

TEST REPORT

ASTM E331

ASTM E330

REPORT No.: 2087.04-105-11-R1

RENDERED TO: GAMCO CORPORATION
Flushing, New York

PRODUCT TYPE: Aluminum Outswing Entry Door

SERIES / MODEL: D350

Test	Summary of Results
Design Pressure	±1680 Pa (±35.09 psf)
Water Penetration Resistance Test Pressure	0 Pa (0 psf)

Test Completion Date: 1/13/2020

Reference must be made to Report No. 2087.04-105-11-R1, revision dated 7/31/2020 for complete test specimen description and detailed test results.

CLIENT INFORMATION: GAMCO CORPORATION
131-10 Maple Avenue
Flushing, New York 11355

TEST LABORATORY: Molimo, LLC
1410 Eden Road
York, Pennsylvania 17402
717-900-6034

PROJECT SUMMARY:

PRODUCT TYPE: Aluminum Outswing Entry Door

SERIES/MODEL: D350

PROJECT SUMMARY:

Molimo, LLC was contracted to perform testing on the above referenced product. The results are tested values and were secured by using the designated test methods.

PROJECT DETAILS:

Test Dates: 10/7/2019 – 1/13/2020

Test Record Retention End Date: 1/13/2024

Test Location: Molimo, LLC test facility in York, Pennsylvania.

Test Specimen Source: The test specimen was provided by the client. Representative samples of the test specimen will be retained by Molimo for a minimum of four years from the test completion date.

Drawing Reference: The test specimen drawings were supplied by the client. The test specimen construction was verified by Molimo and was found to be representative of the product tested. Test specimen drawings are located in Appendix C of this report.

WITNESSES:

The following representatives witnessed all or part of the testing.

Name	Company
Michael D. Stremmel, P.E.	Molimo, LLC
Joseph W. Enriquez	Molimo, LLC

TEST METHODS:

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 E331-00(16) – *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors and Curtain Walls by Uniform Static Air Pressure Difference*

TEST SPECIMEN DESCRIPTION:

PRODUCT SIZES:

Overall Size: 1016 mm x 2184 mm (40" x 86")

Overall Area: 2.22 m² (23.88 ft²)

Leaf Size: 889 mm x 2096 mm (35" x 82-1/2")

FRAME CONSTRUCTION:

Material: Extruded aluminum

Corner Details: Square-cut and butted and mechanically fastened.

Head/Jamb Corners: Secured with two #12 x 1" pan head screws per corner

Sill/Jamb Corners: Secured using an extruded aluminum block under the threshold, using two #8 x 1-1/2" screws into the jamb and one #10 x 1/2" flat head screw into the block

Other Details: The jambs and head were constructed of two pieces of aluminum framing, snap-fit to each other

The head and jambs utilized a snap-in aluminum panel stop.

LEAF CONSTRUCTION:

Material: Extruded aluminum

Corner Details: Square-cut and butted, secured with one 3/8" threaded rod through the top and bottom rail with washers and nuts in each stile. An aluminum shear block was secured at each intersection with one #8 x 1" flat head screw.

REINFORCEMENT: No reinforcement was utilized.

TEST SPECIMEN DESCRIPTION: (Continued)

GLAZING DETAILS: *No conclusions of any kind regarding the adequacy or inadequacy of the glass in any glazed test specimen can be made.*

Description	Detail
Glass Type	1" IG
Glazing Construction (Exterior to Interior)	1/4" Thick tempered glass 1/2" Aluminum box type spacer system 1/4" Thick tempered glass
Glazing Method	Channel glazed using interior and exterior snap-in glazing beads, with bulb gasket against the glass
Glazing Bite	1/2"
Daylight Opening:	756 mm x 1943 mm (29-3/4" x 76-1/2")

WEATHERSTRIPPING:

Description	Quantity	Location
1/4" diameter hollow bulb gasket	1 Row	Head, jambs, and threshold
0.290" high polypile	2 Rows	Leaf bottom rail

DRAINAGE: No drainage was utilized.

HARDWARE:

Description	Quantity	Location
Full length, piano style hinge	1	Hinge stile
Lock assembly	1	Lock stile, 40" from the bottom rail
Interior and exterior pull handle	1	40" From the bottom rail

INSTALLATION: The specimen was installed into a Spruce-Pine-Fir wood buck. The rough opening allowed for a 1/8" shim space. The exterior perimeter of the specimen was sealed with sealant.

Location	Anchor Description	Anchor Spacing
Head and Jambs	1" x 2", 0.050" thick, 3" long aluminum clips, secured to the door frame with one #8 x 1/2" screw and secured to the wood buck with one #8 x 1-1/2" wood screw	3" From each end and spaced 16" on center

TEST RESULTS: The temperature during testing was 19° C (66.5° F).

WATER PENETRATION TESTING: (per ASTM E 331)

Test	Results	Allowable
0 Pa (0 psf)	Pass	No Leakage

UNIFORM LOAD TESTING: (per ASTM E 330)

Design Pressure Test	Results	Allowable
Deflection measured at the panel lock stile +2160 Pa (+45.11 psf) -2160 Pa (-45.11 psf)	1.5 mm (0.06") 11.4 mm (0.45")	Report Only

Structural Test	Results	Allowable
Permanent Set measured at the panel lock stile +3240 Pa (+67.67 psf) -3240 Pa (-67.67 psf)	0.5 mm (0.02") 0.3 mm (0.01")	10.4 mm (0.41") 10.4 mm (0.41")

Note #1: All loads were held for 10 seconds.

Note #2: Tape and film were used to seal against air leakage. In our opinion, the tape and film did not influence the results of the test.

Note #3: Measurements were made on a cantilever span on the lock stile. Lock to corner measurement of 51" (102" overall span) was utilized for all deflection/permanent set measurements. Permanent set allowable is based on 0.04% of the measured span.

General Note: All testing was performed in accordance with reference test methods.

A copy of this report, detailed drawings, datasheets, representative samples of test specimens, or other pertinent project documentation will be retained by Molimo, LLC for the entire test record retention period. At the end of this retention period, the service life of this report will expire.

Results obtained are tested values and were secured by using the designated test methods. This test report does not constitute certification of this product nor an opinion or endorsement by this laboratory. It is the exclusive property of the client so named herein and relates only to the specimen(s) tested. This report may not be reproduced, except in full, without the written permission of Molimo, LLC.

For MOLIMO, LLC:

Joseph W. Enriquez
Project Manager

Michael D. Stremmel, P.E.
Senior Project Engineer

MDS:dro

Attachments (pages): This report is complete only when all attachments listed are included.

Appendix-A: Alteration Addendum (1)

Appendix-B: Air Seal Location (1)

Appendix-C: Drawings (11)

Revision Log

Rev. #	Date	Page(s)	Revision(s)
1	07/31/2020	2, 6, Appendix C	Added drawings to report

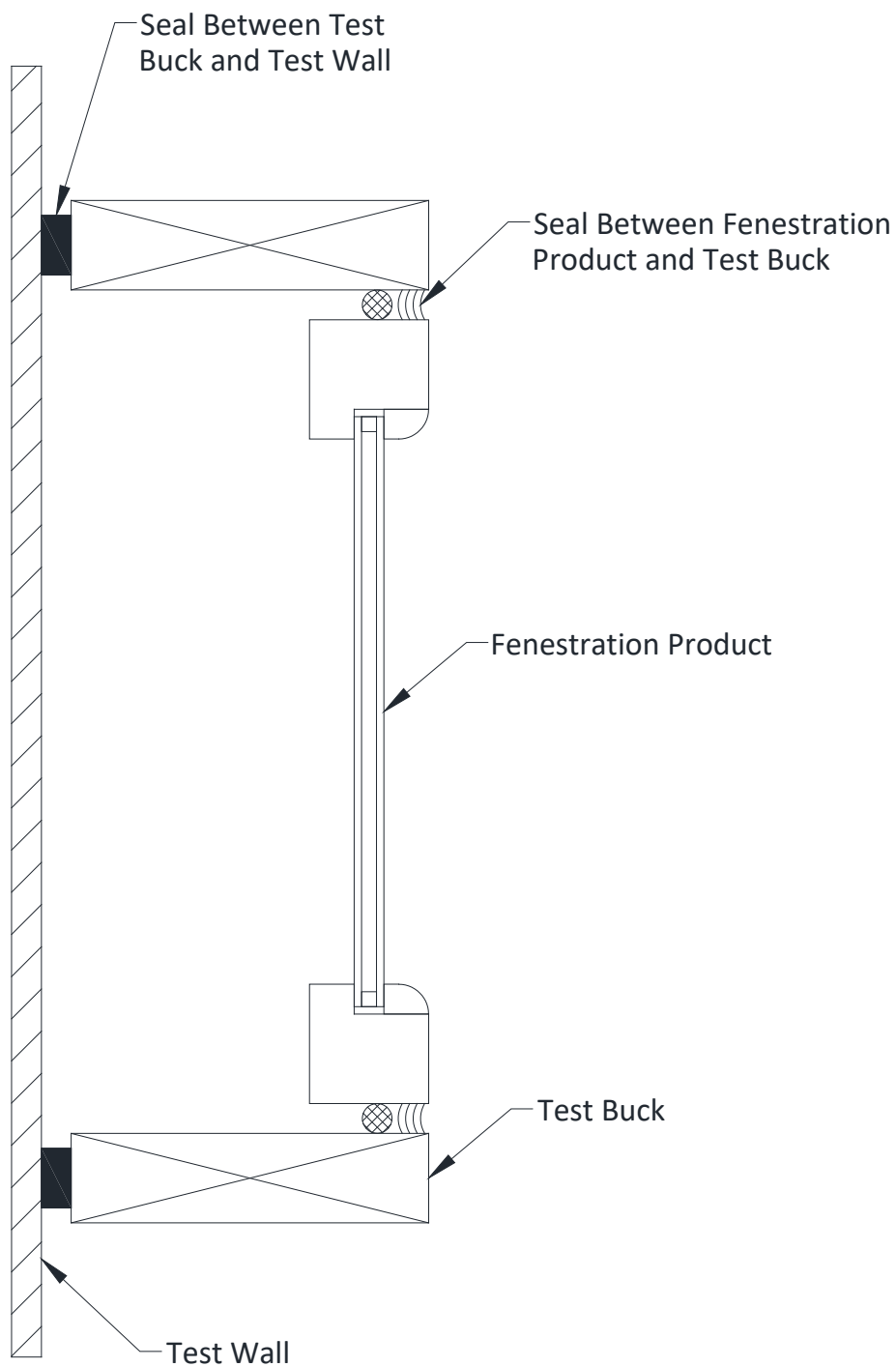
Appendix A

Alteration Addendum

No alterations were performed.

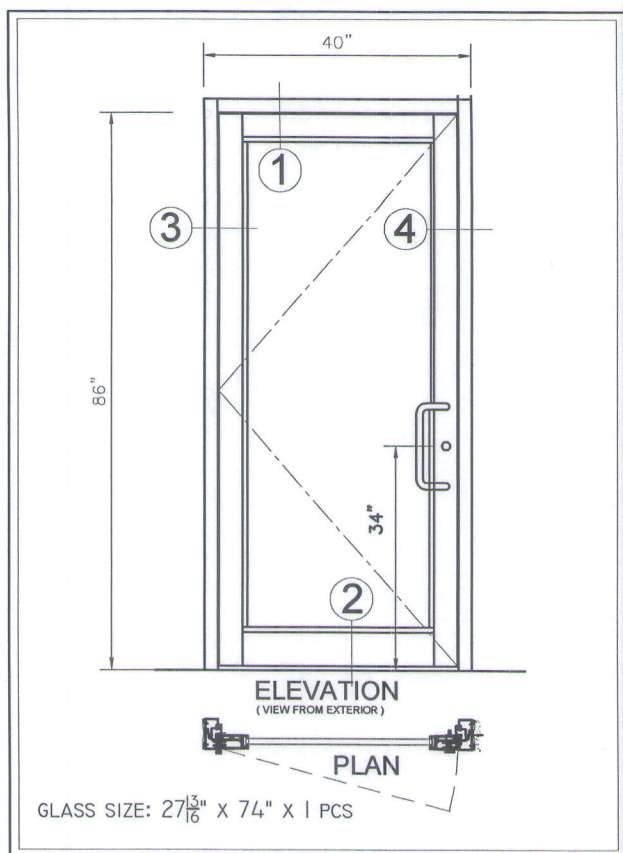
Appendix B

Air Seal Location

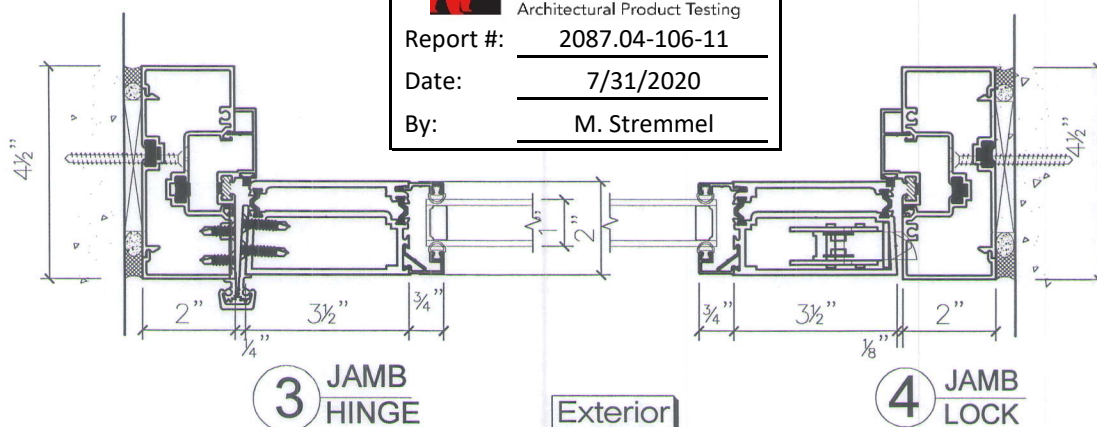
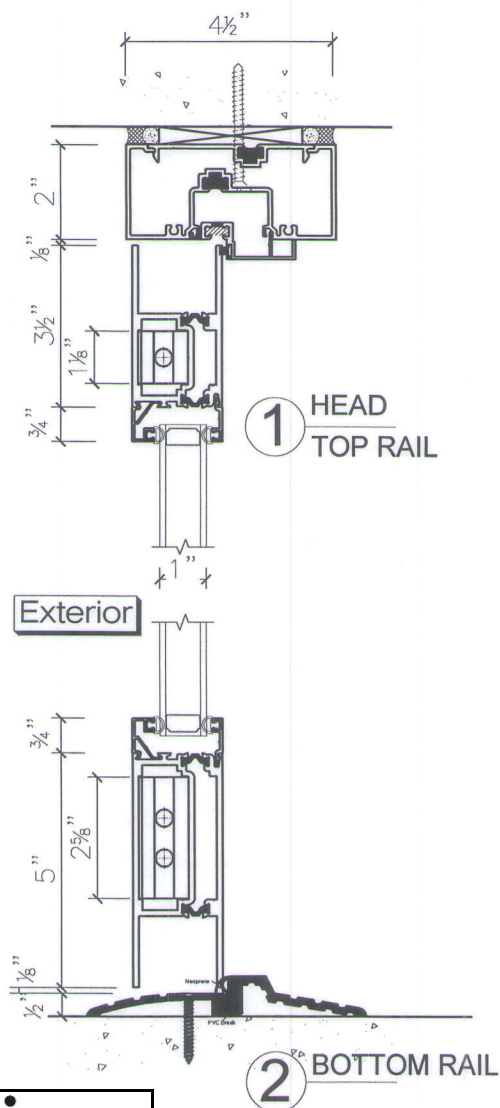


Appendix C

Drawings



TD350 SERIES
MEDIUM STILE DOOR
 1" INSULATING GLASS
 (1/4" CLR.TM. 1/4" CLR. TM.)




MolimoTM
 Architectural Product Testing

Report #: 2087.04-106-11

Date: 7/31/2020

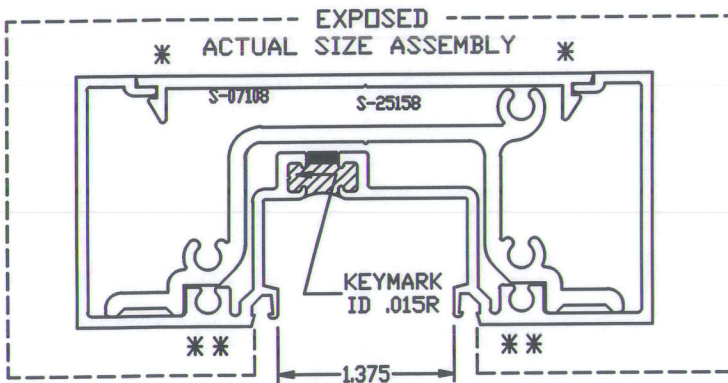
By: M. Stremmel

G	SHEET #	Drawn by: Q.ZHANG	Customer	Revisions		 GAMCO CORPORATION MANUFACTURERS OF FENESTRATION PRODUCTS 131-10 MAPLE AVE. FLUSHING, N.Y.11355 TEL: (718)359-8833 FAX: (718)359-8661 info@gamcocorp.com www.gamcocorp.com
		Checked by: C.CHAN		No.	Date	
		Date: 02/25/2020	Project :			
		Scale: 3" : 12"	TD350 MEDIUM STILE DOOR			

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STRUCTURAL STREAKING IS EXPECTED

UNIFORM PAINT COVERAGE NOT EXPECTED IN THIS AREA



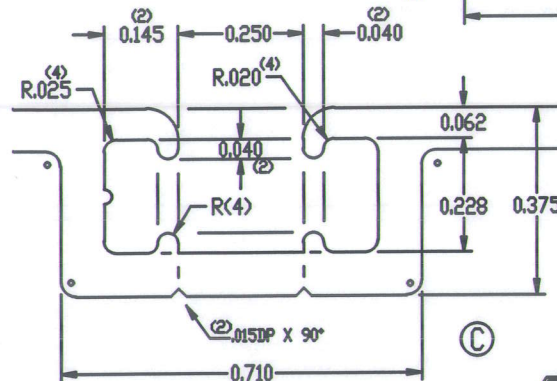
FILL CROSSHATCHED AREA WITH KEYLOCK MATERIAL; DEBRIDGE SHADED AREA

MUST BE FULLY DEBRIDGED

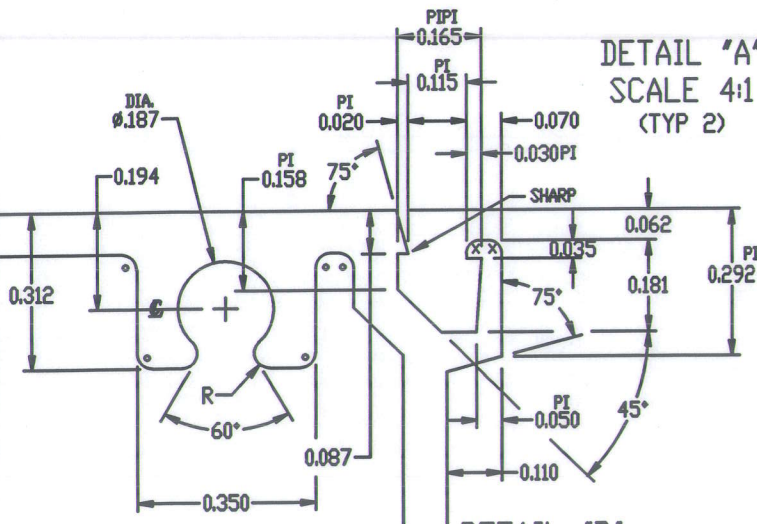
S-15300 MATES WITH:
S-07108 050026
S-15303
S-15304
S-15395 051429
S-15426 051431
S-15916 052002
S-17509 052026
S-65088 DT-00014

FOR ASSEMBLY REFER TO S-65088

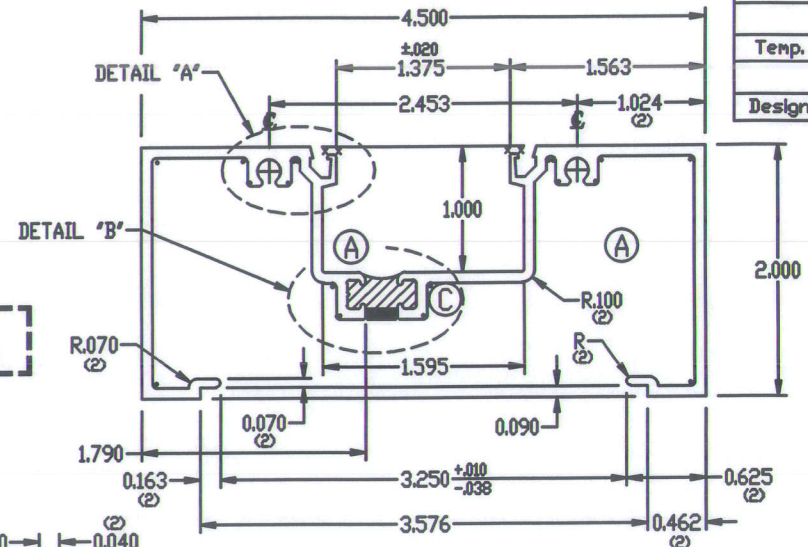
DETAIL "B" SCALE 4:1



DETAIL "A" SCALE 4:1 (TYP 2)



STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE



(.) DENOTES R .030 (18)
(*) DENOTES R .025 (4)



Molimo
Architectural Product Testing

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Date: 7/31/2020

By: M. Stremmel

KEYMARK CORPORATION

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Syn	Revisions	Date
7	PRINT REVISION	10-17-14
A	BARBS REMOVED	08-09-98
B	F&D POCKET FLIPPED	04-02-07
C	F&D POCKET FLIPPED BACK	10-17-14

Unspecified Wall Thickness: .085		Break Ext. Corners .015 Radius or as Noted	
Customer KEYMARK CORPORATION		Customer's Part Number 052001	
Job Name PG-451T		Scale 1:1	
Part Title HEAD / VERTICAL		Date 03-04-90	
Alloy 6063	Area (in ²) 1.164	Finish Perimeter (in) 7.632	Drawn C.J.T.
Temper T-5	Wt./Ft. (Lbs) 1.397	Total Perimeter (in) 27.479	Checked S.J.S. 06
Cavity Size AA	Circle Size (in) 4.9	Exterior Perimeter (in) 27.479	

Estimated For Reference Only	I _x = 0.477	I _y = 2.882	Alodine <input type="checkbox"/>	Type: 00
	S _x = 0.389	S _y = 1.269	Crimp <input type="checkbox"/>	Factor: 20

MIL ☐ Ano. ☐ Drnr. ☐ Drch. ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class ☐ Hollow ☐ Class ☐ FP

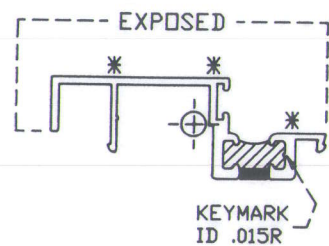
* STRUCTURAL STREAKING IS EXPECTED

LIGHT PAINT COVERAGE EXPECTED IN THIS AREA

STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

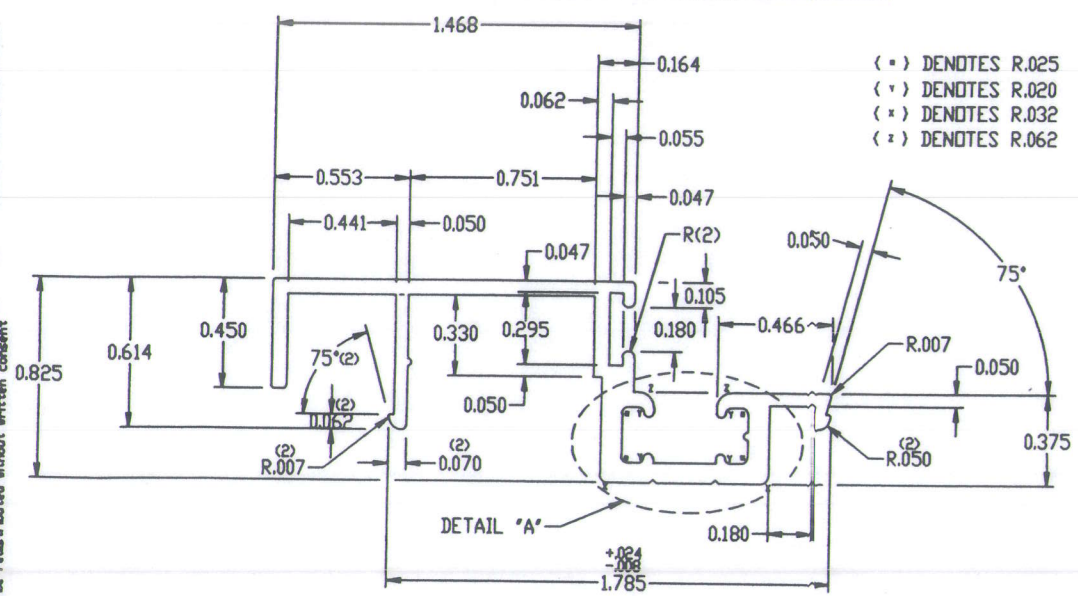
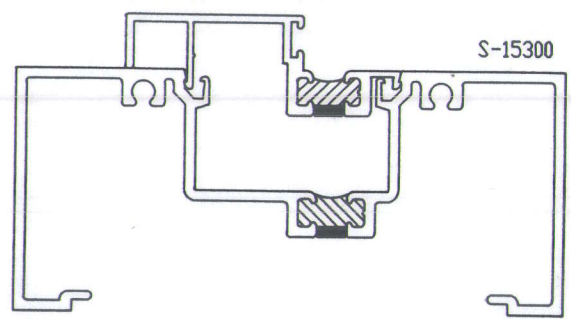
S-65088
Die Number
T-44367
Temp. Number
Design Number

ACTUAL SIZE



FILL CROSSHATCHED AREA WITH KEYLOCK MATERIAL; DEBRIDGE SHADED AREA

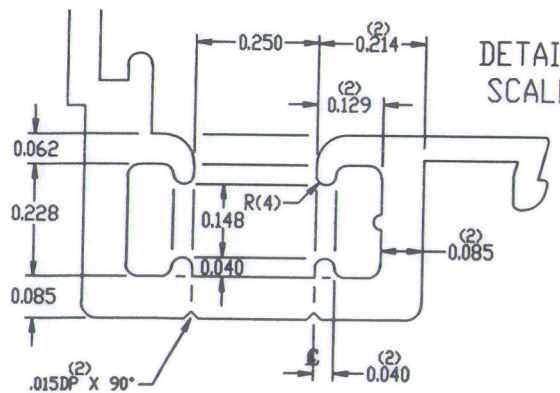
ACTUAL SIZE ASSEMBLY



(.) DENOTES R.025
(.) DENOTES R.020
(.) DENOTES R.032
(.) DENOTES R.062

DETAIL "A"
SCALE 4:1

S-65088 MATES WITH:
S-15300 052001



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Unspecified Wall Thickness: .062		Break Ext. Corners .015 Radius or as Noted	
Customer: GAMCO		Customer's Part Number: DT-00014	
Job Name: T950 SERIES THERMAL DOOR		Scale: 2:1	
Part Title: THERMAL DOOR STOP		Date: 01-22-19	
Alloy: 6063	Area (In ²): 0.325	Finish Perimeter (In): 3.635	Drawn: MJD
Temper: T-5	Wt./Ft. (Lbs): 0.390	Total Perimeter (In): 9.885	Checked: 00
Cavity Size: AA	Circle Size (In): 2.3	Exterior Perimeter (In): 9.885	

Syn.	Revisions	Date

PLEASE MARK PAINTED SURFACES AS PRIMARY & SECONDARY

Estimated For Reference Only: I_x = 0.026, I_y = 0.136, A_{line} ☐, Type: 00, S_x = 0.058, S_y = 0.115, C_{rip} ☐, Factor: 25, M_{in} ☐, A_{no} ☐, D_{rrr} ☐, D_{rcn} ☐, P_c ☐, Solid ☐

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Architectural Product Testing
Report #: 2087.04-106-11
Date: 7/31/2020
By: M. Stremmel

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STRUCTURAL STREAKING
IS EXPECTED

UNIFORM PAINT COVERAGE
NOT EXPECTED IN THIS AREA

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PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

S-17509

Die Number

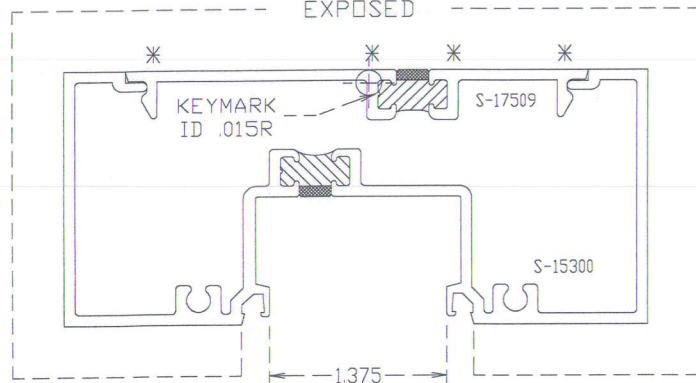
Temp. Number

Design Number

MUST BE FULLY DEBRIDGED

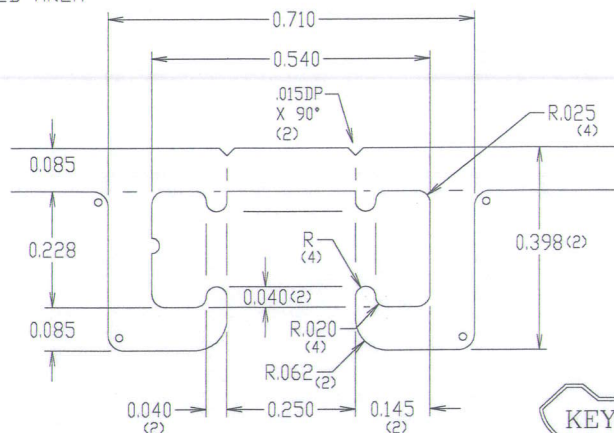
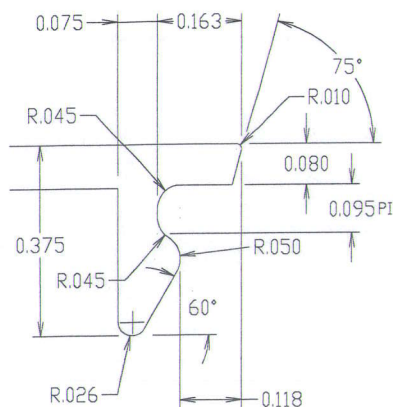
EXPOSED

S-17509 MATES WITH:
S-15300 052001



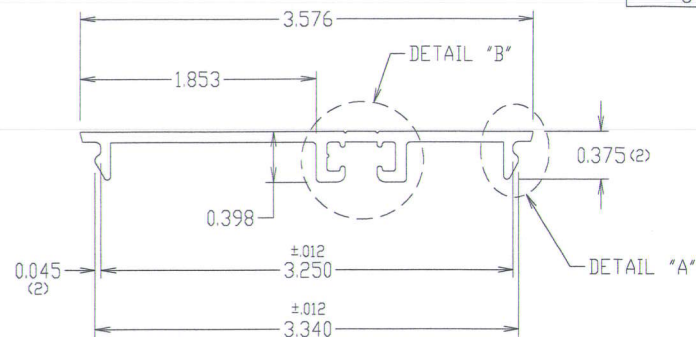
ACTUAL SIZE ASSEMBLY
FILL CROSSHATCHED AREA
WITH KEYLOCK MATERIAL;
DEBRIDGE SHADED AREA

DETAIL "A"
SCALE 4:1
(TYP 2)



DETAIL "B"
SCALE 4:1

() DENOTES R .031 (4)



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Sym.	Revisions	Date
5	PRINT REVISION	10-24-04
	PRINT REDRAWN JR	06-29-04
A	F&D POCKET FLIPPED	09-03-04

Unspecified
Wall Thickness: .085

Break Ext. Corners
.015 Radius or as Noted

Customer
KEYMARK CORPORATION

Customer's
Part Number

Job Name
FG-451T/1451T

052026

Part Title
THERMAL JAMB CLOSURE

Scale
1:1

Alloy
6063

Area (in²)
0.434

Finish Perimeter (in)
3.593

Date
06-26-91

Temper
T-5

Wt./Ft. (Lbs)
0.521

Total Perimeter (in)
10.321

Drawn
S.J.S.

Cavity Size
BB

Circle Size (in)
3.6

Exterior Perimeter (in)
10.321

Checked
S.J.S.

Estimated For Reference Only	I _x = 0.005	I _y = 0.462	Aladine <input type="checkbox"/>	Type: 00
	S _x = 0.018	S _y = 0.247	Crimp <input type="checkbox"/>	Factor: 20

MILL ☐

Ano. ☒

Drnr. ☒

Drcn. ☒

Pc ☐

Solid ☒

Semi-hollow ☐

Class:

Hollow ☐

Class:

FP

A2-00

TD0003
GAMCODT-000
DT-00014.0MM
14.0MMS-6500
H-1754*
STRUCTURAL STREAKING
IS EXPECTEDUNIFORM PAINT COVERAGE
NOT EXPECTED IN THIS AREA →STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED
PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

TYPE 010

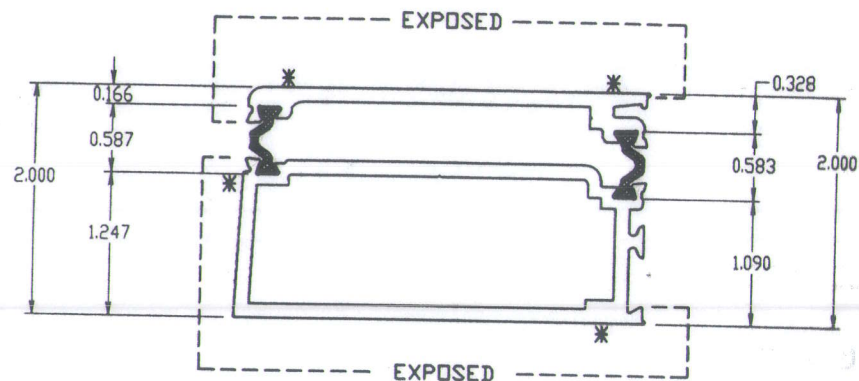
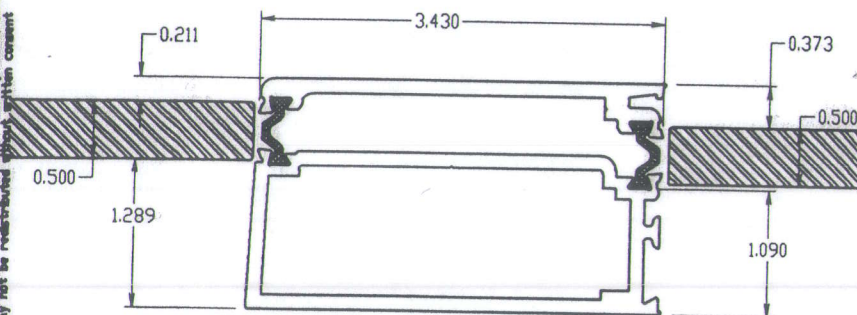
TD0003-GCO

Die Number

Temp. Number

Design Number

14.8MM 'C' THERMAL STRUT

INTERIOR
S-65080/DT-0002BEXTERIOR
H-17549/DT-0001B**Molimo**TM
Architectural Product Testing

Report #: 2087.04-106-11

Date: 7/31/2020

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LAKELAND, FL TEL. (863) 858-5500
WWW.KEYMARKCORP.COMUnspecified
Wall ThicknessBreak Ext. Corners
.015 Radius or as NotedCustomer
GAMCOJob Name
1350T SERIESPart Title
STYLE STRUT ASSEMBLY

Alloy

Temper

Cavity Size

10

Area (in²)

WT./FT. (Lbs)

Circle Size (in)

10

Finish Perimeter (in)

Total Perimeter (in)

Exterior Perimeter (in)

10

Customer's
Part Number

TD-0003

Scale
1:1Date
01-23-19Drawn
MJD

Checked

10

Syn.	Revisions	Date

Estimated For Reference Only	I _x =	I _y =	Modline <input type="checkbox"/>	Type: 010
	S _x =	S _y =	Crimp <input type="checkbox"/>	Factor:

MIL ☐ Ano. ☐ Drvr. ☐ Drcn. ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class: ☐ Hollow ☐ Class: ☐ PP

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TYPE 010

A2-00

TD0001-GCO
Die Number
Temp. Number
Design Number

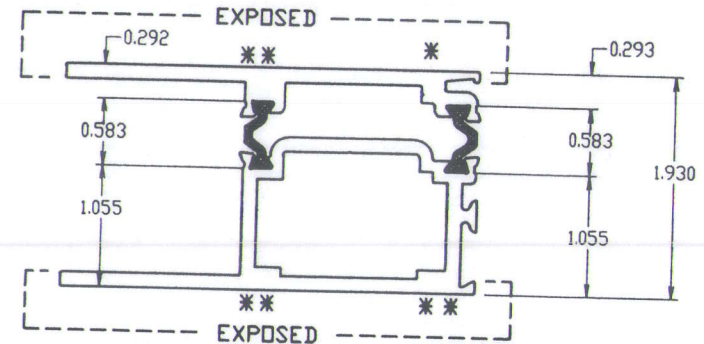
TD0001-GCO
GAMCO

DT-0004B
DT-0003B

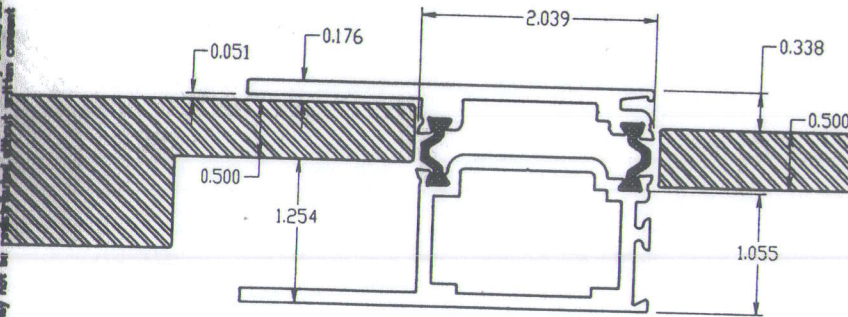
14.8MM 'C'
14.8MM 'C'

14.8MM 'C' THERMAL STRUT

INTERIOR
S-65081/DT-0004B



EXTERIOR
H-17550/DT-0003B



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Architectural Product Testing

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Unspecified
Wall Thickness

Break Ext. Corners
.015 Radius or as Noted

Customer
GAMCO

Job Name
D360T SERIES

Part Title
TOP RAIL STRUT ASSEMBLY

Customer's
Part Number
TD-0001

Scale
1:1

Date
01-24-19

Drawn
MJD

Checked

Alloy

Area (in²)

Finish Perimeter (in)

Temper

Wt./Ft. (Lbs)

Total Perimeter (in)

Cavity Size
10

Circle Size (in)

Exterior Perimeter (in)

Estimated
For
Reference
Only
I_x = I_y =
S_x = S_y =
Modline ☐ Type: 010
Factor: ☐

MM ☐ Ana ☐ Drrr ☐ Drch ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class ☐ Hollow ☐ Class ☐ PP

STRUCTURAL STREAKING
IS EXPECTED

UNIFORM PAINT COVERAGE
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STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED
PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

TYPE 010

TD0002-GCO

Die Number

Temp. Number

Design Number

A2-00

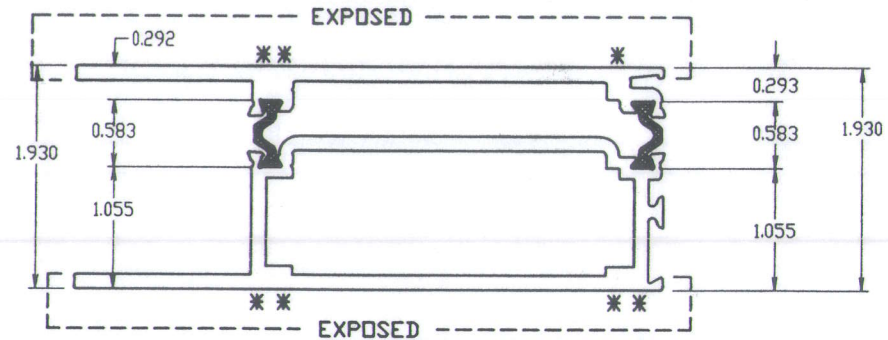
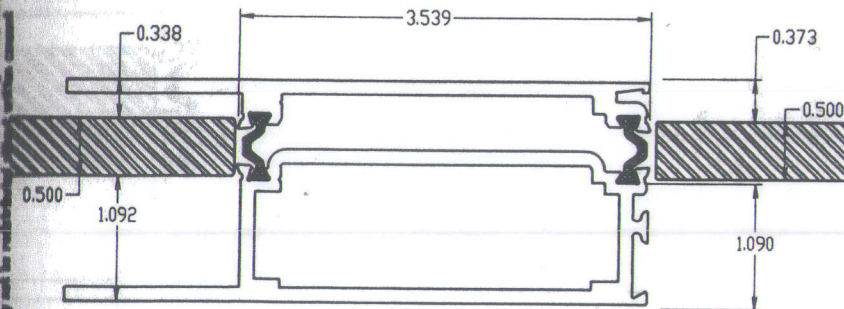
TD0002-GCO
GAMCO

DT-0006B
DT-0005B

14.8MM 'C'
14.8MM 'C'

14.8MM 'C' THERMAL STRUT

INTERIOR
S-65082/DT-0006B



EXTERIOR
H-17551/DT-0005B

S-65082
H-17551



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Unspecified
Wall Thickness

Break Ext. Corners
.015 Radius or as Noted

Customer:
GAMCO
Job Name:
DSSOT SERIES
Customer's
Part Number:
TD-0002

Part Title:
BOTTOM RAIL STRUT ASSEMBLY
Scale:
1:1
Alloy: Area (In²): Finish Perimeter (In):
Temp: Wt/Ft. (Lbs): Total Perimeter (In):
Date:
01-24-19
Cavity Size: Circle Size (In): Exterior Perimeter (In):
10: Checked

Sym.	Revisions	Date

Material
Reference
I_x = I_y =
S_x = S_y =
Modine ☐ Type: 010
Crimp ☐ Factor:

Mill ☐ Ana. ☐ Drn. ☐ Drn. ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class: Hollow ☐ Class: PP

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STRUCTURAL STREAKING IS EXPECTED

LIGHT PAINT COVERAGE EXPECTED IN THIS AREA



STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

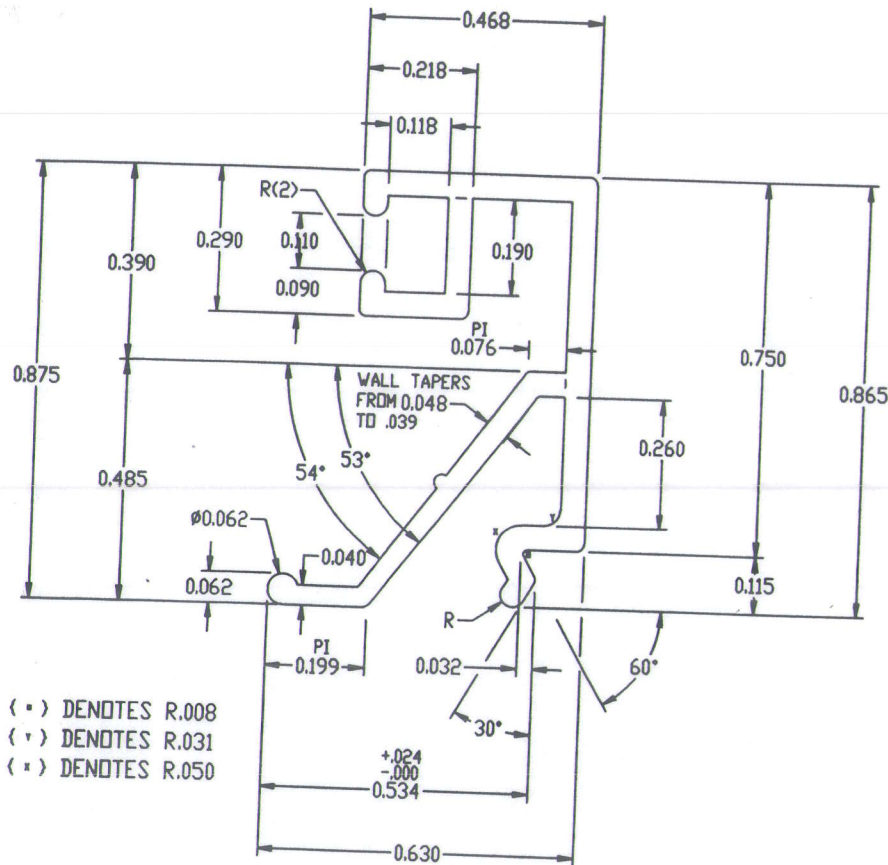
S-65087

Die Number

T-44366

Temp. Number

Design Number



FOR ASSEMBLY
REFER TO H-17549

FOR ASSEMBLY
REFER TO H-17550

FOR ASSEMBLY
REFER TO H-17551

FOR ASSEMBLY
REFER TO H-17552

FOR ASSEMBLY
REFER TO H-17553

ACTUAL SIZE



KEYMARK
ID .015R

S-65087 MATES WITH:
H-17549 DT-0001B
H-17550 DT-0003B
H-17551 DT-0005B
H-17552 DT-0001I
H-17553 DT-0009B



Molimo
Architectural Product Testing

Report #: 2087.04-106-11

Date: 7/31/2020

By: M. Stremmel

KEYMARK CORPORATION



PONDA, NY TEL (516) 863-3421
LAKELAND, FL TEL (863) 868-5500
WWW.KEYMARKCORP.COM

Syn.	Revisions	Date

Unspecified
Wall Thickness: .050

Break Ext. Corners
.015 Radius or as Noted

Customer GAMCO	Customer's Part Number DT-0007B
Job Name TD350 SERIES THERMAL DOOR	Scale 4:1
Part Title GLASS STOP	Date 01-24-19
Alloy 6063	Area (In ²) 0.130
Temper T-5	Finish Perimeter (In) 1.965
Cavity Size	Wt./Ft. (Lbs) 0.156
Circle Size (In) 1.0	Total Perimeter (In) 5.392
Exterior Perimeter (In) 5.392	Drawn MJD
	Checked 00

Estimated for Reference Only
I_x = 0.011 I_y = 0.004
S_x = 0.023 S_y = 0.008
Alodine ☐ Type: 00
Crimp ☐ Factor: 35

PLEASE MARK PAINTED SURFACES
AS PRIMARY & SECONDARY

MILL ☐ Ano. ☐ Drmr. ☐ Drcn. ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class: ☐ Hollow ☐ Class: ☐

* STRUCTURAL STREAKING IS EXPECTED

LIGHT PAINT COVERAGE EXPECTED IN THIS AREA

STANDARD COMMERCIAL TOLERANCES FOR EXTRUDED PRODUCTS APPLY UNLESS SPECIFIED OTHERWISE

S-65086
Die Number
T-44365
Temp. Number
Design Number

S-65086 MATES WITH:
S-65080 DT-0002B
S-65081 DT-0004B
S-65082 DT-0006B
S-65083 DT-00012
S-65084 DT-0010B

FOR ASSEMBLY
REFER TO S-65080

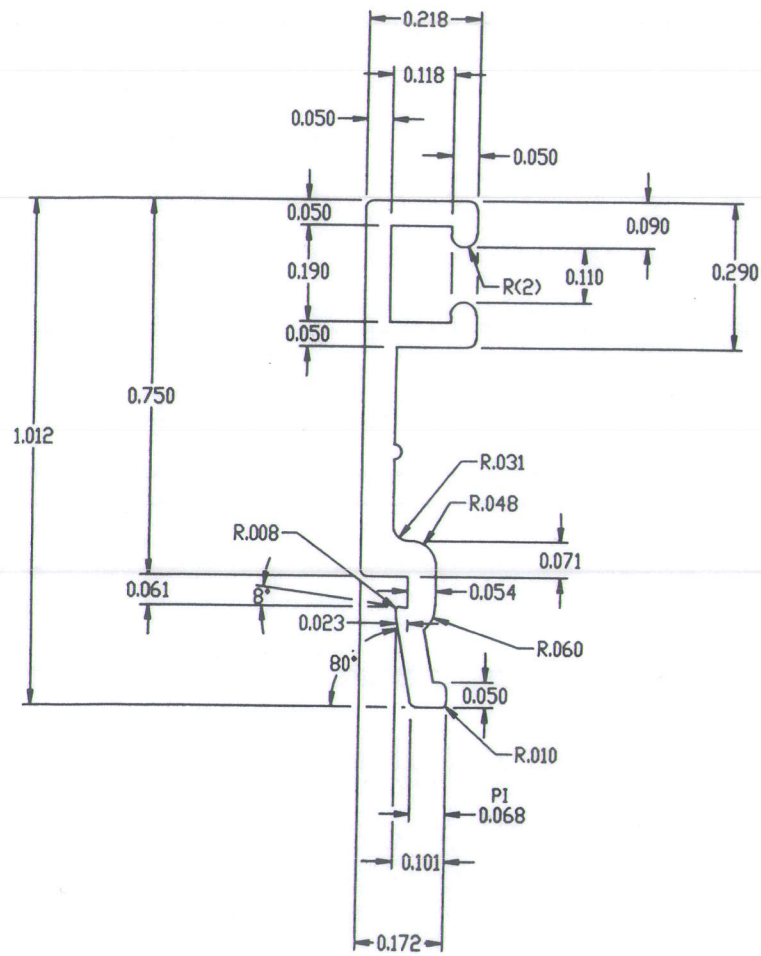
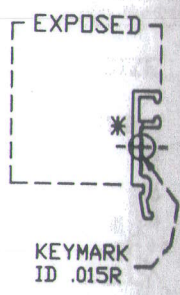
FOR ASSEMBLY
REFER TO S-65081

FOR ASSEMBLY
REFER TO S-65082

FOR ASSEMBLY
REFER TO S-65083

FOR ASSEMBLY
REFER TO S-65084

ACTUAL SIZE



PLEASE MARK PAINTED SURFACES AS PRIMARY & SECONDARY



Report #: 2087.04-106-11
Date: 7/31/2020
By: M. Stremmel



FOUCA, NY TEL (618) 853-3421
LAKELAND, FL TEL (863) 858-5500
WWW.KEYMARKCORP.COM

Unspecified Wall Thickness: .063		Break Ext. Corners .015 Radius or as Noted	
Customer: GAMCO		Customer's Part Number: DT-0008B	
Job Name: TD350 SERIES THERMAL DOOR		Scale: 4:1	
Part Title: THERMAL GLASS STOP EXTERIOR		Date: 01-25-19	
Alloy: 6063	Area (in²): 0.085	Finish Perimeter (in): 0.979	Drawn: N/D
Temper: T-5	Wt./Ft. (Lbs): 0.102	Total Perimeter (in): 3.099	Checked: 00
Cavity Size:	Circle Size (in): 1.0	Exterior Perimeter (in): 3.099	

Syn.	Revisions	Date

Estimated For Reference Only

I _x = 0.008	I _y = 0.000	Alodine <input type="checkbox"/>	Type: 00
S _x = 0.013	S _y = 0.002	Crimp <input type="checkbox"/>	Factor: 30

Factor: 30

☐ Mill ☐ Ano. ☐ Drnr. ☐ Drch. ☐ Pc ☐ Solid ☐ Semi-hollow ☐ Class: ☐ Hollow ☐ Class:



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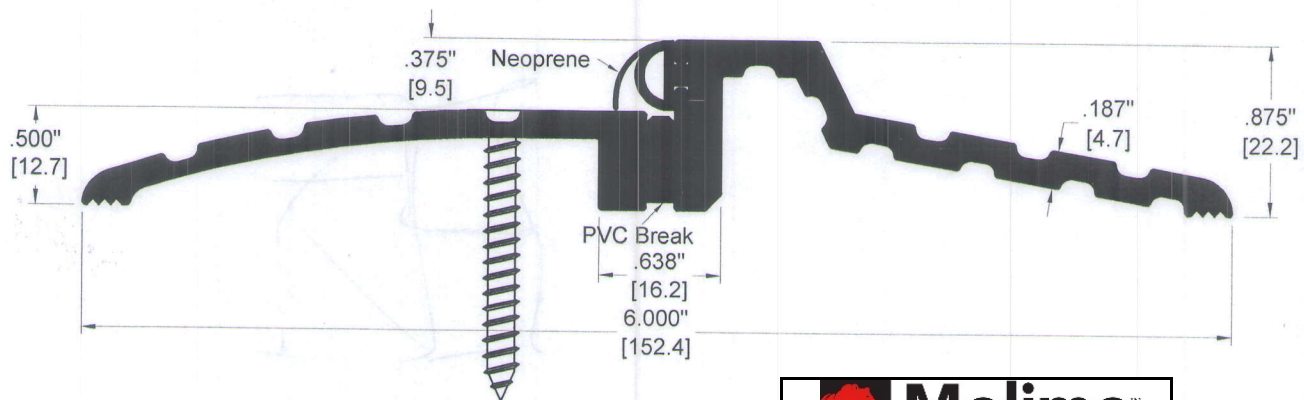



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526
 Rabbeted Threshold
 - Thermal Break