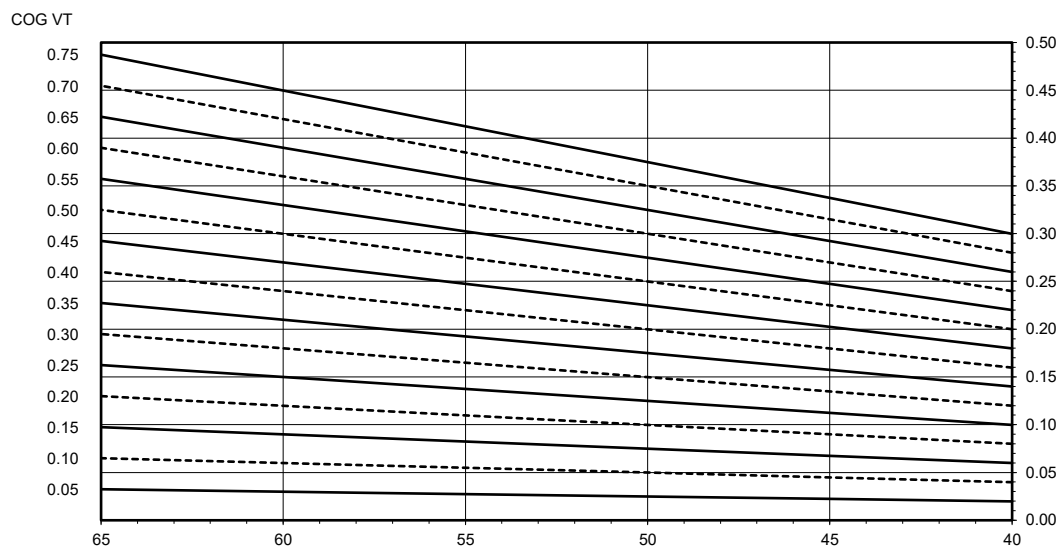
SECTION 6

SIMULATION RESULTS

SHGC CALCULATIONS: System SHGC vs. Percentage of Vision Area



VT CALCULATIONS: System VT vs. Percentage of Vision Area



TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

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Date: 08/25/22

SECTION 6

SIMULATION RESULTS

U-FACTOR CALCULATIONS (351 Medium Stile Door)		
Size Specific U-Factor Matrix*		
Glazing Option	Center-of-Glass U-Factor	Overall U-Factor
1	0.48	0.80
2	0.46	0.79
3	0.44	0.78
4	0.42	0.77
5	0.40	0.76
6	0.38	0.75
7	0.36	0.74
8	0.34	0.74
9	0.32	0.73
10	0.30	0.72
11	0.28	0.71
12	0.26	0.70
13	0.24	0.69
14	0.22	0.68
15	0.20	0.67
16	0.18	0.66
17	0.16	0.65
18	0.14	0.64
19	0.12	0.63
20	0.10	0.62

*The size specific U-Factor matrix is based on the Swinging Door - Single NFRC specimen size of 960mm x 2090mm (37.75 in x 82.375 in). This represents 51.2% Vision Area / Total Area.

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SECTION 6

SIMULATION RESULTS

SHGC/VT CALCULATIONS (351 Medium Stile Door)			
Size Specific SHGC Matrix*		Size Specific VT Matrix*	
Center-of-Glass SHGC	Overall SHGC	Center-of-Glass VT	Overall VT
0.75	0.43	0.75	0.38
0.70	0.40	0.70	0.36
0.65	0.37	0.65	0.33
0.60	0.35	0.60	0.31
0.55	0.32	0.55	0.28
0.50	0.30	0.50	0.26
0.45	0.27	0.45	0.23
0.40	0.25	0.40	0.20
0.35	0.22	0.35	0.18
0.30	0.20	0.30	0.15
0.25	0.17	0.25	0.13
0.20	0.14	0.20	0.10
0.15	0.12	0.15	0.08
0.10	0.09	0.10	0.05
0.05	0.07	0.05	0.03

*The size specific SHGC and VT matrices are based on the Swinging Door - Single NFRC specimen size of 960mm x 2090mm (37.75 in x 82.375 in). This represents 51.2% Vision Area / Total Area.

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SECTION 6
SIMULATION RESULTS

TOTAL PRODUCT CALCULATIONS (351 Medium Stile Door)									
Option Number	COG U-Factor	COG Temperature	Cross Section	Frame Height	Frame U-Factor	Edge U-Factor	Total Product U-Factor		
							40.00% Vision Area	ANSI/NFRC 100-2020	65.00% Vision Area
1	0.48	43.7°F	Head	6.3629	0.9317	0.2212	0.8760	0.7993	0.7024
			L. Jamb	6.5197	1.1898	0.5911			
			R. Jamb	6.5197	1.1898	0.5911			
			Sill	11.603	1.0541	0.2151			
2	0.46	44.8°F	Head	6.3629	0.9317	0.2159	0.8689	0.7902	0.6908
			L. Jamb	6.5197	1.1898	0.5756			
			R. Jamb	6.5197	1.1898	0.5756			
			Sill	11.603	1.0540	0.2095			
3	0.44	45.8°F	Head	6.3629	0.9317	0.2106	0.8619	0.7810	0.6791
			L. Jamb	6.5197	1.1897	0.5602			
			R. Jamb	6.5197	1.1897	0.5602			
			Sill	11.603	1.0539	0.2038			
4	0.42	46.8°F	Head	6.3629	0.9317	0.2054	0.8550	0.7720	0.6675
			L. Jamb	6.5197	1.1897	0.5451			
			R. Jamb	6.5197	1.1897	0.5451			
			Sill	11.603	1.0538	0.1984			
5	0.40	47.9°F	Head	6.3629	0.9316	0.2000	0.8480	0.7628	0.6558
			L. Jamb	6.5197	1.1897	0.5297			
			R. Jamb	6.5197	1.1897	0.5297			
			Sill	11.603	1.0537	0.1928			
6	0.38	48.9°F	Head	6.3629	0.9316	0.1949	0.8411	0.7537	0.6441
			L. Jamb	6.5197	1.1897	0.5148			
			R. Jamb	6.5197	1.1897	0.5148			
			Sill	11.603	1.0536	0.1874			
7	0.36	50.0°F	Head	6.3629	0.9316	0.1897	0.8341	0.7446	0.6325
			L. Jamb	6.5197	1.1897	0.4997			
			R. Jamb	6.5197	1.1897	0.4997			
			Sill	11.603	1.0535	0.1819			
8	0.34	51.0°F	Head	6.3629	0.9306	0.1839	0.8270	0.7353	0.6206
			L. Jamb	6.5197	1.1896	0.4847			
			R. Jamb	6.5197	1.1896	0.4847			
			Sill	11.603	1.0534	0.1765			

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SECTION 6
SIMULATION RESULTS

TOTAL PRODUCT CALCULATIONS (351 Medium Stile Door)									
Option Number	COG U-Factor	COG Temperature	Cross Section	Frame Height	Frame U-Factor	Edge U-Factor	Total Product U-Factor		
							40.00% Vision Area	ANSI/NFRC 100-2020	65.00% Vision Area
9	0.32	52.0°F	Head	6.3629	0.9306	0.1787	0.8201	0.7262	0.6089
			L. Jamb	6.5197	1.1896	0.4697			
			R. Jamb	6.5197	1.1896	0.4697			
			Sill	11.603	1.0533	0.1711			
10	0.30	53.1°F	Head	6.3629	0.9305	0.1736	0.8131	0.7170	0.5970
			L. Jamb	6.5197	1.1896	0.4549			
			R. Jamb	6.5197	1.1896	0.4549			
			Sill	11.603	1.0532	0.1657			
11	0.28	54.2°F	Head	6.3629	0.9305	0.1685	0.8062	0.7079	0.5852
			L. Jamb	6.5197	1.1896	0.4401			
			R. Jamb	6.5197	1.1896	0.4401			
			Sill	11.603	1.0531	0.1603			
12	0.26	55.2°F	Head	6.3629	0.9305	0.1634	0.7992	0.6987	0.5732
			L. Jamb	6.5197	1.1896	0.4254			
			R. Jamb	6.5197	1.1896	0.4254			
			Sill	11.603	1.0530	0.1550			
13	0.24	56.3°F	Head	6.3629	0.9305	0.1583	0.7923	0.6895	0.5614
			L. Jamb	6.5197	1.1897	0.4107			
			R. Jamb	6.5197	1.1897	0.4107			
			Sill	11.603	1.0529	0.1497			
14	0.22	57.3°F	Head	6.3629	0.9306	0.1531	0.7853	0.6804	0.5496
			L. Jamb	6.5197	1.1897	0.3959			
			R. Jamb	6.5197	1.1897	0.3959			
			Sill	11.603	1.0528	0.1443			
15	0.20	58.4°F	Head	6.3629	0.9306	0.1481	0.7784	0.6712	0.5376
			L. Jamb	6.5197	1.1897	0.3813			
			R. Jamb	6.5197	1.1897	0.3813			
			Sill	11.603	1.0527	0.1390			
16	0.18	59.5°F	Head	6.3629	0.9300	0.1434	0.7714	0.6620	0.5258
			L. Jamb	6.5197	1.1892	0.3680			
			R. Jamb	6.5197	1.1892	0.3680			
			Sill	11.603	1.0523	0.1344			

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SECTION 6
SIMULATION RESULTS

TOTAL PRODUCT CALCULATIONS (351 Medium Stile Door)									
Option Number	COG U-Factor	COG Temperature	Cross Section	Frame Height	Frame U-Factor	Edge U-Factor	Total Product U-Factor		
							40.00% Vision Area	ANSI/NFRC 100-2020	65.00% Vision Area
17	0.16	60.6°F	Head	6.3629	0.9300	0.1382	0.7644	0.6527	0.5137
			L. Jamb	6.5197	1.1893	0.3532			
			R. Jamb	6.5197	1.1893	0.3532			
			Sill	11.603	1.0523	0.1290			
18	0.14	61.6°F	Head	6.3629	0.9302	0.1326	0.7573	0.6434	0.5016
			L. Jamb	6.5197	1.1895	0.3374			
			R. Jamb	6.5197	1.1895	0.3374			
			Sill	11.603	1.0523	0.1233			
19	0.12	62.7°F	Head	6.3629	0.9302	0.1275	0.7504	0.6341	0.4895
			L. Jamb	6.5197	1.1895	0.3228			
			R. Jamb	6.5197	1.1895	0.3228			
			Sill	11.603	1.0522	0.1180			
20	0.10	63.9°F	Head	6.3629	0.9303	0.1223	0.7434	0.6248	0.4773
			L. Jamb	6.5197	1.1896	0.3080			
			R. Jamb	6.5197	1.1896	0.3080			
			Sill	11.603	1.0521	0.1127			



Total Quality. Assured.

40 51st Way NE, Suite 100
Fridley, MN 55421

Telephone: 651-636-3835
Facsimile: 717-764-4129
www.intertek.com/building

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

Report No.: N8135.01-201-45 R0

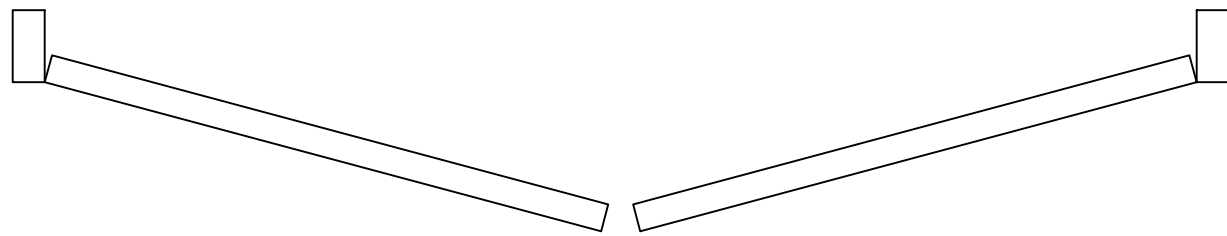
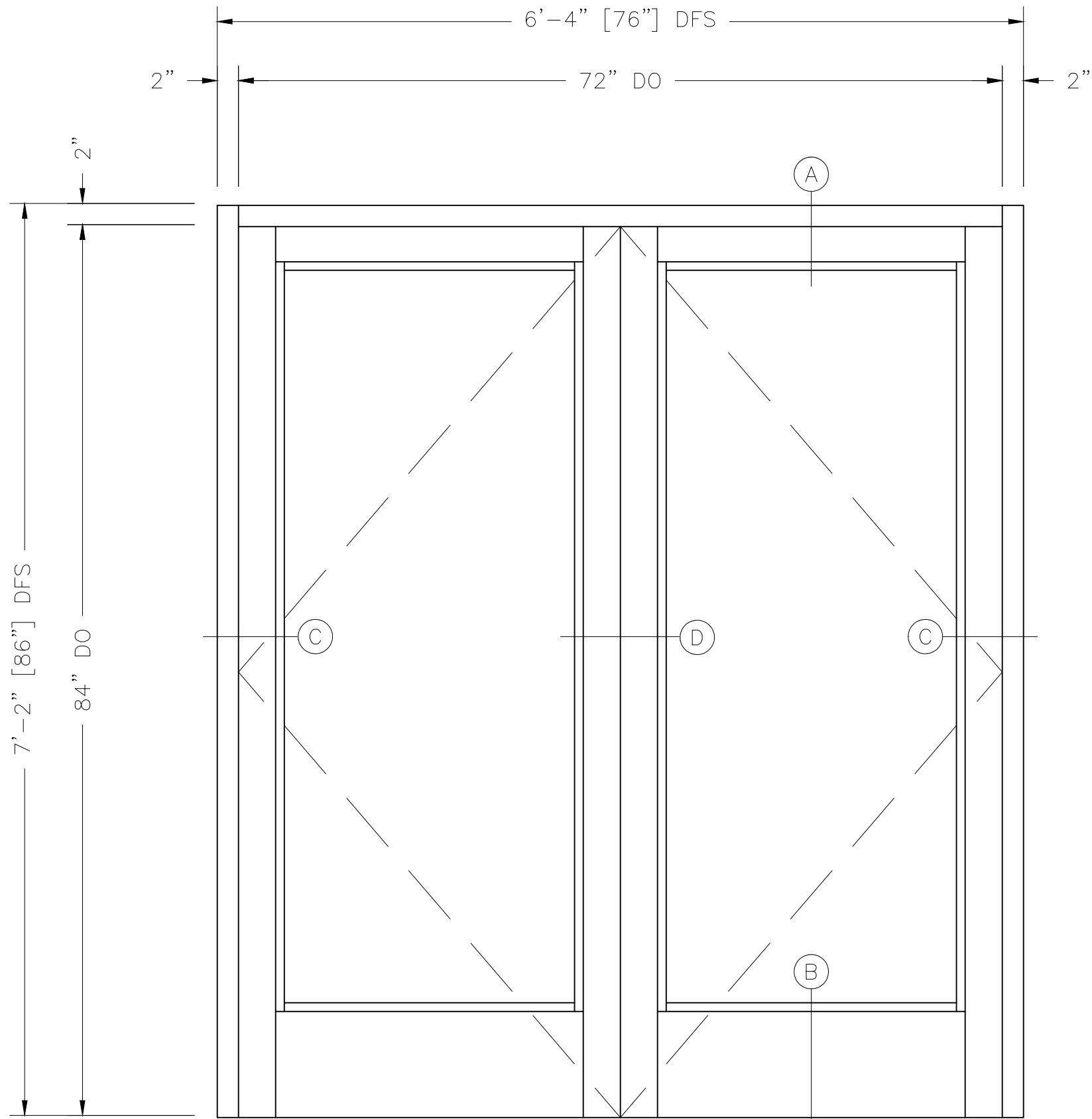
Date: 08/25/22

SECTION 7

DRAWINGS / BILL OF MATERIALS

The drawings which follow have been reviewed by Intertek B&C and are representative of the simulation result(s) reported herein. Any deviations are documented herein or on the drawings.

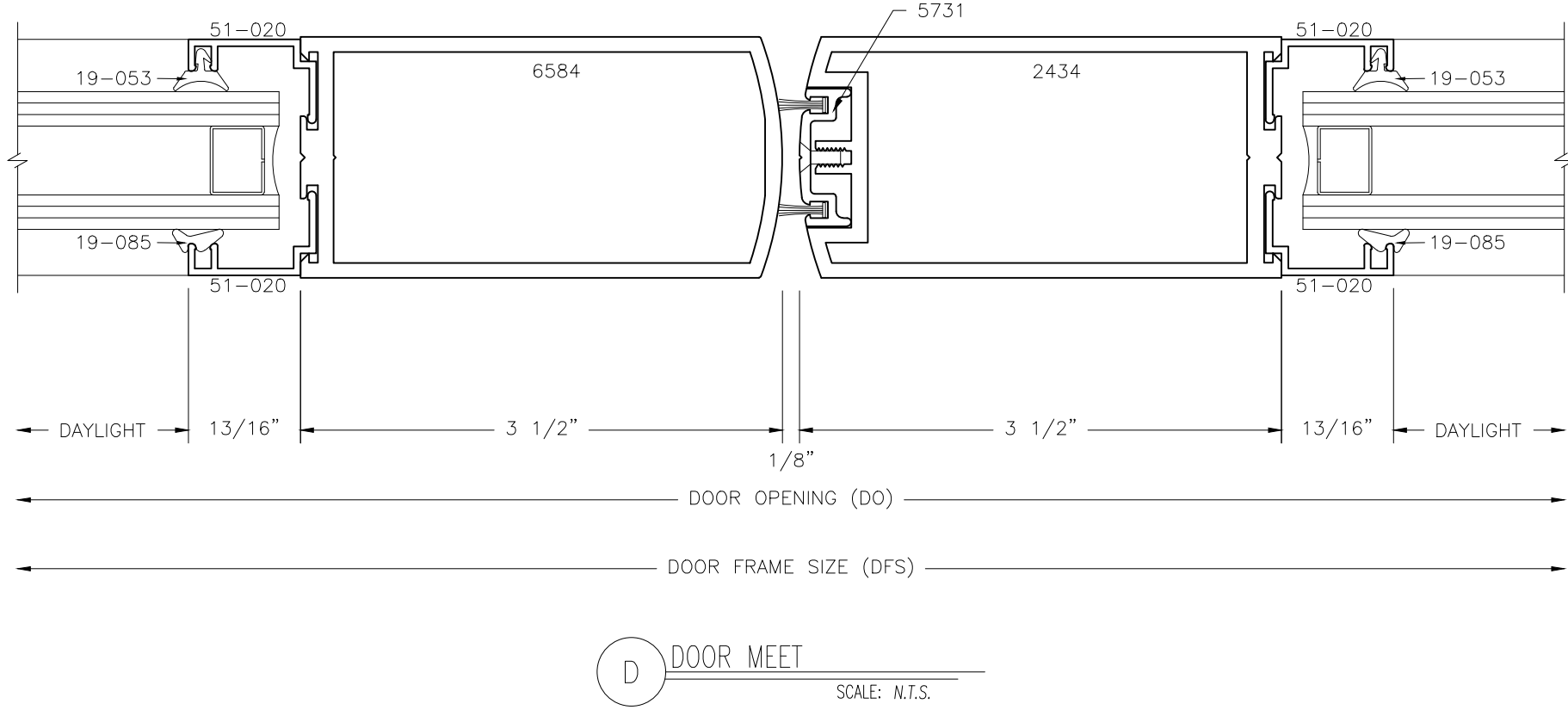
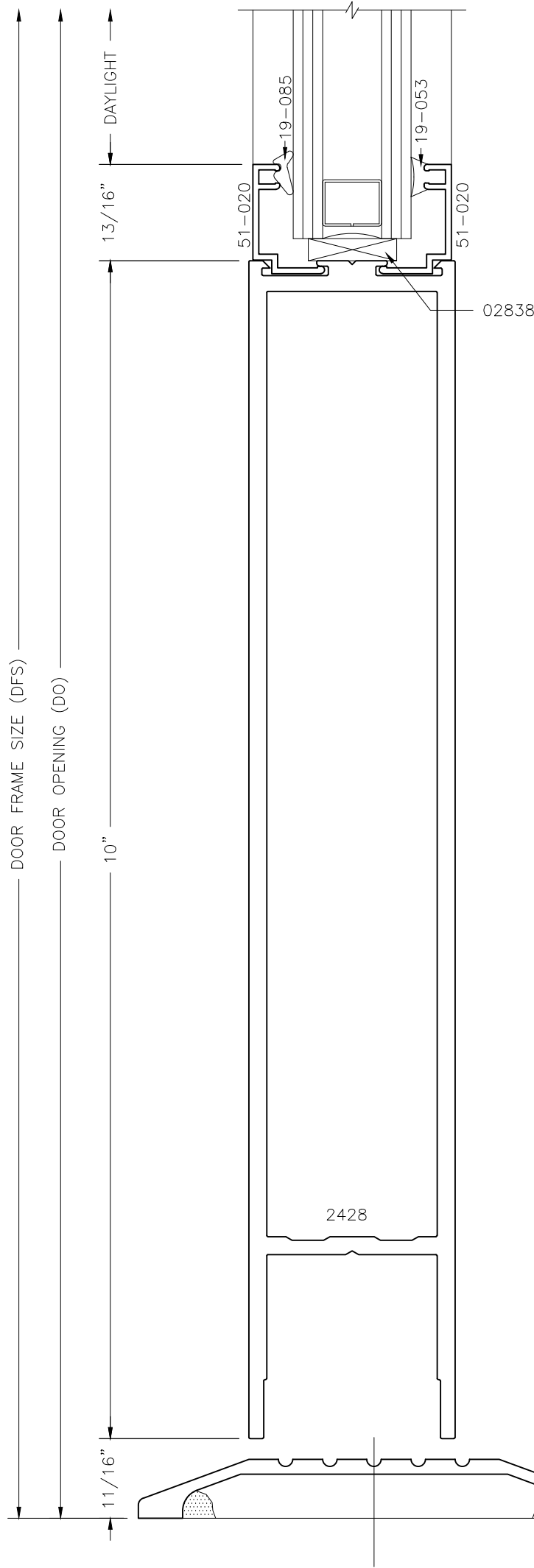
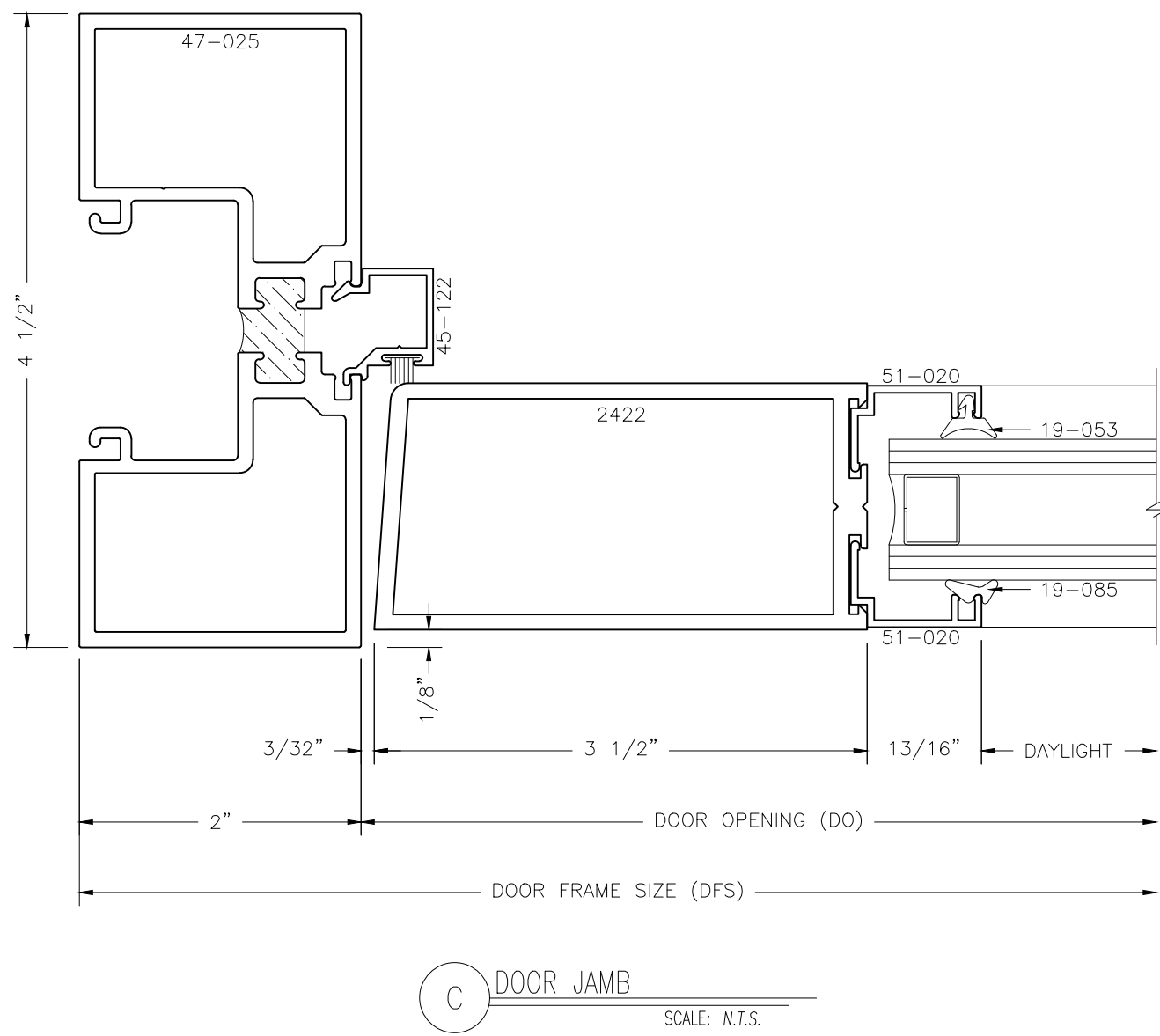
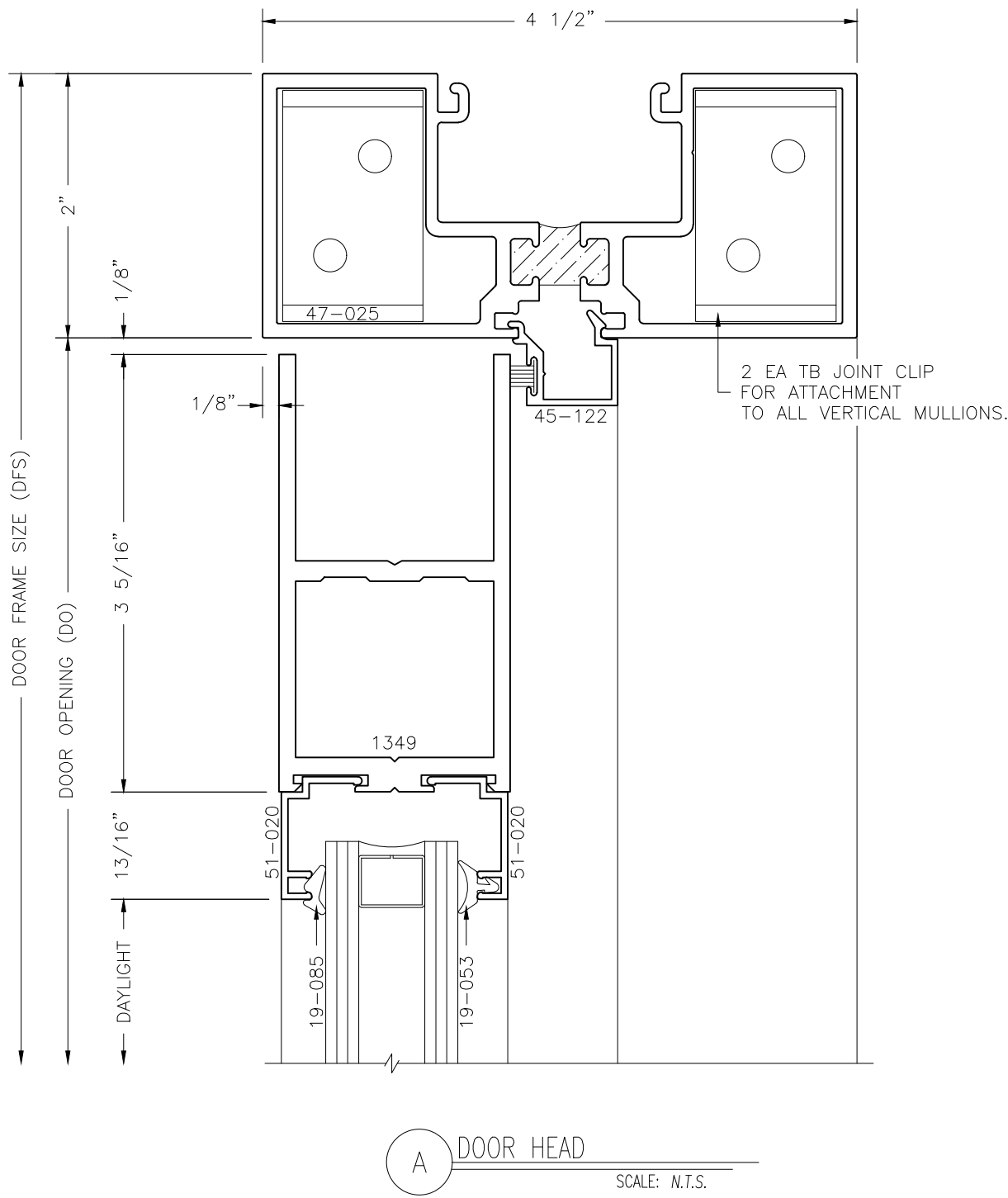
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351 MEDIUM STILE – PAIR
45-025 FRAMING SCALE: N.T.S.

PARTS LIST:		
#	USE	DESCRIPTION
47-025	THERMAL DOOR FRAME	6063-T5 ALUMINUM w/POLYURETHANE THERMAL BREAK
45-122	1/2" DOOR STOP	6063-T6 ALUMINUM
51-020	1" GLASS STOP	6063-T5 ALUMINUM
1349	3 5/16" TOP RAIL	6063-T5 ALUMINUM
2428	10" BOTTOM RAIL	6063-T5 ALUMINUM
2422	BEVELED MEDIUM STILE	6063-T5 ALUMINUM
6584	BULL NOSE MEDIUM STILE	6063-T5 ALUMINUM
2434	BULL NOSE MEDIUM STILE w/ASTRIGAL	6063-T5 ALUMINUM
5731	DOOR ASTRIGAL	6063-T5 ALUMINUM
19-085	GLAZING GASKET	EPDM 70 ±5 DUROMETER
19-053	GLAZING GASKET	EPDM 70 ±5 DUROMETER

TESTING PARAMETERS:
AAMA 507: STANDARD PRACTICE FOR DETERMINING THE THERMAL PERFORMANCE CHARACTERISTICS OF FENESTRATION SYSTEMS INSTALLED IN COMMERCIAL BUILDINGS.
NFRC 100/200/500: PROCEDURES FOR DETERMINING FENESTRATION PRODUCT U-FACTORS, SOLAR HEAT GAIN COEFFICIENT, VISIBLE TRANSMITTANCE AT NORMAL INCIDENCE AND CONDENSATION RESISTANCE VALUES.



REVISIONS

REV	INT'L	DATE	DISCRPTION
A			

TEST:
351 MEDIUM STILE DOOR - PAIR
AAMA 507 COMPUTER SIMULATION
NFRC 100/200/500 COMPUTER
SIMULATION

TESTING AGENCY:
INTERTEK - ATI
40 51ST WAY NE
SUITE 100
FRIDLEY, MN 55421
P: 651.636.3835

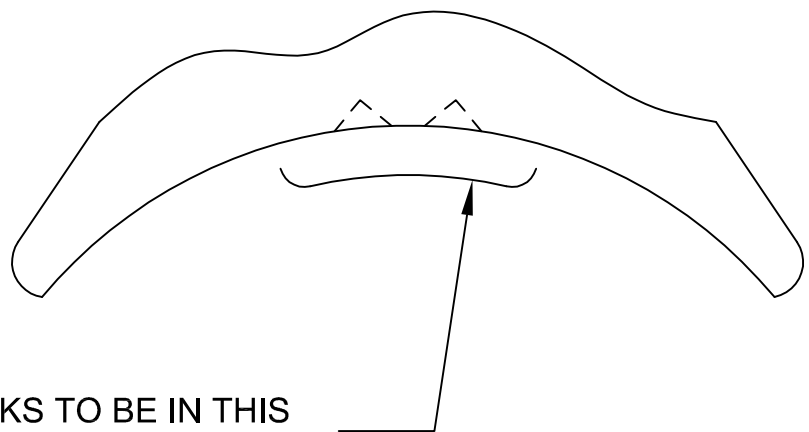
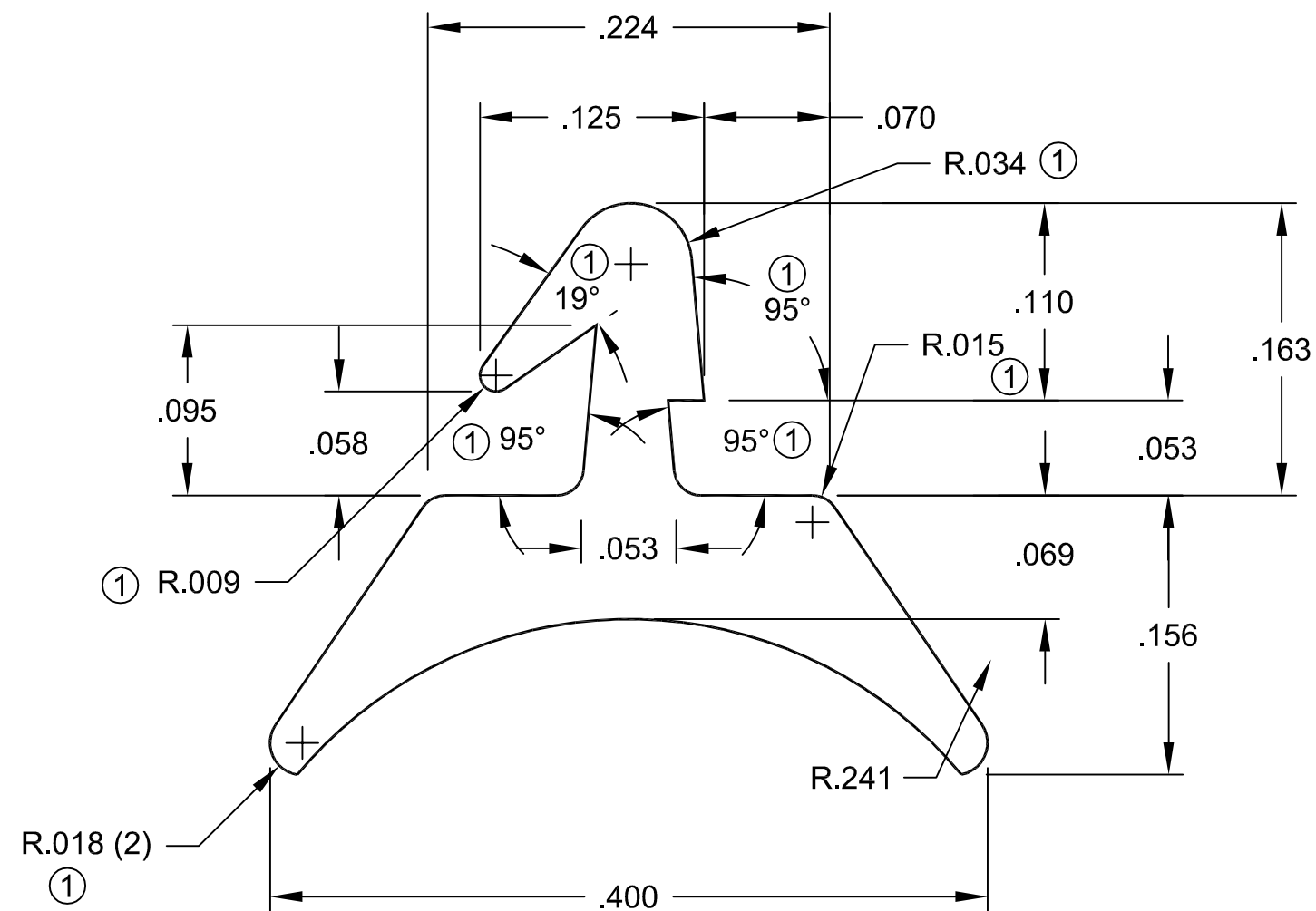
DRAWN BY:
ASHLEY ALT

DATE:
05.10.2022

SHEET #:



FULL SCALE



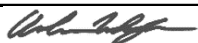
CAVITY ID MARKS TO BE IN THIS LOCATION AND OF TYPE AS SHOWN



Total Quality. Assured.

Report #: N8135.01-201-45

Date: 8/29/22

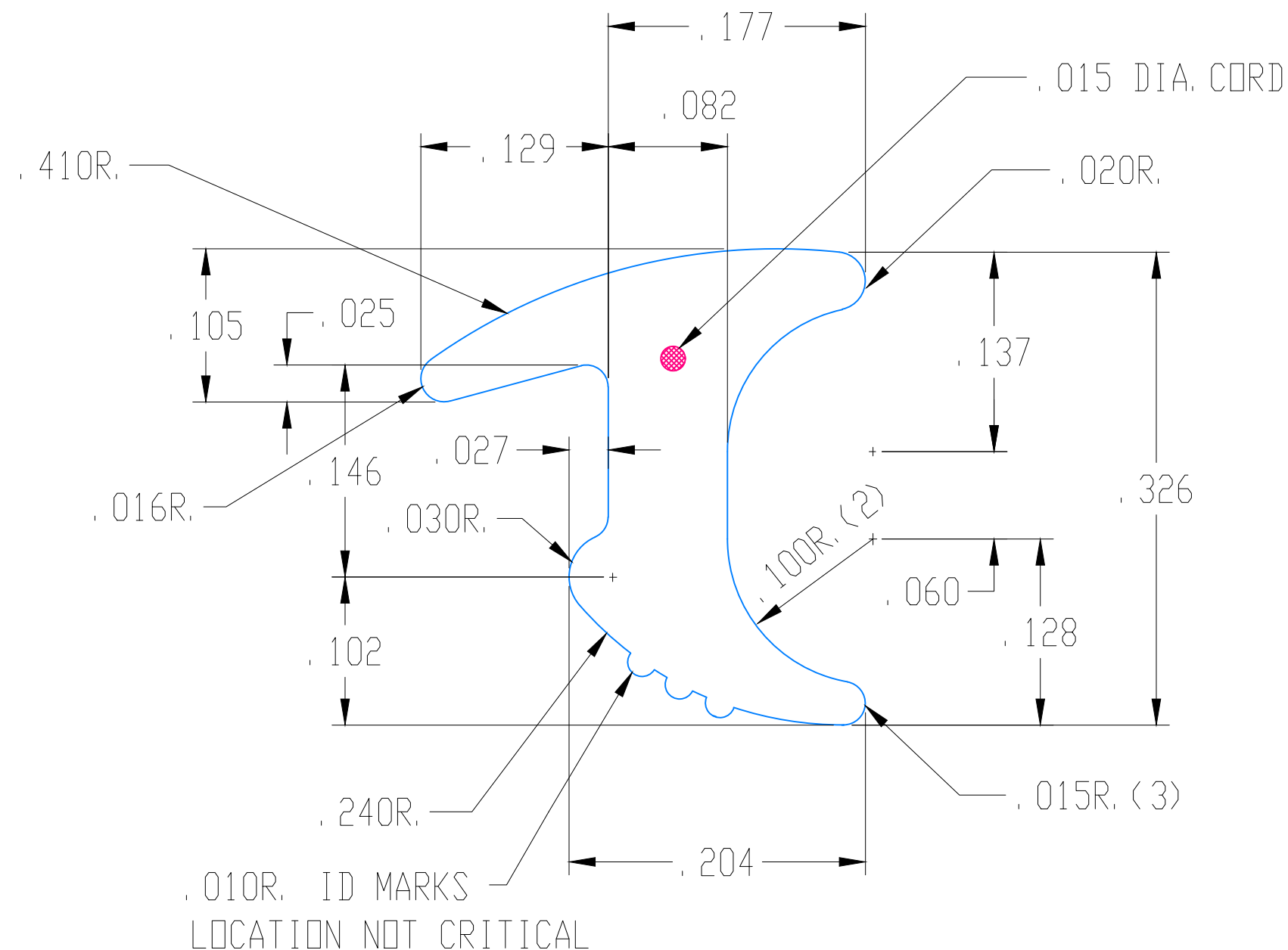
Verified by: 

The design of the gasket shown herein is the product of Tremco Incorporated. No reproduction or use of this design is authorized without the consent of Tremco Incorporated.

		2	1-2-08	ADDED ID MARK LOCATION		DLS	
EXTRUSION CUT LENGTH TOLERANCE		1	8-3-07	ADDED DIMENSIONS (NO PART CHANGE)		DLS	
0	- 1.6"	±.060"		No.	Date	Description	By
1.6"	- 2.5"	±.080"		 SEALANT / WEATHERPROOFING DIVISION 1451 Jacobson Ave Ashland, Ohio 44805 U.S.A. Phone : 800-321-6357 Fax : 419-289-6645			
2.5"	- 4.0"	±.100"					
4.0"	- 6.3"	±.130"					
6.3"	- 10.0"	±.160"					
10.0"	- 16.0"	±.200"					
16.0"	- 25.0"	±.250"		Customer: CMI			Customer Part No. 19-053
25.0"	- 40.0"	±.400"					
40.0"	- 63.0"	±.500"		Project:			
63.0"	- 100.0"	±.630"					
100.0"	- 160.0"	±.800"					
+160.0"	±.50%						
		Drawn by: E. TANGO		Scale: 10X	Date: 6/13/2005		
		Compound: EPDM		Designed F.C. *.125	Drawing No. TR-13921E		
		Durometer: 70 ±5		Area: .039			



FULL SIZE



NOTE: PROFILE TO BE SILICONE COATED



Report #: N8135.01-201-45
Date: 8/29/22
Verified by: 

THE DESIGN OF THE GASKET SHOWN HEREIN IS THE PRODUCT OF TREMCO, INC. NO REPRODUCTION OR USE OF THIS DESIGN IS AUTHORIZED WITHOUT THE CONSENT OF TREMCO.

1	7-27-95	ADD WORLD BANK GRAY EPDM	DAT
1	5-27-86	ADD NOTE	JRB
NO.	DATE	DESCRIPTION	BY
		TREMCO®	1451 JACOBSON AVE. ASHLAND, OH 44805 U. S. A.
TREMCO STANDARD			
DRAWN BY	POIRIER	SCALE 10X	DATE 9-26-85
COMPOUND	EPDM	DESIGNED F. C.	DRAWING NO.
DURIMETER	70±5	AREA .0420	TR-1965E

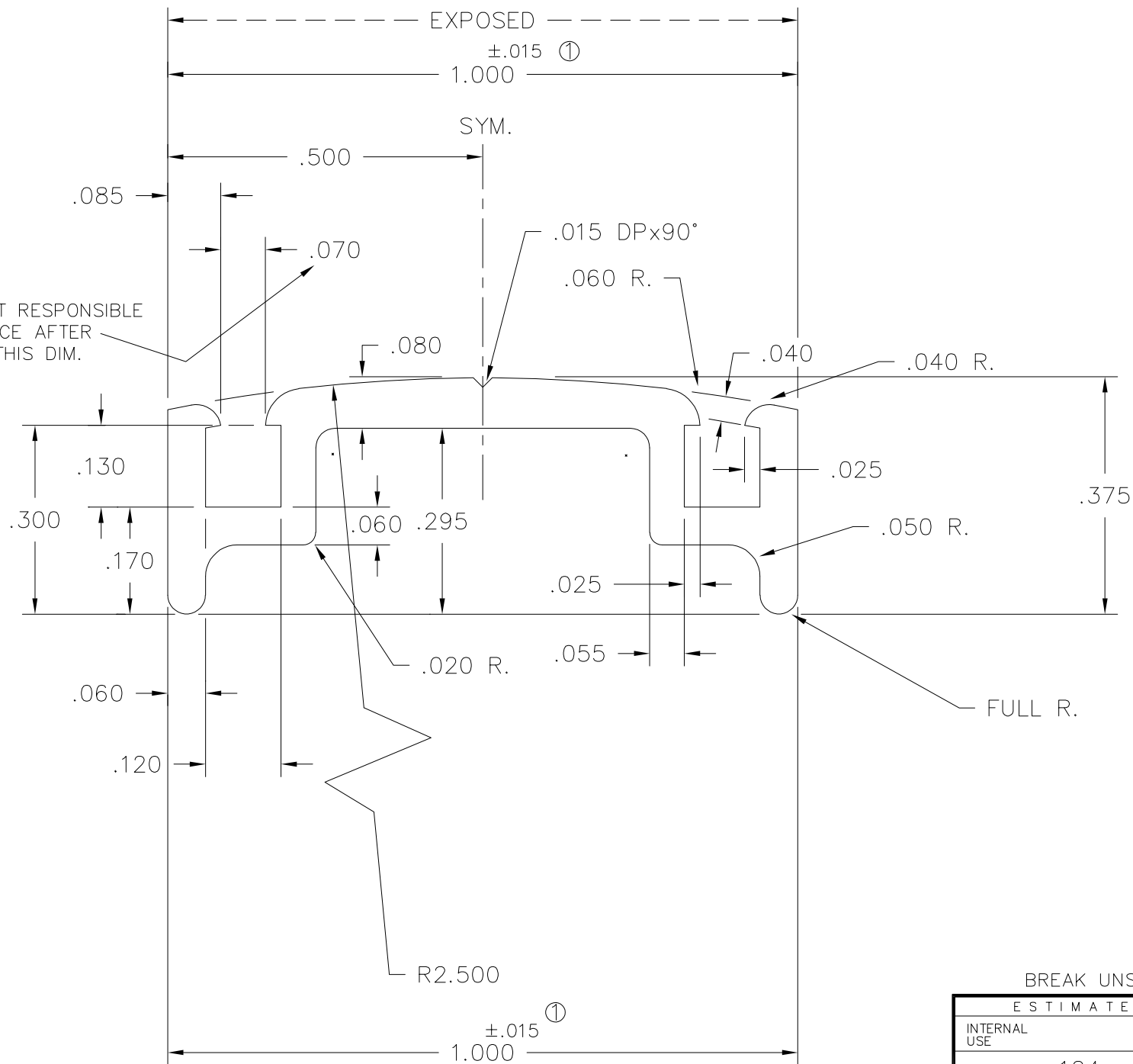
PRINT REVISIONS			DATE
①	ADDED TOL. TO 1.000 DIM	M.C.	7-6-95

CRM-170

REV.

DELHI	TIFTON	BOTH
☒	☐	☐

NOTE:
TIFTON IS NOT RESPONSIBLE
FOR TOLERANCE AFTER
ANODIZE OF THIS DIM.



ACTUAL SIZE

BREAK UNSPECIFIED CORNERS .010 R. ---- TYPICAL WALL UNLESS SPECIFIED OTHERWISE.

ESTIMATED DIE DATA			
INTERNAL USE	6063-T5		
AREA	.124	WT/FT	.149
PERIMETER	3.924	CIRCLE SIZE	1 - 2
OUTSIDE PERIMETER	FACTOR		26
EXPOSED PERIMETER	1.770	SOLID	

CUSTOMER	sapa: Sapa Extrusions, Inc. DELHI, LA 71232
	CMI-CRONSTROMS, INC. 1045 GEMINI ROAD EAGAN, MN 55121
APPLICATION	
DOOR ASTRIGAL	

CADD #	MRC--141 279
SCALE	ACTUAL & 4x
DATE	4-21-95
LAST REVISION	7-6-95
DRAWN	M. COPES
JOB	
CUSTOMER NUMBER	5731



Total Quality. Assured.

Report #: N8135.01-201-45

Date: 8/29/22

Verified by: 

PRESS SIZE	LEGEND		DIE REVISIONS		DATE
	• = .031 R.				
	◦ = .062 R.				
	x = .125 R.				
	⊗ = .250 R.				
	* =				

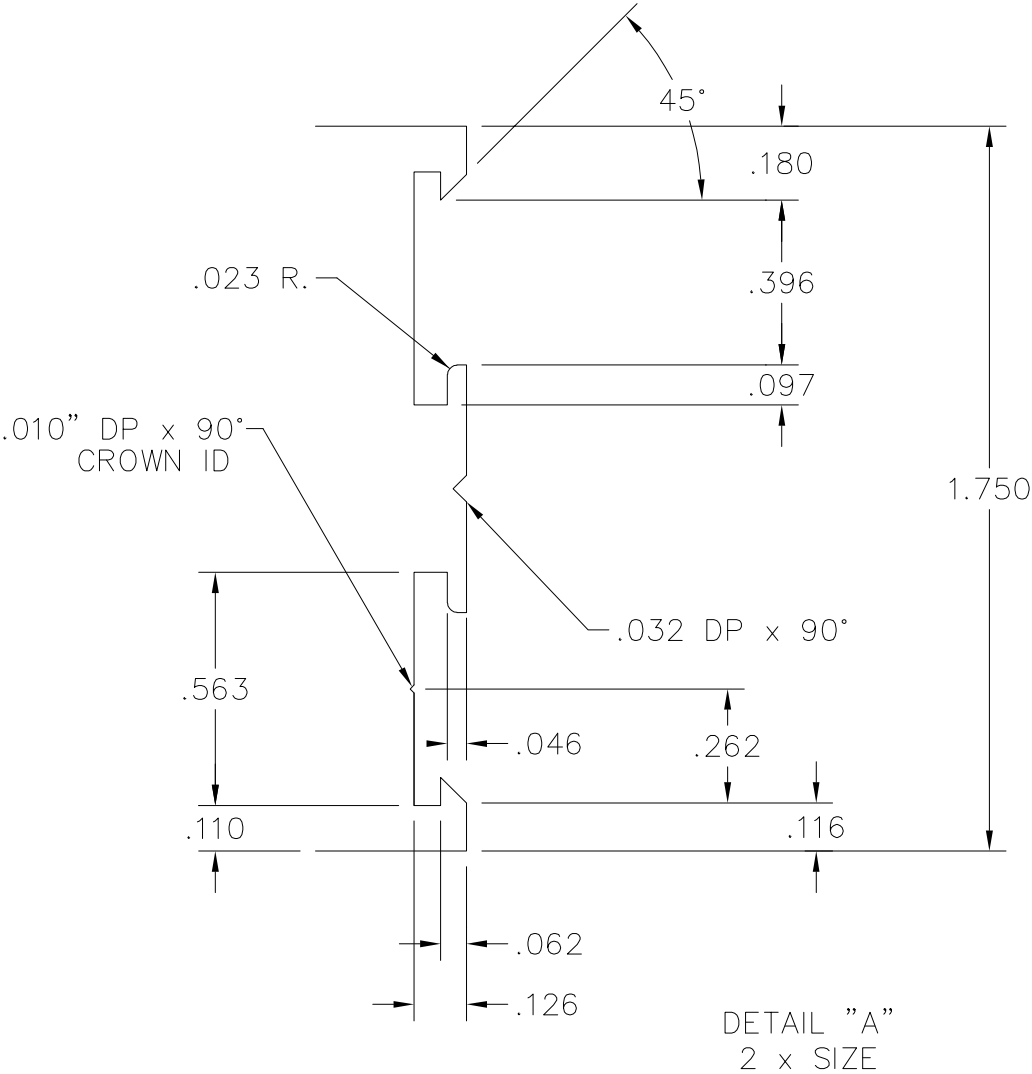
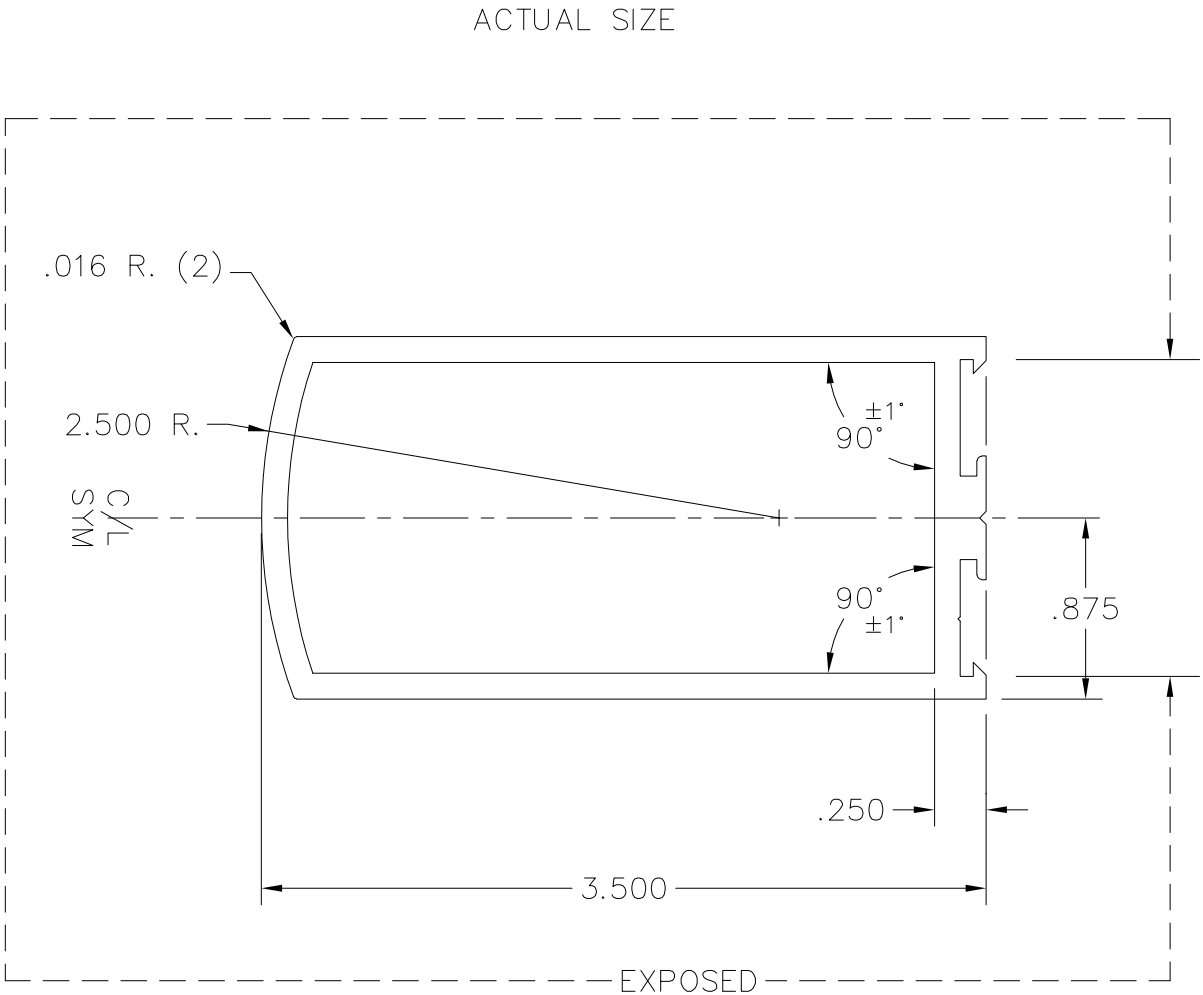
PRINT REVISIONS		DATE

12577

Die Number

6584M

Customer Number



STRAIGHTNESS & TWIST ARE CRITICAL!

BREAK UNSPECIFIED CORNER: .015 R. TYPICAL WALL UNLESS OTHERWISE NOTED: .125



Total Quality. Assured.

Report #: N8135.01-201-45

Date: 8/29/22

Verified by: 

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

		ESTIMATED DIE DATA		 CROWN EXTRUSIONS Crown Extrusions, Inc. 122 Columbla Court N. Chaska, MN 55318 952-448-3533 Fax: 952-448-5328	DIE #	
		ALLOY/TEMPER: 6063-T5			12577	
		AREA 1.277	WT/FT 1.532		SCALE FULL & NOTED	
		PERIMETER 20.360	CIRCLE SIZE 3 - 4		DATE 12-11-08	
		OUTSIDE PERIMETER 11.314	FACTOR 13		LAST REVISION	
PRESS SIZE	EXPOSED PERIMETER 8.698	HOLLOW		CUSTOMER CMI Architectural Products, Inc. 20621 SD Highway 25 DeSmet, SD 57231-5827 605-854-3326 Fax: 605-854-3620	DRAWN TCG	
LEGEND		DIE REVISIONS			DATE	CUSTOMER NUMBER 6584M
• = .031 R.						
◦ = .062 R.						
× = .125 R.						
⊗ = .250 R.						
* =						
		PART NAME:		BULL NOSE MEDIUM STILE		

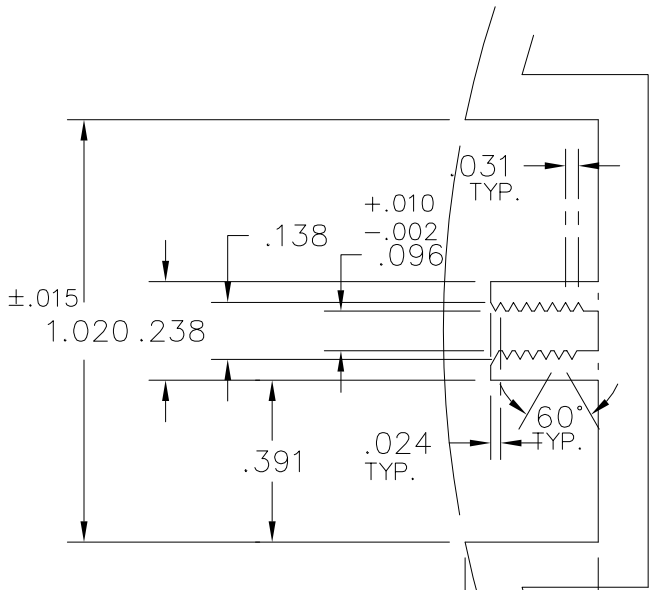
PRINT REVISIONS		DATE

12576

Die Number

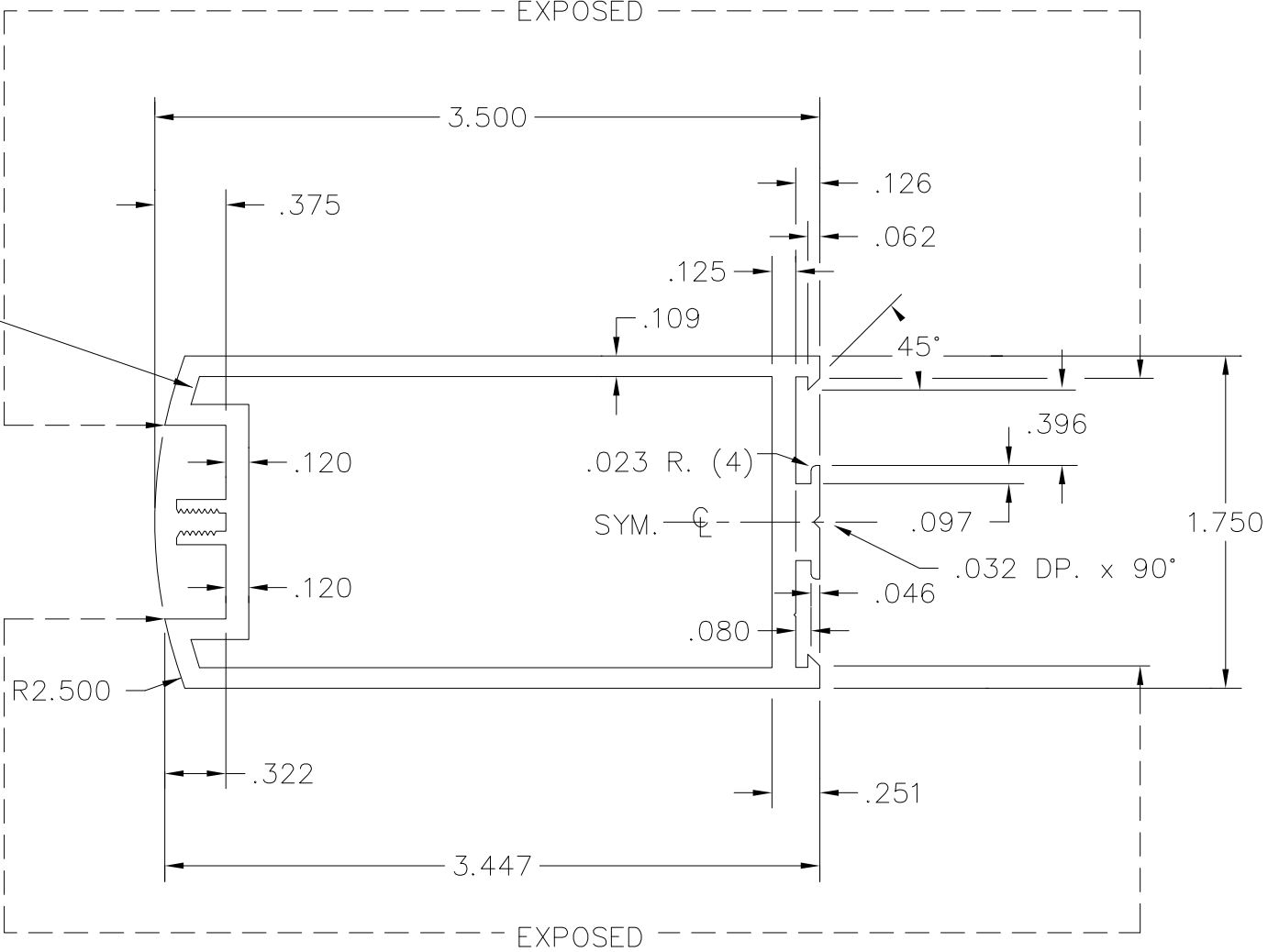
2434M

Customer Number

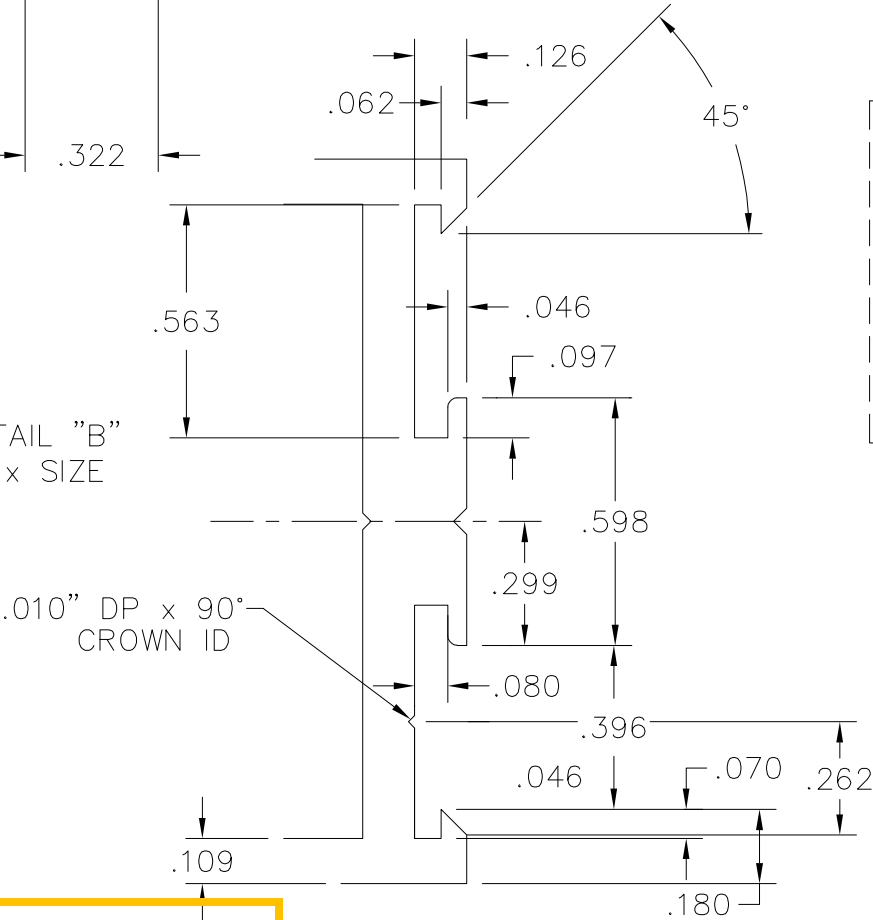


NOTE:
SYMMETRICAL EXCEPT FOR
SCREW RECEIVER AND I.D. MARK.

DETAIL "A"
2 x SIZE



DETAIL "B"
2 x SIZE



BREAK UNSPECIFIED CORNER: .010 R. TYPICAL WALL UNLESS OTHERWISE NOTED: .109



Report #: N8135.01-201-45
Date: 8/29/22
Verified by: 

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

ESTIMATED DIE DATA			
ALLOY/TEMPER:		6063-T5	
AREA	1.257	WT/FT	1.508
PERIMETER	23.002	CIRCLE SIZE	3 - 4
OUTSIDE PERIMETER	13.295	FACTOR	15
EXPOSED PERIMETER	7.664	HOLLOW	

PRESS SIZE	LEGEND		DIE REVISIONS		DATE
	•	= .031 R.			
	◦	= .062 R.			
	x	= .125 R.			
	⊗	= .250 R.			
	*	=			



Crown Extrusions, Inc.
122 Columbla Court N.
Chaska, MN 55318
952-448-3533 Fax: 952-448-5328

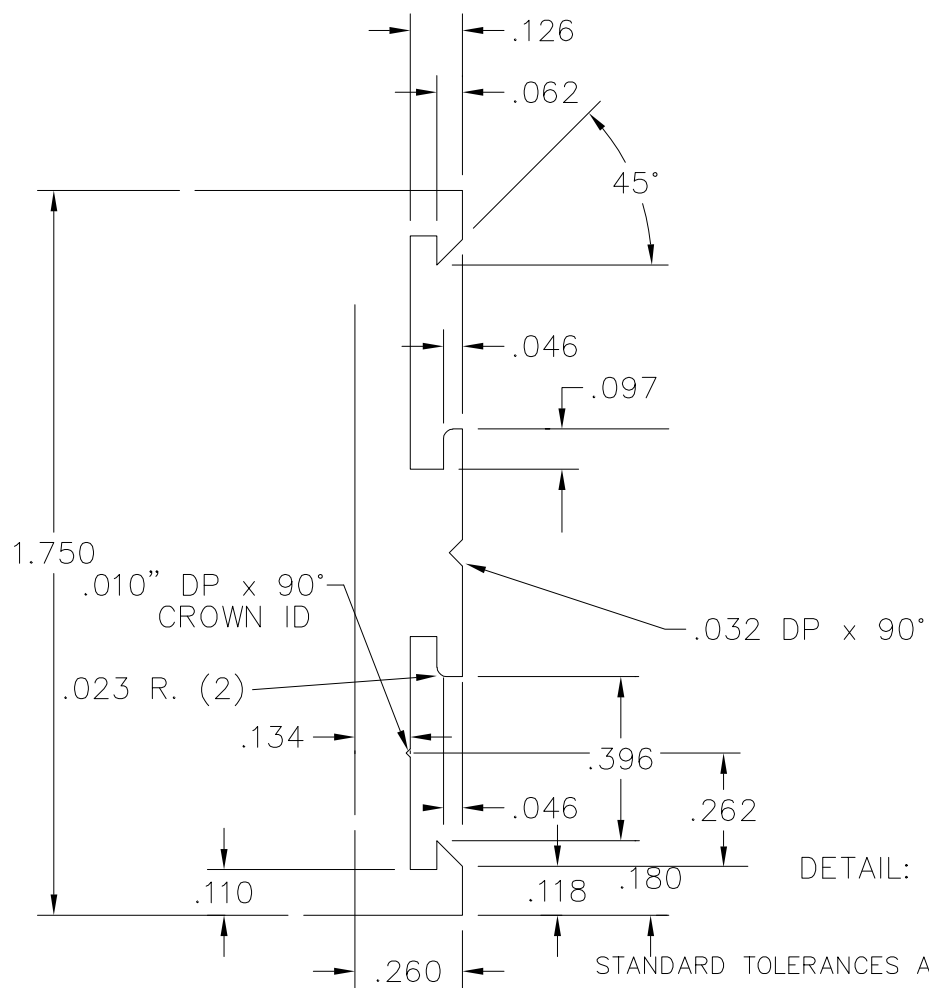
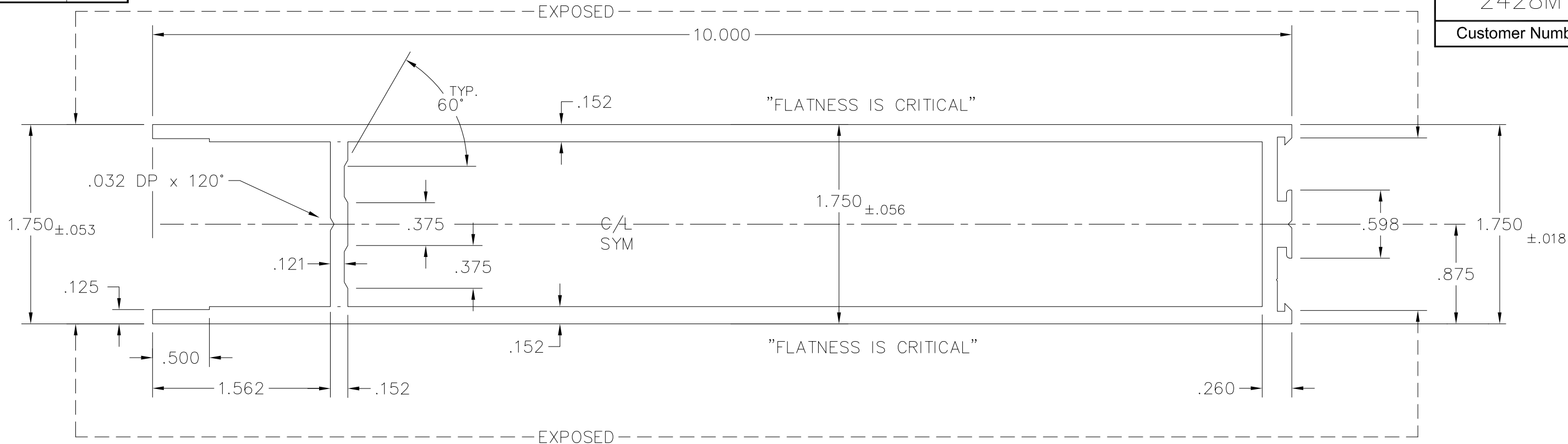
CUSTOMER
CMI Architectural
CMI Architectural Products, Inc.
20621 SD Highway 25
DeSmet, SD 57231-5827
605-854-3326 Fax: 605-854-3620

PART NAME:
MEDIUM BULL NOSE STILE W/ ASTRIGAL

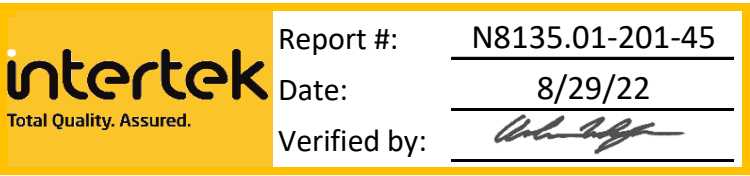
DIE #	12576
SCALE	ACTUAL & NOTED
DATE	12-11-08
LAST REVISION	
DRAWN	TCG
CUSTOMER NUMBER	2434M

PRINT REVISIONS		DATE

12573
Die Number
2428M
Customer Number



ACTUAL SIZE



BREAK UNSPECIFIED CORNER: .010 R. TYPICAL WALL UNLESS OTHERWISE NOTED: -----

PRESS SIZE LEGEND • = .031 R. ○ = .062 R. × = .125 R. ⊗ = .250 R. * =		ESTIMATED DIE DATA		 CROWN EXTRUSIONS Crown Extrusions, Inc. 122 Columbia Court N. Chaska, MN 55318 952-448-3533 Fax: 952-448-5328	DIE #	12573
		ALLOY/TEMPER: 6063-T5			SCALE	ACTUAL & NOTED
		AREA 3.458	WT/FT 4.149			
		PERIMETER 46.725	CIRCLE SIZE 10 - 11			
		OUTSIDE PERIMETER 27.747	FACTOR 11			
EXPOSED PERIMETER 20.236		HOLLOW		CUSTOMER	 CMI Architectural Products, Inc. 20621 SD Highway 25 DeSmet, SD 57231-5827 605-854-3326 Fax: 605-854-3620	
LEGEND		DIE REVISIONS		DATE	PART NAME:	
					10" BOTTOM RAIL	
					</	

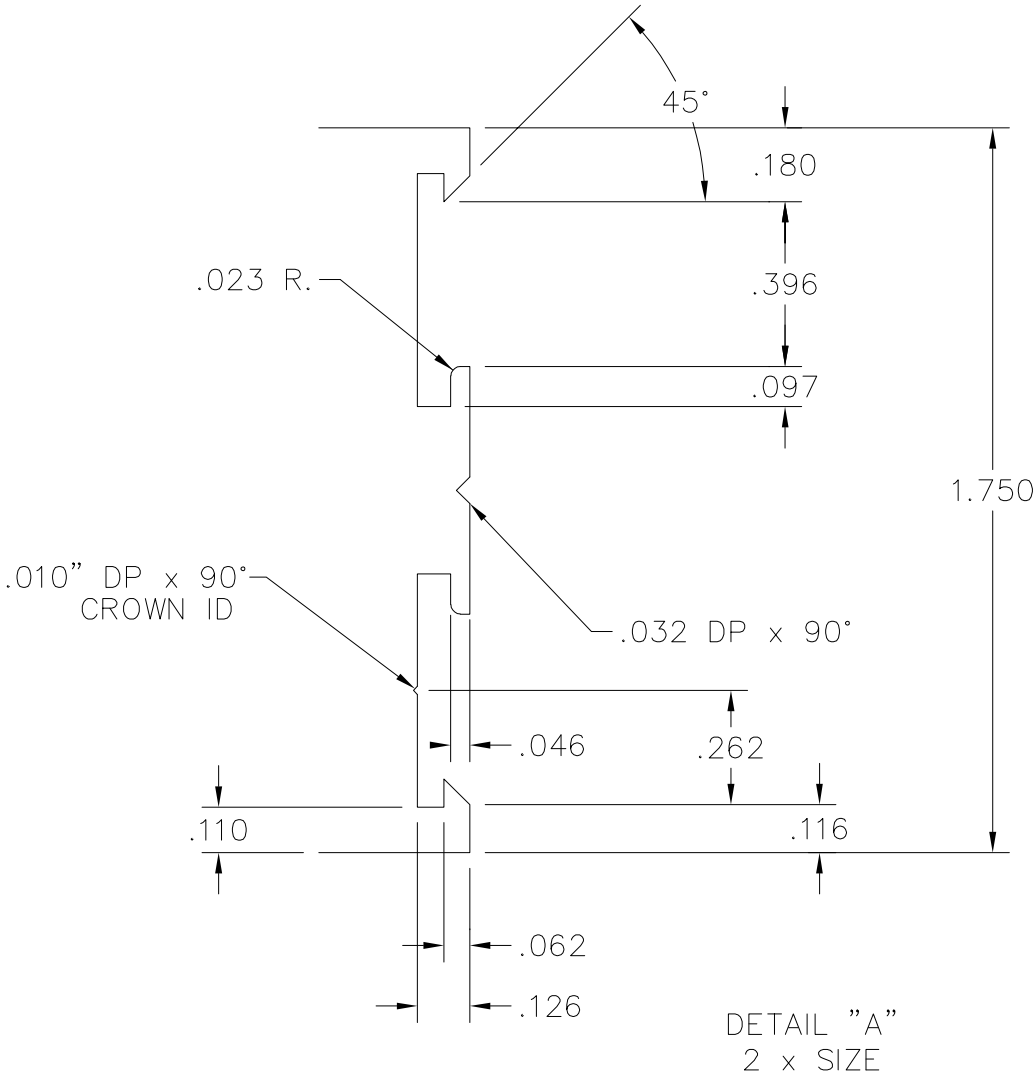
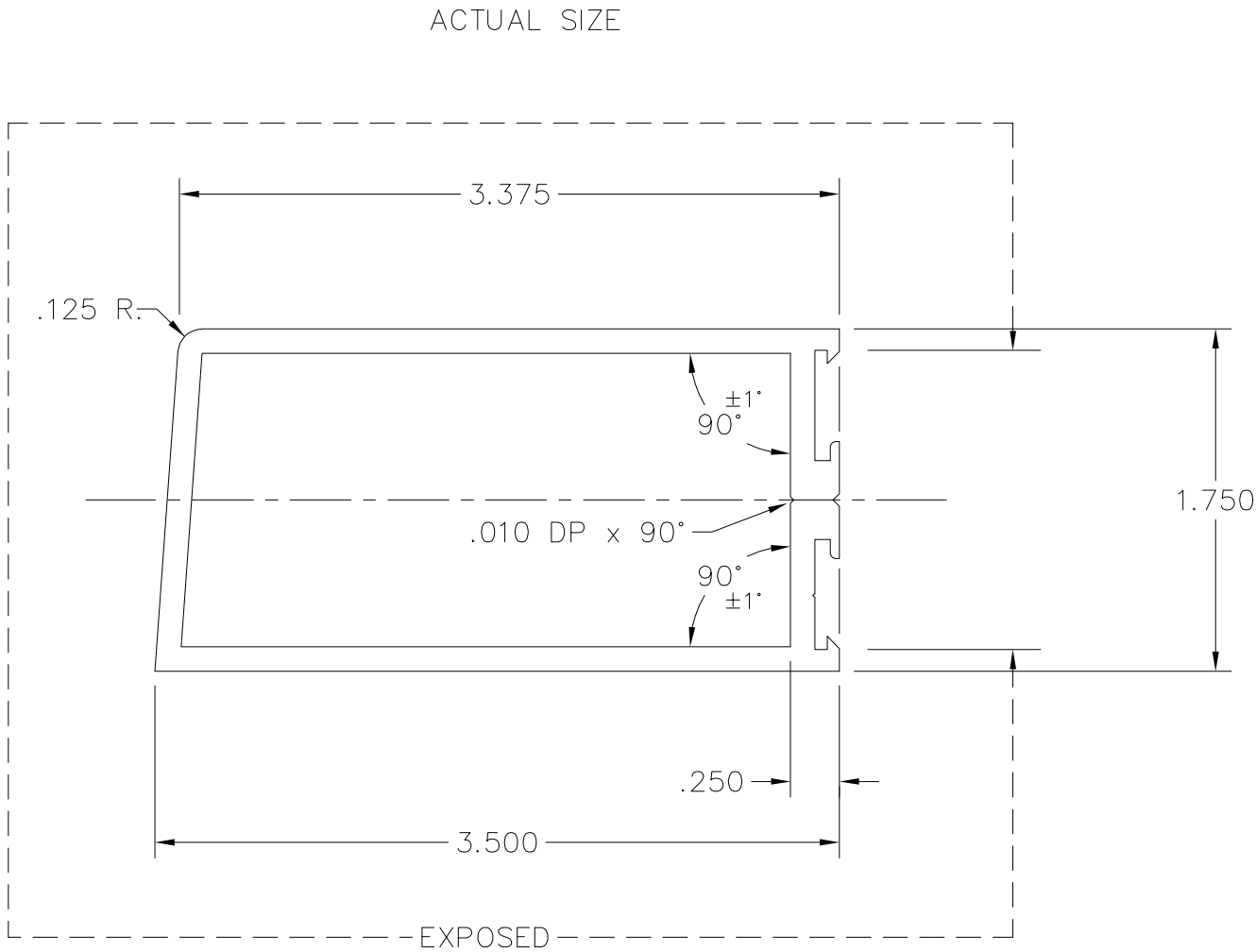
PRINT REVISIONS		DATE

12571

Die Number

2422M

Customer Number



STRAIGHTNESS & TWIST ARE CRITICAL!

BREAK UNSPECIFIED CORNER: .015 R. TYPICAL WALL UNLESS OTHERWISE NOTED: .125



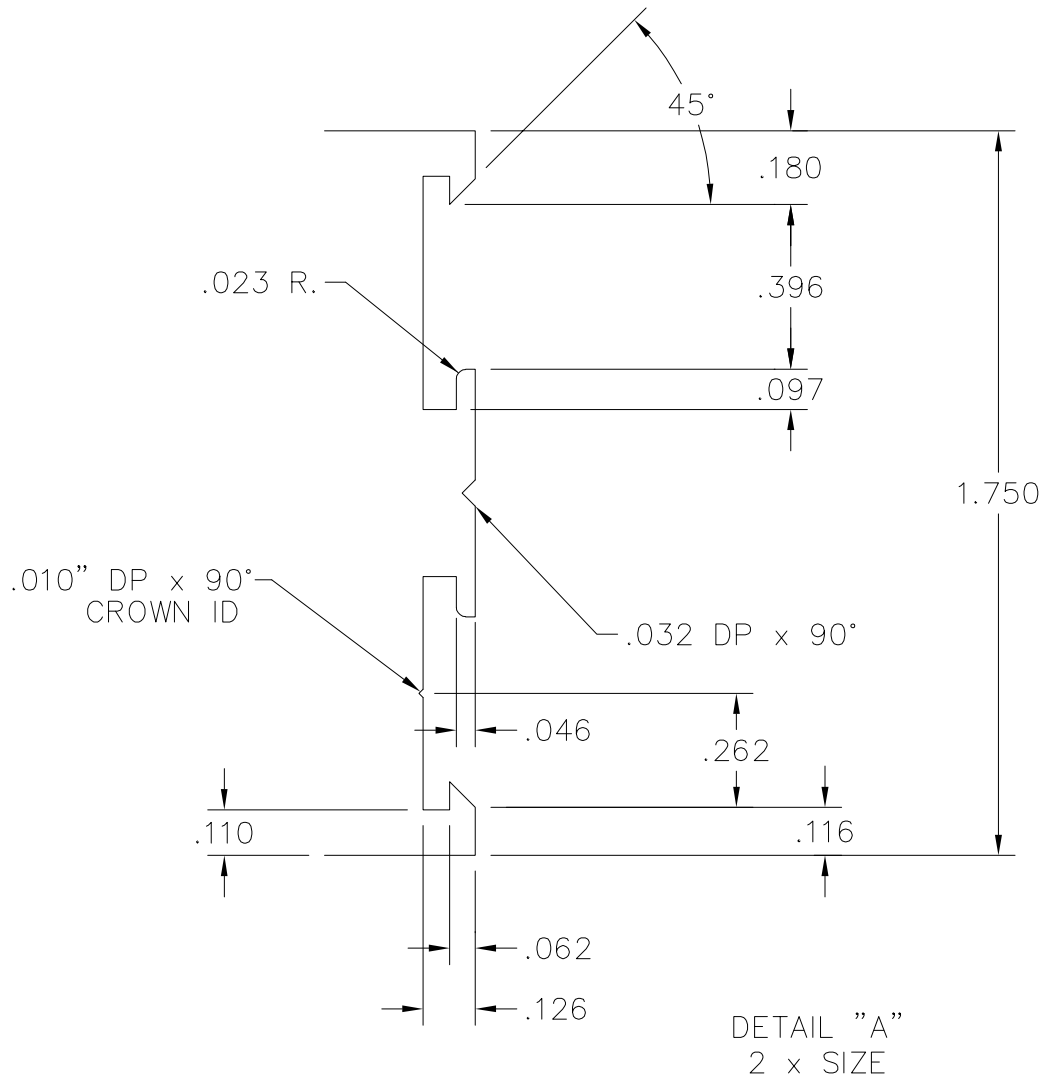
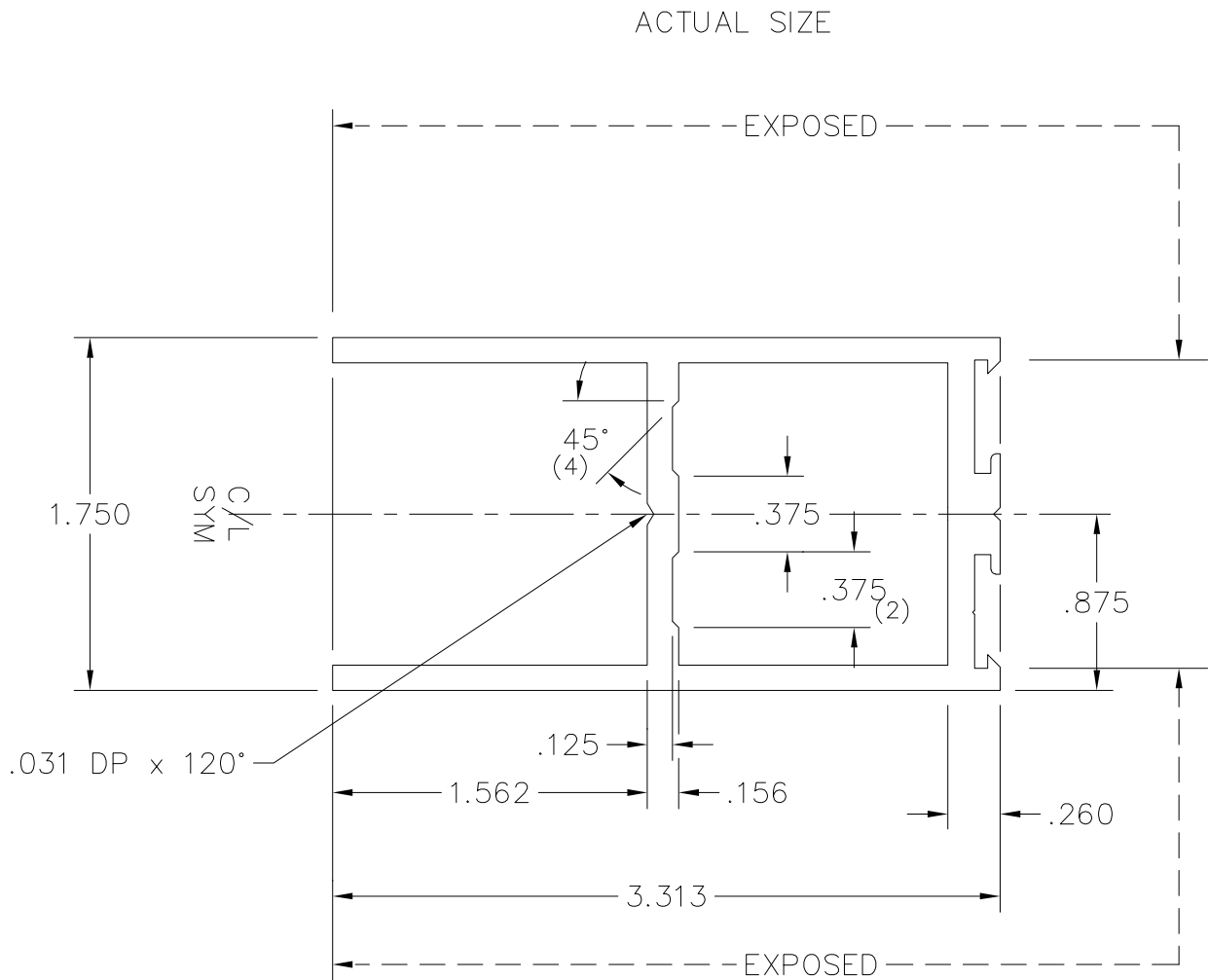
Report #: **N8135.01-201-45**
Date: **8/29/22**
Verified by: *[Signature]*

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

		ESTIMATED DIE DATA		 Crown Extrusions, Inc. 122 Columbla Court N. Chaska, MN 55318 952-448-3533 Fax: 952-448-5328	DIE #
		ALLOY/TEMPER: 6063-T5			12571
		AREA 1.290	WT/FT 1.548		SCALE
		PERIMETER 20.574	CIRCLE SIZE 3 - 4		FULL & NOTED
		OUTSIDE PERIMETER 11.432	FACTOR 13		DATE
PRESS SIZE	EXPOSED PERIMETER 8.816	HOLLOW			12-11-08
LEGEND		DIE REVISIONS		CUSTOMER	LAST REVISION
• = .031 R.				 CMI Architectural Products, Inc. 20621 SD Highway 25 DeSmet, SD 57231-5827 605-854-3326 Fax: 605-854-3620	DRAWN
◦ = .062 R.					TCG
× = .125 R.					CUSTOMER NUMBER
⊗ = .250 R.					2422M
* =					
				PART NAME:	
				BEVELED MEDIUM STILE	

PRINT REVISIONS		DATE

12568
Die Number
1349M
Customer Number



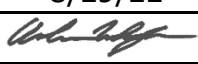
STRAIGHTNESS & TWIST ARE CRITICAL!

BREAK UNSPECIFIED CORNER: .015 R. TYPICAL WALL UNLESS OTHERWISE NOTED: .125



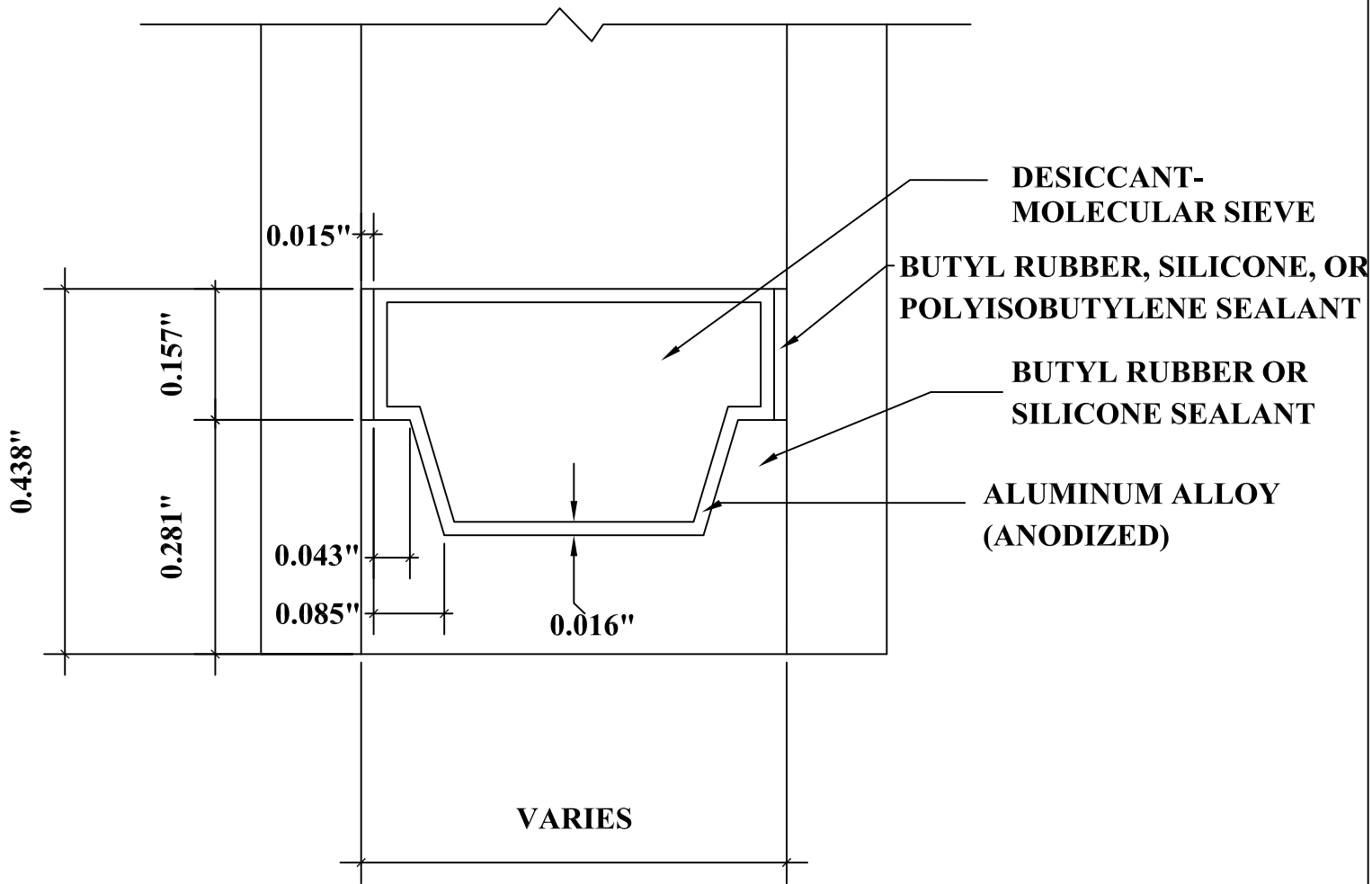
Report #: **N8135.01-201-45**

Date: **8/29/22**

Verified by: 

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

		ESTIMATED DIE DATA			 Crown Extrusions, Inc. 122 Columbla Court N. Chaska, MN 55318 952-448-3533 Fax: 952-448-5328	DIE # 12568	
		ALLOY/TEMPER: 6063-T5				SCALE FULL & NOTED	
		AREA 1.298	WT/FT 1.558	CUSTOMER  CMI Architectural Products, Inc. 20621 SD Highway 25 DeSmet, SD 57231-5827 605-854-3326 Fax: 605-854-3620		DATE 12-11-08	
		PERIMETER 20.109	CIRCLE SIZE 3 - 4			LAST REVISION	
		OUTSIDE PERIMETER 14.363	FACTOR 13			DRAWN TCG	
PRESS SIZE	EXPOSED PERIMETER 6.858	HOLLOW		PART NAME: NARROW BOTTOM RAIL	CUSTOMER NUMBER 1349M		
LEGEND	DIE REVISIONS						
• = .031 R.							
◦ = .062 R.							
× = .125 R.							
⊗ = .250 R.							
* =							



DETAIL FOR THERMAL MODELING OF
ALUMINUM SPACER (A1-D)



Total Quality. Assured.

40 51st Way NE, Suite 100
Fridley, MN 55421

Telephone: 651-636-3835
Facsimile: 717-764-4129
www.intertek.com/building

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

Report No.: N8135.01-201-45 R0

Date: 08/25/22

SECTION 8

REVISION LOG

REVISION #	DATE	PAGES	REVISION
.01R0	08/25/22	N/A	Original Report Issued to CMI Architectural Products, Inc.