

CMI ARCHITECTURAL PRODUCTS, INC. COMPUTER SIMULATION REPORT

SCOPE OF WORK

351 MEDIUM STILE DOOR - ANSI/NFRC 100/200 and NFRC 500

REPORT NUMBER

N3185.02-201-45 R0

TEST DATE

08/25/22

ISSUE DATE

08/25/22

RECORD RETENTION END DATE

08/25/27

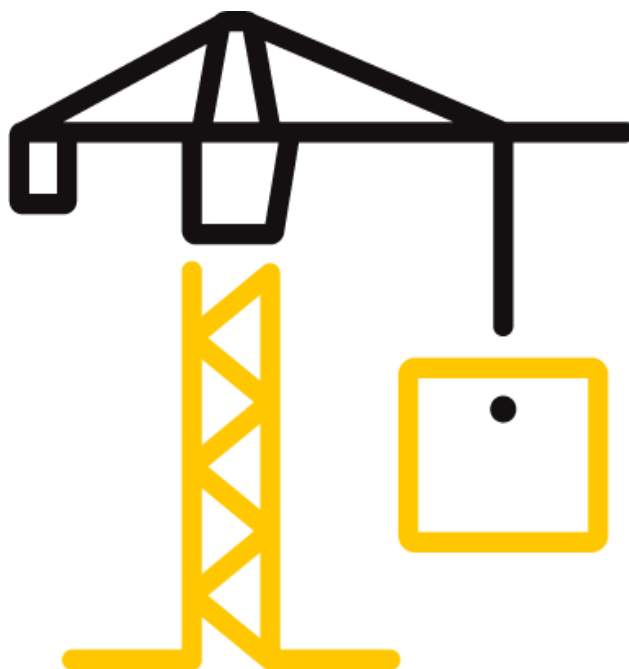
PAGES

23

DOCUMENT CONTROL NUMBER

RT-R-AMER-Test-4044 (01/16/19)

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Telephone: 651-636-3835
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TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

Report No: N3185.02-201-45 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 (B&C) was contracted to perform U-Factor, Solar Heat Gain Coefficient, Visible Transmittance and Condensation Resistance simulations in accordance with the National Fenestration Rating Council (NFRC).

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. Intertek B&C will service this report for the entire test record retention period. The test record retention period ends five years after the test date. Test records, such as detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation, will be retained for the entire test record retention period.

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:

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

NFRC 500-2017, Procedure for Determining Fenestration Product Condensation Resistance Values

**Condensation Resistance results obtained from this procedure are for controlled laboratory conditions and do not include the effects of air movement through the specimen, solar radiation, and the thermal bridging that may occur due to the specific design and construction of the fenestration system opening.*

Ratings values included in this report are for submittals to an NFRC-licensed IA and are not meant to be used directly for labeling purposes. Only those values identified on a valid Certificate of Authorization (CA) by an NFRC accredited Inspection Agency (IA) are to be used for labeling purposes. The ratings values were rounded in accordance with NFRC 601, NFRC Unit and Measurement Policy.

Intertek B&C is an NFRC accredited simulation laboratory and all simulations were conducted in full compliance with NFRC approved procedures and specifications. The values included in this report are not considered in compliance with ANSI/NFRC 100, ANSI/NFRC 200, and/or NFRC 500 unless the associated validation test requirements have been satisfied, as applicable.

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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
NFRC MATERIALS LIBRARY	NFRC 101-2020 [E1A11]

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.
- 3) Single door was used to represent single and double door assemblies per ANSI/NFRC 100-2020, table 4-3, note 5.

SECTION 4

SIMULATION SPECIMEN DESCRIPTION

SERIES/MODEL	351 Medium Stile Door
PRODUCT TYPE	Swinging Door, Single Leaf Entrance Door
FRAME MATERIAL	AT - Aluminum w/ Thermal Breaks - All Members
SASH MATERIAL	AL - Aluminum (Non-thermally broken)
STANDARD SIZE	960mm x 2090mm

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

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SECTION 4 (Continued)
SIMULATION SPECIMEN DESCRIPTION

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

GRID OPTIONS		
GRID SIZE	GRID TYPE	GRID PATTERN
---	---	---

REINFORCEMENT OPTIONS	
LOCATION	MATERIAL
---	---

GAS FILLING TECHNIQUE	
FILL TYPE	METHOD
94.83% Xenon	Dual Probe w/ Concentration Sensor
74.78% Argon	Single Probe, Timed
91.89% Krypton	Dual Probe w/ Concentration Sensor
62.51% Argon	Single Probe, Timed
86.08% Argon	Single Probe, Timed
81.60% Xenon	Single Probe, Timed
94.54% Xenon	Dual Probe w/ Concentration Sensor
81.48% Krypton	Single Probe, Timed
71.52% Xenon	Single Probe, Timed

EDGE-OF-GLASS CONSTRUCTION	
INTERIOR CONDITION	EPDM Gasket
EXTERIOR CONDITION	EPDM Gasket

WEATHERSTRIPPING		
TYPE	QUANTITY	LOCATION
Mohair	1 Row	Head, Jambs

FRAME/SASH MATERIALS FINISH	
INTERIOR	Aluminum (painted)
EXTERIOR	Aluminum (painted)

VALIDATION MATRIX*	
PRODUCT LINE	REPORT NUMBER
---	---

*These products are part of a validation matrix. Only one is required for validation testing.

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

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SECTION 5

SPECIALTY PRODUCTS TABLE

The specialty products method allows the manufacturer to determine the overall product SHGC and VT for any glazing option. The center of glass SHGC and/or VT must be determined using WINDOW 7.4.14. The method calculates overall product SHGC and VT indexed on center of glass properties. All values used in the calculations are truncated to six decimal place precision.

	No Dividers	Dividers < 1	Dividers > 1
SHGC0	0.042097	0.044693	0.047075
SHGC1	0.554083	0.477580	0.412938
VT0	0.000000	0.000000	0.000000
VT1	0.511986	0.432887	0.360300

$$SHGC = SHGC0 + SHGCc (SHGC1 - SHGC0)$$

$$VT = VT0 + VTc (VT1 - VT0)$$

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SECTION 6
SIMULATION RESULTS

TOTAL PRODUCT CALCULATIONS (351 Medium Stile Door)												
Option Number	Pane Thickness 1 (in)	Gap Width 1 (in)	Pane Thickness 2 (in)	Gap Width 2 (in)	Pane Thickness 3 (in)	Gap Width 3 (in)	Pane Thickness 4 (in)	Gap Fill	Low-e (Surface #)	Tint	Spacer	Grid Type
	U-Factor (Btu/Hr-Ft2-F)			Solar Heat Gain Coefficient (SHGC) Grids (None / <1 / >=1)				Visible Transmittance (VT) Grids (None / <1 / >=1)		Condensation Resistance (CR)		
1	COG=0.3200											
	0.230	0.500	0.225					XEN95	0.331(#2)	CL	A1-D	N
	U-Factor 0.73			SHGC(N) 0.13				VT(N) 0.07		CR 48		
2	COG=0.3000											
	0.233	0.500	0.225					ARG75	0.166(#2)	CL	A1-D	N
	U-Factor 0.72			SHGC(N) 0.27				VT(N) 0.27		CR 48		
3	COG=0.2800											
	0.233	0.500	0.225					KRY92	0.166(#2)	CL	A1-D	N
	U-Factor 0.71			SHGC(N) 0.27				VT(N) 0.27		CR 48		
4	COG=0.2600											
	0.223	0.500	0.225					ARG63	0.035(#2)	CL	A1-D	N
	U-Factor 0.70			SHGC(N) 0.24				VT(N) 0.36		CR 48		
5	COG=0.2400											
	0.223	0.500	0.223					ARG86	0.035(#2) / 0.035(#3)	CL	A1-D	N
	U-Factor 0.69			SHGC(N) 0.23				VT(N) 0.32		CR 49		
6	COG=0.2200											
	0.223	0.500	0.223					XEN82	0.018(#2) / 0.018(#3)	CL	A1-D	N
	U-Factor 0.68			SHGC(N) 0.17				VT(N) 0.27		CR 49		
7	COG=0.2000											
	0.223	0.500	0.223					XEN95	0.018(#2) / 0.018(#3)	CL	A1-D	N
	U-Factor 0.67			SHGC(N) 0.17				VT(N) 0.27		CR 49		
8	COG=0.1800											
	0.223	0.250	0.003	0.250	0.225			KRY81/AIR	0.018(#2) / 0.76(#3) / 0.11(#4)	CL	A1-D	N
	U-Factor 0.66			SHGC(N) 0.17				VT(N) 0.29		CR 50		
9	COG=0.1600											
	0.223	0.250	0.003	0.250	0.223			XEN72/AIR	0.018(#2) / 0.76(#3) / 0.11(#4) / 0.018(#5)	CL	A1-D	N
	U-Factor 0.65			SHGC(N) 0.16				VT(N) 0.24		CR 50		



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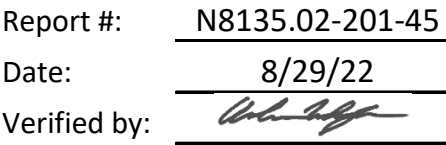
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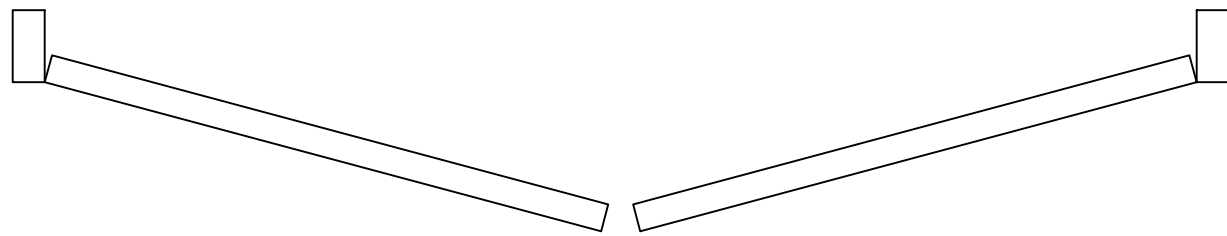
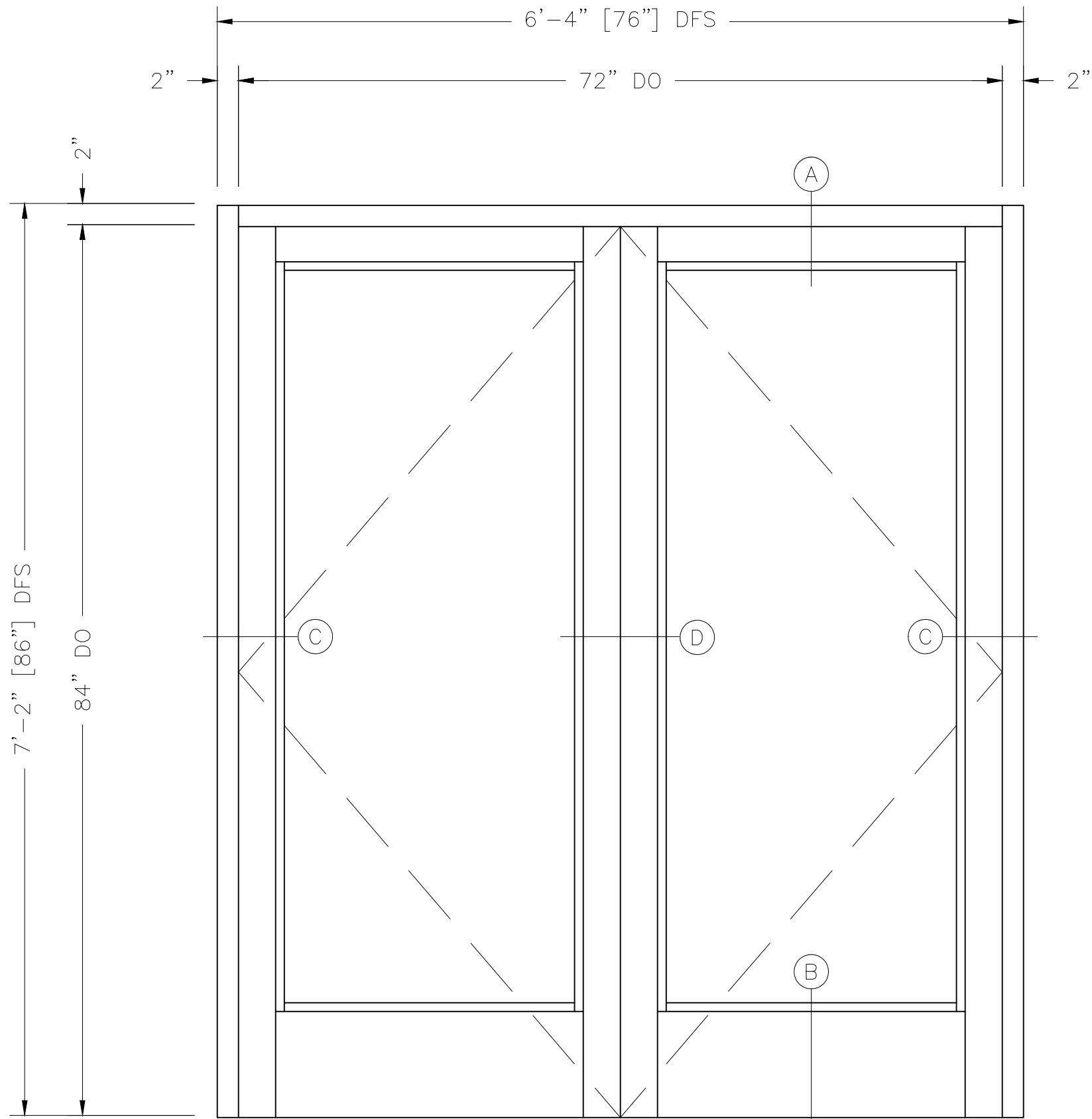
DRAWINGS / BILL OF MATERIALS

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



1

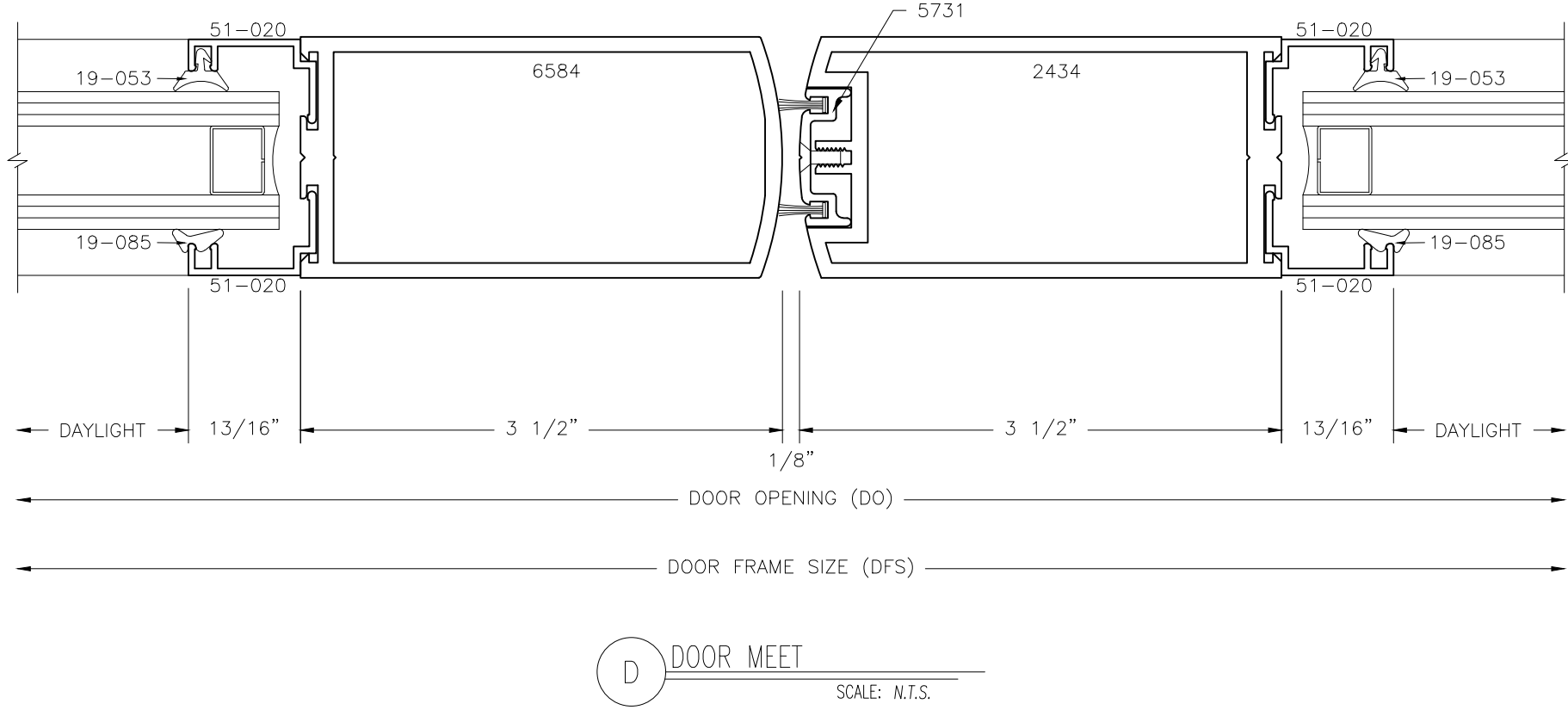
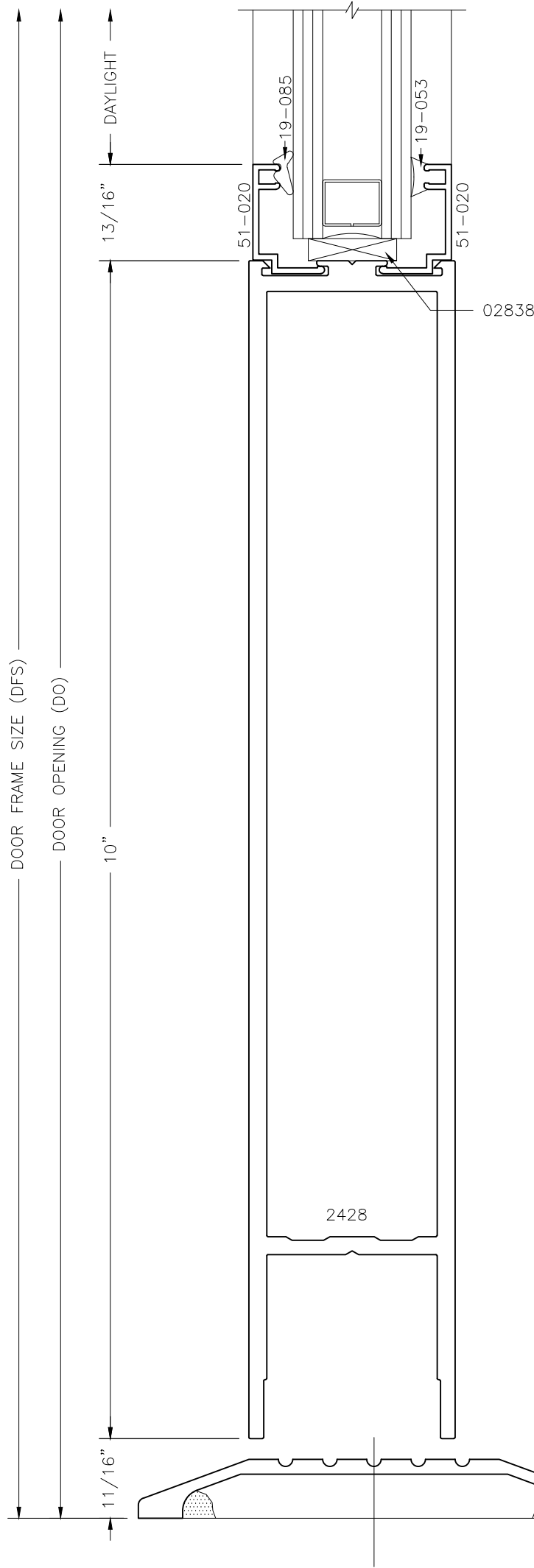
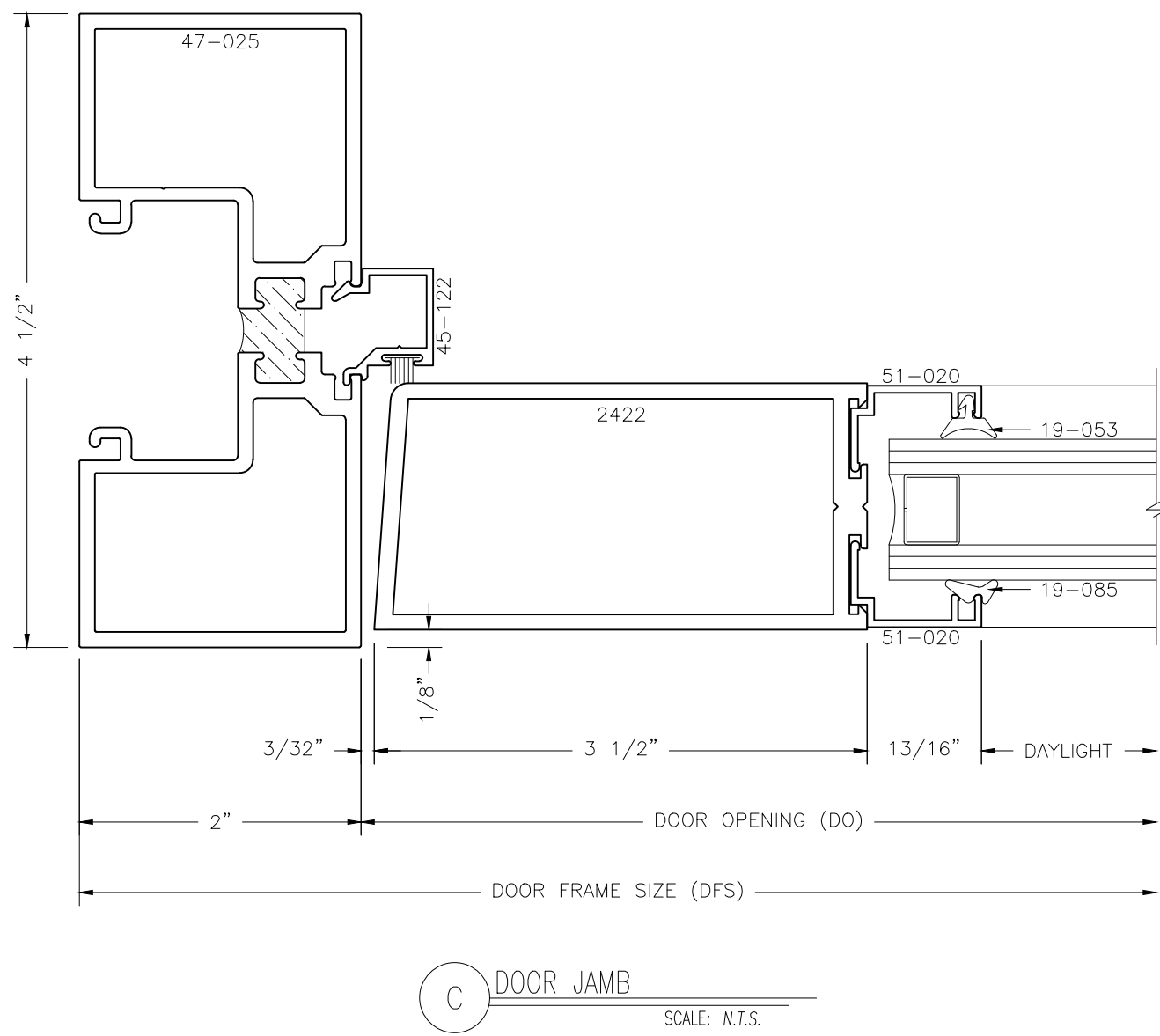
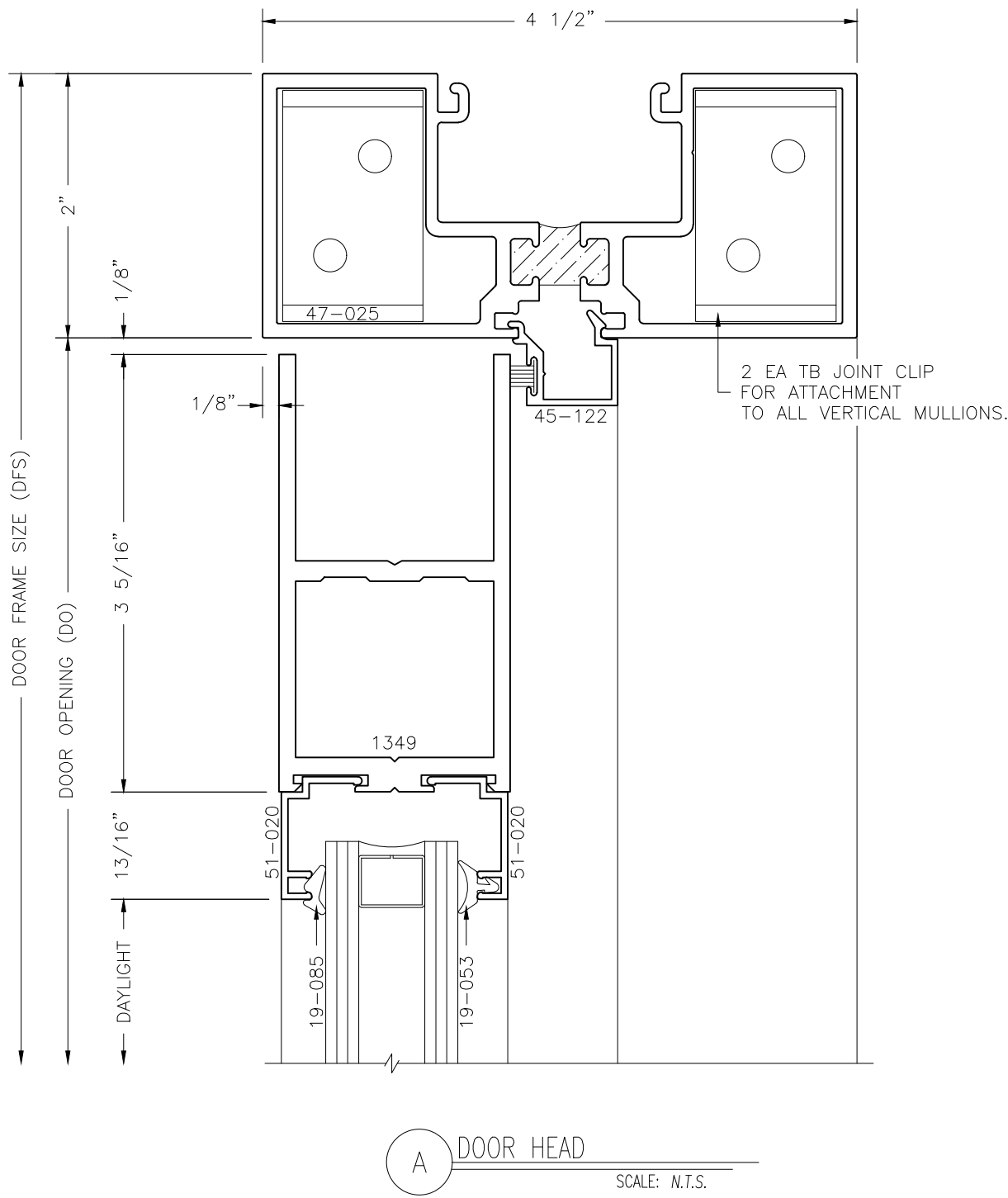




351 MEDIUM STILE – PAIR
45-025 FRAMING SCALE: N.T.S.

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

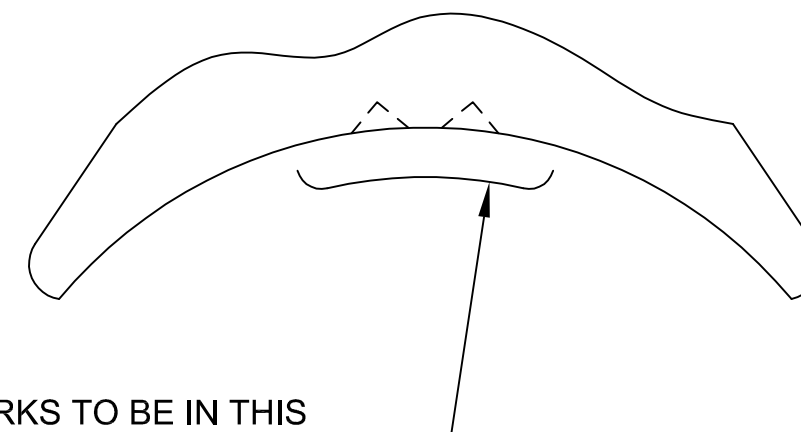
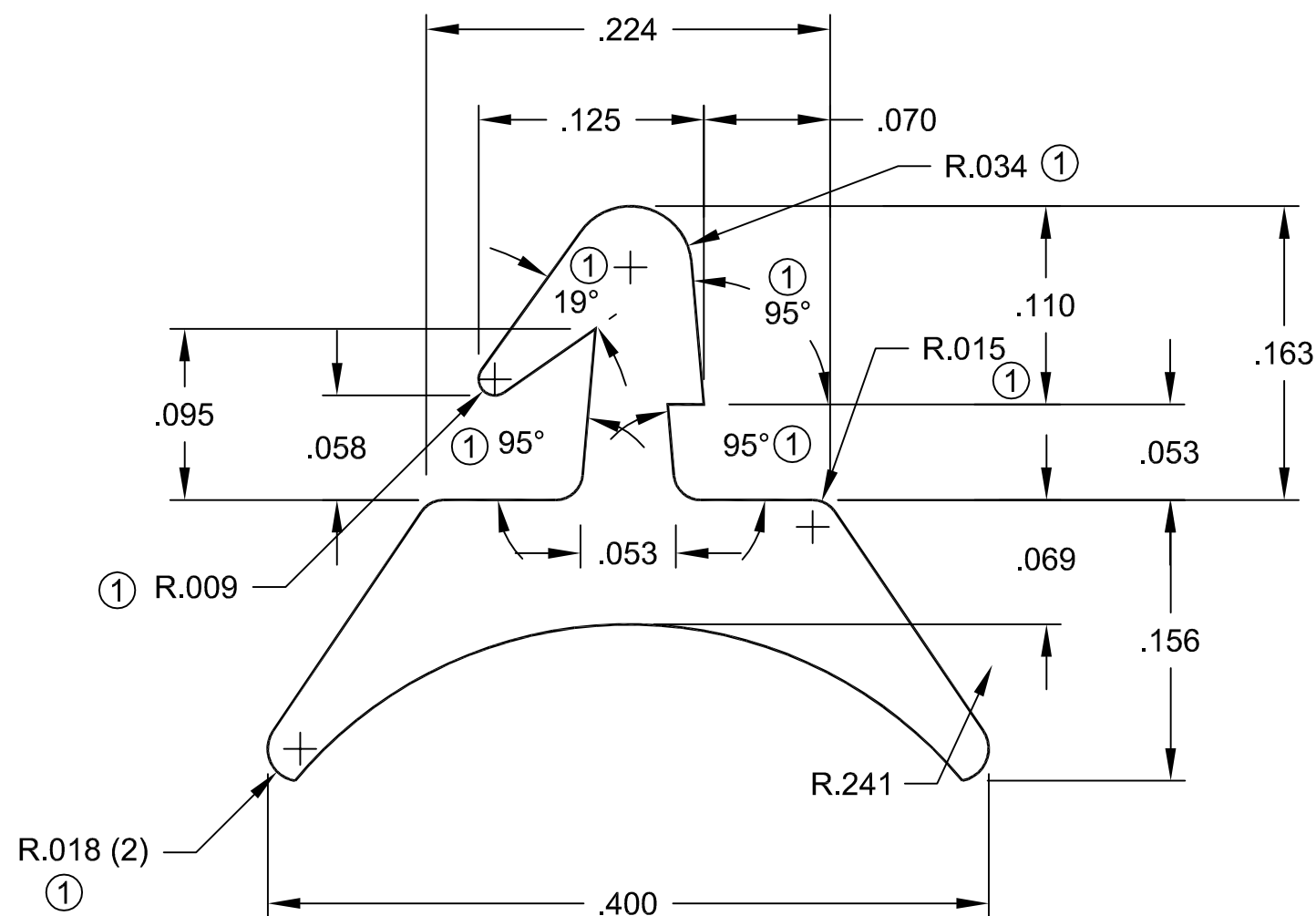
TESTING PARAMETERS:
AAMA 507: STANDARD PRACTICE FOR DETERMINING THE THERMAL PERFORMANCE CHARACTERISTICS OF FENESTRATION SYSTEMS INSTALLED IN COMMERCIAL BUILDINGS.
NFRC 100/200/500: PROCEDURES FOR DETERMINING FENESTRATION PRODUCT U-FACTORS, SOLAR HEAT GAIN COEFFICIENT, VISIBLE TRANSMITTANCE AT NORMAL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



REV	INT'L	DATE	DISCRPTION
A			

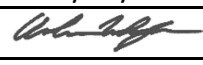


FULL SCALE



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



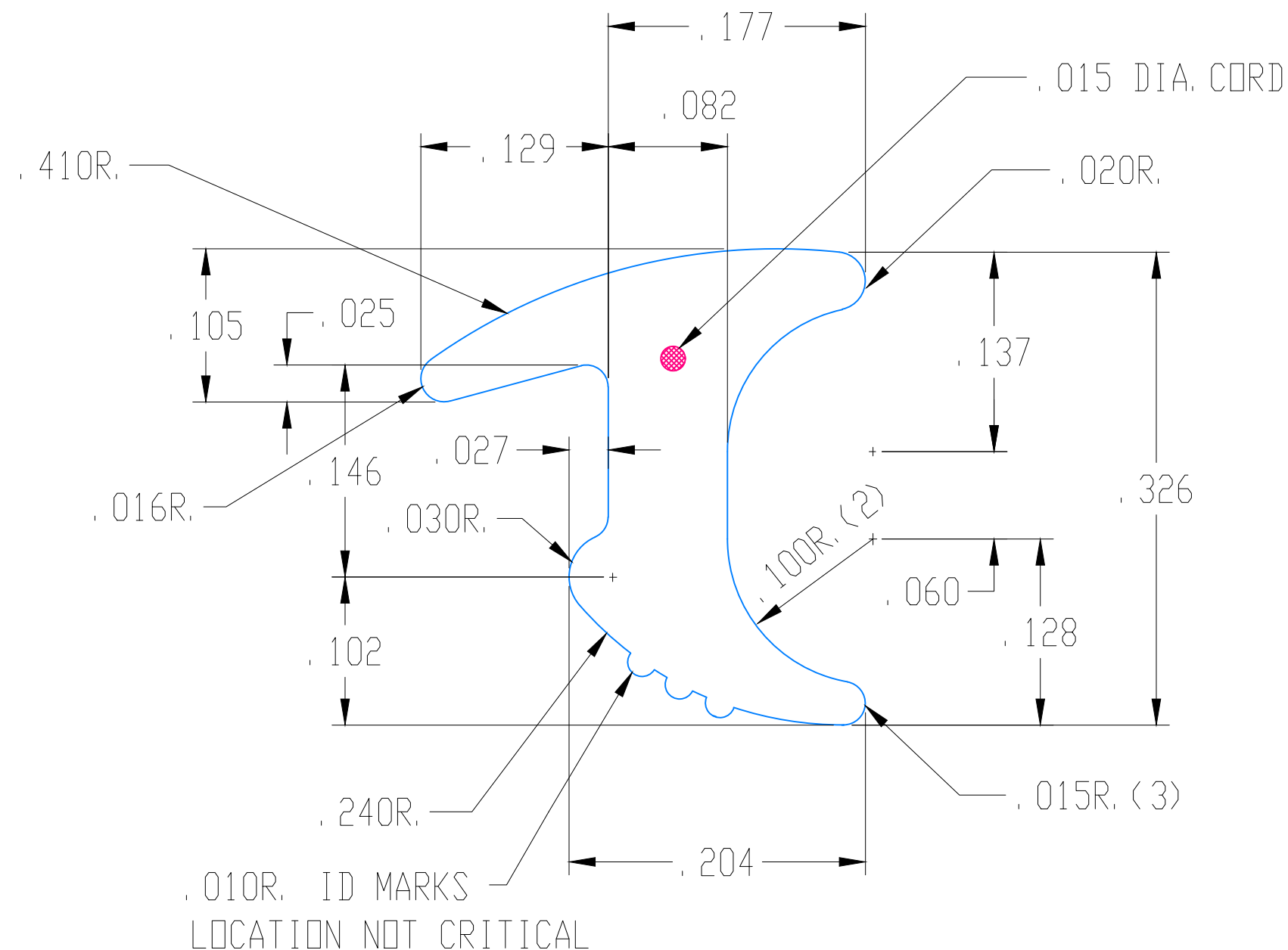
Report #: N8135.02-201-45
Date: 8/29/22
Verified by: 

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"		TREMCO 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"		Customer:				Customer Part No.
6.3"	- 10.0"	±.160"						
10.0"	- 16.0"	±.200"		CMI				19-053
16.0"	- 25.0"	±.250"						
25.0"	- 40.0"	±.400"		Project:				
40.0"	- 63.0"	±.500"						
63.0"	- 100.0"	±.630"		Drawn by: E. TANGO		Scale: 10X	Date: 6/13/2005	
100.0"	- 160.0"	±.800"		Compound: EPDM		Designed F.C. *.125	Drawing No. TR-13921E	
+160.0"		±.50%		Durometer: 70 ±5		Area: .039		



FULL SIZE



NOTE: PROFILE TO BE SILICONE COATED

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.
DUROMETER	70±5	AREA .0420	TR-1965E



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N8135.02-201-45

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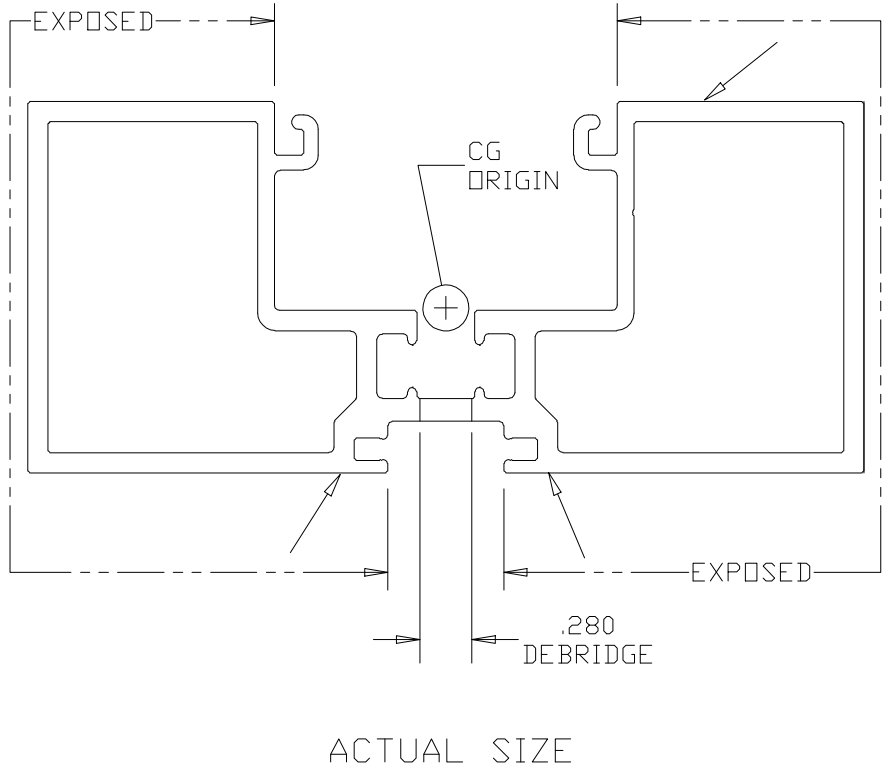
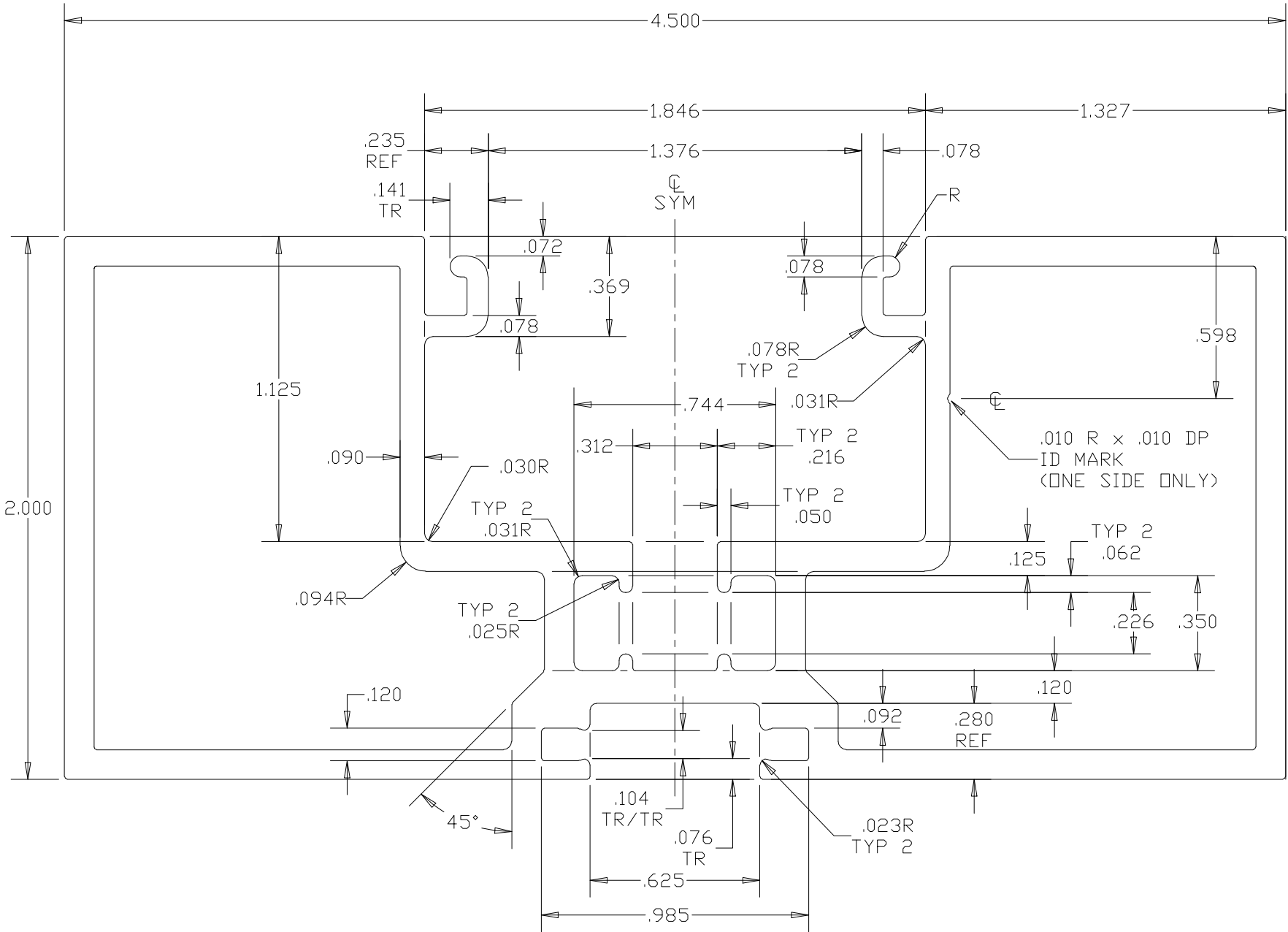
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THE DESIGN OF THE GASKET SHOWN HEREIN IS THE PRODUCT OF TREMCO, INC. NO REPRODUCTION OR USE OF THIS DESIGN IS AUTHORIZED WITHOUT THE CONSENT OF TREMCO.

Standard Aluminum Association tolerances apply unless otherwise noted.			DIE NUMBER	REV
CUST PART #: 47025		TITLE BLOCK: REV A	EUC	CRO-8364
CUST PART NAME: THERMAL DOOR FRAME		DIM AND TOL BLOCK REMOVED	151	
PROPOSAL:	REL. DATE 3-13-12 TMB	ALLOY 6063-T5		FINISH VEL



WARRANTY:
Bonnell warrants that the product(s) supplied by Bonnell shall be free from defects in workmanship and material and shall conform to all descriptions and specifications, as agreed between Bonnell and Purchaser. BONNELL DISCLAIMS ANY OTHER WARRANTY, EXPRESS OR IMPLIED, WHETHER CREATED BY CONTRACT, BY STATUTE OR OTHERWISE BY OPERATION OF LAW, INCLUDING ALL WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.
PURCHASER'S DESIGNS, PLANS, DRAWINGS, SPECIFICATIONS AND REQUIREMENTS.
For any product that is not included in Bonnell's standard product line offered for sale generally in the usual course of Bonnell's business, it is agreed that Purchaser has engaged Bonnell to manufacture such product to Purchaser's specifications and requirements. Bonnell shall not be responsible for the adequacy of prints, drawings, specifications and requirements respecting such product or for the adequacy of the design represented thereby. Bonnell also shall not be responsible for the adequacy of the materials incorporated in such product or for testing or otherwise determining the sufficiency and applicability of the design. Bonnell shall not be responsible for determining or assuring that such product or the use or application of such product conforms with applicable federal, state or local laws, rules or regulations. Bonnell's only warranty with respect to such products shall be as set forth above: All Designs, plans, prints, or drawings of whatever kind prepared by Bonnell with respect to such products are and shall remain the sole property of Bonnell.

CRO-8364

12343

CMI ARCHITECTURAL PRODS, INC.
608 4th STREET S.E.
P.O. BOX T

DE SMET SD 57231



UNSPECIFIED WALLS:	2.77 mm	MASS:	3.264 kg/m	2.194 lb/ft
	.109 in	EST PER:	859.43 mm	33.836 in
UNSPECIFIED RADII:	.25R mm	OUT PER:	517.20 mm	20.362 in
	.010R in	EXP PER:	mm	in
DATE:	3-8-12	BUFF PER:	mm	in
DRAWN:	JMK/TMB	BUFF TURNS:	CLASS:	Hollow III
SCALE:	2:1	FACTOR:	263 metric	15 imperial
THM BAR:	NO	C.C.D.:	125.08 mm	4.924 in
P&D CODE:	EES	P&D AREA:	182.58 mm ²	.283 in ²

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Thickness Tolerance Chart (t)
Date: 8/29/22

File Sizes Less than 10:

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Structural values estimated for reference only.

Up th	.008	0.750	0.999	1.526 x 10 ³ mm ³			.825 in ³	Sy:	27.683 x 10 ³ mm ³	1.689 in ³
0.125 - 0.249	.007	0.500 - 0.749	.009	hollows 10% .010 min .060 max	CGx:	28.22 mm	1.111 in	CGy:	57.15 mm	2.250 in

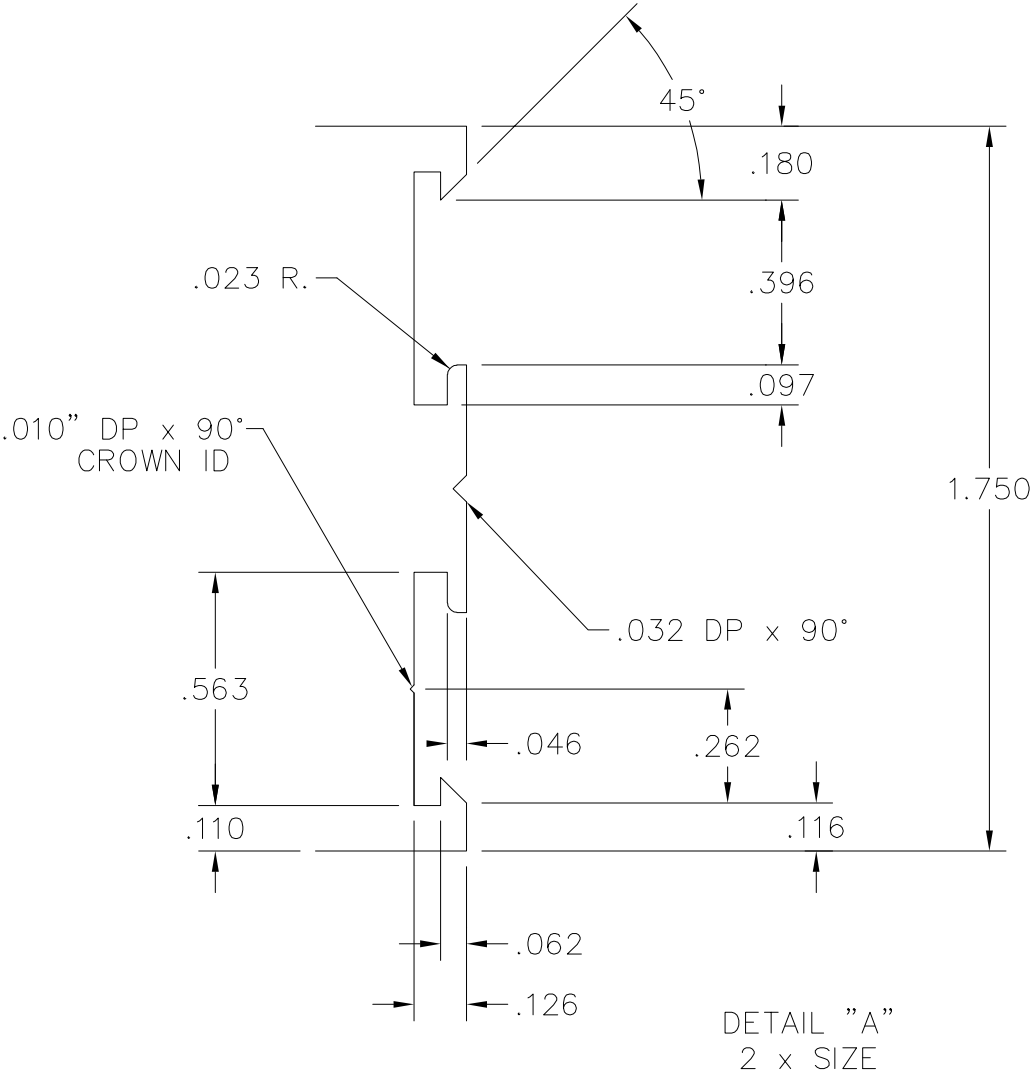
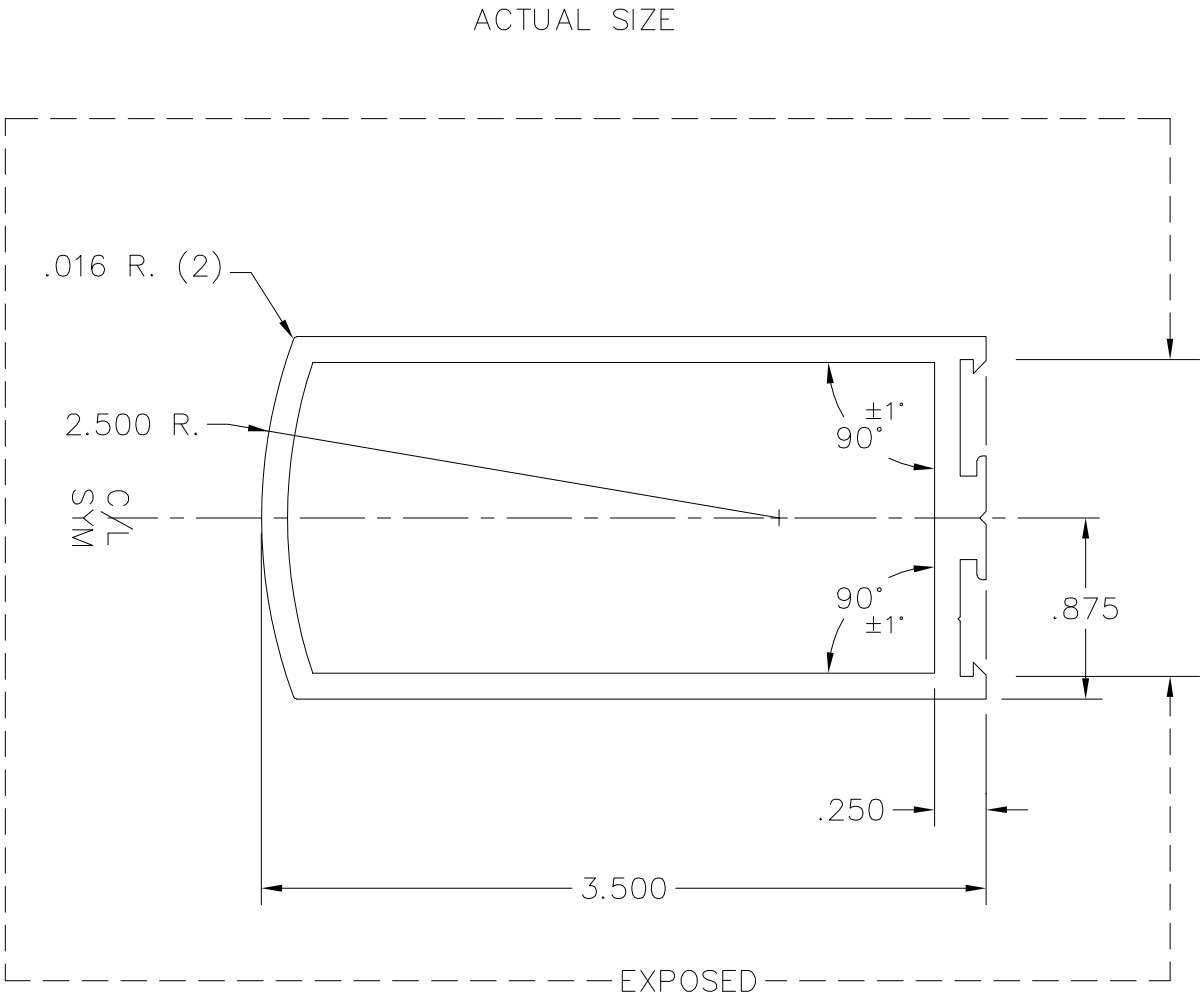
PRINT REVISIONS		DATE

12577

Die Number

6584M

Customer Number



STRAIGHTNESS & TWIST ARE CRITICAL!

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

ESTIMATED DIE DATA			
ALLOY/TEMPER:		6063-T5	
AREA	1.277	WT/FT	1.532
PERIMETER	20.360	CIRCLE SIZE	3 - 4
OUTSIDE PERIMETER	11.314	FACTOR	13
EXPOSED PERIMETER	8.698	HOLLOW	

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

DIE REVISIONS		DATE



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:

BULL NOSE MEDIUM STILE

DIE #

12577

SCALE

FULL & NOTED

DATE

12-11-08

LAST REVISION

DRAWN

TCG

CUSTOMER NUMBER

6584M



Report #: N8135.02-201-45
Date: 8/29/22
Verified by: [Signature]

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

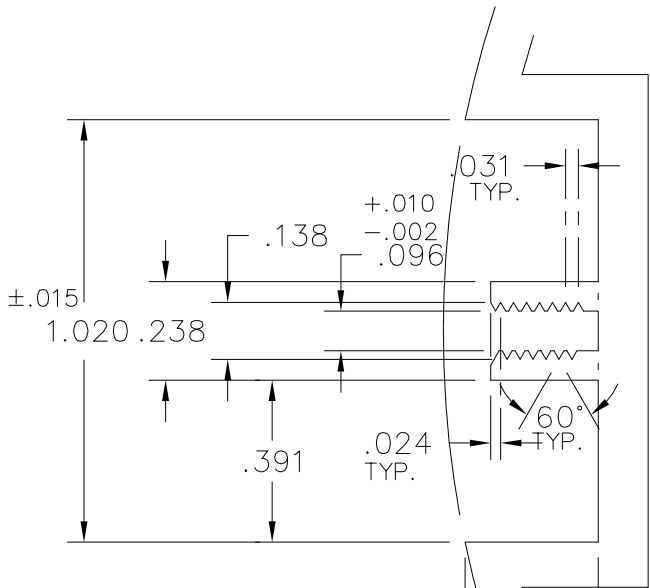
PRINT REVISIONS		DATE

12576

Die Number

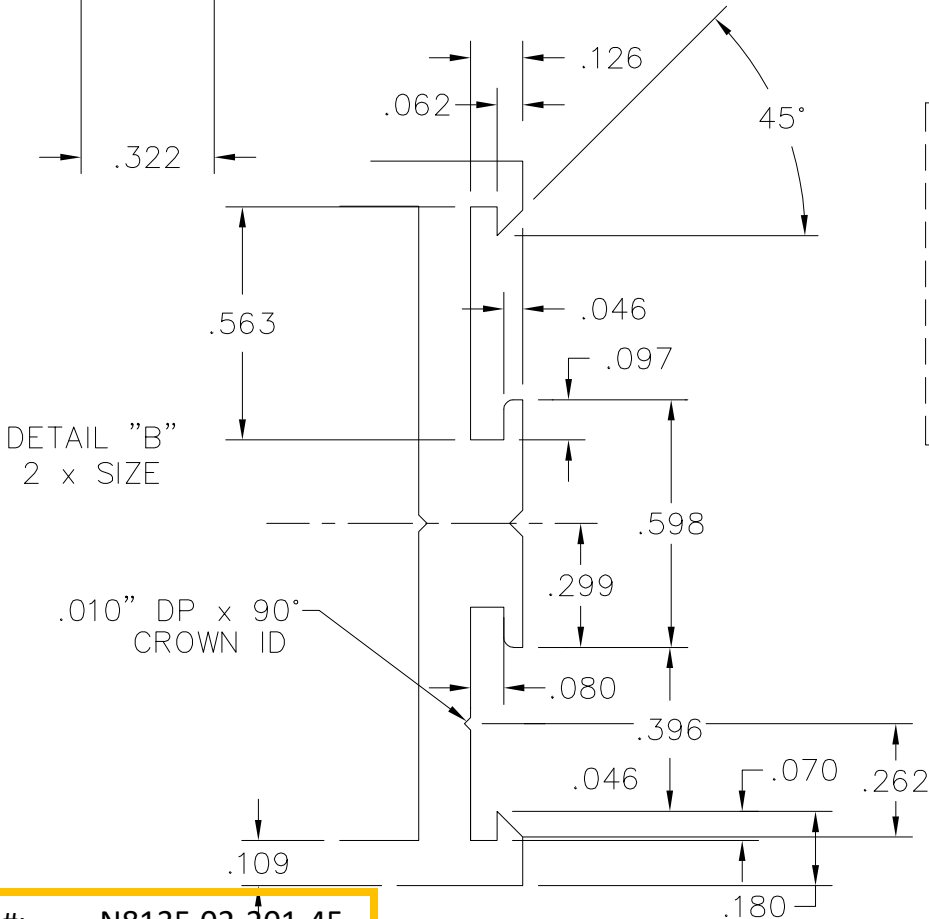
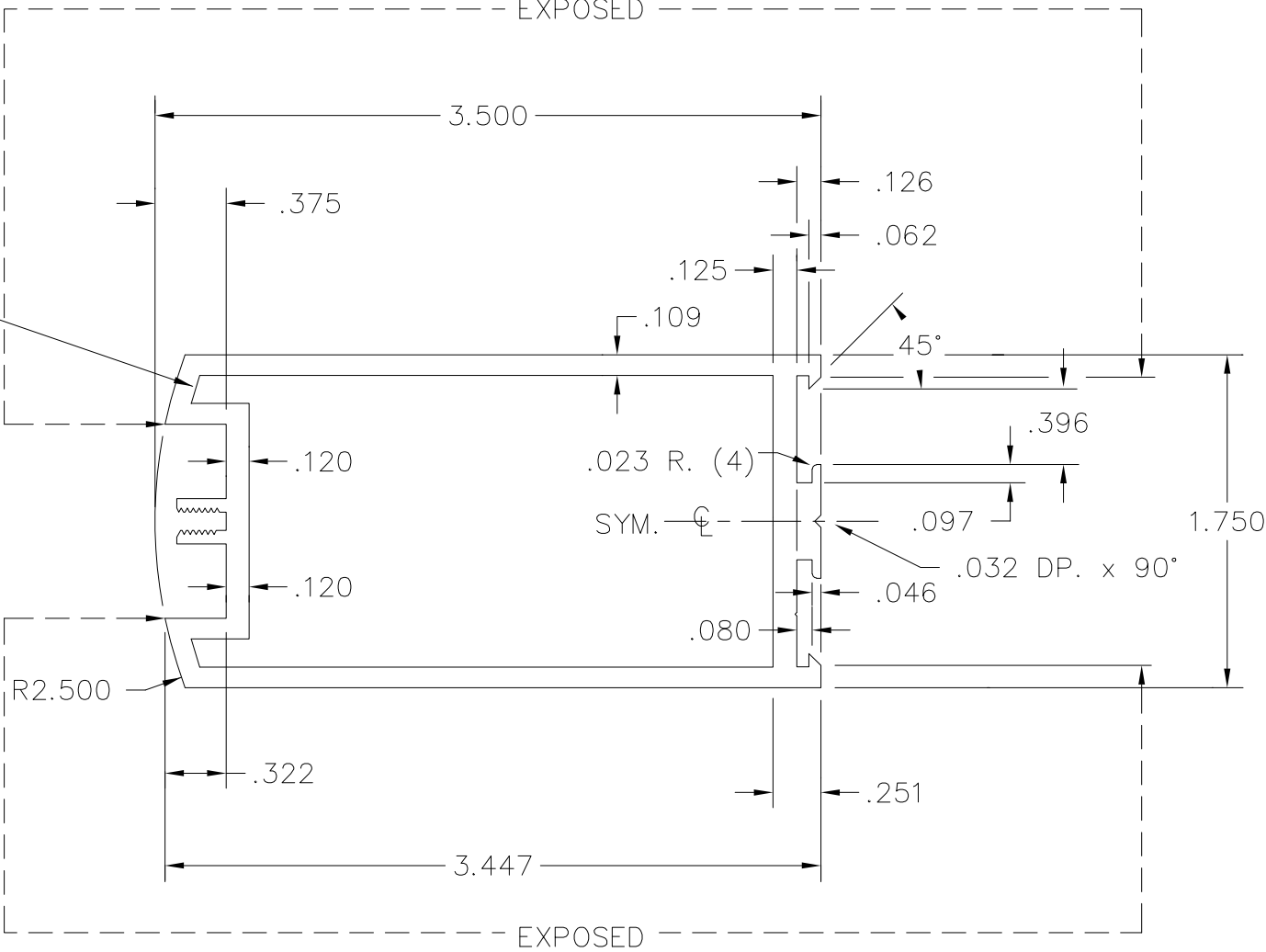
2434M

Customer Number



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

DETAIL "A"
2 x SIZE



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

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

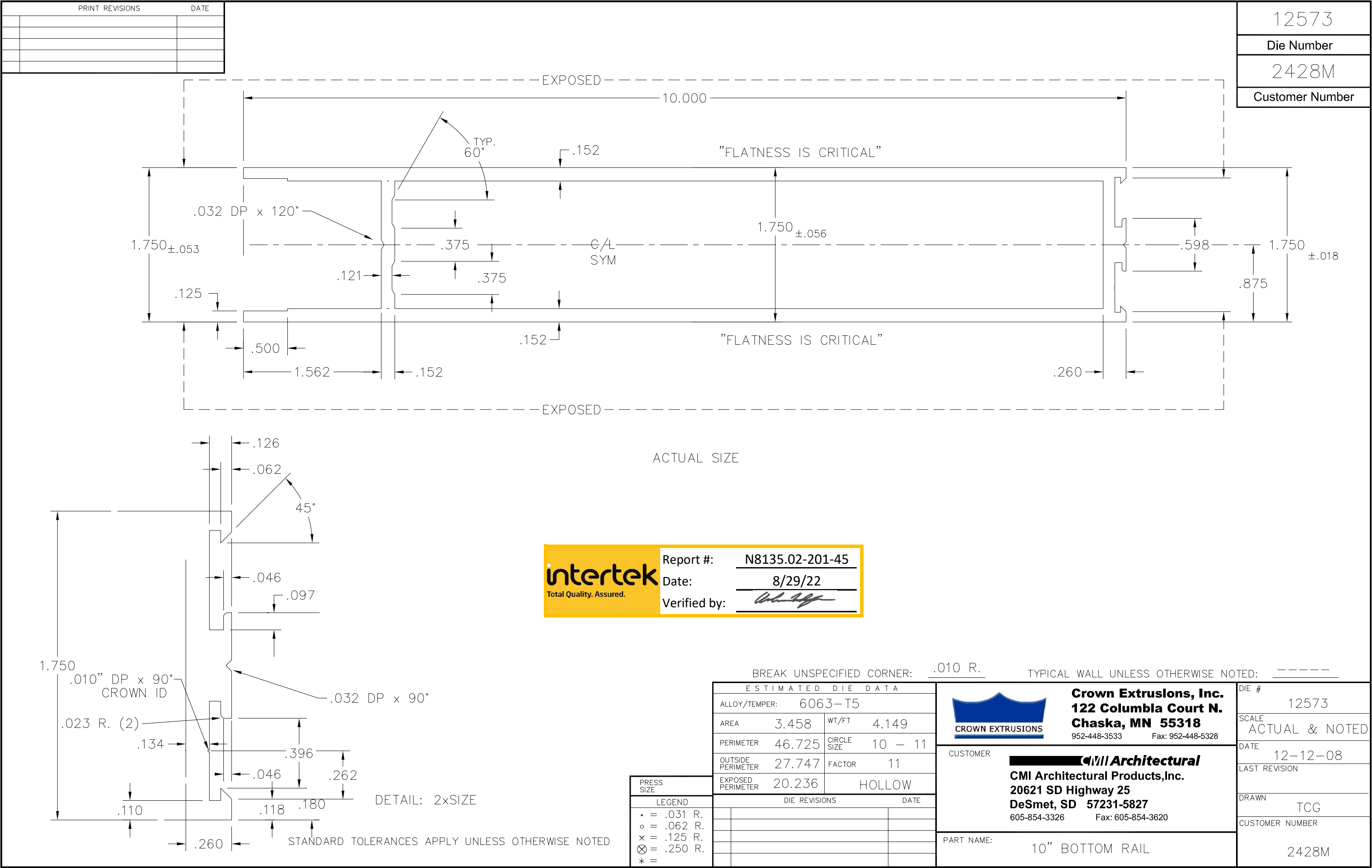
CUSTOMER NUMBER

2434M



Report #: **N8135.02-201-45**
Date: **8/29/22**
Verified by: *[Signature]*

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED



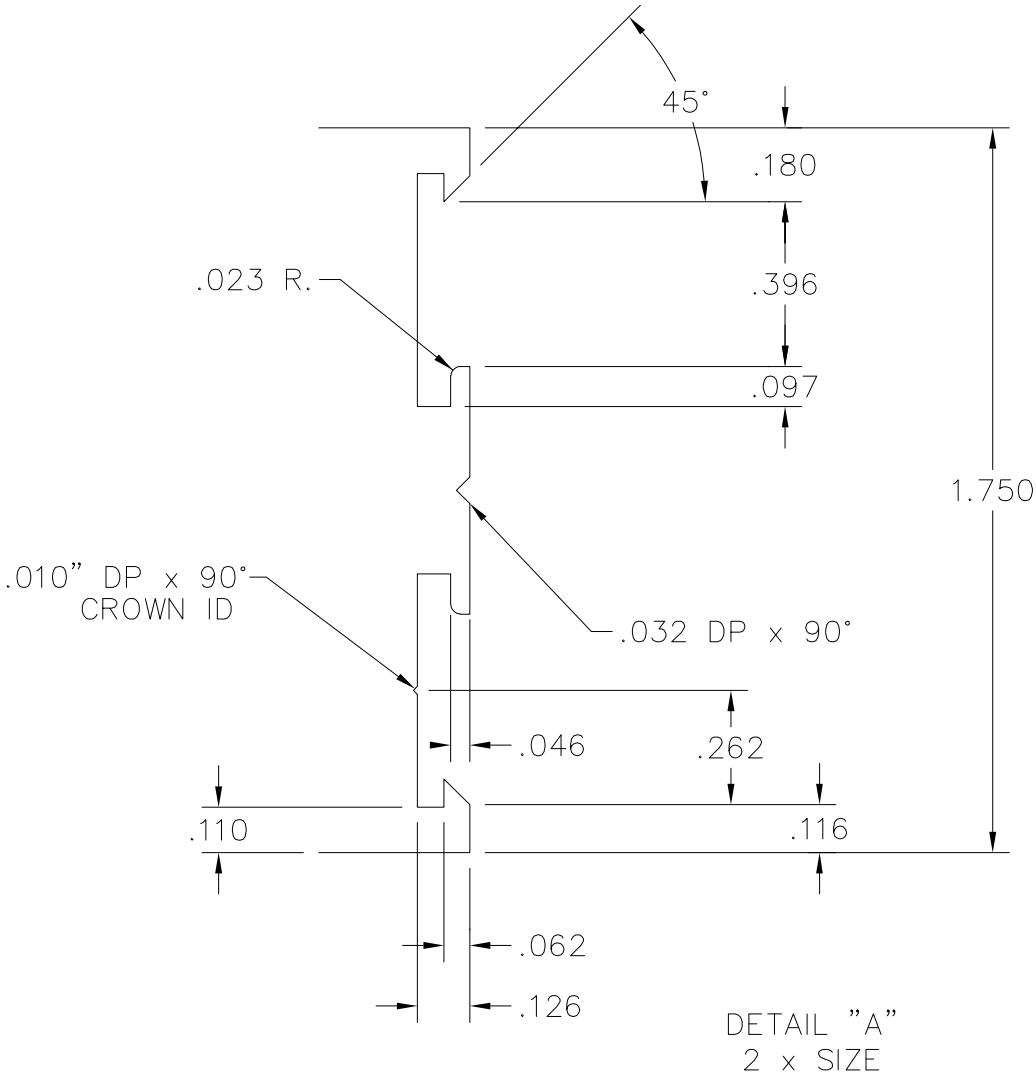
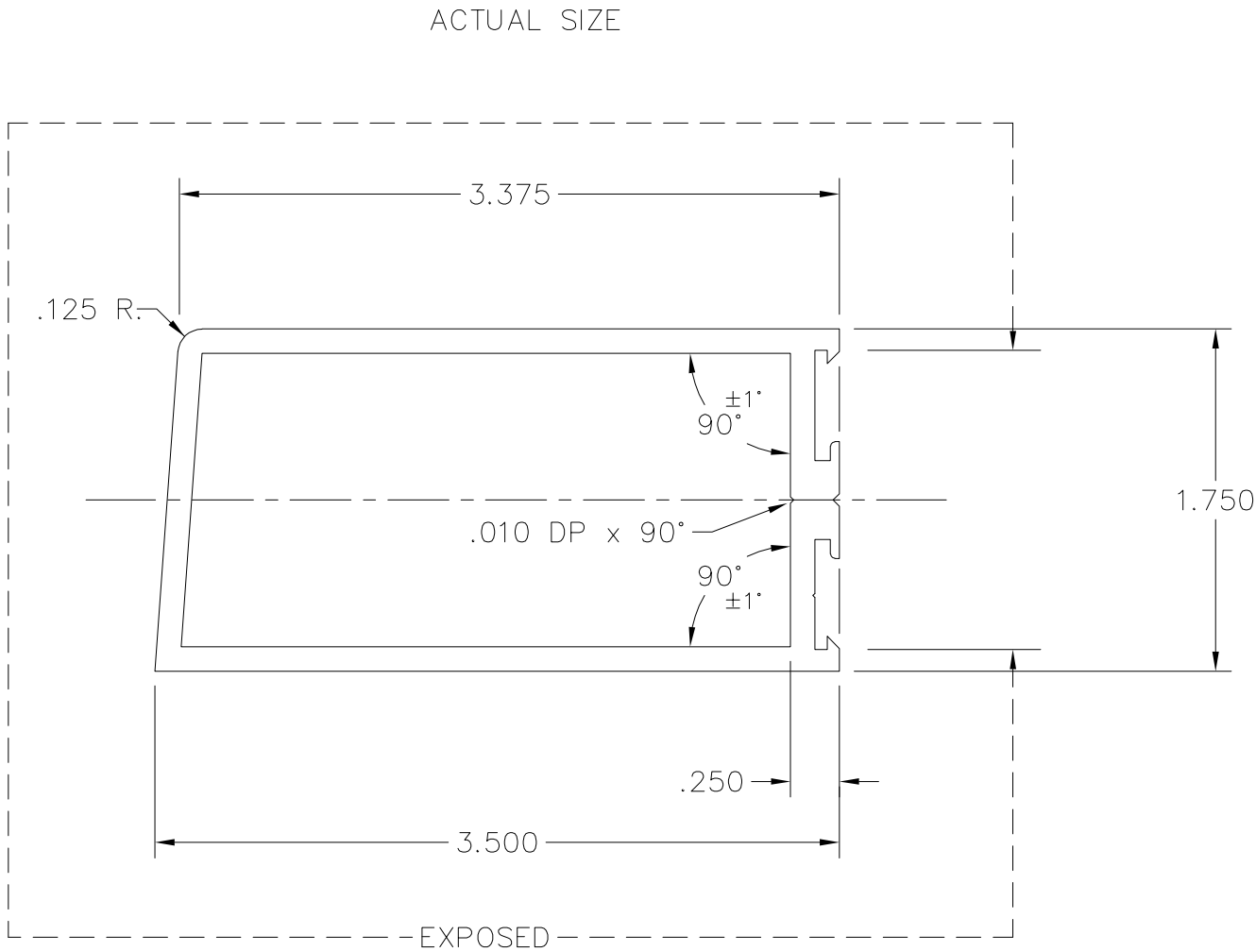
PRINT REVISIONS		DATE

12571

Die Number

2422M

Customer Number



STRAIGHTNESS & TWIST ARE CRITICAL!

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

ESTIMATED DIE DATA			
ALLOY/TEMPER:		6063-T5	
AREA	1.290	WT/FT	1.548
PERIMETER	20.574	CIRCLE SIZE	3 - 4
OUTSIDE PERIMETER	11.432	FACTOR	13
EXPOSED PERIMETER	8.816	HOLLOW	

PRESS SIZE
LEGEND
• = .031 R.
◦ = .062 R.
× = .125 R.
⊗ = .250 R.
* =

DIE REVISIONS		DATE



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:

BEVELED MEDIUM STILE

DIE #

12571

SCALE

FULL & NOTED

DATE

12-11-08

LAST REVISION

DRAWN

TCG

CUSTOMER NUMBER

2422M

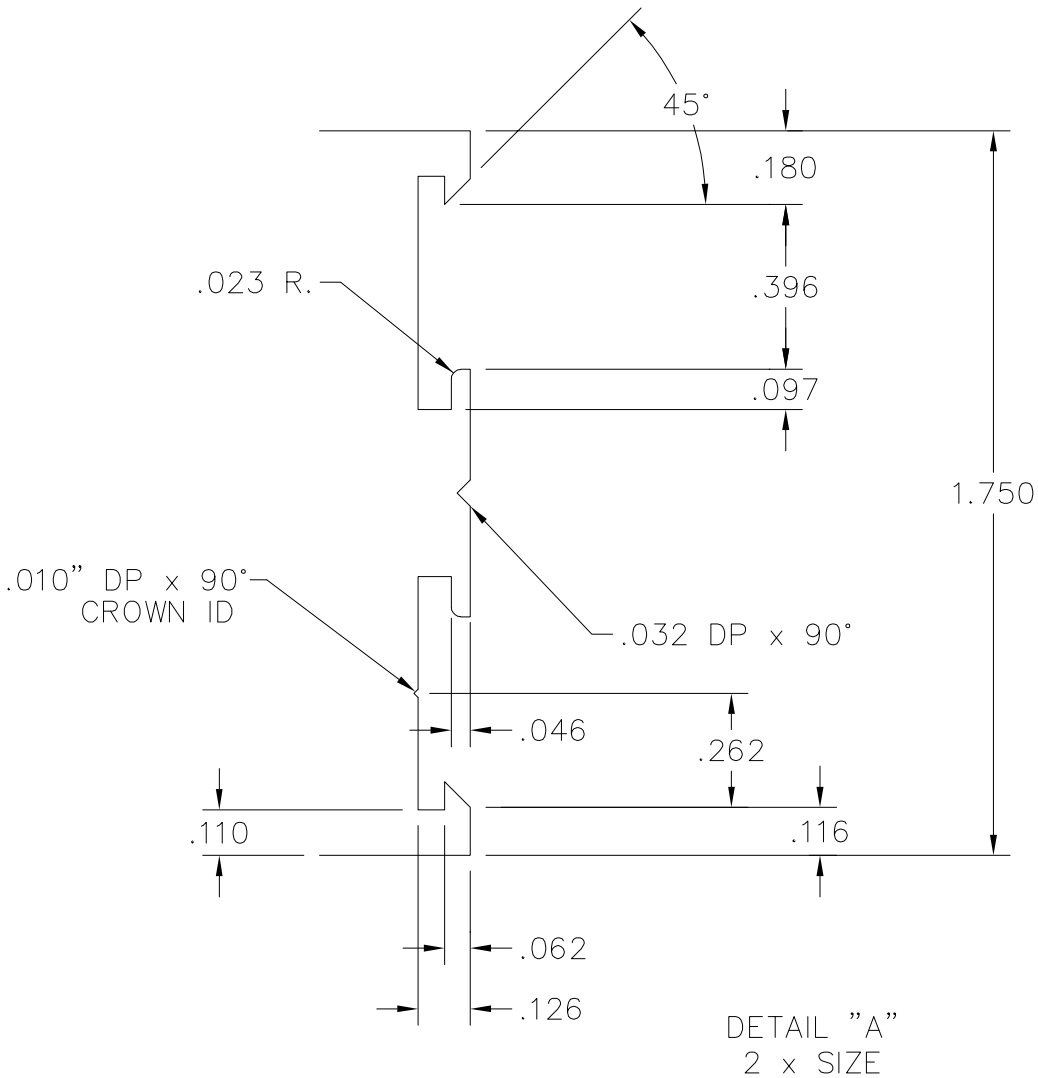
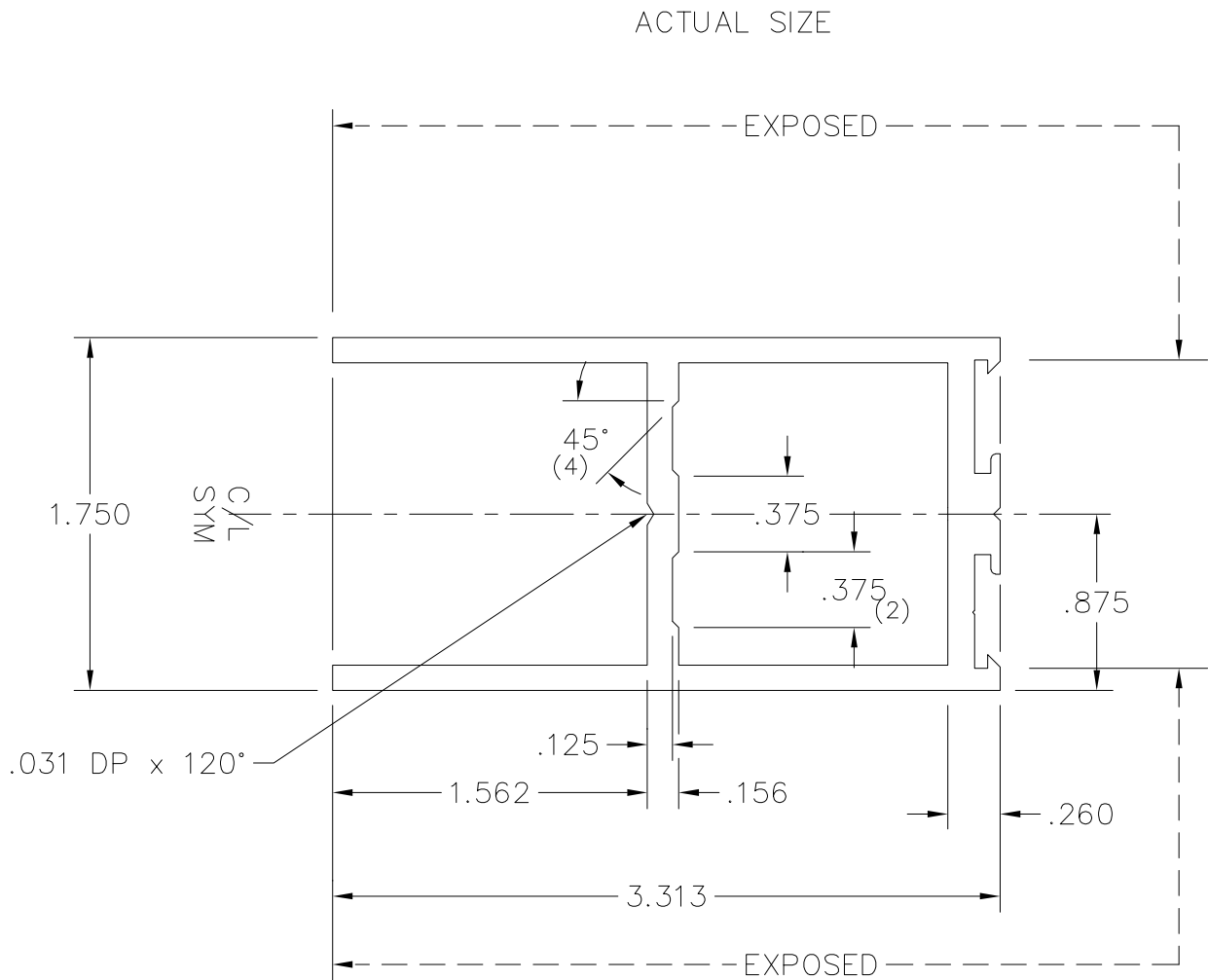


Report #: N8135.02-201-45
Date: 8/29/22
Verified by: [Signature]

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

PRINT REVISIONS		DATE

12568
Die Number
1349M
Customer Number



STRAIGHTNESS & TWIST ARE CRITICAL!

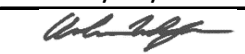
BREAK UNSPECIFIED CORNER: .015 R. TYPICAL WALL UNLESS OTHERWISE NOTED: .125



Total Quality. Assured.

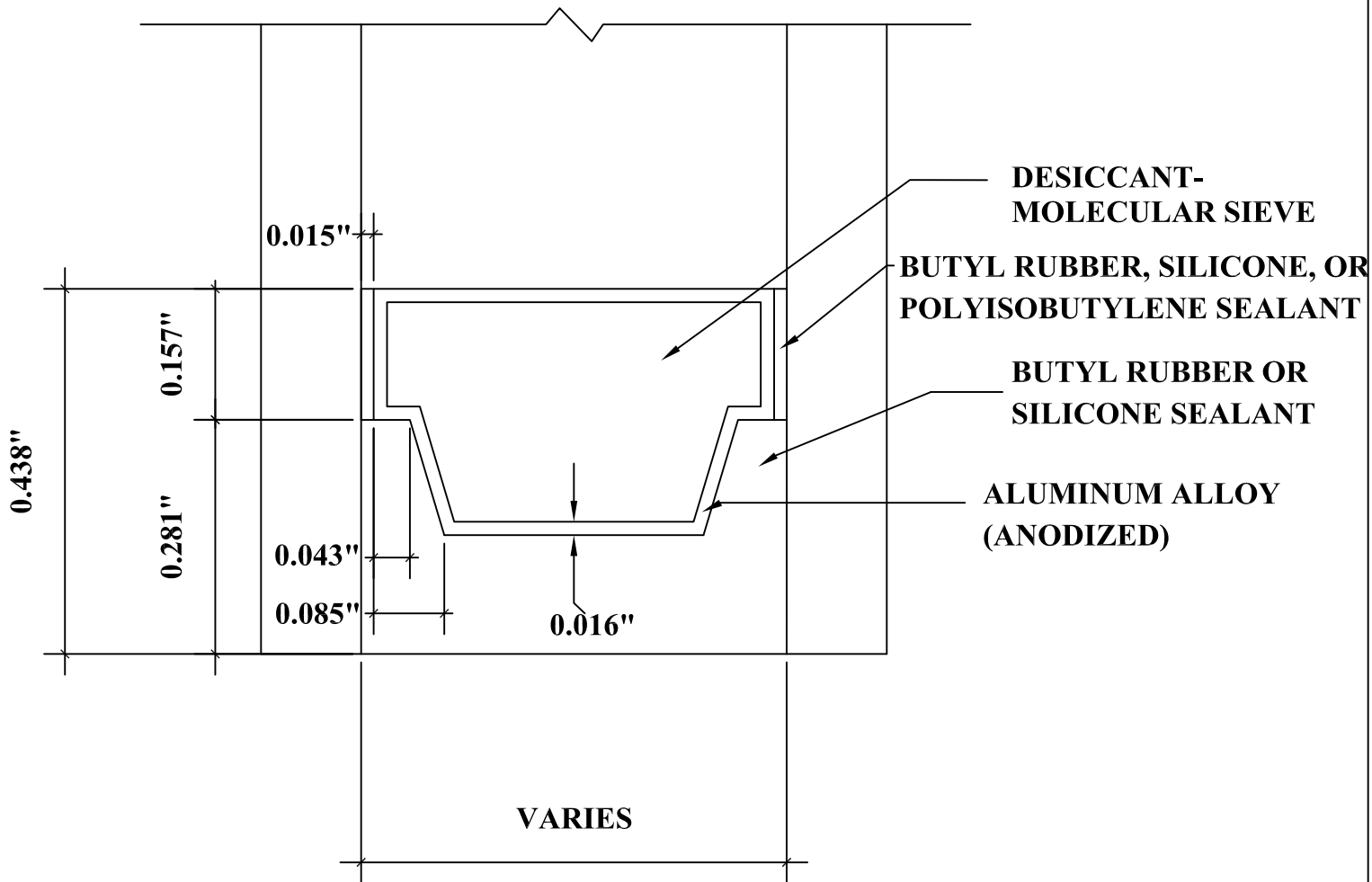
Report #: N8135.02-201-45

Date: 8/29/22

Verified by: 

STANDARD TOLERANCES APPLY UNLESS OTHERWISE NOTED

		E S T I M A T E D D I E D A T A		 CROWN EXTRUSIONS Crown Extrusions, Inc. 122 Columbla Court N. Chaska, MN 55318 952-448-3533 Fax: 952-448-5328	DIE #
		ALLOY/TEMPER: 6063-T5			12568
		AREA 1.298	WT/FT 1.558		SCALE
		PERIMETER 20.109			FULL & NOTED
		CIRCLE SIZE 3 - 4			
PRESS SIZE	OUTSIDE PERIMETER 14.363	FACTOR 13	DATE		
LEGEND	EXPOSED PERIMETER 6.858	HOLLOW	12-11-08		
	DIE REVISIONS		LAST REVISION		
				DRAWN	
				TCG	
				CUSTOMER NUMBER	
				1349M	



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



Total Quality. Assured.

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

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

TEST REPORT FOR CMI ARCHITECTURAL PRODUCTS, INC.

Report No: N3185.02-201-45 R0

Date: 08/25/22

SECTION 8

REVISION LOG

REVISION #	DATE	PAGES	REVISION
.01 R0	08/25/22	N/A	Original report issue. Work requested by Ms. Ashley Alt of CMI Architectural Products, Inc.
