Westlake
Royal Window Solutions™
Legacy Collection



NEW CONSTRUCTION

700 SERIES

700 SERIES

Westlake
Royal Window Solutions™
Legacy Collection



FEATURES

- All welded frame and sash
- Integral nail fin
- J-Channel pocket for seamless siding transition
- Sloped sill for improved water drainage
- Aesthetically pleasing exterior frame design
- Intermediate jamb for continuous head & sill twins and triples
- Aluminum reinforced profiles for superior performance
- Multi-chambered vinyl profile profiles for thermal efficiency
- Dual weatherstripping
- DP 50 performance levels
- Family of products: Singlehung, slider, picture window, shapes

CARDINAL IG

COLOR OPTIONS

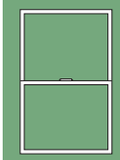
WHITE

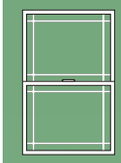
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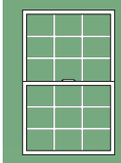
CLAY

EXT INT
BLACK/WHITE

GRILLE OPTIONS


ONE LITE


3/4" PRAIRIE


3/4" COLONIAL


SIMULATED DIVIDED LITE


GRILLE BETWEEN GLASS

You may qualify for a tax credit when you replace your existing windows. For more information, go to energystar.gov

ENERGY STAR PARTNER

NFRC National Fenestration Rating Council® CERTIFIED

For information about measuring & installing Legacy Collection windows, visit our website: WestlakeRoyalWindows.com

6410 Langfield Rd., Building D • Houston, TX 77092 • 281-369-5688

Westlake
Royal Building Products™

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Westlake
Royal Window Solutions™

Westlake Royal Windows LLC

Multi- Family Construction Projects

LIFETIME LIMITED WARRANTY ("WARRANTY")

Vinyl (frame) Windows manufactured by Westlake Royal Windows LLC ("Westlake Royal") are free of defects in design, materials, and workmanship and fit for reasonable purposes for which intended at the time of shipment from our plants in Dallas, Carrollton, Houston, Texas and Baldwin, GA, as set out below.

WHAT WILL WE DO

Any Warranty claim should be presented to Westlake Royal in a timely manner. Thereafter, Westlake Royal will inspect the alleged defect. If the claim is within the Warranty, Westlake Royal will at its option, repair, or replace any defective component without charge. The cost of removing the defective products or installing a repaired or replaced product is not covered unless claim is made within one year of original purchase. Any Warranty claim approved cannot exceed in value more than the original purchase.

WHAT WE COVER AND FOR HOW LONG

Vinyl and or aluminum used in the frames of the Westlake Royal units are warranted to the original purchaser/ developer exclusively for the original ten (10) years of use. This Warranty covers material from blistering, corroding, flaking, or rot under conditions of normal wear and use. Hardware is covered by this Warranty from all defects in design, materials and workmanship for a period of one (1) year from purchase date. Insulated Glass (10 year) from the date of purchase is warranted against defects in materials and workmanship resulting in material obstruction in vision from film formation, moisture, or dust collection between the interior glass surfaces. Specialty glass (tinted, obscure or decorative) is warranted against such defects for a period of ten years from the date of purchase. If a stress crack (glass fracture) is NOT present upon delivery to the construction site, the development of any stress crack is not a result of a manufacturing defect but results from either a handling or installation issue and is not warranted. The cost of removing the defective product or installing a repaired or replaced product is not covered unless the Warranty claim is made within one (1) year after the date of initial purchase.

WHAT WARRANTY DOES NOT COVER

1. Defects or damages attributable to external cases, such as defects caused by (a) installation, soil retention, or normal weathering; (b) accidents, fire, flood , or other acts of God, vandalism, riot or civil disorder, misuse, or abuse; (c) harmful fumes, vapors, or chemical pollutants in the atmosphere, or use of non-approved heat caused by cleaning agents; (d) mildew; (e) building settlement or structural failure of the walls or foundations; (f) stresses resulting from localized heat which cause excessive temperature differentials over glass surfaces or edges; (g) use above 6,000 feet above sea level without capillary breather tubes; (h) use in an environment subject to high vibration (e.g. swimming pool), excess salinity; or other unusual conditions; or (i) any other use or occurrence beyond Westlake Royal's control.
2. Condensation on products which occurs as the natural results of humidity within the house or building area or differences between interior orexterior temperatures does not indicate a defect in the product and is not covered by this Warranty.
3. Changes in the appearance of the hardware that are attributed to normal aging and wear do not indicate a manufacturing defect and are notcovered by this Warranty.
4. Any defects resulting from installation such as but not limited to security system installation, caulk over weep holes in the frame are not covered. It also does not cover any cost of removal or installation of a product or component part.
5. Surface imperfections are inherent in the product and if they are not noticeable within three feet of the surface and do not impact the function of the product, they are not manufacturing defects and are not covered by the Warranty
6. Westlake Royal reserves the right to discontinue or change any component. If the component of the window and patio door originally installed is not available and Westlake Royal determines to make replacement, Westlake Royal may substitute a component designated by Westlake Royal that is equal quality and value.
7. Westlake Royal has no liability beyond repair or replacement of applicable products, and repair or replacement is your sole remedy for Westlake Royal's breach of this Warranty. Westlake Royal will have no liability for any lost time, inconvenience, loss of use, personal injury, property damage, or any other incidental or consequential damage.
8. No sales representative or distributor is authorized to modify this Warranty or to extend any other Warranty on Westlake Royal products.
9. Color change due to normal weathering is excluded from this Warranty. Normal weathering is defined as any exposure to ultraviolet (sun) light, weather and atmospheric conditions which will cause any colored or painted surface to fade, darken, chalk or acquire a surface accumulation of dirt and stains. The severity of these conditions depends on air quality, location of your home and other local conditions.
10. This Warranty is the only one Westlake Royal makes and Westlake Royal expressly disclaims any other express or implied warranty, including any warranty of merchantability or fitness for a purpose.

STATE LAW RIGHTS

Some states do not allow the limitation on how long a warranty lasts or the exclusion or limitation of incidental or consequential damages, so the limitations or exclusions in paragraphs 7 and 10 may not apply to you. This Warranty gives you specific rights, and you may also have other rights which vary from state to state.

Westlake
Royal Window Solutions™

FIELD TESTING- In the event *Westlake Royal Windows,* (Seller), windows and/or doors are subject to "Field-Testing" as a conditional requirement of the supply agreement, the following conditions are required from the Buyer:

A. Requirement of fenestration product "Field-Testing" from buyer must be provided in writing prior to execution of any supply agreement from seller.
B. Project specification for fenestration design pressures must be provided from buyer and included in all executable documents prior to execution of any supply agreement from seller.
C. "Field-Testing "must be performed as per AAMA 502 protocol for the "Voluntary Specification for Field Testing of Newly Installed Fenestration Products"
D. Product design pressure will be determined based on the specifics of the project, not the product designation of the window.
E. All "Field-Testing" equipment must be properly calibrated and testing agency must provide proof of equipment compliance upon request
F. No more than (3) fenestration openings will be subject to "Field-Testing" unless otherwise noted and approved by Seller.
G. "Field-testing" pressures should never exceed 2/3 of the project specifications for fenestration products
H. Seller must be notified in writing two-weeks prior to any scheduled "Field-testing"
I. Buyer agrees to allow the Seller the opportunity to apply remediation on any failed fenestration products
J. Seller is not responsible for the cost or reimbursement of any related "Field-testing" fees
K. Seller is not responsible and cannot be held liable for failures on fenestration products due to installation practices that deviate from tested and accepted installation techniques

Buyer Signature _____ Date _____

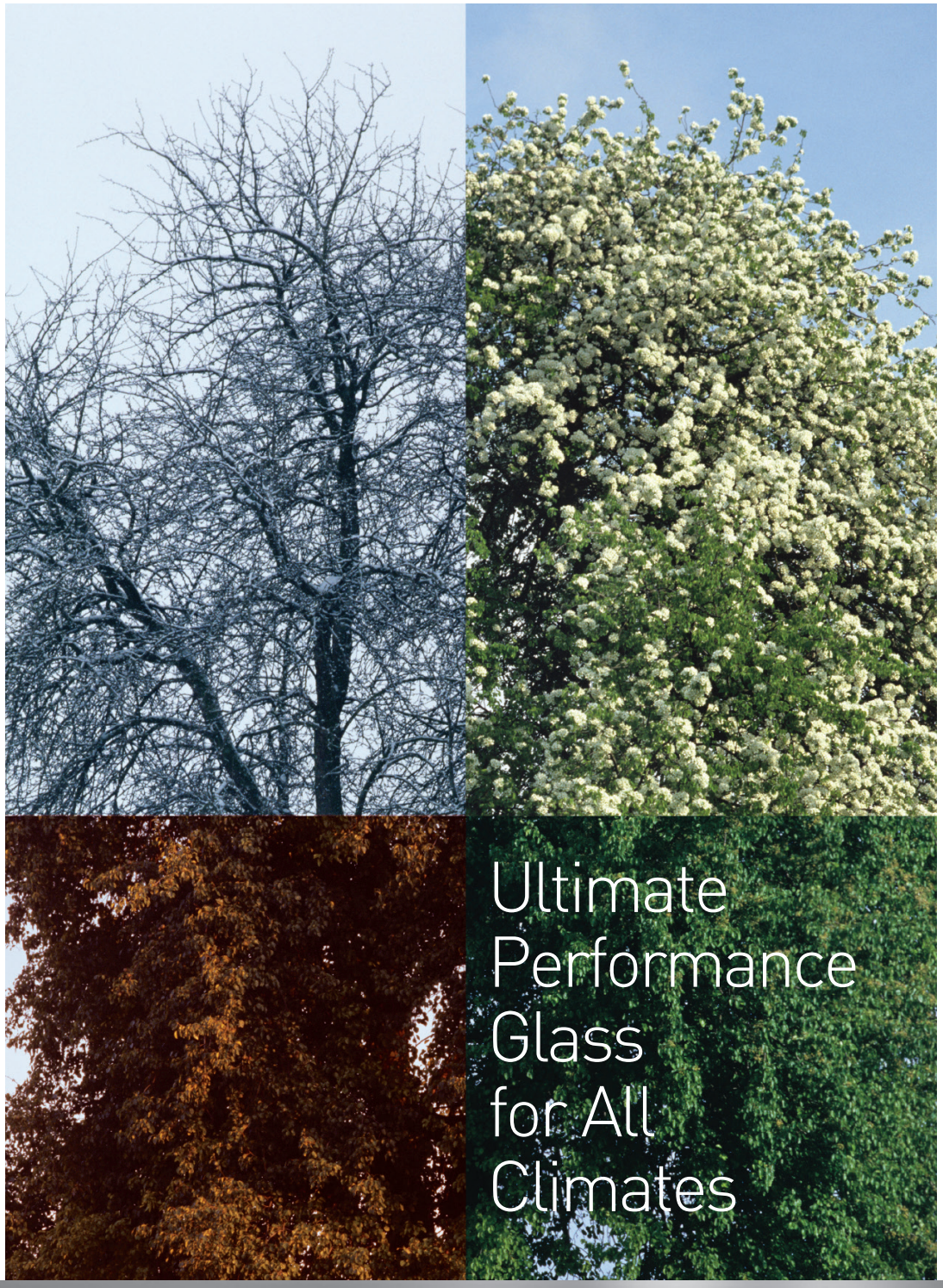
Printed Name _____

Company Name _____

Please email to: jwrigh4@westlake.com

For additional information on AAMA (American Architectural Manufacturer's Association) see aamanet.org

545 E. John Carpenter Freeway
Suite 1900, Las Colinas, TX 75062



Ultimate Performance Glass for All Climates

CARDINAL CG
A CARDINAL GLASS INDUSTRIES COMPANY

ENGINEERING THE FUTURE OF COATED GLASS



Cardinal LoĒ³-366® glass is the ultimate performance glass. It just might make all other low-e glass obsolete. LoĒ³-366 delivers the ideal balance of solar control and high visibility. And it provides the highest levels of year-round comfort and energy savings. It's also the one glass you can use to be compliant in every ENERGY STAR zone – in a double-pane window. Couple it with LoĒ-i89®, and you're compliant in the North. Its low SHGC makes it compliant throughout the rest of the country as well. It's the perfect glass wherever you live.

When the temperature soars, ordinary window glass just can't handle the heat. And tinted glass spoils the view. Cardinal LoĒ³-366, however, has been specially formulated to reject the sun's heat without affecting the view. It lets more light in and keeps more heat out. So your home stays cool and comfortable. Our patented LoĒ³-366 coating provides the ultimate in performance of all our LoĒ products.

What's more, LoĒ³-366 provides exceptional fading protection as well. It blocks 95% of the sun's damaging ultraviolet rays (a leading cause of fading), so it will help your furniture, carpets, curtains and wall coverings stay beautiful for years to come.



During cold weather, the insulating effect of your windows has a direct impact on how your rooms feel. Typically, 75% of the exposed surface of a window is glass, and the temperature of the room-side of the glass directly affects the air temperature in the room. The better insulated the window glass, the warmer your room will be.

In fact, the Efficient Windows Collaborative (www.efficientwindows.org) suggests that when glass surface temperatures fall below 52°F, there is a risk of thermal discomfort. To maintain the best comfort during the winter, select a glass product that produces surface temperatures that will stay above this point during the coldest outdoor conditions.



INSIDE GLASS AND OUTSIDE TEMPERATURES

The table below compares the room-side center of glass temperatures of different glass types against two different winter conditions.

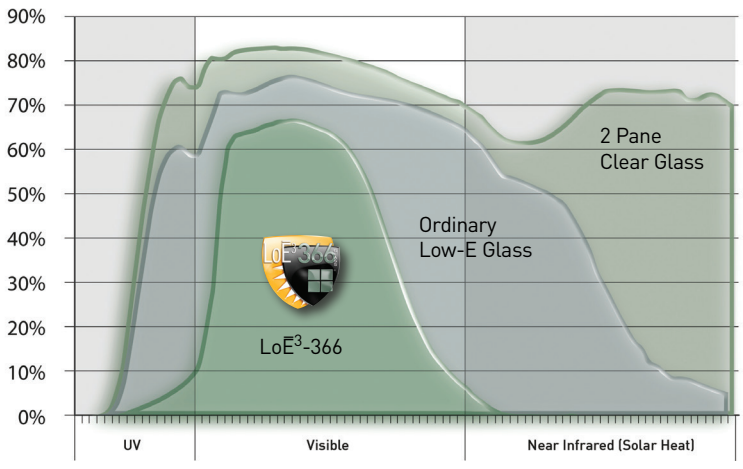
IG TYPE AND COATING	OUTSIDE TEMPERATURES	
	VERY COLD OUTSIDE -20°F (-30°C)	COLD OUTSIDE 20°F (-10°C)
	INSIDE TEMPERATURES	
Single-pane, Clear	0°F (-19°C)	31°F (-3°C)
Double-pane, Clear	37°F (2°C)	51°F (9°C)
Ordinary low-e (air fill)	46°F (7°C)	57°F (13°C)
LoĒ³-366 (air fill)	**49°F (9°C)**	**58°F (14°C)**
LoĒ³-366 (argon fill)	**52°F (11°C)**	**60°F (15°C)**

The superior insulating capability of Cardinal LoĒ³-366 is a key factor in the construction of comfortable windows for cold climates. The dramatic comfort improvement from windows with warm glass surfaces also means the relative humidity of the indoor air can be controlled and maintained properly. Proper humidity levels (not too much, not too little) will improve comfort and promote a healthier living environment.

A unique triple-layer coating.

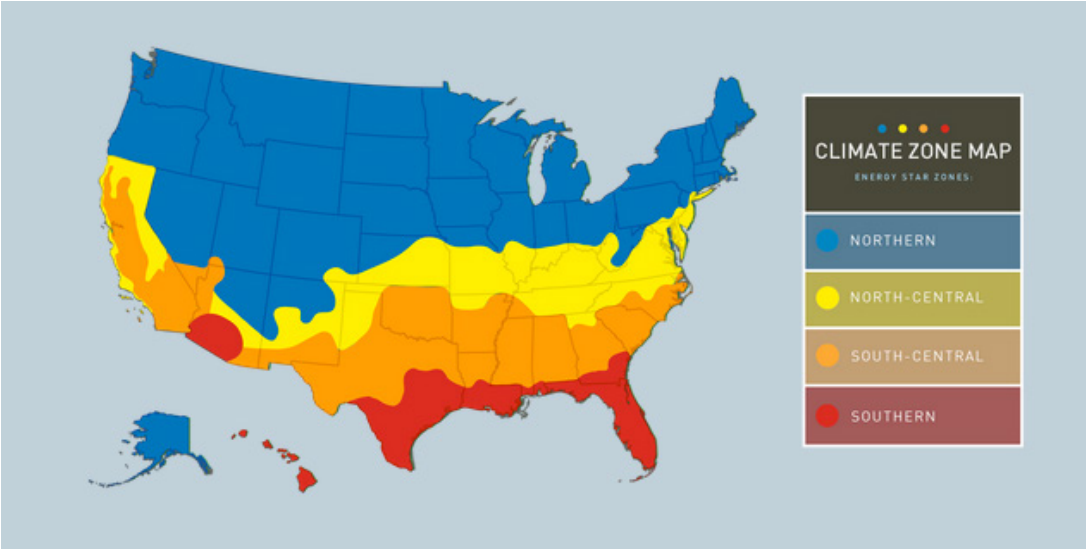
For years, Cardinal has been setting the standard for energy efficient glass. Top-of-the-line residential window and door manufacturers all rely on our high quality. Our patented state-of-the-art sputter coating processes are unmatched by any other glass manufacturer.

Now we've raised the bar. LoĒ³-366 adds a third layer of silver coating. Result: a clear coating that blocks even more solar gain, reflects heat, and lets the light stream in. LoĒ³-366 actually outperforms the tinted glass often used in warm climates.



ENERGY STAR, everywhere.

The goal of the ENERGY STAR Windows program is to be better than code. LoĒ³-366 is the one low-E product that can qualify in all four climate zones: superior insulating value in the North, and clear solar control for everywhere else in the country.



GLASS PERFORMANCE

IG TYPE AND COATING	VISIBLE LIGHT			FADE TRANSMISSION		SOLAR	U-FACTOR	
	TRANSMIT-TANCE	EXTERNAL REFLECTANCE	INTERNAL REFLECTANCE	UV	ISO	HEAT GAIN COEFFICIENT	AIR FILL IP / SI	ARGON FILL IP / SI
Single-pane, Clear	90%	8%	8%	0.71	0.84	0.86	1.04 / 5.91	—
Double-pane, Clear	82%	15%	15%	0.58	0.75	0.78	0.48 / 2.73	—
Ordinary low-e	76%	17%	17%	0.50	0.68	0.72	0.34 / 1.93	0.30 / 1.70
LoĒ³-366	**65%**	**11%**	**12%**	**0.05**	**0.43**	**0.27**	**0.29 / 1.65**	**0.24 / 1.36**

LoĒ³-366 - Your choice for all seasons.

LoĒ³-366 is the ultimate performance glass, with energy savings throughout the year, in every part of the country. All with exceptional visibility. It's the perfect glass wherever you live.

LoĒ³-366 can be purchased in hurricane-resistant laminated glass, as well as in a variety of shapes and sizes.

To learn more about LoĒ³-366 and other Cardinal glass products, ask your window manufacturer, contractor or architect.

CARDINAL CG
ENGINEERING THE FUTURE OF COATED GLASS

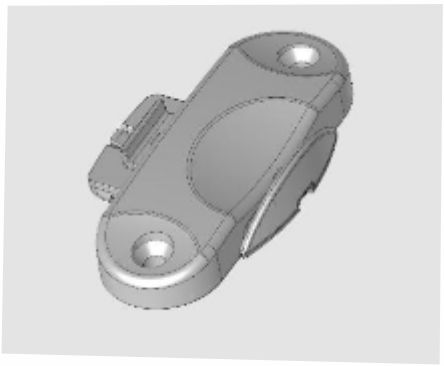
775 Prairie Center Drive,
Eden Prairie, MN 55344
cardinalcorp.com

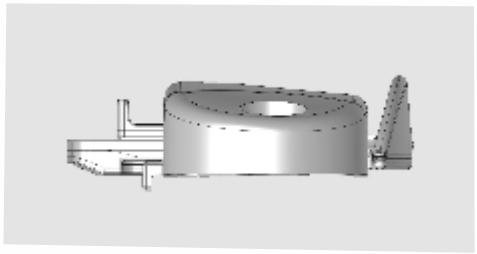
3/1/2023

Legacy Houston Series 700 LE 366						
Glass	Single Hung			Picture Window		
3/4” Overall	U-Factor	SHGC	VT	U-Factor	SHGC	VT
LE 366 air no grilles	33	22	51	30	23	53
LE 366 air w/ grilles	33	20	46	30	21	48
LE 366 argon no grilles	29	22	51	26	23	53
LE 366 argon w/ grilles	29	20	46	26	21	48

Please note: Numbers listed are based on a 3050. Window size and glass configuration can affect these numbers.

Single Hung Auto Lock
Single Hung ADA Lock



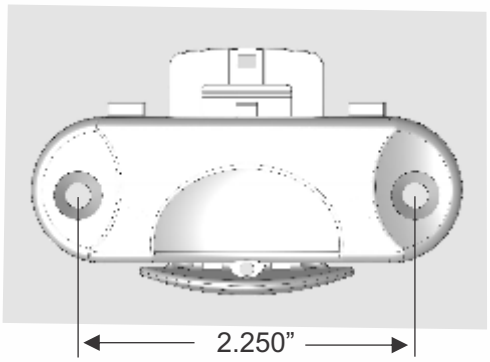


Single Hung Auto Lock works with
most meeting rail grooves
Tongue Thickness is Less than Sweep Lock Tongue to Accomodate Plunger Pressure

Designed as a Drop In for Sweep Lock Fabs

1950-00 Standard

1950-200 with ADA Pull String



LAWRENCE
INDUSTRIES, INC.
www.lawrenceindustriesinc.com

100% Made in USA

WOCD

www.visionhardware.com



WOCD

Model Number:
1761

Material:
N.A.

Description:
Window opening control device, in-slot mount, fit in thin slot .285" x 1.892", fit 1.3mm to 2.1mm wall thickness. used in vinyl window

Sales Contact:
(800) 220-4756
sales@visionhardware.com

500 Metuchen Road
South Plainfield NJ 07080

intertek
Total Quality. Assured.

WESTLAKE ROYAL WINDOWS
TEST REPORT

SCOPE OF WORK
AAMA/WDMA/CSA 101/I.S.2/A440 TESTING ON SERIES 700 FIXED WINDOW

REPORT NUMBER
N6485.01-801-44 R2

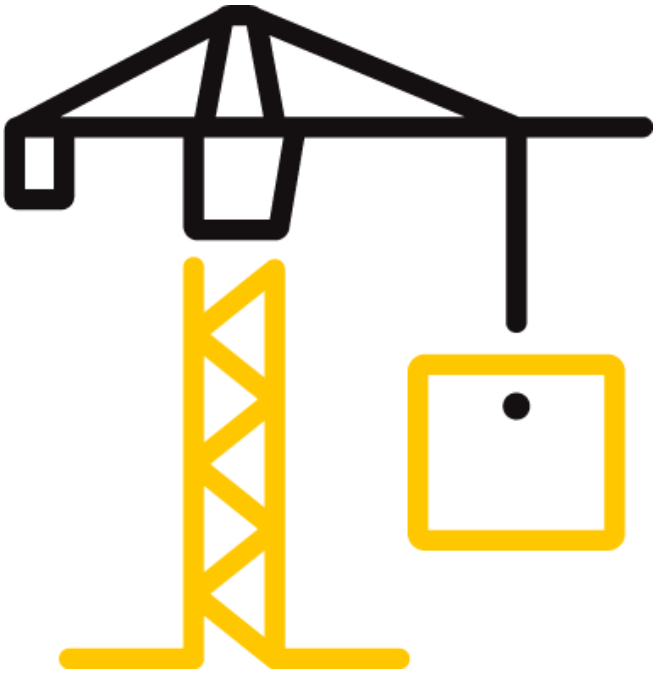
TEST DATE(S)
05/09/22 - 05/10/22

ISSUE DATE
06/10/22

REISSUE DATE
09/20/22

PAGES
15

DOCUMENT CONTROL NUMBER
RT-R-AMER-Test-2804 (01/15/21)
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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

REPORT ISSUED TO

WESTLAKE ROYAL WINDOWS
6410 Langfield Rd., Bldg D
Houston, TX 77092

SECTION 1

SCOPE

Architectural Testing, Inc. (an Intertek company) dba Intertek Building & Construction (B&C) was contracted by Westlake Royal Windows to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 on their Series 700 Fixed Window. Results obtained are tested values and were secured by using the designated test method(s). Testing was conducted at the Intertek test facility in Plano, TX. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory.

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 four 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.

Unless differently required, Intertek reports apply the "Simple Acceptance" rule, also called “Shared Risk approach,” of ILAC-G8:09/2019, Guidelines on Decision Rules and Statements of Conformity.

For INTERTEK B&C:

COMPLETED BY:	Jeffrey Crump	**REVIEWED BY:**	Lucio “Fred” Muñoz
TITLE:	Laboratory Manager – Building & Construction	**TITLE:**	Project Manager
SIGNATURE:	Digitally Signed by: Jeffrey Crump	**SIGNATURE:**	Digitally Signed by: Lucio Munoz
DATE:	09/20/22	**DATE:**	09/20/22

JC:cm

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

SECTION 2
SUMMARY OF TEST RESULTS

TITLE	RESULTS
AAMA/WDMA/CSA 101/I.S.2/A440-17	R-PG50-FW 1219 x 1524 (48 x 60)
Design Pressure	±2400 Pa (±50.13 psf)
Air Infiltration	<0.10 L/s/m^2 (<0.01 cfm/ft^2)
Canadian Air Infiltration/Exfiltration Level	Fixed
Water Penetration Resistance Test Pressure	360 Pa (7.52 psf)

Reference must be made to Intertek B&C Report No. N6485.01-801-44, dated 06/07/22 for complete test specimen description and detailed test results.

SECTION 3
TEST SPECIFICATION(S)/METHOD(S)

The specimens were evaluated in accordance with the following:

AAMA/WDMA/CSA 101/I.S.2/A440-17- *North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

The following test methods were used during testing:

AAMA 205-15, *In-Plant Testing Guidelines for Manufacturers and Independent Laboratories*

ASTM E283-04(2012), *Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*

ASTM E330/E330M-14, *Standard Test Method for Structural Performance of Exterior Windows, Doors, Skylights and Curtain Walls by Uniform Static Air Pressure Difference*

ASTM E547-00(2016), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Cyclic Static Air Pressure Difference*

ASTM F588-17, *Standard Test Methods for Measuring the Forced Entry Resistance of Window Assemblies, Excluding Glazing Impact*

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

SECTION 4
MATERIAL SOURCE/INSTALLATION

Test specimen was provided by the client. Representative samples of the test specimen(s) will be retained by Intertek B&C for a minimum of four years from the test completion date.

The specimen was installed into a Pine wood buck. The rough opening allowed for a 1/8" shim space and the exterior perimeter of the specimen was sealed to the test buck.

LOCATION	ANCHOR DESCRIPTION	ANCHOR SPACING
Frame nail fin	#8 x 1-5/8	2" from each end and 9" O.C.

SECTION 5
EQUIPMENT

EQUIPMENT	ASSET NUMBER(S)	CALIBRATION DUE DATE
Force Gauge(s)		

SECTION 6
LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Isaac Delbosque	Westlake Royal Windows
Jeffrey Crump	Intertek B&C
Alex Buruian	Intertek B&C

SECTION 7
TEST SPECIMEN DESCRIPTION

Product Type: Fixed Window
Series/Model: 700

Product Size(s):

Test Specimen #1

OVERALL AREA:	WIDTH		HEIGHT	
1.9 m^2 (20.0 ft^2)	millimeters	inches	millimeters	inches
Overall size	1219	48	1524	60

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

Frame Construction:

MEMBER	MATERIAL	DESCRIPTION
Head, sill and jambs	PVC	Extruded vinyl

	JOINERY TYPE	DETAIL
All corners	Mitered	Welded

Reinforcement: *No reinforcement was utilized.*

Weatherstripping: *No weatherstripping was utilized.*

Glazing: *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

GLASS TYPE	SPACER TYPE	INTERIOR LITE	EXTERIOR LITE	GLAZING METHOD
3/4" IG	Aluminum	1/8 annealed	1/8 annealed	Interior glazed with Novaguard liquid back bedding at the exterior face of glass and vinyl glazing bead located at the interior face of glass.

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Head, sill and jams	2	1095 x 1400	43-1/8 x 55-1/8	1/2

Drainage:

METHOD	SIZE	QUANTITY	LOCATION
Weepslot with plastic baffles	3/4” wide by 3/16” high	2	2” from each end of frame sill

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

SECTION 8
TEST RESULTS

The temperature range during testing was 25°C (77°F) The results are tabulated as follows:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Air Leakage, Infiltration per ASTM E283 at 75 Pa (1.57 psf)	<0.10 L/s/m^2 (<0.01 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Air Leakage, Exfiltration per ASTM E283 at 75 Pa (1.57 psf)	<0.10 L/s/m^2 (<0.01 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Canadian Air Infiltration/Exfiltration Level	Fixed	N/A	
Water Penetration, per ASTM E547 at 360 Pa (7.52 psf)	Pass	No leakage	3
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	 2.3 mm (0.09”) 9.7 mm (0.38”)	 Report only	5, 6, 7, 8
Uniform Load Structural, per ASTM E330 Permanent set taken at meeting rail +3600 Pa (+75.19 psf) -3600 Pa (-75.196 psf)	 0.30 mm (0.01”) 0.80 mm (0.03”)	 1.02mm (0.04”) max. 1.02 mm (0.04”) max.	6, 7, 8
Forced Entry Resistance, per ASTM F588, Type: - Grade: 10	Pass	No entry	
Thermoplastic Corner Weld	Pass	Meets as stated	

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Note 1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440 for air leakage resistance.

Note 2: Test Date 05/10/22 / Time: 10:00 AM (Air Note Only)

Note 3: Without insect screen.

Note 4: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.

Note 5: The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation. The deflection data is recorded in this report for special code compliance and information only.

Note 6: Loads were held for 10 seconds.

Note 7: Tape and film were not used to seal against air leakage during structural testing.

Note 8: Reference Intertek B&C Report No. N6485.01-801-44, dated 06/07/22 *for complete Gateway test specimen description and test results.*

SECTION 9
ALTERATIONS

No alterations were required.

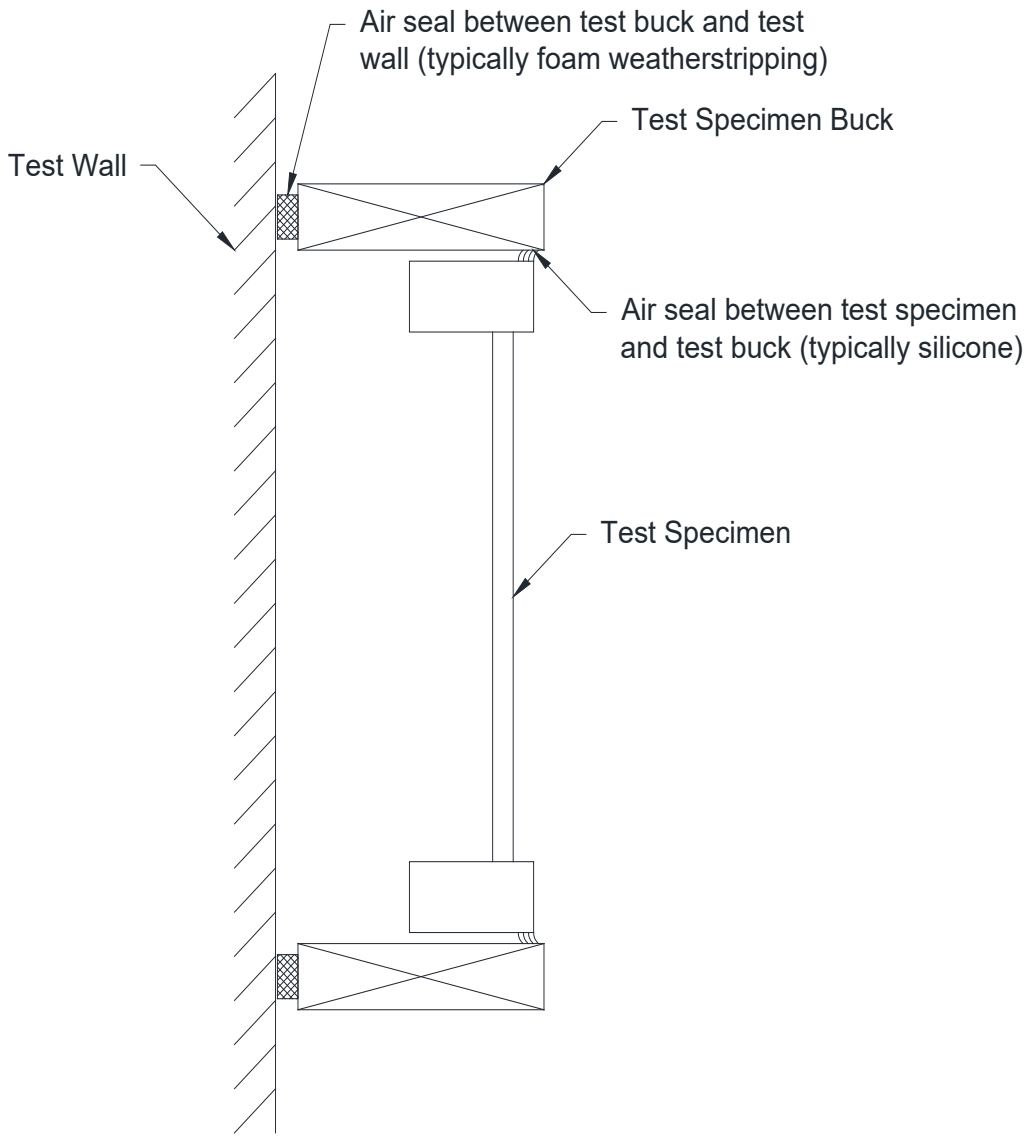
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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

SECTION 10
LOCATION OF AIR SEAL

The air seal between the test specimen and the test wall is detailed below. The seal is made of foam weatherstripping and is attached to the edge of the test specimen buck. The test specimen buck is placed against the test wall and clamped in place, compressing the weatherstripping and creating a seal.



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SECTION 11
CONCLUSION

The specimen tested successfully met the performance requirements for a R-PG50-FW.

Reference Intertek B&C Report No. N6485.01-801-44, dated 06/07/22 for complete *Gateway* test specimen description and test results.

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SECTION 12
DRAWINGS

The test specimen drawings have been reviewed by Intertek B&C and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek B&C per the drawings included in this report. Any deviations are documented herein or on the drawings.

VEKA INC.

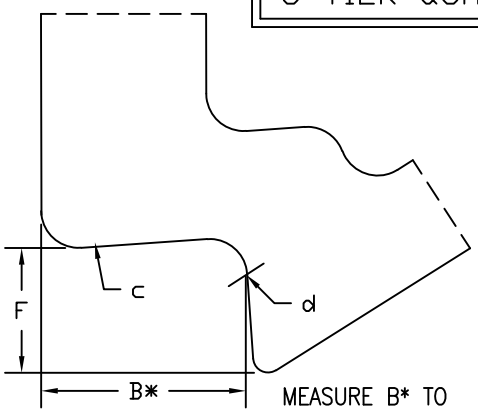
QUALITY ASSURANCE INSPECTION SHEET

DRAWN: JMN
CHECKED: BJF
APPROVED: RS

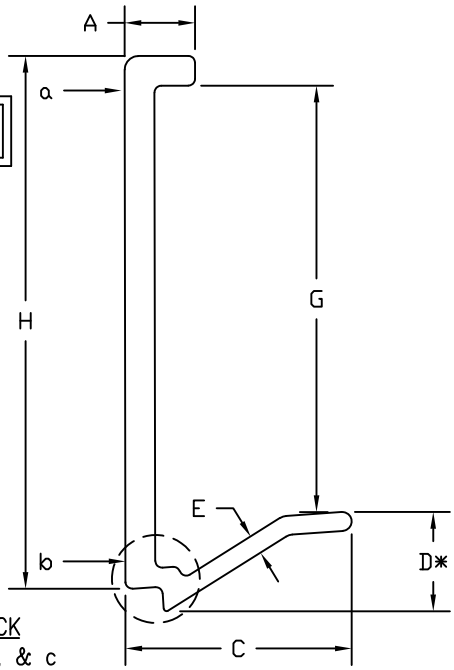
EXT NO. _____
COLOR NO. _____

DATE REV H: 11 AUG 2015

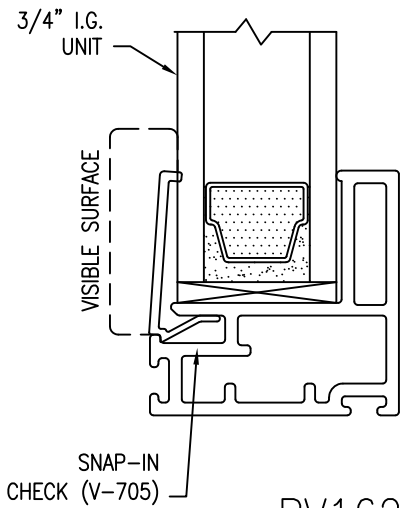
3-TIER QUALIFIED



MEASURE B* TO
END OF FILLET (pt. d)



✳ = COMPARATOR CHECK
USE LINE-UP PTS. a, b, & c



BV162

RED	A = 2.6 +0.2, −0.4										
	B*= 1.3 ±0.3										
	C = 8.5 ±0.2										
	D*= 3.7 ±0.3										
	E = 0.7 ±0.2										
	F = 0.8 ±0.2										
	G = 15.7 ±0.3										
	GO-GAUGE CHECK										
BLUE	H = 19.7 ±0.3										
BLACK											
FUNCTION/AESTHETICS	SQUARENESS ON COMPARATOR										
	BOW. MAX 1mm/M.										
	SURFACE [1(OK) 2 3 4 5(BAD)]										
	SNAP-IN CHECK (V-705)										
	PROFILE LENGTH ±1"										
	WEIGHT										

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~~Report #:~~	~~N6485.01-801-44~~
Date:	09/14/22
Verified by:	J.Crump

BILL OF MATERIALS

PICTURE (SHB3W)
WESTLAKE WINDOWS

NOTE: THIS BILL OF MATERIALS REFLECTS THE SYSTEM AS TESTED. DEVIATION FROM THE BILL OF MATERIALS IS NOT RECOMMENDED BY VEKA INC. AND MAY REDUCE THE PERFORMANCE OF THE FINISHED PRODUCT.

PVC PROFILES:	PART #	# PER UNIT	SOURCE
HEAD	SHB302	1	VEKA
JAMB	SHB302	2	VEKA
SILL	SHB302	1	VEKA
GLAZING BEAD (3/4" GLASS)	BV162	4	VEKA
GLAZING BEAD (5/8” GLASS)	V-722	4	VEKA

HARDWARE:	PART #	# PER UNIT	SOURCE
WEEP COVER	1238**	2	VISION

GLAZING:	PART #	#PER UNIT	SOURCE
LIQUID BACK BEDDING	SBC1M150	A/R	NOVAGUARD
GLAZING BLOCKS	1/8" X ¾” X 1”	A/R	TREMCO

**** = COLOR** **A/R = AS REQUIRED** **7 MARCH 2022**

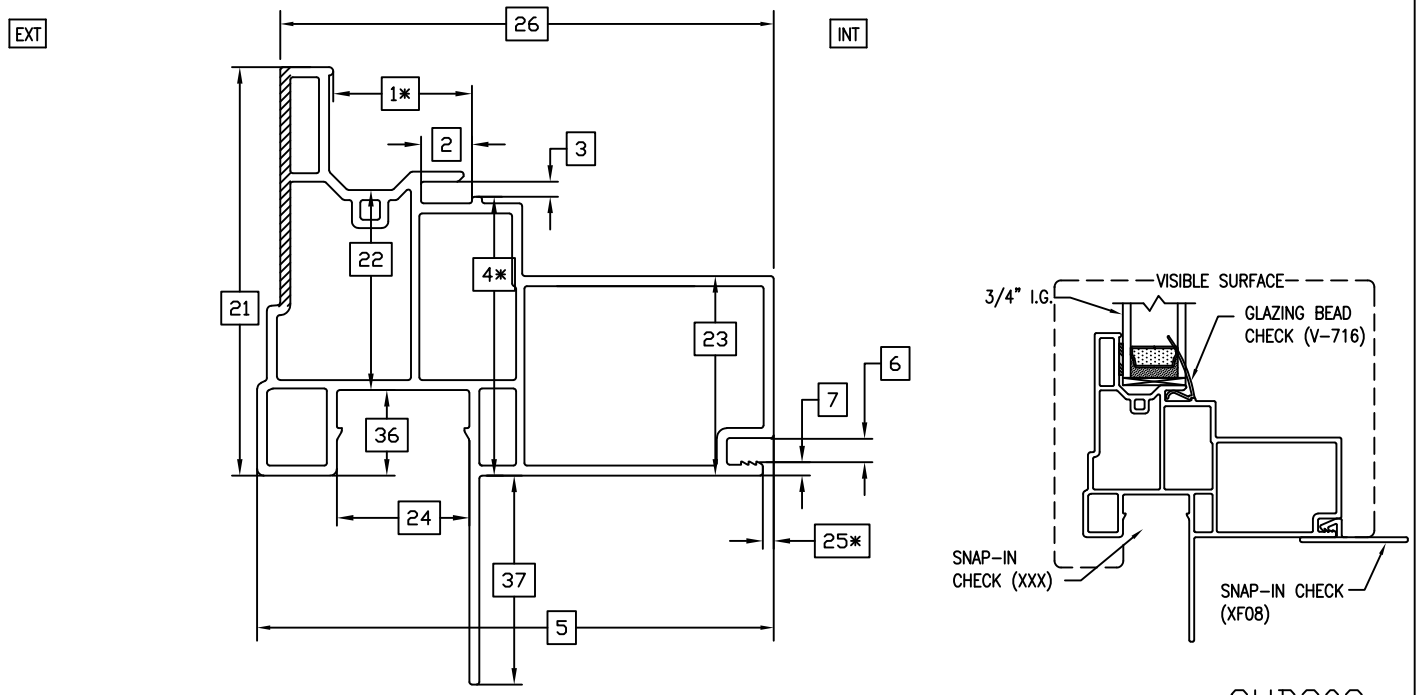
intertek Total Quality. Assured.	Report #:	N6485.01-801-44
	Date:	09/14/22
	Verified by:	J.Crump

VEKA INC.
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED: SMB
APPROVED:

DATE REV A: 18 SEPT 2018



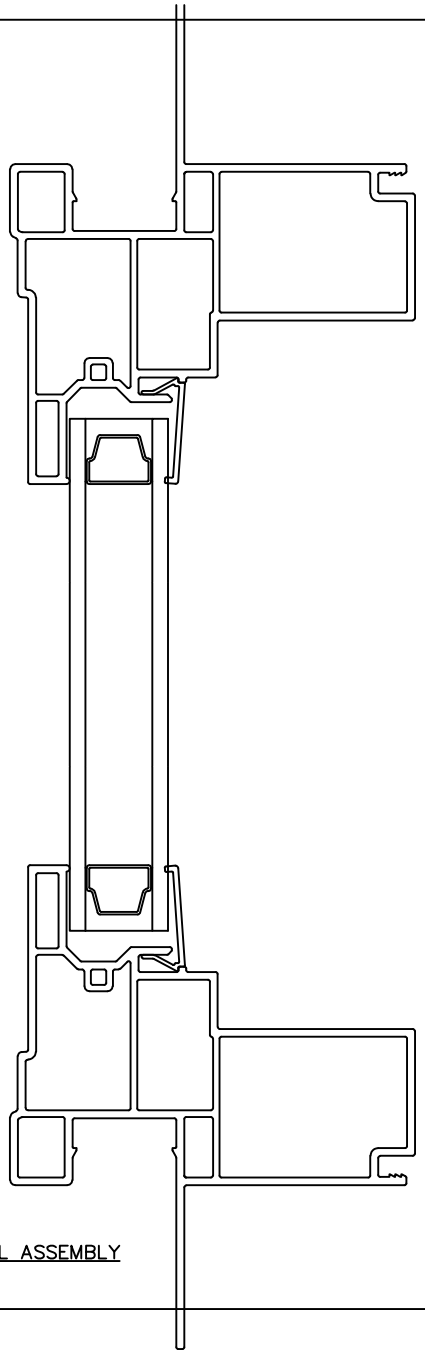
SHB302

* = COMPARATOR CHECK

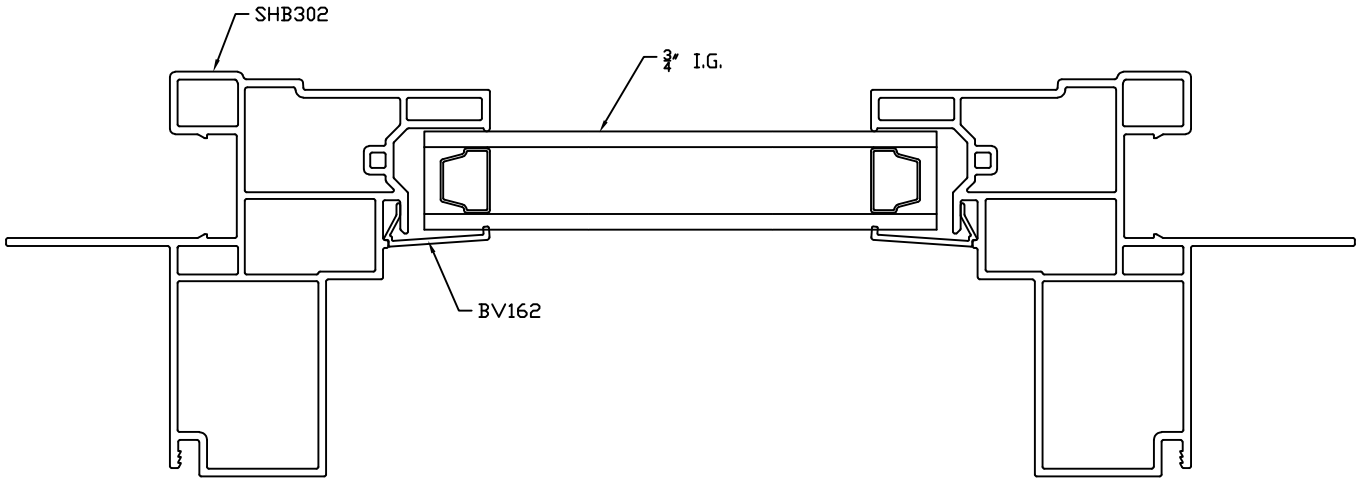
RED	1*= 21.1 ±0.3					BLUE	21 = 62.1 ±0.3				
	2 = 7.7 +0.3, −0.1						22 = 30.4 ±0.3				
	3 = 2.3 ±0.2						23 = 30.3 ±0.3				
	4*= 42.4 ±0.3						24 = 20.1 ±0.3				
	5 = 78.5 ±0.3						25*= 1.6 +0.2, −0.3				
	6 = 3.6 ±0.2						26 = 75.0 ±0.3				
	7 = 2.2 ±0.2						27 =				
	8 =						28 =				
	9 =						29 =				
	10 =						30 =				
	11 =						31 =				
	12 =						32 =				
	13 =						33 =				
	14 =						34 =				
	15 =						35 =				
	16 =					BLACK	36 = 13.0 ±0.4, −0.2				
	17 =						37 = 31.8 ±0.5				
	18 =						38 =				
	19 =						39 =				
	20 =						40 = LENGTH ±1"				
	GO-GAUGE CHECK					FUNCTION/AESTHETICS	SQUARENESS CHECK				
	BOW MAX. 1mm/M.						SURFACE BOOTH P/F				
	PROFILE WEIGHT						PIVOT SHOE FIT				
WALL REF.	OUTER WALL 1.5						SNAP-IN CK (XF08)				
	INNER WEBS 1.3						GLAZING BEAD CK (V-716)				
	IMPACT WALL										

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Report #:	N6485.01-801-44
Date:	09/14/22
Verified by:	I.Crump



VERTICAL ASSEMBLY



HORIZONAL ASSEMBLY

Report #:	N6485.01-801-44
Date:	09/14/22
Verified by:	J.Crump

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VEKA INC.
100 VEKA DRIVE
FOMBELL, PA 16123

DRAWN: TJF	DATE:7 MARCH 2022	SCALE:
CHK'D:	DATE:	APPV'D:
TITLE: PICTURE WINDOW ASSEMBLY WESTLAKE SERIES 700		DWG. # SHB3W–a

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: N6485.01-801-44 R2
Date: 06/10/22

SECTION 13
REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	06/10/22	N/A	Original Report Issue
1	09/12/22	6	Add note 8 to test result
2	09/14/22	5	Add annealed to glass type

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WESTLAKE ROYAL WINDOWS
TEST REPORT

SCOPE OF WORK

AAMA/WDMA/CSA 101/I.S.2/A440-11 TESTING ON SERIES: 700 PVC TWIN SINGLE HUNG WINDOW

REPORT NUMBER
K7217.01-801-44-R1

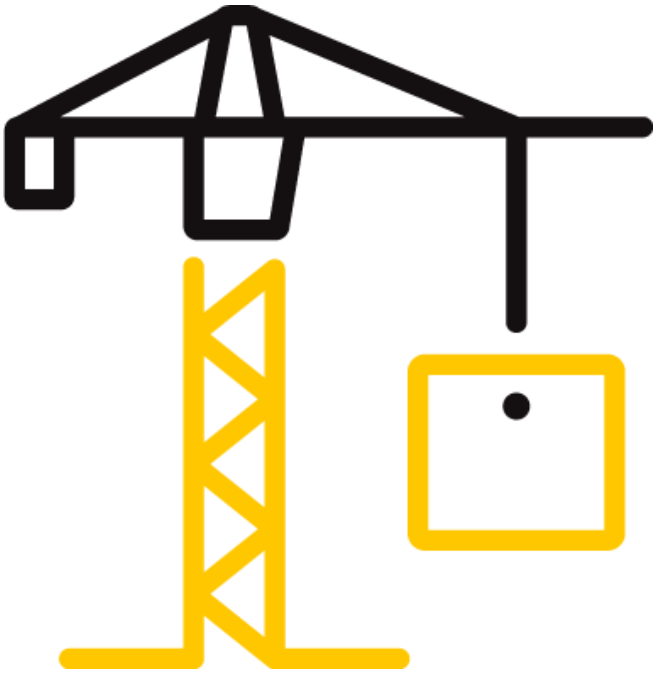
TEST DATE(S)
03/02/20

ISSUE DATE 03/19/20
REVISION DATE 07/22/22

RECORD RETENTION END DATE
03/10/24

PAGES
28

DOCUMENT CONTROL NUMBER
ATI 00438 (07/24/17)
RT-R-AMER-Test-2804
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(Validator / Operations Administrator)

AAMA CERTIFICATION PROGRAM

An FGIA Product Certification Program

WAIVER OF RETEST

March 24, 2022

Westlake Royal Windows - Legacy Collection
6410 Langfield Rd., Building D
Houston, TX 77092

Attn: John Wnuk

Dear John:

Per your written request, you are hereby granted a waiver of retest to modify the intermediate frame and reinforcement in your Series 700 Twin SH. As indicated in the drawings and calculations submitted with your request, the modified intermediate frame (SHB320) and reinforcement (M-16046) show superior strength to the intermediate frame (V-718) and reinforcement (2480-A) utilized in the structural performance testing of the Series 700 Twin SH.

This waiver approval is based on the drawings and calculations submitted with your request, and only applies to air, water, and structural testing.

Sincerely,

John G. Smith
Associated Laboratories, Inc.

Jason Seals
Fenestration and Glazing Industry Alliance

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Plano, Texas 75074

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

REPORT ISSUED TO
WESTLAKE ROYAL WINDOWS
6410 LANFFIELD ROAD BUILDING D
HOUSTON, TX 77092

SECTION 1
SCOPE

Intertek Building & Construction (B&C) was contracted by Westlake Royal Windows to perform testing in accordance with AAMA/WDMA/CSA 101/I.S.2/A440-11 - *North American Fenestration Standard/Specification for Windows, Doors, and Skylights* on their Series 700 Twin PVC Single Hung Window. Results obtained are tested values and were secured by using the designated test method(s). Testing was conducted at Intertek test facility in Plano, TX. This report does not constitute certification of this product nor an opinion or endorsement by this laboratory.

For INTERTEK B&C:

COMPLETED BY:	Jeffrey Crump, FMPC	**REVIEWED BY:**	Lucio "Fred" Muñoz
TITLE:	Lab Manager – Building and Construction	**TITLE:**	Project Manager
SIGNATURE:	Digitally Signed by: Jeffrey Crump	**SIGNATURE:**	Digitally Signed for: Fred Munoz by Cassandra Matthews
DATE:	07/22/22	**DATE:**	07/22/22

JC:cm

This report is for the exclusive use of Intertek's Client and is provided pursuant to the agreement between Intertek and its Client. Intertek's responsibility and liability are limited to the terms and conditions of the agreement. Intertek assumes no liability to any party, other than to the Client in accordance with the agreement, for any loss, expense or damage occasioned by the use of this report. Only the Client is authorized to permit copying or distribution of this report and then only in its entirety. Any use of the Intertek name or one of its marks for the sale or advertisement of the tested material, product or service must first be approved in writing by Intertek. The observations and test results in this report are relevant only to the sample(s) tested. This report by itself does not imply that the material, product, or service is or has ever been under an Intertek certification program.

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

SECTION 2
SUMMARY OF TEST RESULTS

TITLE	SERIES 250 SINGLE HUNG WINDOW
AAMA/WDMA/CSA 101/I.S.2/A440-11	Class R-PG50-H
Design Pressure	+/-2400 Pa (+50.13 psf)
Air Infiltration	0.25 L/s/m^2 (0.05 cfm/ft^2)
Water Penetration Resistance Test Pressure	360 Pa (7.52 psf)

SECTION 3
TEST METHOD(S)

The specimens were evaluated in accordance with the following:

> **AAMA/WDMA/CSA 101/I.S.2/A440-11**, *NAFS 2011 - North American Fenestration Standard/Specification for Windows, Doors, and Skylights*

SECTION 4
MATERIAL SOURCE/INSTALLATION

Test specimens were provided by the client. Representative samples of the test specimen(s) will be retained by Intertek B&C for a minimum of four years from the test completion date.

The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/8" shim space. The nail fin perimeter of the window was sealed to the wood test buck with sealant. Installation of the tested product was performed by the client.

LOCATION	ANCHOR DESCRIPTION	ANCHOR LOCATION
Integral nail fin	#6 x -1-5/8" screws	2" from each end of the window frame and 12" max O.C.

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

SECTION 5
EQUIPMENT

Control Panel: 63467
Weather Station: 63305

SECTION 6
LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Clint Barnett	Boral Windows
Richard Cole	Boral Windows
Jeffrey Crump	Intertek B&C

SECTION 7
GATEWAY

Reference Intertek B&C Report No. J7217.01-801-44, dated 03/10/20 for complete *Gateway* test specimen description and test results.

SECTION 8
TEST SPECIMEN DESCRIPTION

Product Type: PVC Twin Single Hung Window
Series/Model: 700

Product Size(s):

Test Specimen

OVERALL AREA:	**WIDTH**		**HEIGHT**	
481 m² (5184 ft²)	**millimeters**	**inches**	**millimeters**	**inches**
Overall size	1829	72	1829	72
Sash size	841	33-1/8	724	28-1/2
Sash DLO	783	31	667	26-1/4
Fixed DLO	783	31	972	38-1/4
Screen size	806	31-3/4	706	27-13/16

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

Frame Construction:

FRAME MEMBER	MATERIAL	DESCRIPTION
Head, sill, jambs, fixed meeting rail	PVC	Extruded

	JOINERY TYPE	DETAIL
All corners	Mitered	Thermally welded
Fixed meeting rail	Coped and butted	Fastened with two #8 x 3” truss head screws at jamb end and with a metal clip at the intermediate jamb. Each metal clip was fastened to the fixed meeting rail reinforcement with one # 8 x 1” flat head screw.
Intermediate Jamb	Coped and butted	Fastened with four #8 x 3” truss head screws at each end. Screw heads and Joints were sealed

Sash Construction:

SASH MEMBER	MATERIAL	DESCRIPTION
All rails and stiles	PVC	Extruded
	JOINERY TYPE	**DETAIL**
All corners	Mitered	Thermally welded

Reinforcement:

DRAWING NUMBER	LOCATION	MATERIALS
D-202616	Fixed meeting rail	Extruded aluminum
D-202685	Lock rail	Extruded aluminum
D18995	Intermediate Jamb	Extruded aluminum

Weatherstripping:

DESCRIPTION	QUANTITY	LOCATION
0.187" backed by 0.290" high center fin pile	2 Rows	Stiles
0.187" backed by 0.290" high center fin pile	1 Row	Sill
0.187" backed by 0.220" high center fin pile	1 Row	Lock Rail
½” Foam Bulb	1 Row	Bulb Seal

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

Glazing: *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen(s) can be made.*

GLASS TYPE	SPACER TYPE	INTERIOR LITE	EXTERIOR LITE	GLAZING METHOD
3/4" IG	Duraseal	1/8" annealed	1/8" annealed	The sash was exterior wet glazed with the fixed lite interior wet glazed with silicone.

LOCATION	QUANTITY	DAYLIGHT OPENING		GLASS BITE
		millimeters	inches	
Sash	2	787 x 667	31 x 26-1/4	1/2"
Fixed lite	2	787 x 972	31 x 38-1/4	1/2"

Drainage:

DRAINAGE METHOD	SIZE	QUANTITY	LOCATION
Weepslot with flap	1" wide by 1/4" high	2	Exterior sill face, one 3” from each end
Weepslot	1" wide by 3/16" deep	2	Sill intermediate floor, one at each end
Weephole	1" wide by 3/16" deep	2	Sill intermediate wall, one on each end
Weephole	¾” Wide 1-1/4” deep weep hole	2	End of sill each end
Weephole	3/8” Weep hole	2	Under Glazing

Hardware:

DESCRIPTION	QUANTITY	LOCATION
Metal cam lock	4	Lock rail, one 8" in from each end of sash with integral keeper groove at exterior meeting rail
Amesbury B&T Balance	4	One per jamb, two per integral mullion
Pivot Bar	4	Sash bottom rail
Submarine Tilt Latch	4	Top Sash each end

Screen Construction:

FRAME MATERIAL	CORNER CONSTRUCTION	MESH TYPE	MESH ATTACHMENT METHOD
Formed aluminum	Miter-cut with snap-in plastic corner keys	Fiber	Flexible vinyl spline

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SECTION 9
TEST RESULTS

The temperature during testing was 21.1°C (70°F). The results are tabulated as follows:

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Operating Force, per ASTM E2068	Initiate Motion: 49 N (11 lbf) Maintain Motion: 44.5 N (10 lbf) Locks: 9 N (2 lbf)	Report only 200N (45 lbf) max 100 N (22.5 lbf) max	
Air Leakage, Infiltration per ASTM E283 at 75 Pa (1.57 psf)	0.25 L/s/m^2 (0.05 cfm/ft^2)	1.5 L/s/m^2 (0.3 cfm/ft^2) max.	1, 2
Water Penetration, per ASTM E547 144 Pa (3.08 psf)	N/A	N/A	4
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +720 Pa (+15.04 psf) -720 Pa (-15.04 psf)	 N/A N/A	 N/A N/A	6, 7
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +1080 Pa (+22.56 psf) -1080 Pa (-22.56 psf)	 N/A N/A	 N/A N/A	6, 7

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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

TITLE OF TEST	RESULTS	ALLOWED	NOTE
Water Penetration, per ASTM E547 @ 360 Pa (7.52 psf)	Pass	No leakage	3
Uniform Load Deflection, per ASTM E330 Deflections taken at meeting rail +2400 Pa (+50.13 psf) -2400 Pa (-50.13 psf)	 29 mm (1.14") 24 mm (0.95")	 N/A N/A	6, 7
Uniform Load Structural, per ASTM E330 Permanent Set taken at the meeting rail +3600 Pa (+75.19 psf) -3600 Pa (-75.19 psf)	 6 mm (0.24") 6.3 mm (0.25")	 7.3 mm (0.29") 7.3 mm (0.29")	6, 7
Forced Entry Resistance, per ASTM F588, Type: A - Grade: 10	Pass	No entry	
Thermoplastic Corner Weld	Pass	Meets as stated	
Deglazing, per ASTM E987 Operating direction, 320 N (72 lbf) Remaining direction, 230 N (52 lbf)	 Pass Pass	 Meets as stated Meets as stated	

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Note 1: The tested specimen meets (or exceeds) the performance levels specified in AAMA/WDMA/CSA 101/I.S.2/A440 for air leakage resistance.

Note 2: Test Date 03/02/20

Note 3: With and without insect screen(s).

Note 4: The client opted to start at a pressure higher than the minimum required. Test results are reported under Optional Performance.

Note 5: The deflections reported are not limited by AAMA/WDMA/CSA 101/I.S.2/A440 for this product designation. The deflection data is recorded in this report for special code compliance and information only.

Note 6: Loads were held for 10 seconds.

Note 7: Tape and film were used to seal against air leakage during structural testing. In our opinion, the tape and film did not influence the results of the test.

SECTION 10
ALTERATIONS

No alterations were required.

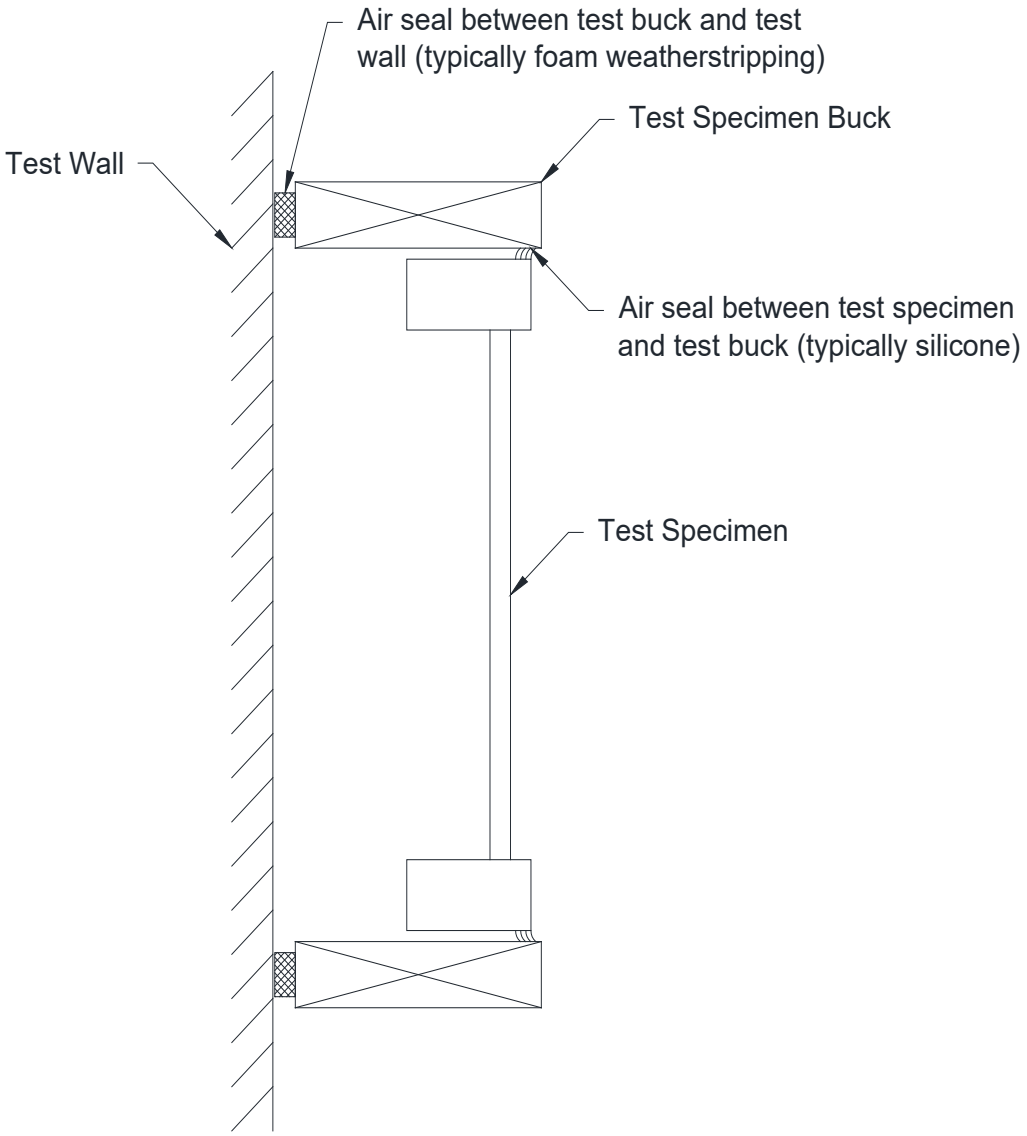
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TEST REPORT FOR WESTLAKE ROYAL WINDOWS
Report No.: K7217.01-801-44-r1
Date: 03/19/20

SECTION 11
LOCATION OF AIR SEAL

The air seal between the test specimen and the test wall is detailed below. The seal is made of foam weatherstripping and is attached to the edge of the test specimen buck. The test specimen buck is placed against the test wall and clamped in place, compressing the weatherstripping and creating a seal.



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SECTION 12
CONCLUSION

The specimens tested successfully met the performance requirements for the following ratings:

TEST SPECIMEN(S)	TITLE	SUMMARY OF RESULTS
1	101/I.S.2/A440-11	Class R-PG50-H

***General Note**: An asterisk (*) next to the size designation indicates that the size tested for optional performance was smaller than the Gateway test size for the product type and class.*

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SECTION 13
DRAWINGS

The test specimen drawings have been reviewed by Intertek B&C and are representative of the test specimen(s) reported herein. Test specimen construction was verified by Intertek B&C per the drawings included in this report. Any deviations are documented herein or on the drawings.

***Note**: Complete drawings packet on file with Intertek B&C.*

BILL OF MATERIALS

SINGLE HUNG (SHB3WW)
SLOPED SILL SMALL SASH

NOTE: THIS BILL OF MATERIALS REFLECTS THE SYSTEM AS TESTED. DEVIATION FROM THE BILL OF MATERIALS IS NOT RECOMMENDED BY VEKA INC. AND MAY REDUCE THE PERFORMANCE OF THE FINISHED PRODUCT.

PVC PROFILES:	PART #	# PER UNIT	SOURCE
HEAD	SHB302	1	VEKA
JAMB	SHB301	2	VEKA
SILL	SHB303	1	VEKA
MEETING RAIL	V-706	1	VEKA
SASH STILE	V-705	2	VEKA
LOCK RAIL	V-704/SE4636	1	VEKA
BOTTOM RAIL	V-705/SE4637	1	VEKA
GLAZING BEAD (3/4" GLASS)	V-716	8	VEKA
GLAZING BEAD (3/4" GLASS)	BV162	8	VEKA
SASH STOP	V-717	2	VEKA
BALANCE COVER	V-760	2	VEKA
INTERMEDIATE JAMB	V-718	1	VEKA
HEAD EXPANDER	AC0156	1	OTHER
H-MULL	AM0096	1	OTHER
J-CHANNEL COVER	AC0155	4	OTHER
SILL ANGLE	AC0157	1	OTHER

REINFORCING PROFILES: Refer to test report for specific reinforcing configurations.

KEEPER RAIL (V-706)	#2230	1	ASCEND
LOCK RAIL (V-704)	#2244	1	ASCEND
STILES (V-705)	#2244	2	ASCEND
INTERMEDIATE JAMB	D-18985	A/R	EXTRUDERS OF ATRIUM

HARDWARE:

LOCK	4621A**	1-2	VISION
TILT LATCH ASSEMBLY	7233AA**	Left and Right	HILL DESIGN
BALANCE	BLOCK AND TACKLE	2	AMESBURY
PIVOT BAR	23111	2	AMESBURY
WEEP HOLE COVER (OUTER)	VWG1625**	2	FAST-SPEC
NITE VENT LATCH	1761**	2	VISION
DRY WALL CLIP	VCP024H-C (WITHOUT NUBS)	2	FOUR JAKS
OR			
DRY WALL CLIP	VCP024 (WITH NUBS)	2	FOUR JAKS

BILL OF MATERIALS

SINGLE HUNG (SHB3WW)
SLOPED SILL SMALL SASH

NOTE: THIS BILL OF MATERIALS REFLECTS THE SYSTEM AS TESTED. DEVIATION FROM THE BILL OF MATERIALS IS NOT RECOMMENDED BY VEKA INC. AND MAY REDUCE THE PERFORMANCE OF THE FINISHED PRODUCT.

WEATHERSTRIPPING:	PART #	#PER UNIT	SOURCE
BOTTOM SASH BULB	32684**	1	AMESBURY
LOCK RAIL (V-704)	.230 X .187	A/R	AMESBURY ULTRAFAB
FRAME SILL (SHB303)	.270 X 187	A/R	AMESBURY ULTRAFAB
COMMON SASH (V-705)	.310 X .187	A/R	AMESBURY ULTRAFAB
GLAZING:			
DOUBLE FACE TAPE	1/16" X 1/2" AWT**	A/R	ARLON
	1/16" X 1/2"	A/R	VENTURE
LIQUID BACK BEDDING	SBC1M150	A/R	NOVAGUARD
SILICONE	896	A/R	PECORA
	899	A/R	DOW CORNING
GLAZING BLOCKS	1/8" THICK	A/R	TREMCO
SILICONE SEALANT	NOVAFLEX M418*	A/R	NOVAGUARD
SCREWS: NOTE ALL SCREWS ARE ZINC PLATED OR STAINLESS STEEL SHEET METAL TYPE, UNLESS OTHEREWISE NOTED.			
LOCK	#8 X 5/8" FHP**	2-4	MERCHANTS
MEETING RAIL	#8 X 2-1/2" THP**	2	MERCHANTS
BALANCE	#8 X 3/8" PHP	A/R	MERCHANTS
PIVOT BAR	#6 X 3/8" PHP	8	MERCHANTS
INTERMEDIATE JAMB	#8 X 3" THP	4	MERCHANTS
DRY WALL CLIP			
(MEETING RAIL TO CLIP)	#8 X 3/4" WITH #6 HEAD FHP	2	AU-VE-CO
(CLIP TO JAMB)	#8 X 1" FHP	4	MERCHANTS

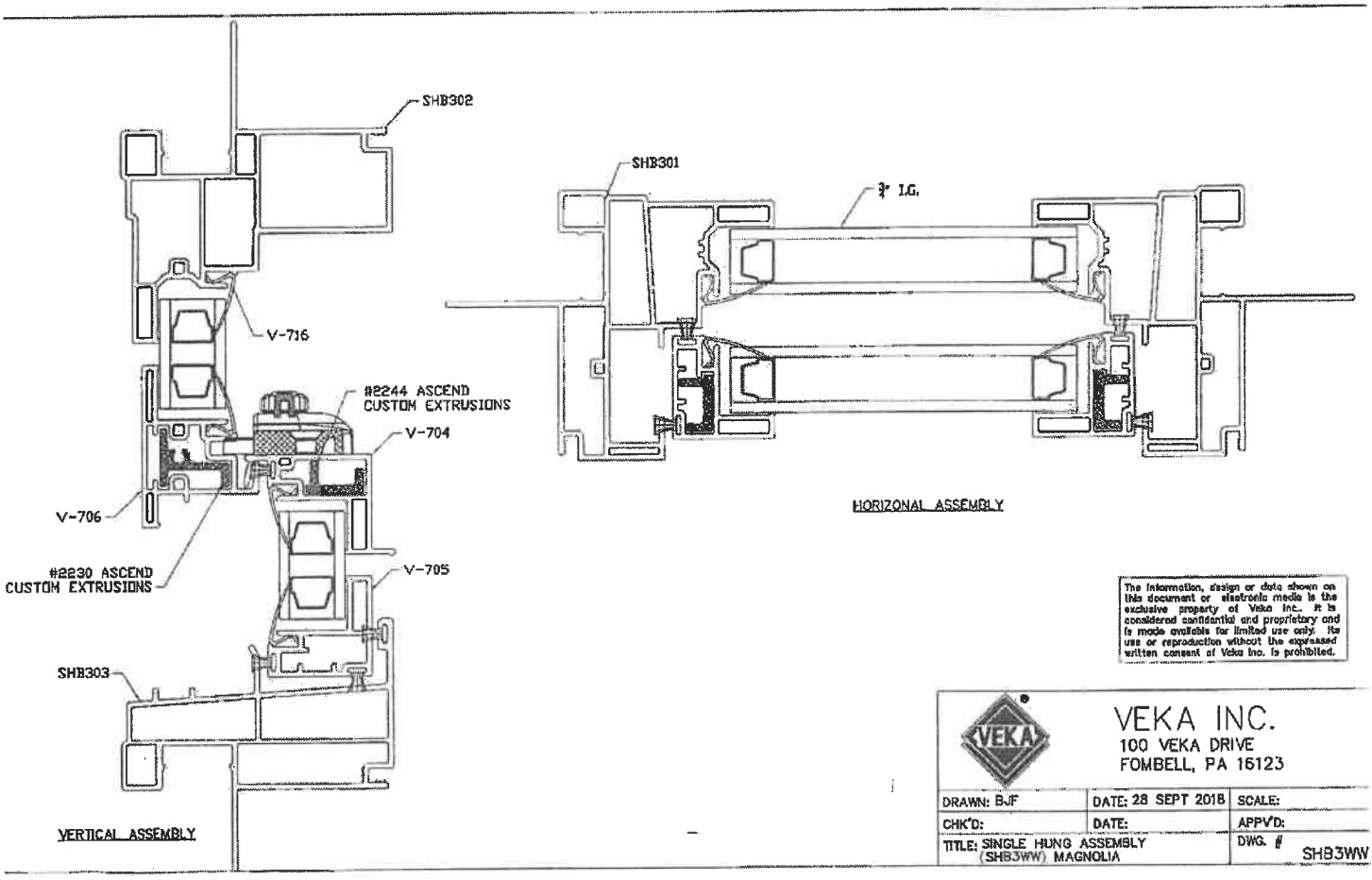
** = COLOR

A/R = AS REQUIRED

Rev. 01-28-20

intertek
Total Quality Assured.

Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump



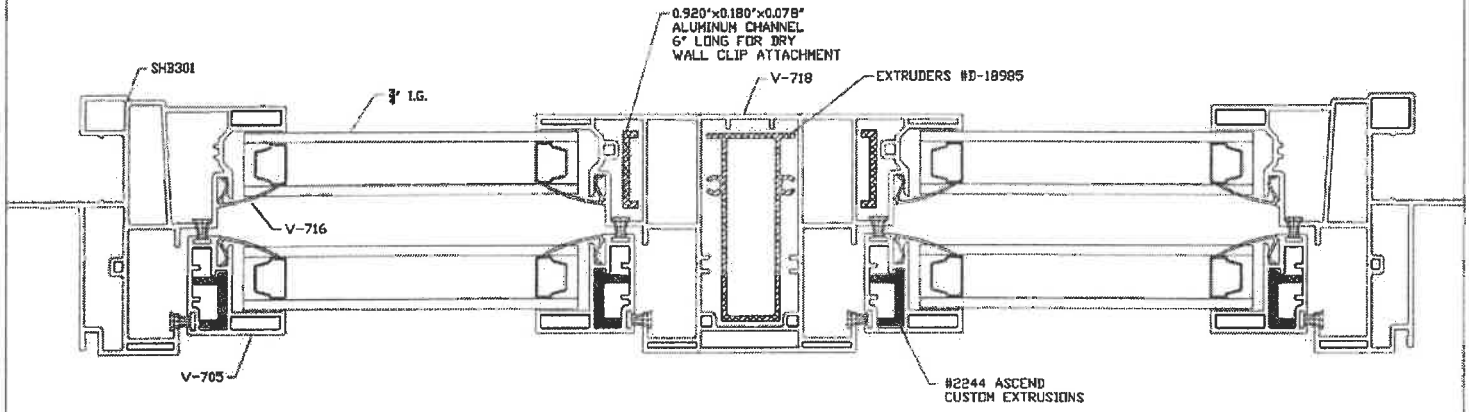
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VEKA INC.
100 VEKA DRIVE
FOMBELL, PA 16123

DRAWN: BJF	DATE: 28 SEPT 2018	SCALE:
CHK'D:	DATE:	APPV'D:
TITLE: SINGLE HUNG ASSEMBLY (SHB3WW) MAGNOLIA		DWG. # SHB3WW

Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump

Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump



HORIZONAL ASSEMBLY

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VEKA INC.
100 VEKA DRIVE
FOMBELL, PA 16123

DRAWN: BJF	DATE: 28 SEPT 2018	SCALE:
CHK'D:	DATE:	APPV'D:
TITLE: SINGLE HUNG TWIN ASSEMBLY (SHB3WW) MAGNOLIA		DWG. # SHB3WW

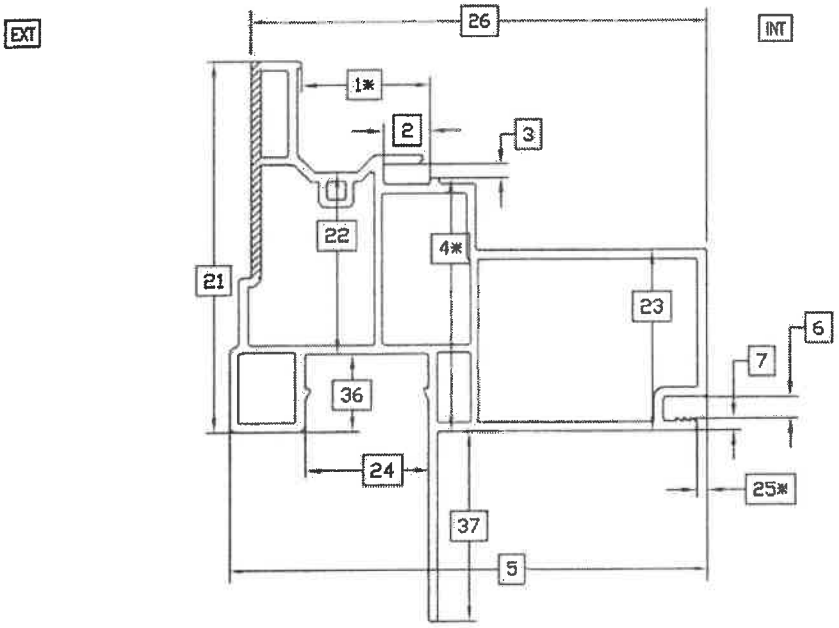
VEKA INC.

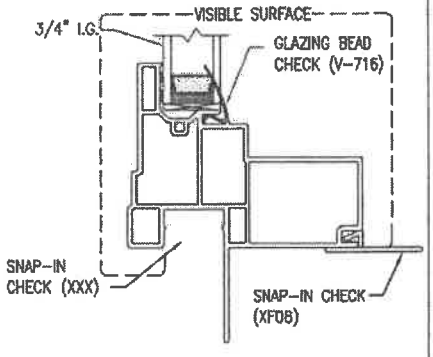
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED: SMB
APPROVED: _____

DATE REV A: 18 SEPT 2018





SHB302

* = COMPARATOR CHECK

RED	1*= 21.1 ±0.3					
	2 = 7.7 +0.3, −0.1					
	3 = 2.3 ±0.2					
	4*= 42.4 ±0.3					
	5 = 78.5 ±0.3					
	6 = 3.6 ±0.2					
	7 = 2.2 ±0.2					
	8 =					
	9 =					
	10 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT					
WALL REF.	OUTER WALL 1.5					
	INNER WEBS 1.3					
	IMPACT WALL					

intertek
Total Quality. Assured.

Report #: K7217.01-801-44
Date: 03/19/20
Verified by: J. Crump

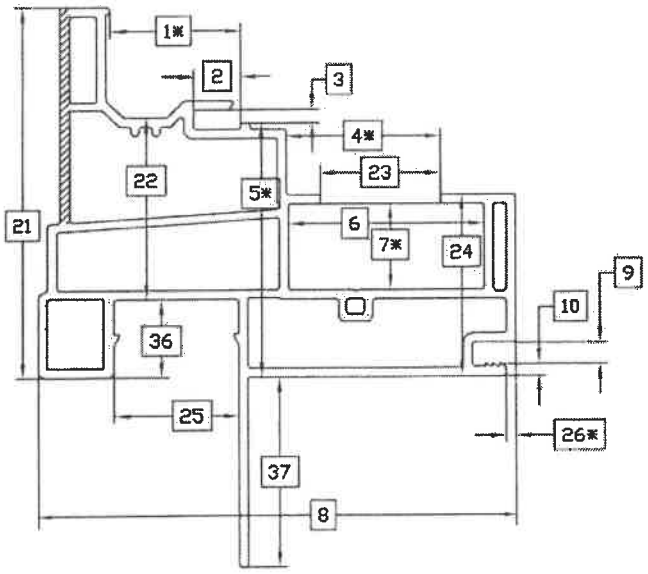
BLUE	21 = 62.1 ±0.3					
	22 = 30.4 ±0.3					
	23 = 30.3 ±0.3					
	24 = 20.1 ±0.3					
	25*= 1.6 +0.2, −0.3					
	26 = 75.0 ±0.3					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 = 13.0 ±0.4, −0.2					
	37 = 31.8 ±0.5					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	PIVOT SHOE FIT					
	SNAP-IN CK (XF08)					
	GLAZING BEAD CK (V-716)					

VEKA INC.
PRODUCT CONTROL SHEET

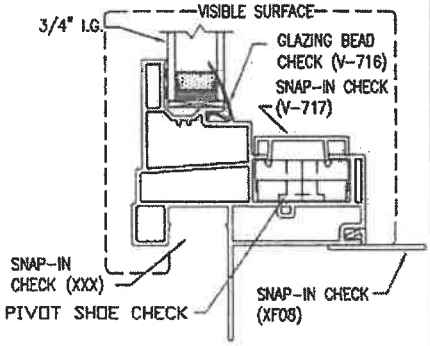
3-TIER QUALIFIED

DRAWN: JMN
CHECKED: JLB
APPROVED: _____
DATE: 7 SEPT 2018

EXT



INT



SHB301

*= COMPARATOR CHECK

RED	1*= 21.1 ±0.3					
	2 = 7.7 +0.3, −0.1					
	3 = 2.3 ±0.2					
	4*= 25.8 ±0.3					
	5*= 42.4 ±0.3					
	6 = 32.8 ±0.3					
	7*= 14.3 ±0.3					
	8 = 78.5 ±0.3					
	9 = 3.6 ±0.2					
	10 = 2.2 ±0.2					
	11 =					
	12 =					
	13 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT					
WALL REF.	OUTER WALL 1.5					
	INNER WEBS 1.3					
	IMPACT WALL					

BLUE	21 = 62.1 ±0.3					
	22 = 30.4 ±0.3					
	23 = 20.2 ±0.3					
	24 = 30.3 ±0.3					
	25 = 20.1 ±0.3					
	26*= 1.6 +0.2, −0.3					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 = 13.0 ±0.4, −0.2					
	37 = 31.8 ±0.5					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	PIVOT SHOE FIT					
	SNAP-IN CK (XF08, V-717)					
	GLAZING BEAD CK (V-716)					

intertek
Total Quality Assured.

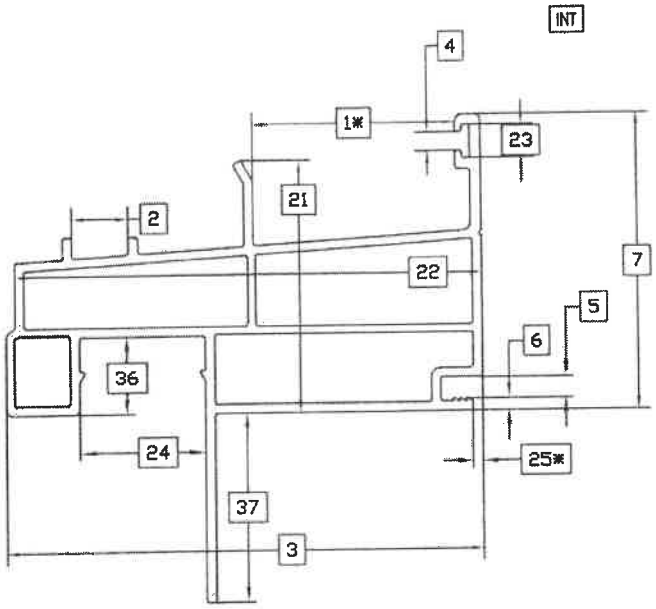
Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump

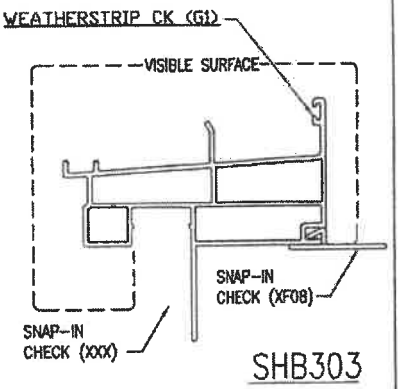
VEKA INC.
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED: JLB
APPROVED:
DATE: 10 SEPT 2018

EXT





SHB303

* = COMPARATOR CHECK

RED	1*= 33.9 +0.4, −0.2	BLUE	21 = 42.1 ±0.3			
	2 = 9.1 ±0.3		22 = 77.0 ±0.3			
	3 = 78.5 ±0.3		23 = 5.5 ±0.3			
	4 = 3.2 +0.2,−0.3		24 = 20.1 ±0.3			
	5 = 3.6 ±0.2		25*= 1.6 ±0.3			
	6 = 2.2 ±0.3		26 =			
	7 = 49.5 ±0.3		27 =			
	8 =		28 =			
	9 =		29 =			
	10 =		30 =			
	11 =		31 =			
	12 =		32 =			
	13 =		33 =			
	14 =		34 =			
	15 =		35 =			
	16 =	BLACK	36 = 13.0 ±0.4, −0.2			
	17 =		37 = 31.8 ±0.5			
	18 =		38 =			
	19 =		39 =			
	20 =		40 = LENGTH ±1"			
	GO-GAUGE CHECK	FUNCTION/AESTHETICS	SQUARENESS CHECK			
	BOW MAX. 1mm/M.		SURFACE BOOTH P/F			
	PROFILE WEIGHT		SNAP-IN CK (XF08)			
WALL REF.	OUTER WALL 1.5		WEATHERSTRIP CK			
	INNER WEBS 1.3					

intertek
Total Quality. Assured.
Report #: K7217.01-801-44
Date: 03/19/20
Verified by: J. Crump

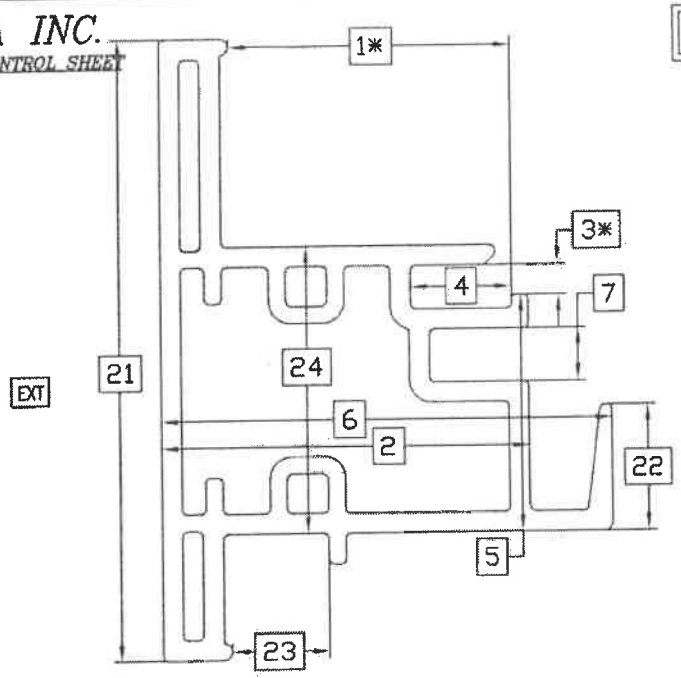
VEKA INC.

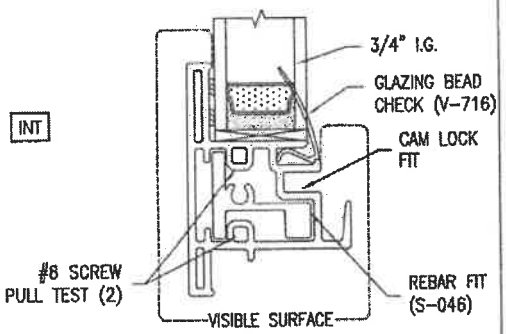
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED:
APPROVED:

DATE REV F: 1 MAR 2017





V-706

* = COMPARATOR CHECK

RED	1*= 21.1 ±0.3					
	2 = 27.6 ±0.3					
	3*= 2.3 ±0.2					
	4 = 7.7 +0.3, −0.1					
	5 = 18.0 ±0.2					
	6 = 33.9 ±0.3					
	7 = 4.1 ±0.3					
	8 =					
	9 =					
	10 =					
	11 =					
	12 =					
	13 =					
	14 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT					
WALL REF.	OUTER WALL 1.5					
	INNER WALL 1.3					

BLUE	21 = 47.2 ±0.3					
	22 = 9.6 +0.2, −0.4					
	23 = 7.1 ±0.3					
	24 = 21.8 ±0.3					
	25 =					
	26 =					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 =					
	37 =					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	GLAZING BEAD CK (V-716)					
	REBAR (S-046)					
	#8 SCREW PULL TEST					
	CAM LOCK FIT					

intertek
Total Quality. Assured.

Report #: K7217.01-801-44
Date: 03/19/20
Verified by: J. Crump

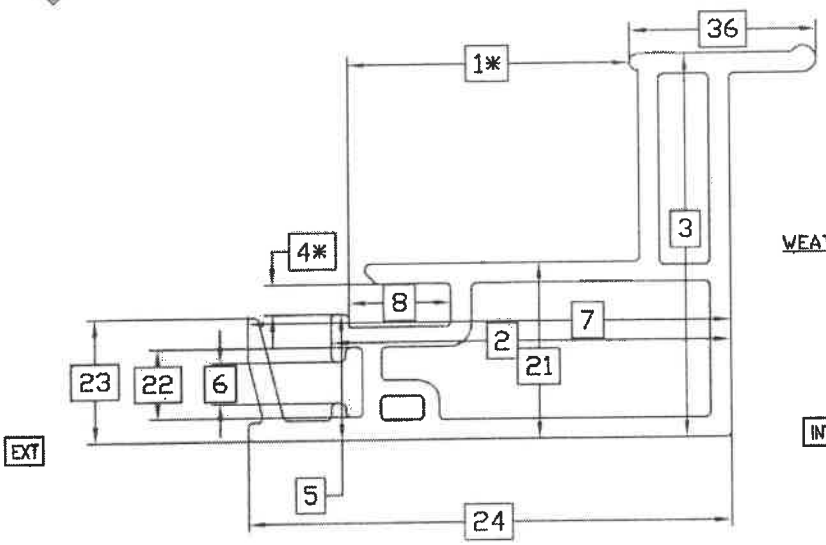
VEKA INC.

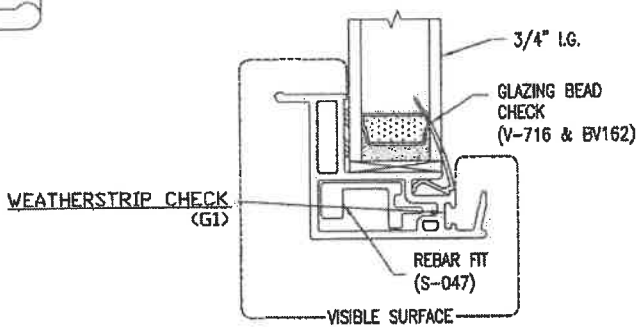
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED:
APPROVED: JCS

DATE REV F: 18 MAY 2015





V-704

* = COMPARATOR CHECK

RED	1*= 21.1 ±0.3					
	2 = 29.9 ±0.3					
	3 = 29.4 ±0.3					
	4*= 2.3 ±0.2					
	5 = 9.7 ±0.2					
	6 = 3.2 +0.2, −0.3					
	7 = 36.3 ±0.3					
	8 = 7.7 +0.3, −0.1					
	9 =					
	10 =					
	11 =					
	12 =					
	13 =					
	14 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT					
WALL REF.	OUTER WALL 1.5					
	INNER WALL 1.3					

BLUE	21 = 13.5 ±0.3					
	22 = 5.3 ±0.3					
	23 = 9.5 +0.2, −0.4					
	24 = 36.3 ±0.3					
	25 =					
	26 =					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 = 14.3 ±0.4					
	37 =					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	GLAZING BEAD CK (V-716)					
	WEATHERSTRIP CK					
	REBAR (S-047)					

intertek
Total Quality. Assured.

Report #: K7217.01.801-44
Date: 03/19/20
Verified by: J. Crump

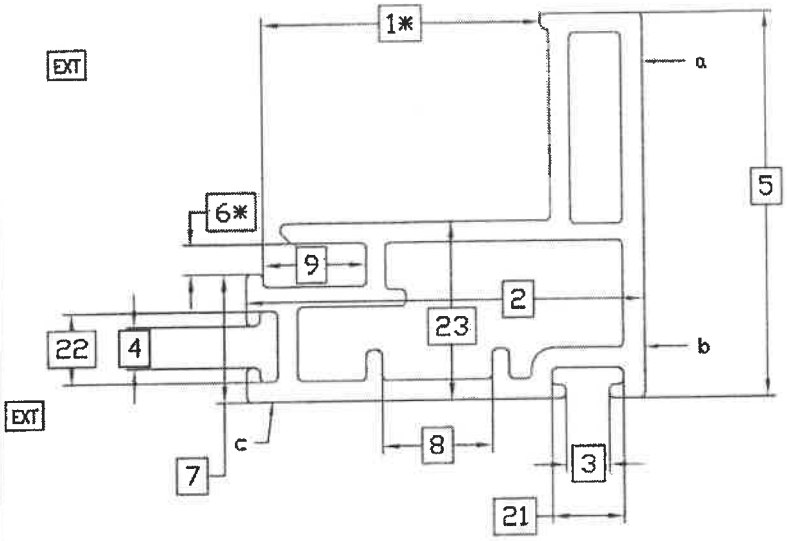
VEKA INC.

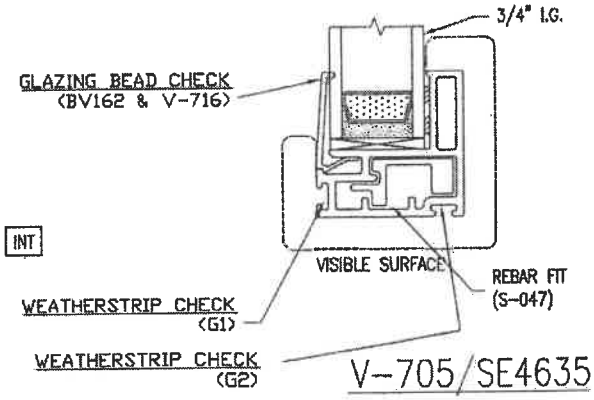
PRODUCT CONTROL SHEET

3-TIER QUALIFIED

DRAWN: JMN
CHECKED:
APPROVED: JCS

DATE REV 0: 28 OCT 2016





V-705/SE4635

* = COMPARATOR CHECK (USE LINE-UP PTS. a, b, & c)

RED	1*= 21.1 ±0.3					
	2 = 29.9 ±0.3					
	3 = 3.2 +0.2, −0.3					
	4 = 3.2 +0.2, −0.3					
	5 = 29.4 ±0.3					
	6*= 2.3 ±0.2					
	7 = 9.7 ±0.2					
	8 = 8.3 ±0.3					
	9 = 7.7 +0.3, −0.1					
	10 =					
	11 =					
	12 =					
	13 =					
	14 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT					
WALL REF.	OUTER WALL 1.5					
	INNER WALL 1.3					

BLUE	21 = 5.3 ±0.3					
	22 = 5.3 ±0.3					
	23 = 13.5 ±0.3					
	24 =					
	25 =					
	26 =					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 =					
	37 =					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	GLAZING BEAD CK (BV162 & V-716)					
	WEATHERSTRIP CK					
	REBAR (S-047)					

intertek
Total Quality. Assured.

Report #:	K7217.01-80144
Date:	03/19/20
Verified by:	J. Crump

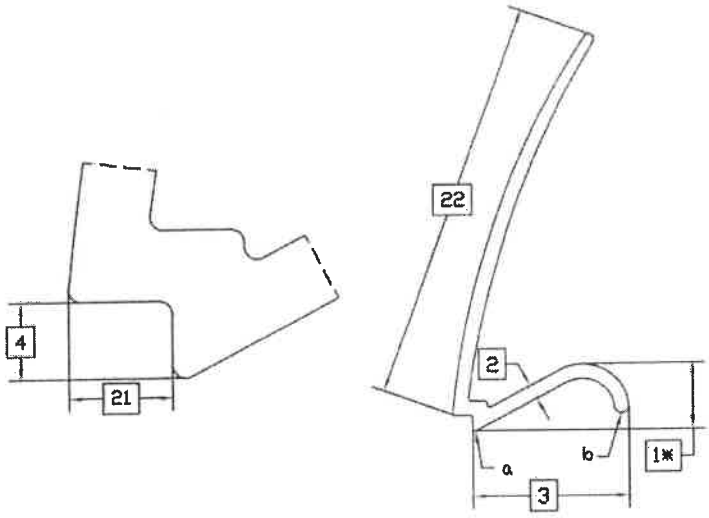
VEKA INC.

PRODUCT CONTROL SHEET

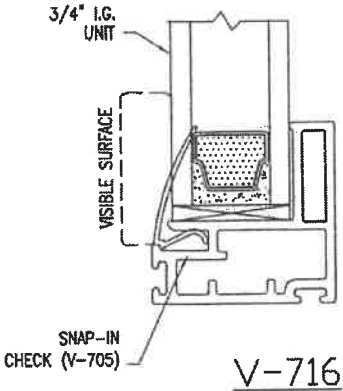
3-TIER QUALIFIED

DRAWN: JMN
CHECKED:
APPROVED:

DATE rev e: 30 MAY 2018



USE LINE-UP PTS. a & b



V-716

* = COMPARATOR/ PROMEX CHECK

RED	1*= 3.3 ±0.3					
	2 = 0.7 ±0.2					
	3 = 7.7 +0.0. −0.4					
	4 = 0.8 ±0.2					
	5 =					
	6 =					
	7 =					
	8 =					
	9 =					
	10 =					
	11 =					
	12 =					
	13 =					
	14 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT ±10%					
WALL REF.	0.7 WALL					

BLUE	21 = 1.0 ±0.3					
	22 = 20.4 ±0.4					
	23 =					
	24 =					
	25 =					
	26 =					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 =					
	37 =					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SURFACE BOOTH P/F					
	SNAP-IN CK (V-705)					

intertek
Total Quality. Assured.

Report #: K7217.01-801-44
Date: 03/19/20
Verified by: J. Crump

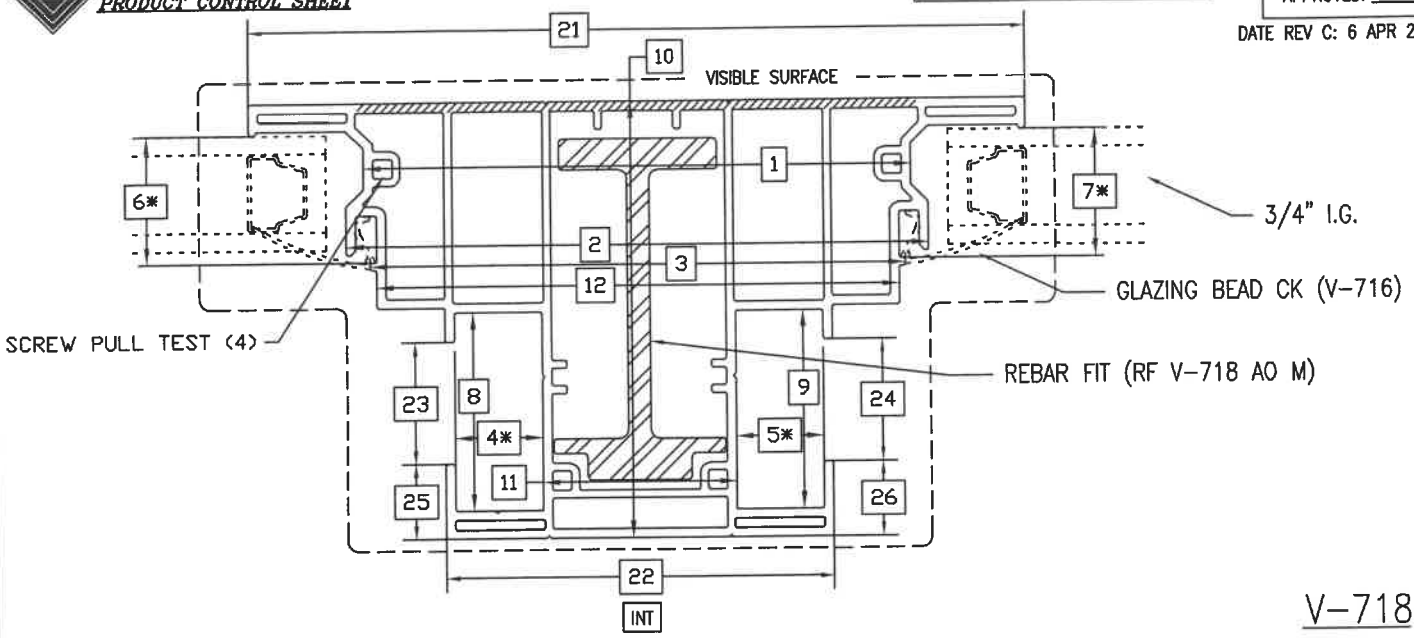
VEKA INC.

PRODUCT CONTROL SHEET

EXT

3-TIER QUALIFIED

DRAWN: JMN
CHECKED:
APPROVED:
DATE REV C: 6 APR 2018



V-718

* = COMPARATOR/ PROMEX CHECK

RED	1 = 89.7 ±0.3					
	2 = 95.3 ±0.3					
	3 = 87.6 ±0.3					
	4*= 14.3 ±0.3					
	5*= 14.3 ±0.3					
	6*= 21.1 ±0.3					
	7*= 21.1 ±0.3					
	8 = 32.8 ±0.3					
	9 = 32.8 ±0.3					
	10 = 72.1 ±0.3					
	11 = 31.9 ±0.3					
	12 = 85.6 ±0.3					
	13 =					
	14 =					
	15 =					
	16 =					
	17 =					
	18 =					
	19 =					
	20 =					
	GO-GAUGE CHECK					
	BOW MAX. 1mm/M.					
	PROFILE WEIGHT ±10%					
WALL REF.	OUTER WALL 1.5					
	INNER WEBS 1.3					
	IMPACT WALL					

BLUE	21 = 127.0 ±0.4					
	22 = 63.5 ±0.3					
	23 = 20.2 ±0.3					
	24 = 20.2 ±0.3					
	25 = 12.4 ±0.3					
	26 = 12.4 ±0.3					
	27 =					
	28 =					
	29 =					
	30 =					
	31 =					
	32 =					
	33 =					
	34 =					
	35 =					
BLACK	36 =					
	37 =					
	38 =					
	39 =					
	40 = LENGTH ±1"					
FUNCTION/AESTHETICS	SQUARENESS CHECK					
	SURFACE BOOTH P/F					
	PIVOT SHOE FIT					
	#8 SCREW PULL TEST					
	GLAZING BEAD (V-716)					
	REBAR FIT					

intertek
Total Quality. Assured.

Report #: K7217.01-801-44
Date: 03/19/20
Verified by: J. Crump

SOLID	SEMI-HOLLOW	HOLLOW
■	□	□

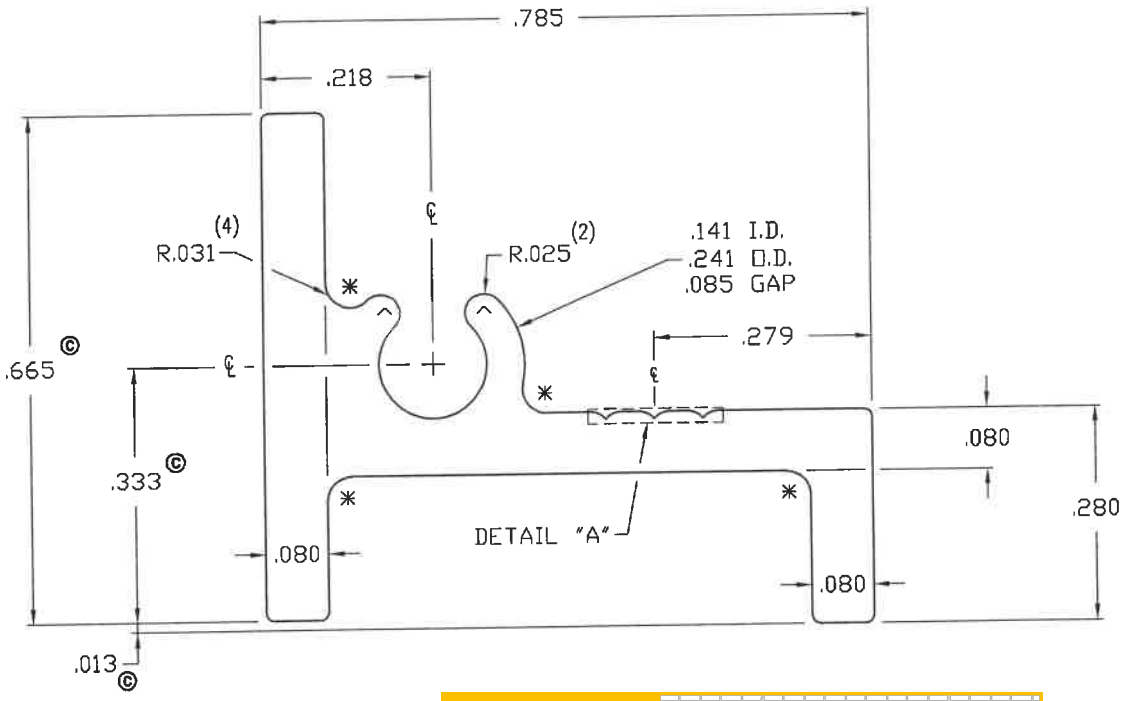
TITLE

STIFFENER

DIE NO.	2230-C
CUSTOMER PT. NO.	-
CUTTING LENGTH	-

ALLOY: 6063 TEMPER: T5 CIRCLE SIZE: 1.2 © P/P POCKET SIZE: -

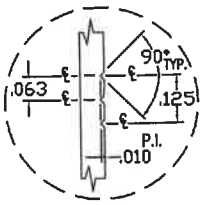
ALL TOLERANCES -- ALUMINUM ASSOCIATION STANDARD -- UNLESS SPECIFIED OTHERWISE



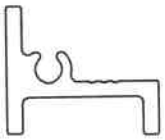
intertek
Total Quality. Assured.

Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump

DETAIL "A"
SCALE 2:1
I.D. MARKS



ACTUAL SIZE



NO EXPOSED SURFACE

±.006
.080 TYPICAL WALL THICKNESS EXCEPT AS NOTED

BREAK SHARP CORNERS .010 R. EXCEPT AS NOTED

EST.AREA in^2	.146 ©	EST.TOTAL PER.	3.546 ©
EST.AREA cm^2	-	EST.OUTSIDE PER.	-
EST.WT. PER ft	.175 ©	CODE (P) FACTOR	20 ©
MAX WT.PER ft	.189 ©	PRESS LOCATION:	-
DIE SIZE	-	BACKER SIZE	- -

DATE	NO.	REVISIONS	BY
10/1/14	1	CHANGED CUSTOMER NAME TO KRESTMARK	RM
10/22/14	B	REVISED SHAPE & DATA PER CUSTOMER	RM
11/24/14	C	ADDED METAL TO LEFT SIDE & REVISED DATA .520 TO .665	RM



ASCEND CUSTOM EXTRUSIONS, LLC.

P.O. Box 1270
Wylie, Texas 75098-1270

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CUSTOMER:	KRESTMARK ①				
CITY:	-				
DRAWN BY:	RM	DATE:	9/18/14	DWG. NO.	D-202616
SCALE:	4:1				

SOLID	SEMI-HOLLOW	HOLLOW
■	□	□

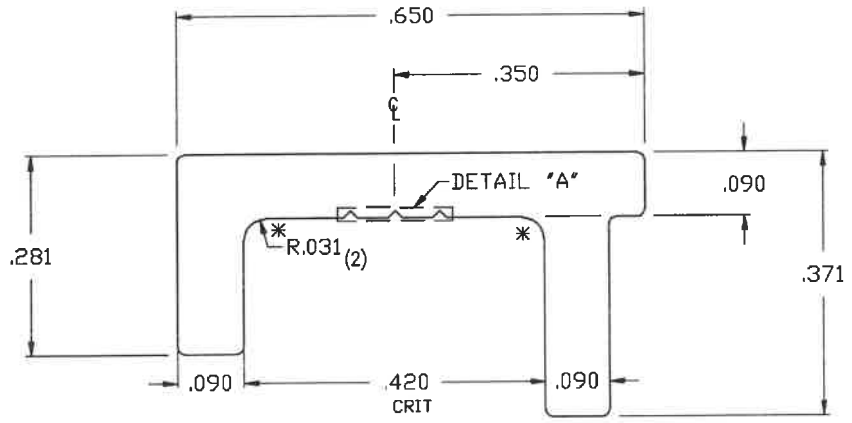
TITLE

RAIL STIFFENER

DIE NO.	2244-A
CUSTOMER PT. NO.	-
CUTTING LENGTH	-

ALLOY: 6063 TEMPER: T5 CIRCLE SIZE: 0.8 P/P POCKET SIZE: -

ALL TOLERANCES -- ALUMINUM ASSOCIATION STANDARD -- UNLESS SPECIFIED OTHERWISE



intertek
Total Quality Assured.

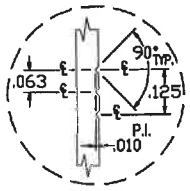
Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump

ACTUAL SIZE



NO EXPOSED SURFACE

DETAIL "A"
SCALE 2:1
I.D. MARKS



±.006
.090 TYPICAL WALL THICKNESS EXCEPT AS NOTED

BREAK SHARP CORNERS .010 R. EXCEPT AS NOTED

EST.AREA in^2	.101	EST.TOTAL PER.	2.387
EST.AREA cm^2	-	EST.OUTSIDE PER.	-
EST.WT. PER ft	.131	CODE (P) FACTOR	18
EST.Kg. PER M	-	PRESS LOCATION:	-
DIE SIZE	-	BACKER SIZE	-

DATE	NO.	REVISIONS	BY
-	-	-	-



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CUSTOMER:	KRESTMARK		
CITY:	-		
DRAWN BY: RM	DATE: 10/22/14	DWG. NO.	D-202685
SCALE: 4:1			

SOLID	SEMI-HOLLOW	HOLLOW
☐	☐ CLASS II	

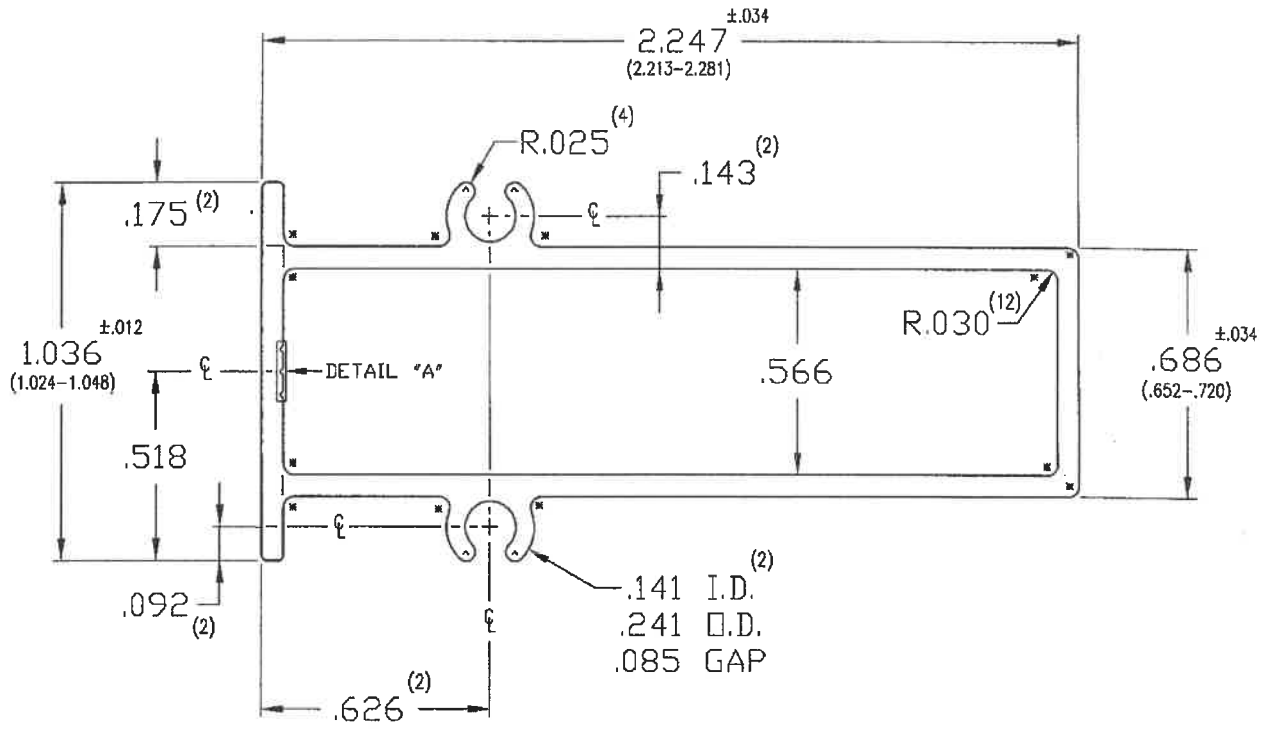
TITLE

450 COMMON JAMB

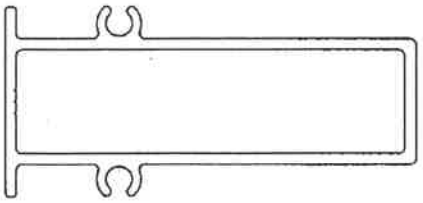
DIE NO.	2480-A
CUSTOMER PT. NO.	-
CUTTING LENGTH	-

ALLOY: 6063 TEMPER: T5 CIRCLE SIZE: 2.5 P/P POCKET SIZE: -

ALL TOLERANCES -- ALUMINUM ASSOCIATION STANDARD -- UNLESS SPECIFIED OTHERWISE



ACTUAL SIZE



NO EXPOSED SURFACE

DRAWING APPROVAL

Please approve die print & return one copy.

X _____

Date _____

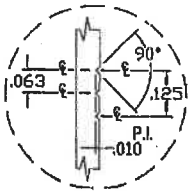
Sample Length _____

Tooling Cost _____

intertek Total Quality. Assured.

Report #:	K7217.01-801-44
Date:	03/19/20
Verified by:	J. Crump

DETAIL "A" SCALE 2:1 I.D. MARKS



±.006
.060 TYPICAL WALL THICKNESS EXCEPT AS NOTED

BREAK SHARP CORNERS .015 R. EXCEPT AS NOTED

EST.AREA in²	.401	EST.TOTAL PER.	13.047
EST.AREA cm²	-	EST.OUTSIDE PER.	7.688
EST.WT. PER ft	.481	CODE (P) FACTOR	27
MAX WT.PER ft	.519	PRESS LOCATION:	-
DIE SIZE	-	BACKER SIZE -	-

DATE	NO.	REVISIONS	BY
-	-	-	-



ASCEND CUSTOM EXTRUSIONS, LLC.

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Wylie, Texas 75098-1270

CUSTOMER:	KRESTMARK				
CITY:	-				
DRAWN BY:	RM	DATE:	3/23/15	DWG. NO.	D-203023
SCALE:	2:1				

1909 10th Street, Suite 100
Plano, Texas 75074

Telephone: 469-814-0687
www.intertek.com/building

SECTION 14
REVISION LOG

REVISION #	DATE	PAGES	REVISION
0	03/19/20	N/A	Original Report Issue
1	07/22/22	Cover, 2	Changed client name to Westlake Royal Windows

Westlake
Royal Window Solutions™
Legacy Collection



NEW CONSTRUCTION

900 SERIES

900 SERIES



FEATURES

- Single-point locking hardware.
- All welded frame & sash.
- Internal weep system.
- Plated steel adjustable tandem rollers, lock and striker.
- New construction nail fin.
- Flexible PVC bumpers.
- Field Reversible. (XO, OX)
- 16 gauge steel reinforcing.
- Accommodates up to 1" glazing.
- Dual seal weatherstripping.
- Exterior glazed.
- AAMA approved PVC lineal certification.
- NFRC simulations.
- ENERGY STAR® Partner.

OPTIONS

- Two-point locking hardware.
- Keyed lock cylinder.

CARDINAL IG

COLOR OPTIONS

WHITE PEBBLESTONE CLAY

PERFORMANCE DATA

	U-F	SHGC
Clear Glass No Grids	.46	.70
Clear Glass w/ Grids	.46	.62
LoE366 Air No Grids	.30	.24
LoE366 Air w/ Grids	.30	.21
LoE366 Argon No Grids	.27	.24
LoE366 Argon w/ Grids	.27	.21

Check local jurisdictions for current energy codes.
AAMA Performance Data: R-PG30-SGD.

You may qualify for a tax credit when you replace your existing windows. For more information, go to energystar.gov

For information about measuring & installing Legacy Collection windows, visit our website: WestlakeRoyalWindows.com

1813 Kelly Blvd. • Carrollton, TX • PH: 972.996.5165 • FX: 972.996.5194

Westlake Royal Building Products™

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AAMA CERTIFICATION PROGRAM

An FGIA Product Certification Program

AUTHORIZATION FOR PRODUCT CERTIFICATION

Legacy Vinyl Windows, L.P.
1813 Kelly Blvd.
Carrollton, TX 75006

Attn: John Wnuk

This authorization is based on the successful completion of tests, and the reporting to the AAMA Validator of the results of the tests by an AAMA Accredited Laboratory. The product information below will be added to the next update of the AAMA Certified Products Directory.

SPECIFICATION	RECORD OF PRODUCT TESTED			
AAMA/WDMA/CSA 101/I.S.2/A440-17 R-PG15-2426x2426 (96x96)-SD				
COMPANY AND CODE	**CPD NO.**	**SERIES MODEL & PRODUCT DESCRIPTION**	**MAXIMUM SIZE TESTED**	
Legacy Vinyl Windows, L.P. Code: LVW	**20478**	**900 SGD (PVC)(OX)(OG)(INS GL) (REINF)(ASTM)**	**FRAME 2426 mm x 2426 mm (8'0" x 8'0")**	**PANEL 1241 mm x 2369 mm (4'1" x 7'9")**

This Certification will expire **December 13, 2027** and requires validation until then by continued listing in the current AAMA Certified Products Directory.

Product Tested and Reported by: **Construction Consulting Laboratory**

Report No.: **CCL 22-234**

Date of Report: **December 14, 2022**

Evaluated for Certification: **December 15, 2022**

Associated Laboratories, Inc.

A·L·I

(Validator / Operations Administrator)

Authorized for Certification: **December 15, 2022**

Fenestration and Glazing Industry Alliance