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IPSWICH BAY GLASS CO., INC.
MOCK-UP TEST REPORT

SCOPE OF WORK
PERFORMANCE MOCK-UP TESTING ON THERMTEK CURTAIN WALL SYSTEM

REPORT NUMBER
S5146.01-250-32 R0

TEST DATE(S)
09/25/25 - 10/15/25

ISSUE DATE
10/17/25

PAGES
41

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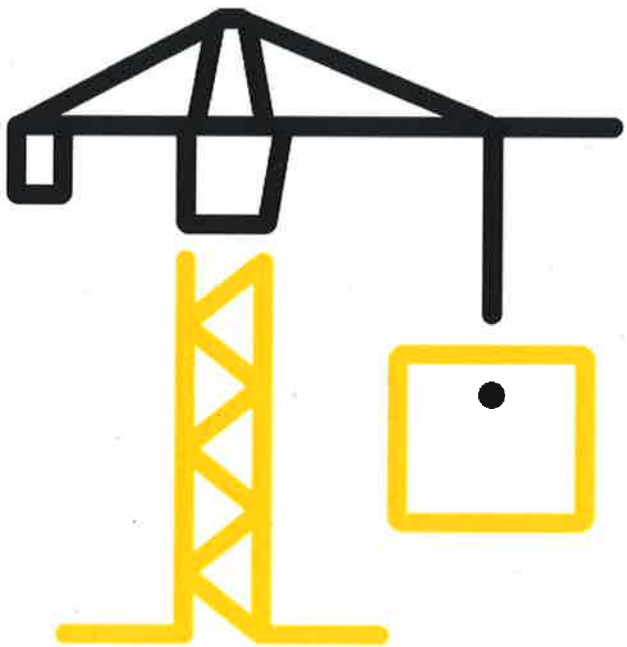

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TEST REPORT FOR IPSWICH BAY GLASS CO., INC.
Report No.: S5146.01-250-32 R0
Date: 10/17/25

REPORT ISSUED TO
IPSWICH BAY GLASS CO., INC.
P.O Box 511
Rowley, Massachusetts 01969

PROJECT
THERMTEK

For INTERTEK B&C:

COMPLETED BY:	Ryan Ignacio, FMPC	**REVIEWED BY:**	Jonathan Dodd, FMPC
TITLE:	Technical Lead Building & Construction	**TITLE:**	Laboratory Manager Building & Construction
SIGNATURE:	Digitally Signed by: Ryan Ignacio	**SIGNATURE:**	Digitally Signed by: Jonathan Dodd
DATE:	10/17/25	**DATE:**	10/17/25

ri:jd

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Report No.: S5146.01-250-32 R0
Date: 10/17/25

SECTION 1
SCOPE

Architectural Testing, Inc. (an Intertek company) dba Intertek Building & Construction (B&C) was contracted by Ipswich Bay Glass Co., Inc. to perform performance testing on a curtain wall mock-up for the above referenced project at the Intertek test facility in Windham, New Hampshire. Results obtained are tested values and were secured in accordance with the attached test procedure dated 9/23/2025. This report includes complete written and photographic documentation of all testing performed and a copy of "As-Built" mock-up drawings.

This report does not constitute certification of this product nor an opinion or endorsement by this laboratory. This report and related test records that are retained such as "As-Built" mock-up drawings, datasheets, or other pertinent project documentation will be serviced by Intertek B&C for the entire test record retention period. At the end of this retention period, such materials shall be discarded without notice and the service life of this report by Intertek B&C will expire.

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.

SECTION 2
TEST METHODS

Mock-up testing was performed in accordance with referenced test methods as specified in the bid documents.

Air Infiltration/Exfiltration: ASTM E283/E283M-19, *Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Skylights, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen*. Testing was conducted at 6.24 psf positive and negative static air pressure difference.

Static Pressure Water Resistance: ASTM E331-00(2023), *Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference*. Testing was conducted at 15 psf positive static air pressure difference for a 15-minute duration. Water was applied to the mock-up at a minimum rate of 5 gal/ft^2/hr.

Dynamic Pressure Water Resistance: AAMA 501.1-17, *Standard Test Method for Water Penetration of Windows, Curtain Walls and Doors Using Dynamic Pressure*. Testing was conducted with a dynamic pressure equivalent of 15 psf for a 15-minute duration. Water was applied to the mock-up at a minimum rate of 5 gal/ft^2/hr.

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TEST METHODS (Continued)

Structural Performance: ASTM E330/E330M-14(2021), *Standard Test Method for Structural Performance of Exterior Windows, Door, Skylights and Curtain Walls by Uniform Static Air Pressure Difference*. Testing was conducted at positive and negative loads as described in the test procedure and listed in the test results.

Inter-Story Horizontal and Seismic Displacement Tests: AAMA 501.4-18, *Recommended Static Test Method for Evaluating Window Wall, Curtain Wall and Storefront Systems Subjected to Seismic and Wind-Induced Inter-Story Drift.* Three complete cycles were performed in the horizontal direction at the floor simulation parallel and perpendicular to the main elevation. Testing was conducted at the design displacement(s) as described in the test procedure and listed in the test results. The mock-up was inspected prior to and after the test.

Inter-Story Vertical Displacement Test: AAMA 501.7-17, *Recommended Static Test Method for Evaluating Windows, Window Wall, Curtain Wall and Storefront Systems Subjected to Vertical Inter-Story Movements.* Three complete cycles were performed in the vertical direction at the floor simulation. Testing was conducted at the design displacement(s) as described in the test procedure and listed in the test results. The mock-up was inspected prior to and after the test.

Thermal Cycling: AAMA 501.5-23, *Test Method for Serviceability of Exterior Fenestration After Thermal Cycling*. Testing was conducted at the conditions and tolerances described in the test procedure and listed in the test results. Three complete cycles were performed. The mock-up was inspected prior to and after the test.

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TEST REPORT FOR IPSWICH BAY GLASS CO., INC.
Report No.: S5146.01-250-32 R0
Date: 10/17/25

SECTION 3
LIST OF OFFICIAL OBSERVERS

NAME	COMPANY
Michael Sloane	Ipswich Bay Glass Co., Inc.
Steve Gower	Ipswich Bay Glass Co., Inc.
Michael Anness	Ipswich Bay Glass Co., Inc.
Peter Thayer	Intertek B&C
Matt Morin	Intertek B&C
Brandon Petit	Intertek B&C
Jonathan Dodd	Intertek B&C

SECTION 4
GENERAL MOCK-UP DESCRIPTION

Project Type
Curtain Wall System

Mock-Up Size

Curtain Wall: 20' 00" wide by 14' 00" high

See "Drawings" Section for more detailed dimensions and layout

Material Source/Installation
The mock-up materials/components were supplied by Ipswich Bay Glass Co., Inc.. The installation of the mock-up was completed by Ipswich Bay Glass Co., Inc..

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TEST REPORT FOR IPSWICH BAY GLASS CO., INC.
Report No.: S5146.01-250-32 R0
Date: 10/17/25

SECTION 5
PRELIMINARY TEST RESULTS

***General Note**: Unless otherwise stated, all comments relative to location are as viewed from the interior.*

DATE: 9/25/2025	TEMP: 70	BP: 29.97
TITLE OF TEST	**MEASURED**	**ALLOWED**
Preload @ ±20.05 psf	No visible damage	No visible damage
Static Pressure Air Infiltration @6.24 psf	PASSED	0.06 cfm/ft^2 max
Static Pressure Air Exfiltration @ 6.24 psf	PASSED	0.06 cfm/ft^2 max

SECTION 6
FINAL TEST RESULTS

***General Note**: Unless otherwise stated, all comments relative to location are as viewed from the interior.*

DATE: 9/25/2025	TEMP: 70	BP: 29.97
TITLE OF TEST	**MEASURED**	**ALLOWED**
Preload @ ±20.05 psf	No visible damage	No visible damage
Static Pressure Air Infiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft^2	0.06 cfm/ft^2 max.
Static Pressure Air Exfiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft^2	0.06 cfm/ft^2 max.

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Report No.: S5146.01-250-32 R0
Date: 10/17/25

FINAL TEST RESULTS (Continued)

DATE: 9/25/2025	TEMP: 70	BP: 29.97
TITLE OF TEST	**MEASURED**	**ALLOWED**
Static Pressure Water Resistance @ 15 psf	PASSED	
	No uncontrolled leakage	No uncontrolled leakage
Dynamic Pressure Water Resistance @ 15 psf	PASSED	
	No uncontrolled leakage	No uncontrolled leakage
Uniform Load Deflection	PASSED	
@ +20.05 psf (Preload)	No visible damage See Table #1 and Sketch #1	No visible damage See Table #1 and Sketch #1
@ +40.10 psf (Design Load)		
@ -20.05 psf (Preload)		
@ -40.10 psf (Design Load)		
Repeat Static Pressure Air Infiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft^2	0.06 cfm/ft^2 max.
Repeat Static Pressure Air Exfiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft^2 See Note #_	0.06 cfm/ft^2 max.
Repeat Static Pressure Water Resistance @ 15 psf	PASSED	
	No uncontrolled leakage	No uncontrolled leakage
Repeat Dynamic Pressure Water Resistance @ 15 psf	PASSED	
	No uncontrolled leakage	No uncontrolled leakage
Inter-Story Horizontal Displacement @ ±0.50" (3 cycles)	PASSED	
	No visible damage	No visible damage

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TEST REPORT FOR IPSWICH BAY GLASS CO., INC.
Report No.: S5146.01-250-32 R0
Date: 10/17/25

FINAL TEST RESULTS (Continued)

DATE: 9/30/2025	TEMP: 66	BP: 30.07
TITLE OF TEST	**MEASURED**	**ALLOWED**
Inter-story Vertical Displacement @ ±1.00" (3 cycles)	PASSED No visible damage	 No visible damage
Repeat Static Pressure Air Infiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft²	0.06 cfm/ft² max.
Repeat Static Pressure Air Exfiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft²	0.06 cfm/ft² max.
Repeat Static Pressure Water Resistance @ 15 psf	PASSED No uncontrolled leakage	 No uncontrolled leakage

FINAL TEST RESULTS (Continued)

DATE through DATE:	10/7/2025-10/9/2025	
Thermal Cycling @-0°F — +180°F (3 cycles)	PASSED No visible damage	 No visible damage
DATE: 10/14/2025	**TEMP** 66	**BP:** 30.07
Repeat Static Pressure Air Infiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft²	0.09 cfm/ft² max.

DATE: 10/14/2025	TEMP: 66	BP: 30.07
TITLE OF TEST	**MEASURED**	**ALLOWED**
Repeat Static Pressure Air Exfiltration @ 6.24 psf	PASSED	
System	<0.01 cfm/ft²	0.06 cfm/ft² max.
Repeat Static Pressure Water Resistance @ 15 psf	PASSED No uncontrolled leakage	 No uncontrolled leakage

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Report No.: S5146.01-250-32 R0
Date: 10/17/25

FINAL TEST RESULTS (Continued)

DATE: 10/15/2025	TEMP: 66	BP: 29.97
TITLE OF TEST	**MEASURED**	**ALLOWED**
Uniform Structural Overloads	PASSED	
@ +30.08 psf (Preload)	No structural failure See Table #2 and Sketch #1	No structural failure See Table #2 and Sketch #1
@ +60.15 psf (Overload)		
@ -30.08 psf (Preload)		
@ -60.15 psf (Overload)		
Seismic Horizontal Displacement @ ±1.00" (3 cycles)	PASSED	
	No glass/component fallout	No glass/component fallout
Seismic Vertical Displacement @ ±1.00" (3 cycles)	PASSED	
	No glass/component fallout	No glass/component fallout

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TEST REPORT FOR IPSWICH BAY GLASS CO., INC.
Report No.: S5146.01-250-32 R0
Date: 10/17/25

SECTION 7
TEST PROCEDURE

RENDERED TO
IPSWICH BAY GLASS CO., INC
P.O Box 511
Rowley, Ma 01969

Performance Mock-Up

Mock-up testing for IPSWICH BAY GLASS CO., INC. shall be performed in accordance with referenced test methods as specified in the bid documents. Mock-up testing shall be observed by the Engineer and/or the Owner, Architect and their consultants during construction and testing. All pretesting shall be documented and included in the comprehensive test report.

The final test procedure shall be as follows:

1. **PRELOAD (ASTM E330)**

   To set the specimen for testing, a positive/negative differential (inward acting) of **20 psf** (50% design load), held for a minimum of ten (10) seconds, and then released. The wall and anchoring will be inspected for any failure.

   Allowable
   No visible signs of failure shall be allowed.

   motion must register at or below 5 lb.

2. **STATIC AIR INFILTRATION TEST (ASTM E283)**

   The mock-up exterior face will be covered with polyethylene (plastic sheeting). The mock-up will then be subjected to a positive static pressure differential of **6.24 psf**. The air infiltration required to maintain the air pressure differential is measured. This air infiltration reading represents the chamber tare for both infiltration and exfiltration readings. The polyethylene will be removed and the mock-up specimen will again be subjected to a positive static pressure differential of **6.24 psf**. Air infiltration will be measured. The total air infiltration reading represents the amount of air through the specimen including chamber tare. Subtracting the chamber tare from the latter total reading yields the net amount of air infiltration through the mock-up. Dividing the mock-up air leakages by the mock-up area yields the air infiltration rate.

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Allowable
Air infiltration shall not exceed **0.06 cfm** per square foot of fixed wall area.

3. STATIC WATER PENETRATION TEST (ASTM E331)

A fifteen (15) minute water penetration test will be conducted on the wall system with a water application rate of 5 gal/hr/ft^2 at a pressure differential of **15.0 psf**. No uncontrolled water penetration is allowed.

Allowable
No uncontrolled water leakage.

Note: Water penetration is defined as the appearance of uncontrolled water on the indoor face of any part of the work. "Controlled" water or condensation is that which is demonstrably drained harmlessly to the exterior of the work without endangering or wetting adjacent surfaces or insulation, and not visible in the final construction. This definition and conditions are relevant to all water tests, both static and dynamic, throughout this procedure.

4. DYNAMIC WATER PENETRATION (AAMA 501.1)

A fifteen (15) minute water penetration test will be conducted on the system with a water application rate of 5 gal/hr/ft^2 and dynamic air stream equivalent to static pressure of **15.0 psf**.

Allowable
No uncontrolled water leakage.

5. UNIFORM STRUCTURAL DESIGN LOAD TEST (ASTM E330)

Deflection of the system shall be measured and recorded at design pressure when held for **ten (10)** seconds and evaluated using the following allowable criteria:

Each load shall be held as follows:

+ **20 psf** - 50% Positive Design Load (10 seconds)
+ **40 psf** - 100% Positive Design Load (**30** seconds)
- **20 psf** - 50% Negative Design Load (10 seconds)
- **40 psf** - 100% Negative Design Load (**30** seconds)

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Allowable Criteria

- Deflection Normal to Wall Plane: L/175 or 3/4" max.
- Glass Deflection: Limited to L/120 or 3/4" where "L" is the lesser glass dimension.

6. REPEAT STATIC AIR INFILTRATION TEST (ASTM E283)

The mock-up specimen will be subjected to a positive and negative static pressure differential of 6.24 psf Air infiltration and exfiltration will be measured.

Allowable

Air infiltration shall not exceed **0.06 cfm** per square foot of fixed wall area.

7. REPEAT STATIC WATER PENETRATION TEST (ASTM E331)

Repeat Test No. 5 as stated above.

8. REPEAT DYNAMIC WATER PENETRATION (AAMA 501.1)

Repeat Test No. 6 as stated above.

9. INTERSTORY DIFFERENTIAL HORIZONTAL MOVEMENT TEST (AAMA 501.4)

Three (3) complete cycles shall be performed in the horizontal direction parallel to the main elevation at the intermediate simulation. Parallel horizontal movement will be 0.50" to the left, then back to zero, 0.50" to the right, and then back to zero (one cycle).

Allowable

There shall be no failure or gross permanent distortion of anchors, frame, glass, or panels. Structural silicone shall not experience adhesive or cohesive failure along any glass, frame or panel edge. Glazing gaskets may not disengage and weather seals may not fail.

10. INTERSTORY DIFFERENTIAL VERTICAL MOVEMENT TEST (AAMA 501.7)

Three (3) complete cycles shall be performed uniformly in the vertical direction at the supplied columns. Movement shall occur at the mid-span between the job specific columns, deflecting the slab simulation. Vertical movement will be 0.75" down, then back to zero, 0.75" up, and then back to zero (one cycle)

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Allowable
There shall be no failure or gross permanent distortion of anchors, frame, glass, or panels. Structural silicone shall not experience adhesive or cohesive failure along any glass, frame or panel edge. Glazing gaskets may not disengage and weather seals may not fail.

11. REPEAT STATIC AIR INFILTRATION TEST (ASTM E283)

Repeat Test No. 10 as stated above. (reference the repeat not first air test)

12. REPEAT STATIC WATER PENETRATION TEST (ASTM E331)

Repeat Test No. 5 as stated above.

13. Thermal Cycling (AAMA 501.5- 3 Cycles)

Allowable

After completion of the thermal cycling test there shall be no permanent damage due to expansion and contraction. The test specimen should be able to comply with the project specified requirements for air leakage and water resistance after the thermal cycling test.

14. REPEAT STATIC AIR INFILTRATION TEST (ASTM E283)

Repeat Test No. 10 as stated above. (reference the repeat not first air test)

15. REPEAT STATIC WATER PENETRATION TEST (ASTM E331)

Repeat Test No. 5 as stated above.

16. UNIFORM STRUCTURAL OVER LOAD TEST (ASTM E330)

Permanent deformation of the system shall be measured and recorded at 1.5 x design pressure when held for ten (10) seconds and evaluated using the following allowable criteria:

Each load shall be held as follows:

+ **30 psf** - 75% Positive Design Load
+ **60 psf** - 150% Positive Design Load
- **30 psf** - 75% Negative Design Load
- **60 psf** - 150% Negative Design Load

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Allowable
The net permanent set shall not exceed **0.2%** of the clear span.

17. SEISMIC MOVEMENT DISPLACEMENT TEST (AAMA 501.4)

Three (3) complete cycles shall be performed in the horizontal direction parallel to the main elevation at the **intermediate** simulation. Parallel horizontal movement will be 1.00" left, back to zero, 1.00" right and back to zero (one cycle).

Allowable
At the conclusion of this test there shall be no glass breakage, permanent damage to frame members, or anchors.

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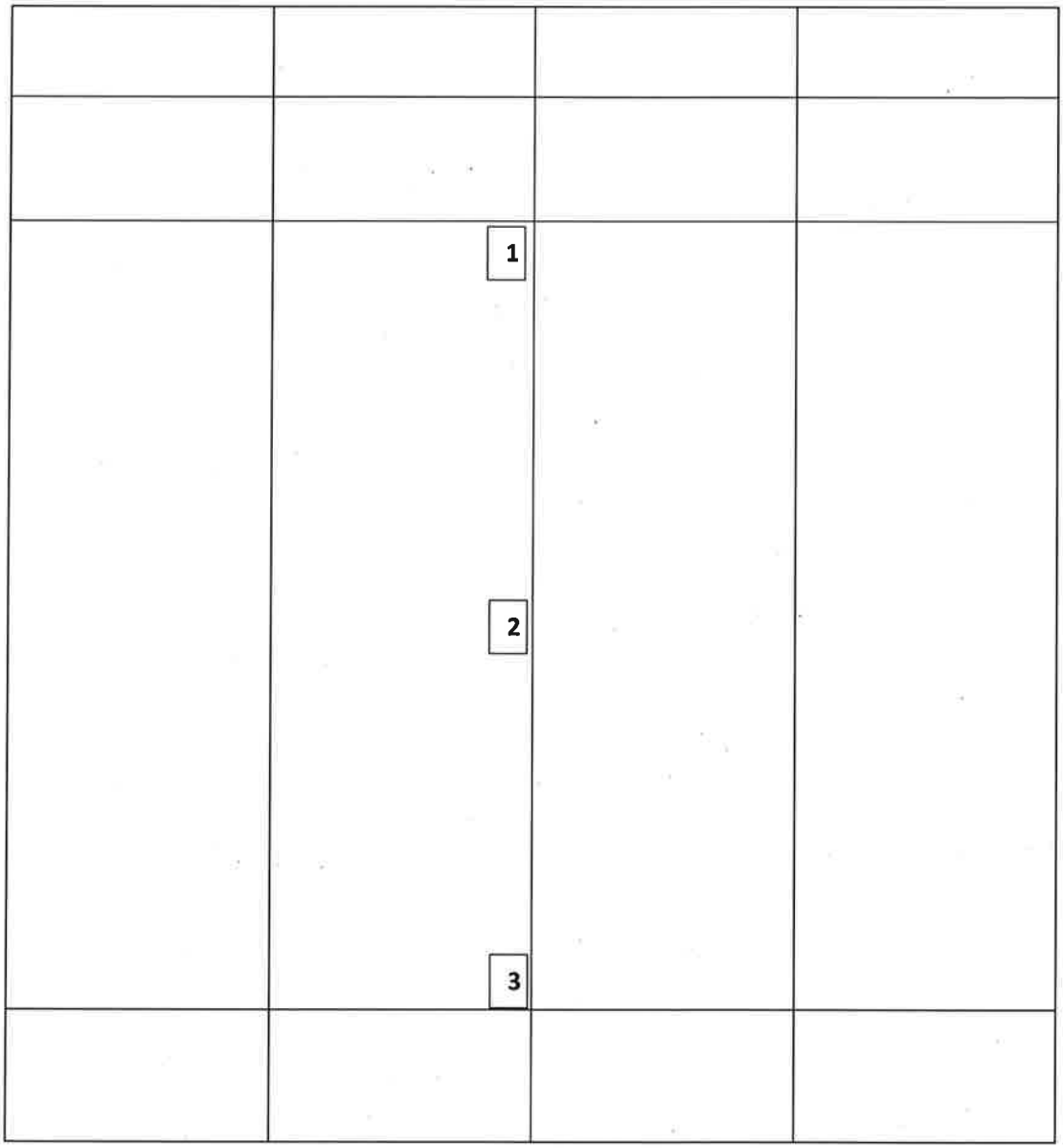
SECTION 8
SKETCHES



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SECTION 9
TABLES

TABLE #1 - Uniform Load Deflection (Deflection in inches)

INDICATOR LOCATION	POSITIVE 40.10 psf	NET DEFLECTION	NEGATIVE 40.10 psf	NET DEFLECTION	ALLOWED*
1	0.38	0.25	0.42	0.25	0.71
2	0.55		0.64		
3	0.23		0.37		

***General Note**: Allowable amounts are based on L/175 of their clear span for framing members. Refer to Sketch #1 for dial indicator locations and to the test procedure for additional information regarding allowable deflections.*

TABLE #2 - Uniform Structural Overloads (Permanent Set in inches)

INDICATOR LOCATION	POSITIVE 60.15 psf	NET PERM. SET	NEGATIVE 60.15 psf	NET PERM. SET	ALLOWED*
1	0.06	0.02	0.17	0.01	0.24
2	0.08		0.23		
3	0.06		0.27		

***General Note**: Allowable amounts are based on 0.02% of their clear span for framing members. Refer to Sketch #1 for dial indicator locations and to the test procedure for additional information regarding allowable deflections.*

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SECTION 10
CONCLUSION

The mock-up met the specified performance requirements.

Regarding the glass tested, no conclusions of any kind regarding the adequacy or inadequacy of the glass in the test specimen are to be drawn from the test.

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SECTION 11
PHOTOGRAPHS

Photo No. 1
Exterior View

Photo No. 2
Dynamic Example

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Facsimile: 717-764-4129
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SECTION 12
DRAWINGS

The "As-Built" drawings for the Thermtek System dated 9/23/2025, which follow, have been supplied by Ipswich Bay Glass Co., Inc. as representative of the As-Completed project condition reported herein. Intertek bears no responsibility for accuracy and/or completeness of the supplied drawings.

PERFORMANCE MOCKUP
IBG THERMTEK 25S-D & UNITIZED 25U-D

DESIGN CRITERIA

** SEE PERFORMANCE MOCKUP TESTING OUTLINE FOR MORE INFORMATION**

METAL FINISHES

A. FINISH FOR ALL EXPOSED SURFACES
1.) PERMAFLUOR MEDIUM BRONZE UC109361

MATERIALS

A. FRAMING

1.) IBG THERMTEK 25S-D & UNITIZED 25U-D
3" x 9 3/4" CURTAINWALL SCREW SPLINE SYSTEM

B. SEALANT

1.) PERIMETER SEALS ARE DOWSIL 756 (BLACK)

2.) ALL INTERIOR METAL TO METAL JOINTS TO BE DOWSIL 756 (BLACK)

3.) STRUCTURAL SEALANT (SHOP APPLIED) TO BE DOWSIL 983 (BLACK)

4.) STRUCTURAL SEALANT (FIELD APPLIED) TO BE DOWSIL 795 (BLACK)

GLASS TYPES

GL-2T	1" INSULATED VISION UNIT

PERFORMANCE MOCKUP TESTING OUTLINE:

1) PRELOAD AT + 20 PSF (50% DESIGN LOAD) ---------- (ASTM E330)
2) STATIC PRESSURE / AIR INFILTRATION ---------- (ASTM E283)
   @ 6.24 PSF / ALLOWED 0.06 CFM/FT² MAX
3) STATIC PRESSURE / WATER RESISTANCE ---------- (ASTM E331)
   @ 15 PSF / NO UNCONTROLLED LEAKAGE ALLOWED
4) DYNAMIC PRESSURE / WATER RESISTANCE ---------- (AAMA 501.1)
   @ 15 PSF / NO UNCONTROLLED LEAKAGE ALLOWED
5) UNIFORM LOAD DEFLECTION ---------- (ASTM E330)
   @ + 20 PSF (PRELOAD)
   @ + 40 PSF (DESIGN LOAD)
   @ - 20 PSF (PRELOAD)
   @ - 40 PSF (DESIGN LOAD)
6) REPEAT STATIC PRESSURE / AIR INFILTRATION ---------- (ASTM E283)
   @ 6.24 PSF/ ALLOWED 0.06 CFM/FT² MAX.
7) REPEAT STATIC PRESSURE / WATER RESISTANCE ---------- (ASTM E331)
   @ 15 PSF/ NO UNCONTROLLED LEAKAGE ALLOWED
8) REPEAT DYNAMIC PRESSURE / WATER RESISTANCE ---------- (AAMA 501.1)
   @ 15 PSF / NO UNCONTROLLED LEAKAGE ALLOWED
9) INTERSTORY DIFFERENTIAL VERTICAL MOVEMENT ---------- (AAMA 501.7)
   @ 1" UP/1" DOWN 3 CYCLES
10) INTERSTORY DIFFERENTIAL HORIZONTAL MOVEMENT (AAMA 501.4)
   @ ½" LEFT/½" RIGHT 3 CYCLES
11) REPEAT STATIC PRESSURE / AIR INFILTRATION ---------- (ASTM E283)
   @ 6.24 PSF/ ALLOWED 0.06 CFM/FT² MAX.
12) REPEAT STATIC PRESSURE / WATER RESISTANCE ---------- (ASTM E331)
   @ 15 PSF/ NO UNCONTROLLED LEAKAGE ALLOWED
13) THERMAL CYCLES (3) ---------- (AAMA 501.5)
14) REPEAT STATIC PRESSURE / AIR INFILTRATION ---------- (ASTM E283)
   @ 6.24 PSF/ ALLOWED 0.06 CFM/FT² MAX.
15) REPEAT STATIC PRESSURE / WATER RESISTANCE ---------- (ASTM E331)
   @ 15 PSF/ NO UNCONTROLLED LEAKAGE ALLOWED
16) UNIFORM STRUCTURAL OVERLOADS ---------- (ASTM E330)
   @ + 30.0 PSF (PRELOAD)
   @ + 60.0 PSF (OVERLOAD)
   @ - 30.0 PSF (PRELOAD)
   @ - 60.0 PSF (OVERLOAD)
17) SEISMIC HORIZONTAL ---------- (AAMA 501.4)
   DISPLACEMENT @ 1.00" 3 CYCLES - LEFT AND RIGHT
   NO VISIBLE DAMAGE

END OF TESTING

PERFORMANCE MOCKUP ELEVATION

AS BUILT SET OF 10/16/25

Sheet List Table

Sheet Number	Sheet Title
PMU CP1.01	COVER PAGE
PMU SD1.01	SYSTEM DATA
PMU SD1.02	SYSTEM DATA
PMU SD1.03	SYSTEM DATA
PMU SD1.04	SYSTEM DATA
PMU E1.01	ELEVATION, PLAN AND SECTION
PMU D1.01	SECTION DETAILS

Sheet List Table

Sheet Number	Sheet Title
PMU D1.01A	SECTION DETAILS
PMU D1.02	SECTION DETAILS
PMU D1.03	SECTION DETAILS
PMU D1.03A	SECTION DETAILS
PMU D1.04	PLAN & PLAN DETAILS
PMU D1.51	PMU PLAN DETAILS
PMU D1.52	PMU PLAN DETAILS

Sheet List Table

Sheet Number	Sheet Title
PMU D1.53	PMU PLAN DETAILS
PMU D1.54	PMU PLAN DETAILS
PMU D1.55	PMU PLAN DETAILS
PMU D1.56	PMU PLAN DETAILS
PMU D1.57	PMU PLAN DETAILS
PMU D1.58	PMU PLAN DETAILS
PMU D1.59	PMU PLAN DETAILS

PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

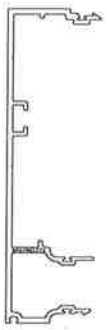
PERFORMANCE MOCKUP

IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6644

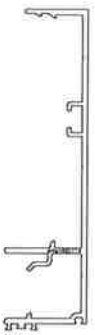
25S-D & 25U-D | TESTING

PMU CP1.01

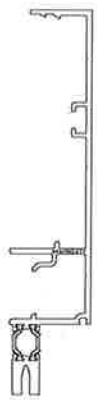
IBG THERMTEK 25S-D & 25U-D EXTRUSIONS



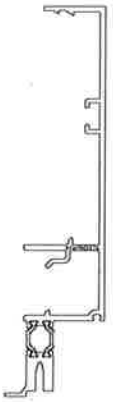
846IBG219
SPLIT VERTICAL MULLION - MALE
FINISH: PAINTED
(25S-D & 25U-D)



846IBG274
SSG SPLIT VERTICAL MULLION- FEMALE
FINISH: PAINTED
(25S-D & 25U-D)



846IBG217
CAPTURED SPLIT VERTICAL MULLION- FEMALE
FINISH: PAINTED
(25S-D)



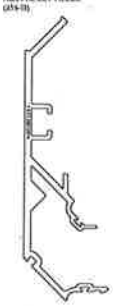
846IBG216
CAPTURED SPLIT VERTICAL MULLION- FEMALE
FINISH: PAINTED
(25U-D)

846IBG285
CAPTURED SPLIT VERTICAL CORNER MULLION
- FRONT FEMALE HALF
FINISH: PAINTED
(25S-D & 25U-D)

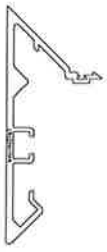
25D-7 PINNING CLIP
ALUMINUM COVER PINNING CLIP
FINISH: MILL
(25S-D & 25U-D)

171321
ABS POCKET FILLER
(25S-D)

846IBG297
ABS POCKET FILLER
(25S-D & 25U-D)

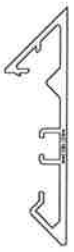


846IBG241
SSG SPLIT VERTICAL CORNER MULLION
- FRONT MALE HALF
FINISH: PAINTED
(25S-D & 25U-D)

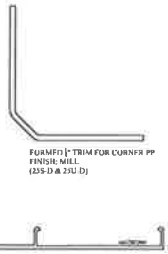


846IBG263
SPLIT VERTICAL CORNER MULLION
- REAR MALE HALF
FINISH: PAINTED
(25S-D & 25U-D)

846IBG283
SPLIT VERTICAL CORNER MULLION
- FRONT FEMALE HALF
FINISH: PAINTED
(25S-D & 25U-D)

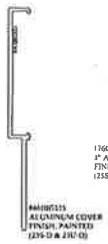


846IBG284
SPLIT VERTICAL CORNER MULLION
- REAR FEMALE HALF
FINISH: PAINTED
(25S-D & 25U-D)



FORMED 3" TRIM FOR CORNER PP
FINISH: MILL
(25S-D & 25U-D)

846IBG290
ALUMINUM COVER COVER
FINISH: PAINTED
(25S-D & 25U-D)



846IBG315
ALUMINUM COVER
FINISH: PAINTED
(25S-D & 25U-D)

176011
3" ALUMINUM COVER
FINISH: PAINTED
(25S-D & 25U-D)

069256
1" x 1" TUBE
FINISH: BLACK PAINT
(25S-D & 25U-D)

215413
1 3/16" x 1" CHANNEL
FINISH: PAINTED
(25S-D)

DRAWINGS

DATE	REVISED/ISSUED FOR	NO
04-25-23	INCLUDES ALUMINUM COVER	1
05-25-23	REV. FOR TAKE UP	2
05-26-23	AS BUILT DRAWINGS	3

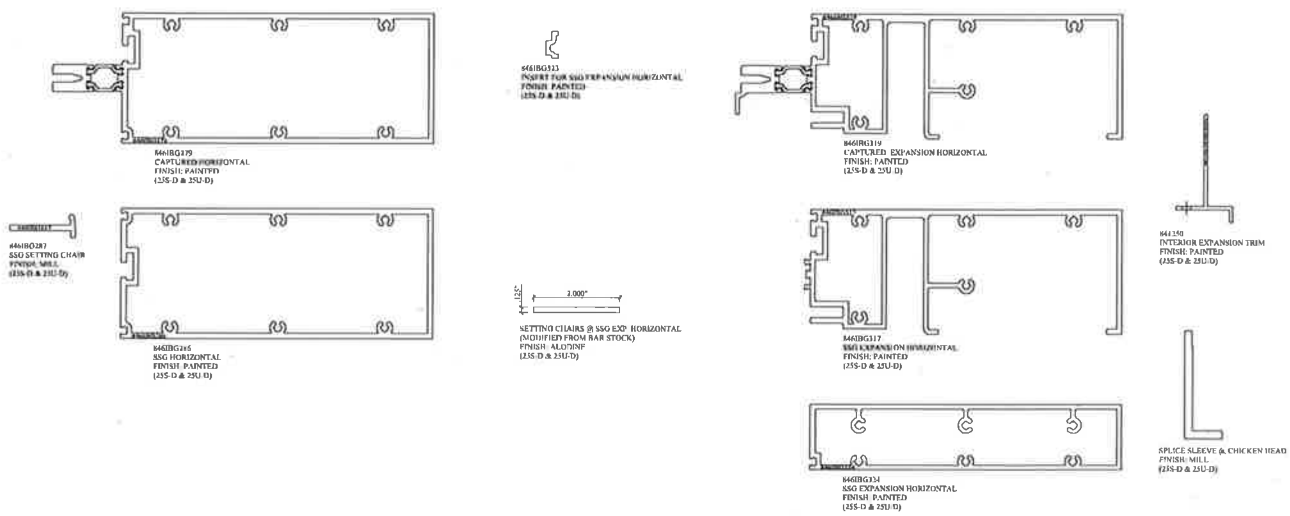
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
POWER BAY GLASS CO., INC. 450 CONGRESS ST. BOWLEY, MA 01969

PROJECT	PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
ADDRESS	POWER BAY GLASS CO., INC. 450 CONGRESS ST. BOWLEY, MA 01969
CONTRACTOR	N/A
DRAWN	RANGER
CHKD	
APPROVED	
DATE	04-25-23
SCALE	N.T.S.
DESCRIPTION	PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

IPSWICH BAY GLASS
BOWLEY, MA 01969
(978) 948-6644

JOB #	25S-D & 25U-D
DWG #	05276
DWG BY	PMG
SHEET	SD1 OF 1

IBG THERMTEK 25S-D & 25U-D EXTRUSIONS

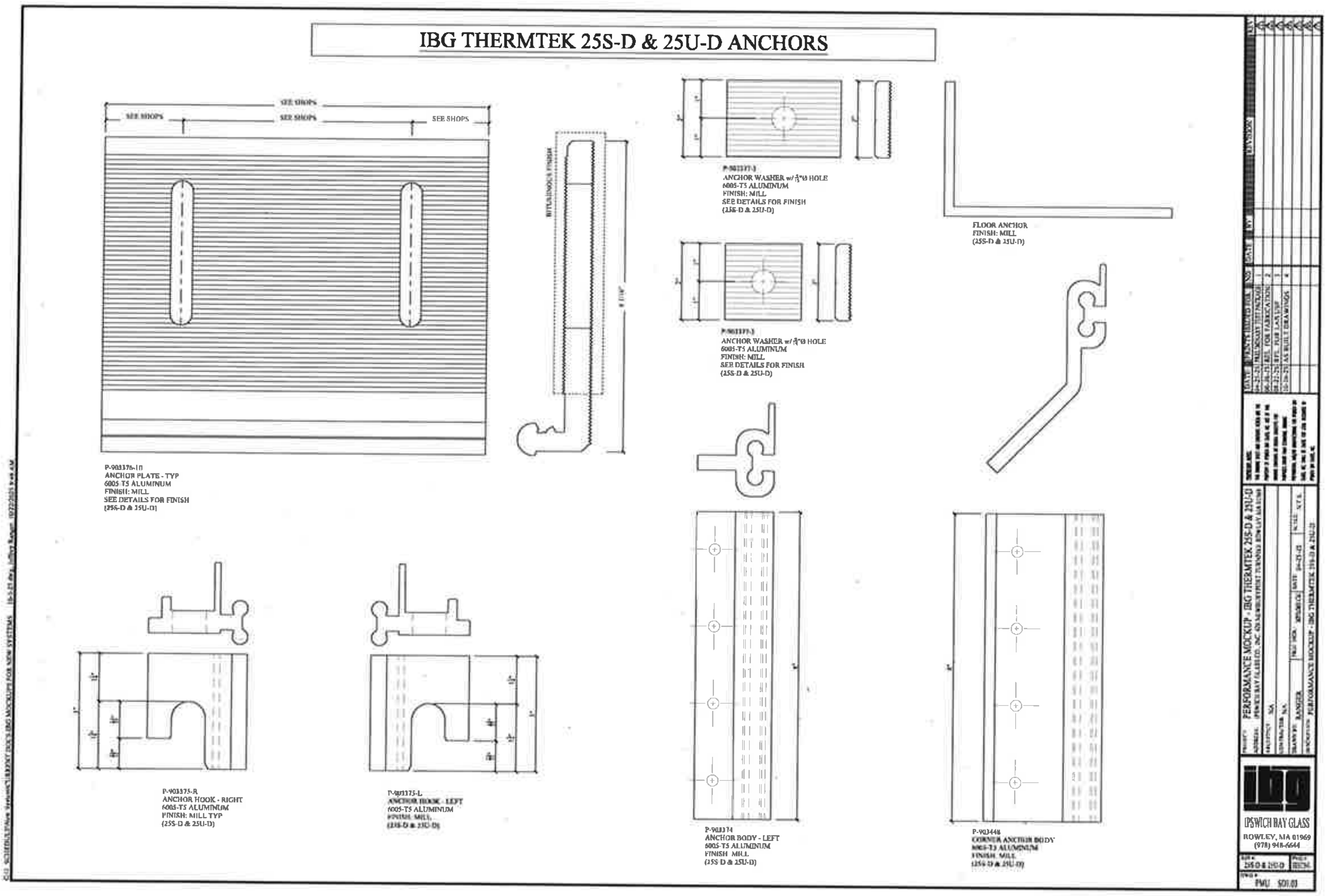


ENSINGER EXTRUSIONS

PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6644

PMU SD1.02


IBG THERMTEK 25S-D & 25U-D ANCHORS
SEE SHOPS
SEE SHOPS
SEE SHOPS
SEE SHOPS
BITUMINOUS FINISH
P-903376-10
ANCHOR PLATE - TYP
6005-T5 ALUMINUM
FINISH: MILL
SEE DETAILS FOR FINISH
(25S-D & 25U-D)
ANCHOR WASHER w/ HOLE
6005-T5 ALUMINUM
FINISH: MILL
SEE DETAILS FOR FINISH
(25S-D & 25U-D)
ANCHOR WASHER w/ HOLE
6005-T5 ALUMINUM
FINISH: MILL
SEE DETAILS FOR FINISH
(25S-D & 25U-D)
FLOOR ANCHOR
FINISH: MILL
(25S-D & 25U-D)
P-903375-R
ANCHOR HOOK - RIGHT
6005-T5 ALUMINUM
FINISH: MILL TYP
(25S-D & 25U-D)
P-903375-L
ANCHOR HOOK - LEFT
6005-T5 ALUMINUM
P-903374
ANCHOR BODY - LEFT
6005-T5 ALUMINUM
FINISH MILL
(25S D & 25U-D)
P-903448
CORNER ANCHOR BODY
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
RANGER
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6644
PMU S01.03

IBG THERMTEK 25S-D & 25U-D ACCESSORIES

Part No.	Description	Series
027-874	AIRLOC T BULB WEATHER STRIP MAT#1 - VYRAM (87± DURO) MAT#2 - POLYPROPYLENE (68±5 DURO) MAT#3 - SANTOPRENE FOAM	(25S-D & 25U-D)
127-092	VERTICAL AIR SEAL MAT#1 - POLYETHYLENE (68±5 DURO) MAT#2 - SANTOPRENE w SILICONE ADDITIVE (65±5 DURO)	(25S-D & 25U-D)
127-091	T BULB WEATHER STRIP MAT#1 - POLYPROPYLENE (68±5 DURO) MAT#2 - SANTOPRENE (65±5 DURO)	(25U-D)
167-303	THERMAL SEPARATOR EPDM BLACK (70±5 DURO)	(25S-D & 25U-D)
027-852	EXTERIOR FIXED GASKET EPDM BLACK (60±5 DURO)	(25S-D & 25U-D)
846IBG299	INTERIOR FIXED GASKET DENSE EPDM BLACK (60±5 DURO)	(25S-D & 25U-D)
846IBG275	EXTERIOR FIXED GASKET EPDM BLACK (60±5 DURO)	(25U-D)
127-024	GASKET @ EXPANSION HORIZONTAL EPDM BLACK (SPONGE DURO)	(25S-D & 25U-D)
841-260 / 127-063	HORIZONTAL AIR SEAL ☑ 841-260 SILICONE BLACK (70±5 DURO) ☐ 127 063 EPDM BLACK (70±5 DURO)	(25S-D & 25U-D)
425-150	6" ISOLATION CLIP (3 PER HORIZ) RIGID PVD	(25S-D & 25U-D)
027 858 (±)	SETTING BLOCK ☐ EPDM BLACK (85±5 DURO) ☑ SILICONE BLACK (85±5 DURO)	(25S-D & 25U-D)
	TR PHILLY (TRPS232) FOAM BLOCK $\frac{3}{4}$" x 2" x 12" LONG	(25S-D & 25U-D)
	FOAM IN GLAZING POCKETS (NOT SHOWN ON DETAILS FOR CLARITY)	(25S-D & 25U-D)

Part No.	Description	Series
	CUSTOM CLIP FOR 3" MULLION (NTS) .125" ALUM SHEET (MILL) JAMB CLIP	(25S-D & 25U-D)
127-096	.032 X 4" SILICONE SHEET	(25S-D & 25U-D)
841-132	GASKET AT STACK HORIZONTAL SILICONE BLACK (70±5 DURO)	(25S-D & 25U-D)
846IBG334	JOINT PLUG FOR CAPTURED MULLION TO CAPTURED HORIZONTAL SILICONE (70± DURO) CUT FROM 846IBG133	(25S-D)
846IBG329	JOINT PLUG FOR SSG MULLION TO CAPTURED HORIZONTALS SILICONE (70± DURO) CUT FROM 846IBG295	(25S-D)
846IBG335	JOINT PLUG FOR CAPTURED CORNER MULLION TO CAPTURED HORIZONTAL SILICONE (70± DURO) CUT FROM 846IBG133	(25S-D)
846IBG330	JOINT PLUG FOR SSG CORNER MULLION TO CAPTURED HORIZONTAL SILICONE (70± DURO) CUT FROM 846IBG295	(25S-D)

Part No.	Description	Series	Part No.	Description	Series
	$\frac{3}{8}$" (NARROW) WASHER, GRADE 5, STEEL - ZINC PLATED ANCHOR BODY TO VERTICAL	(25S-D & 25U-D)	029-118	#10 x 1" TYPE AB PHTF - ROBERTSON DRIVE, SERIES 300 S.S. VERT TO HORIZ SPLINE SCREW	(25S-D & 25U-D)
	$\frac{3}{8}$" SPLIT LOCK WASHER, GRADE 5 (MINIMUM), STEEL - ZINC PLATED ANCHOR BODY TO VERTICAL VERTICAL TO STACK SLEEVE	(25S-D & 25U-D)	841-255	#10 x 1$\frac{1}{2}$" TYPE AB PHTF - ROBERTSON DRIVE, SERIES 300 S.S. CORNER VERT TO HORIZ SPLINE SCREW	(25S-D & 25U-D)
	$\frac{3}{8}$" - 16 HEX MACHINE SCREW NUT, GRADE 5, STEEL - ZINC PLATED ANCHOR BODY TO VERTICAL VERTICAL TO STACK SLEEVE	(25S-D & 25U-D)	126-406	$\frac{1}{4}$" x 1" TYPE AB HHTF, SERIES 300 S.S. PRESSURE PLATE	(25S-D & 25U-D)
	$\frac{3}{8}$" - 16 x 1$\frac{1}{2}$" HEX HEAD STEEL BOLT, GRADE 5, STEEL - ZINC PLATED ANCHOR BODY TO VERTICAL	(25S-D & 25U-D)	126-520	$\frac{1}{4}$" x $\frac{3}{4}$" TYPE AB HHTF, SERIES 300 S.S. PRESSURE PLATE	(25S-D & 25U-D)
	$\frac{3}{8}$" - 16 x $\frac{3}{4}$" HEX HEAD STEEL BOLT, GRADE 5, ZINC PLATED VERTICAL TO STACK SLEEVE	(25S-D & 25U-D)	126-408	#10 x $\frac{5}{8}$" TYPE B PHTF, SERIES 300 S.S.	(25S-D & 25U-D)
	$\frac{1}{4}$" - 20 x $\frac{3}{4}$" HWH TYPE F SCREW ZINC PLATED (#1412FSW) ANCHOR HOOK TO FLOOR ANCHOR (ANTI LIFT)	(25S-D & 25U-D)			
	#14 x 1" HWH TEK, ZINC PLATED ANCHOR HOOK TO ANCHOR BODY (DEADLOAD)	(25S-D & 25U-D)		#10 X $\frac{3}{4}$" FLAT HEAD UNDERCUT SMS, SERIES 300 S.S. SSG HEAD TRIM	(25S-D & 25U-D)
0133179	$\frac{1}{2}$" - 13 x 1" CUP POINT SET SCREWS IN ALLOY STEEL - ZINC PLATED ANCHOR BODY @ TOP (DEADLOAD)	(25S-D & 25U-D)		#10 x $\frac{3}{4}$" FLAT HEAD TEK, SERIES 300 S.S. JAMB CLIP EXTERIOR	(25S-D & 25U-D)
0135171	$\frac{1}{2}$" - 13 x $\frac{1}{2}$" CUP POINT SET SCREWS IN ALLOY STEEL - ZINC PLATED ANCHOR BODY @ TOP (WINDLOAD) ANCHOR BODY @ BOTTOM	(25S-D & 25U-D)		#12 x 1$\frac{1}{2}$" FLAT HEAD TEK, SERIES 300 S.S. GASKET HOLDER GASKET HOLDER/SSG SETTING CHAIR	(25S-D & 25U-D)
				1/4 x 1" FLAT HEAD TEK, SERIES 300 S.S. SPLICE SLEEVE (HORIZONTAL)	(25S-D & 25U-D)
				1/4 x 1 1/4" FLAT HEAD TEK, SERIES 300 S.S. SPLICE SLEEVE (HORIZONTAL)	(25S-D & 25U-D)
				#10 x $\frac{3}{4}$" PAN HEAD TEK, SERIES 300 S.S. INTERIOR STACK TRIM	(25S-D & 25U-D)
				#10 x $\frac{3}{4}$" PAN HEAD TEK, SERIES 300 S.S. CORNER MULLION FIXING END DAMS SSG HEAD TRIM	(25S-D & 25U-D)
				$\frac{1}{4}$" x 1$\frac{1}{2}$" PH TEK, SERIES 300 S.S. CORNER PRESSURE PLATE ASSEMBLY	(25S-D & 25U-D)
				#12 x 1" HWH TEK, SERIES 300 S.S. ANGLE TO BOX STARTER CHICKEN HEAD TO HORIZONTAL	(25S-D & 25U-D)
				#12 x 1$\frac{1}{2}$" HWH TEK, SERIES 300 S.S. STACK SLEEVE TO VERTICAL	(25S-D & 25U-D)

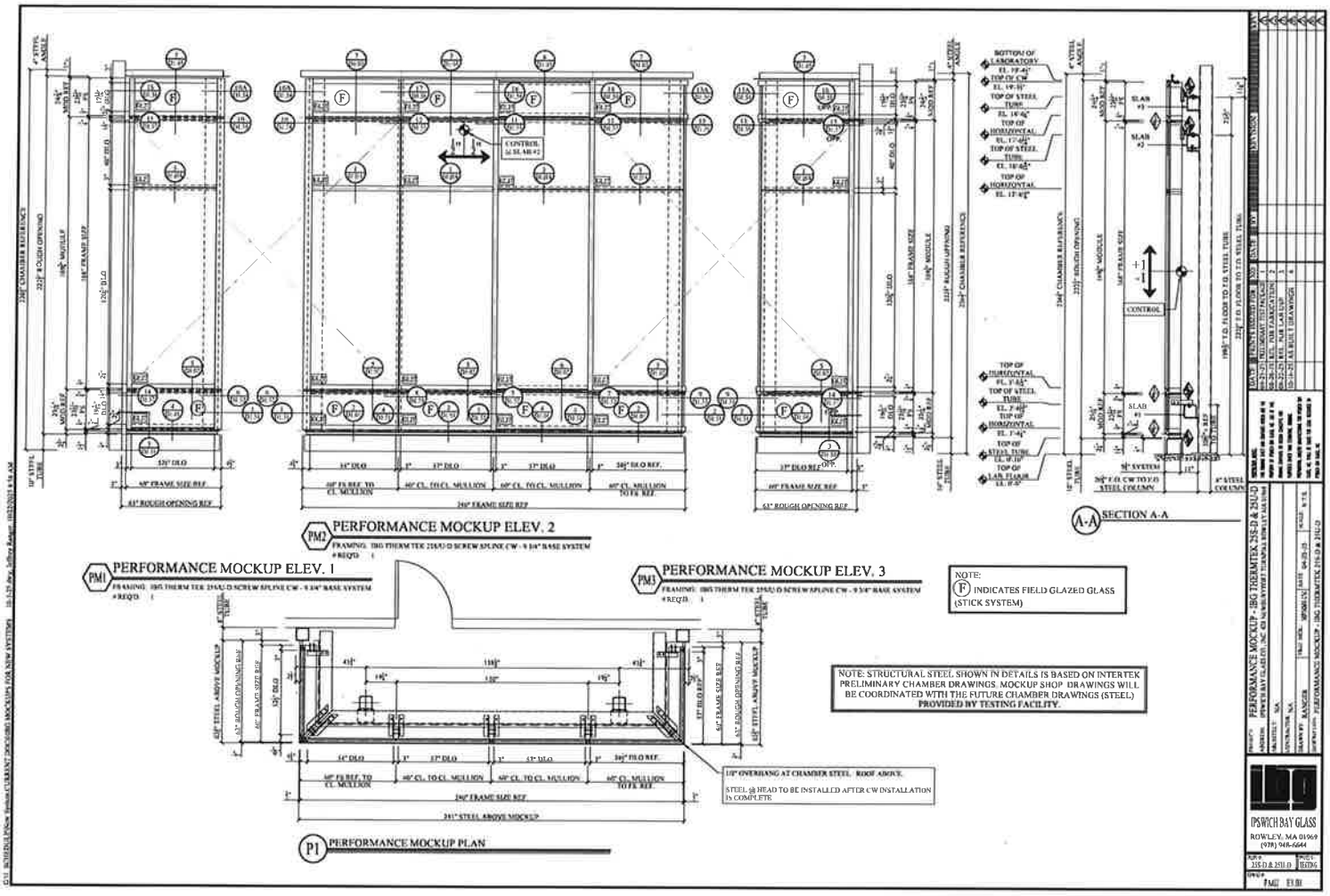
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

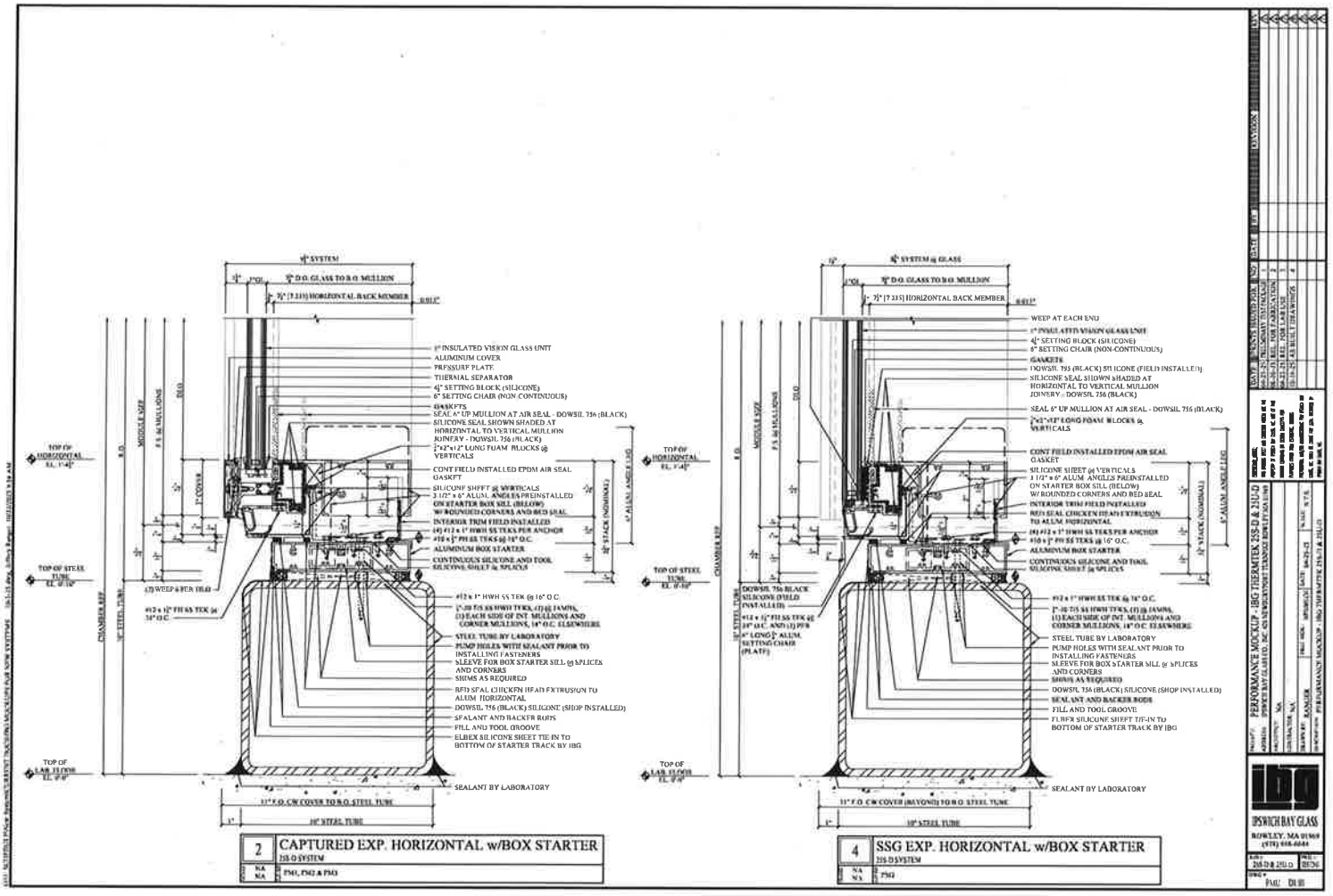
SCALE: N.T.S.

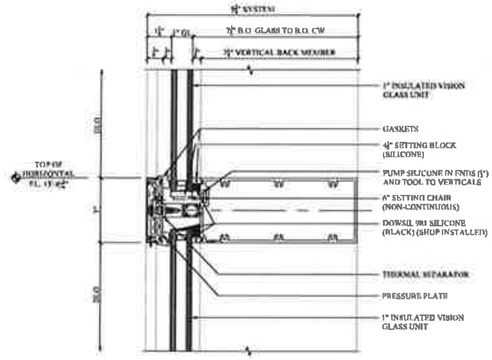
IPSWICH BAY GLASS
ROWLEY, MA 01969

25S-D & 25U-D

PMU SD1.04


PM2 PERFORMANCE MOCKUP ELEV. 2
PM1 PERFORMANCE MOCKUP ELEV. 1
PM3 PERFORMANCE MOCKUP ELEV. 3
P1 PERFORMANCE MOCKUP PLAN
A-A SECTION A-A
NOTE:
(F) INDICATES FIELD GLAZED GLASS (STICK SYSTEM)
NOTE: STRUCTURAL STEEL SHOWN IN DETAILS IS BASED ON INTERTEK PRELIMINARY CHAMBER DRAWINGS. MOCKUP SHOP DRAWINGS WILL BE COORDINATED WITH THE FUTURE CHAMBER DRAWINGS (STEEL) PROVIDED BY TESTING FACILITY.
1/8" OVERHANG AT CHAMBER STEEL ROOF ABOVE.
STEEL @ HEAD TO BE INSTALLED AFTER CW INSTALLATION IS COMPLETE
IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6644

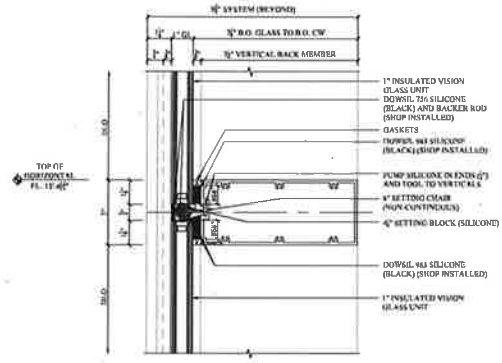

2 CAPTURED EXP. HORIZONTAL w/BOX STARTER
2SS-D SYSTEM
PM1, PM2 & PM3
4 SSG EXP. HORIZONTAL w/BOX STARTER
2SS-D SYSTEM
PM3
SEALANT BY LABORATORY
PERFORMANCE MOCKUP - IBG THERMTEX 2SS-D & 2SU-D
IPSWICH BAY GLASS
BOWLEY, MA 01969
(978) 948-8444



1 CAPTURED HORIZONTALS

25U-D SYSTEM

NA NA PM2



3 SSG HORIZONTALS

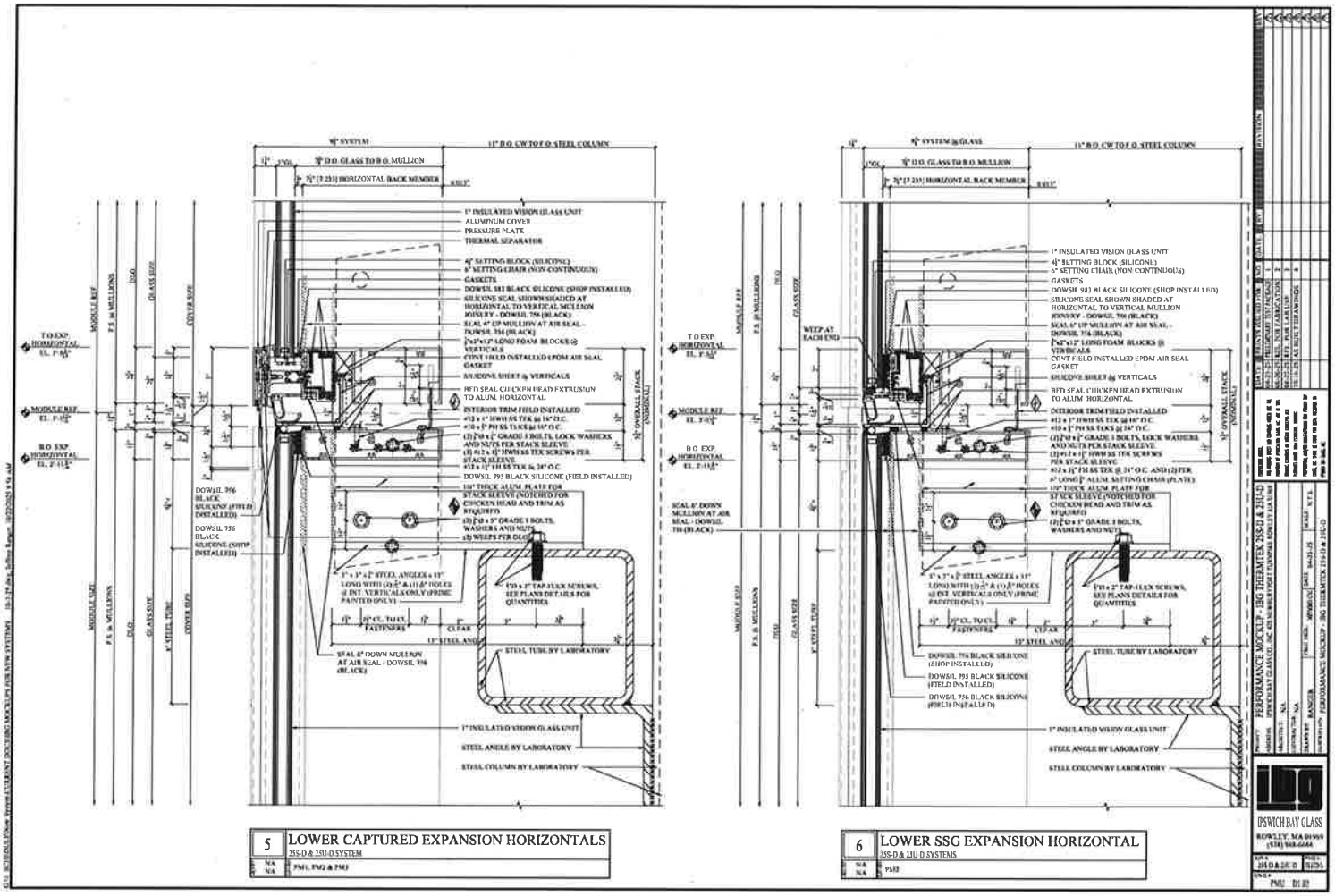
25U-D SYSTEM

NA NA PM1, PM2 & PM3

PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

IPSWICH BAY GLASS

ROWLEY, MA 01969



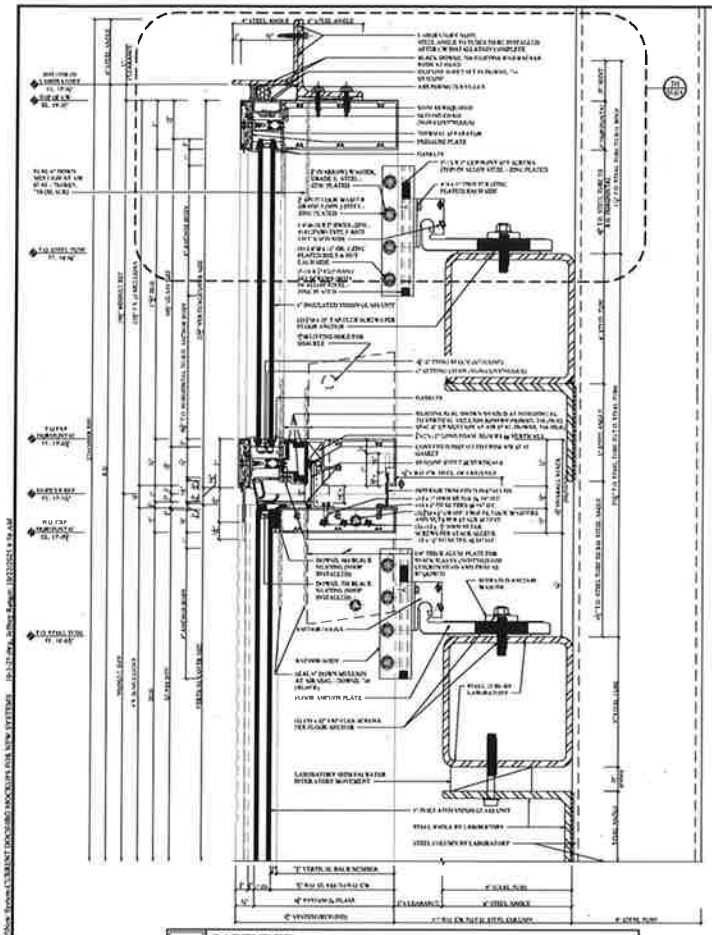
5	LOWER CAPTURED EXPANSION HORIZONTALS
	35S-D & 25U-D SYSTEM
	PM1, PM2 & PM3

6	LOWER SSG EXPANSION HORIZONTAL
	35S-D & 25U-D SYSTEMS
	PM2

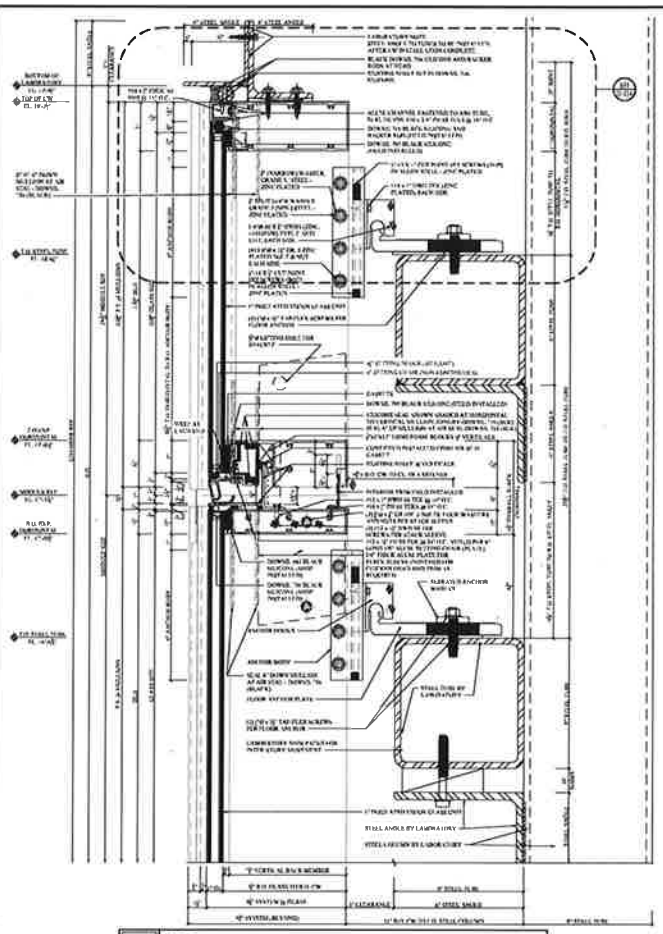
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
IPSWICH BAY GLASS CO. INC 426 NEWBURYPORT TURNPIKE ROWLEY MA 01969

IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6666

PM1 PM2 PM3



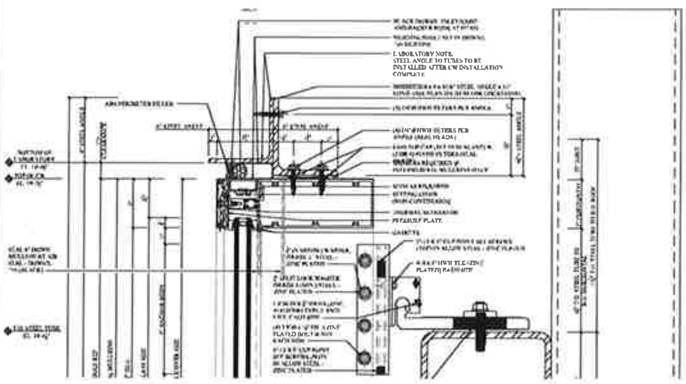
7	CAPTURED UPPER EXP. HORIZONTAL & HEAD DETAIL 195-D & 192-D SYSTEMS
NA NA	PM1, PM2 & PM3



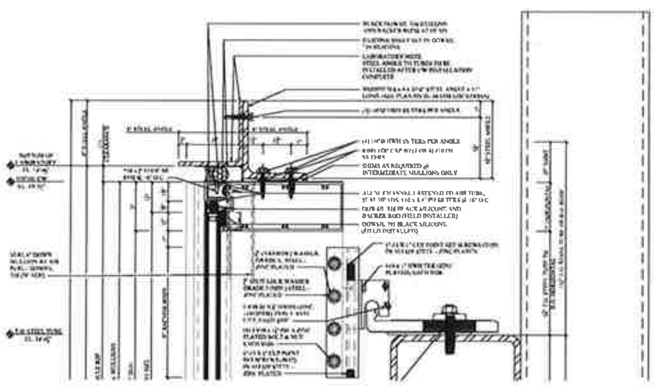
8	SSG UPPER EXP. HORIZONTAL & HEAD DETAIL 195-D & 192-D SYSTEMS
NA NA	PM2

IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6644

PMU D1.03



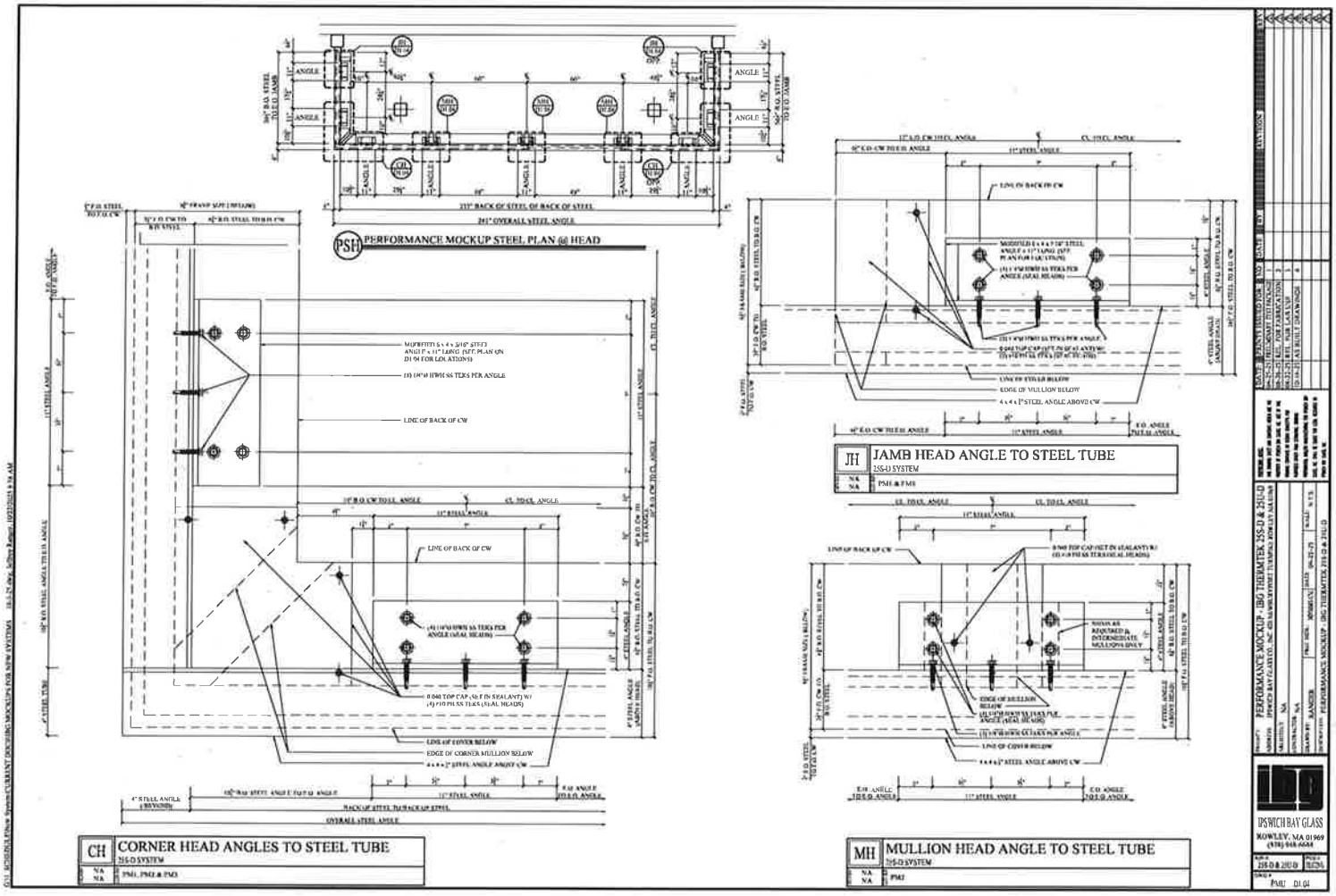
7H CAPTURED HEAD DETAIL & STEEL ANGLE
2SS-D SYSTEM
NA NA PM1, PM3 & PM5

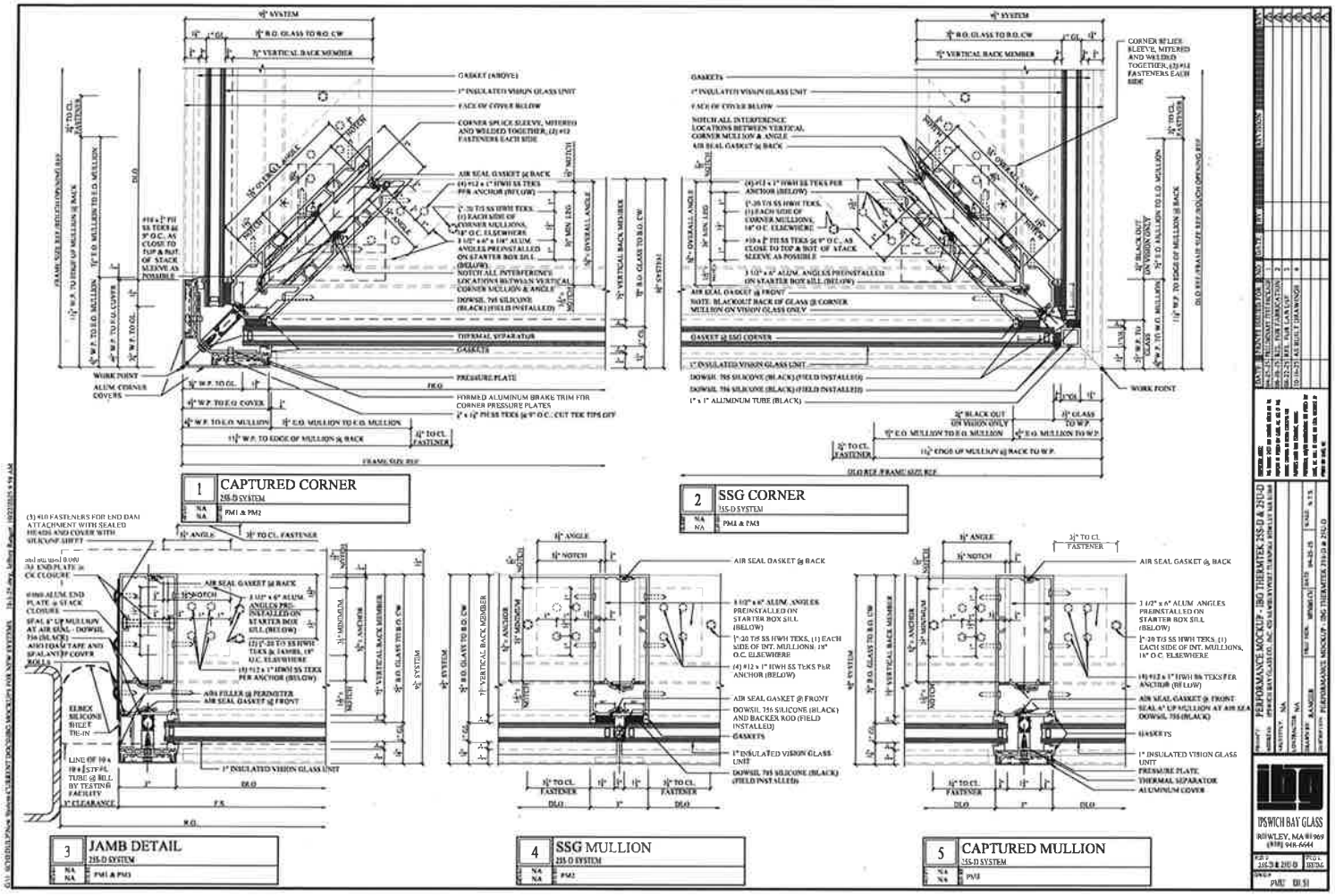


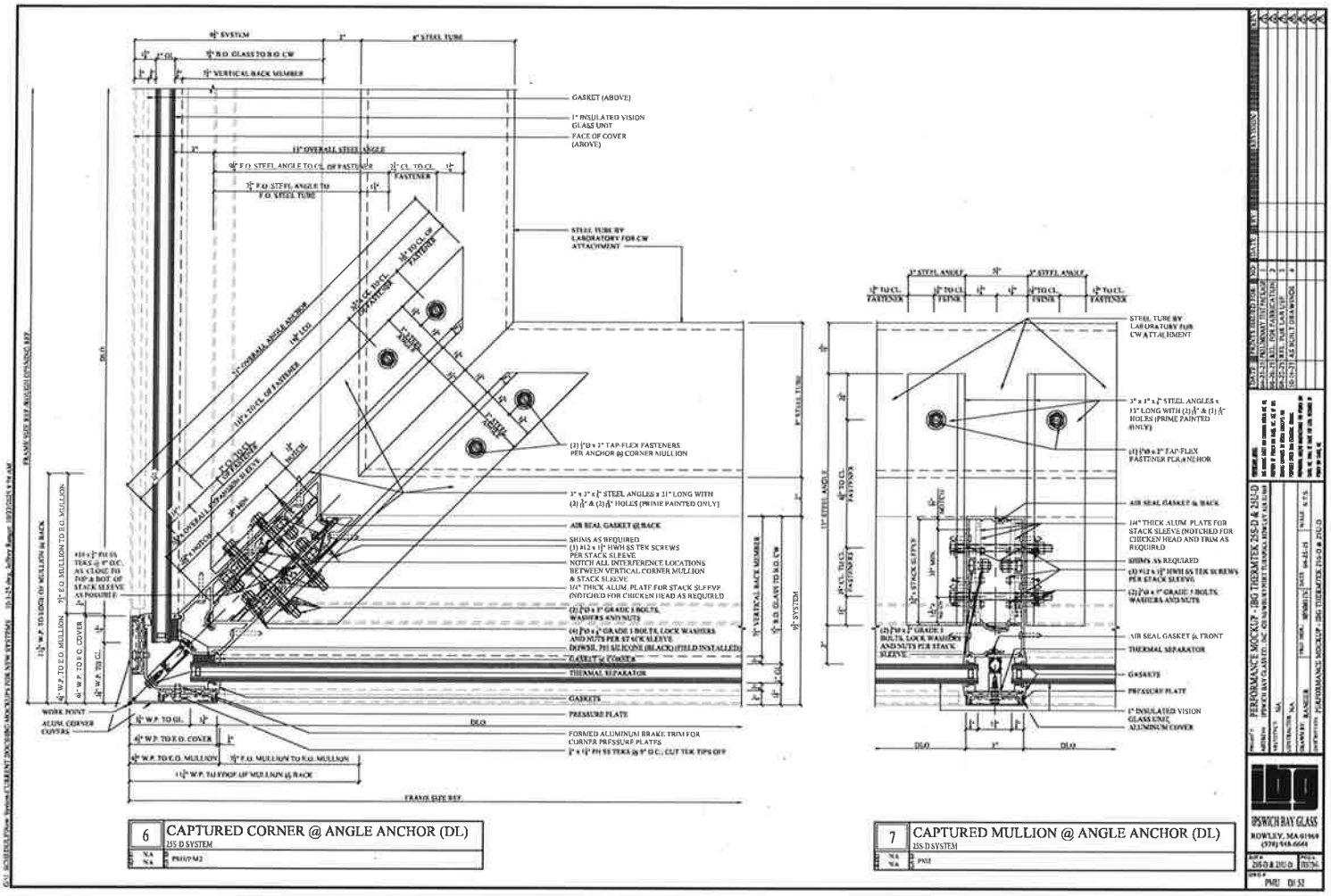
8H SSG HEAD DETAIL & STEEL ANGLE
2SS-D SYSTEM
NA NA PM2

PERFORMANCE MOCKUP - IBG THERMTEK 2SS-D & 2SU-D

IPSWICH BAY GLASS
ROWLEY, MA 01969

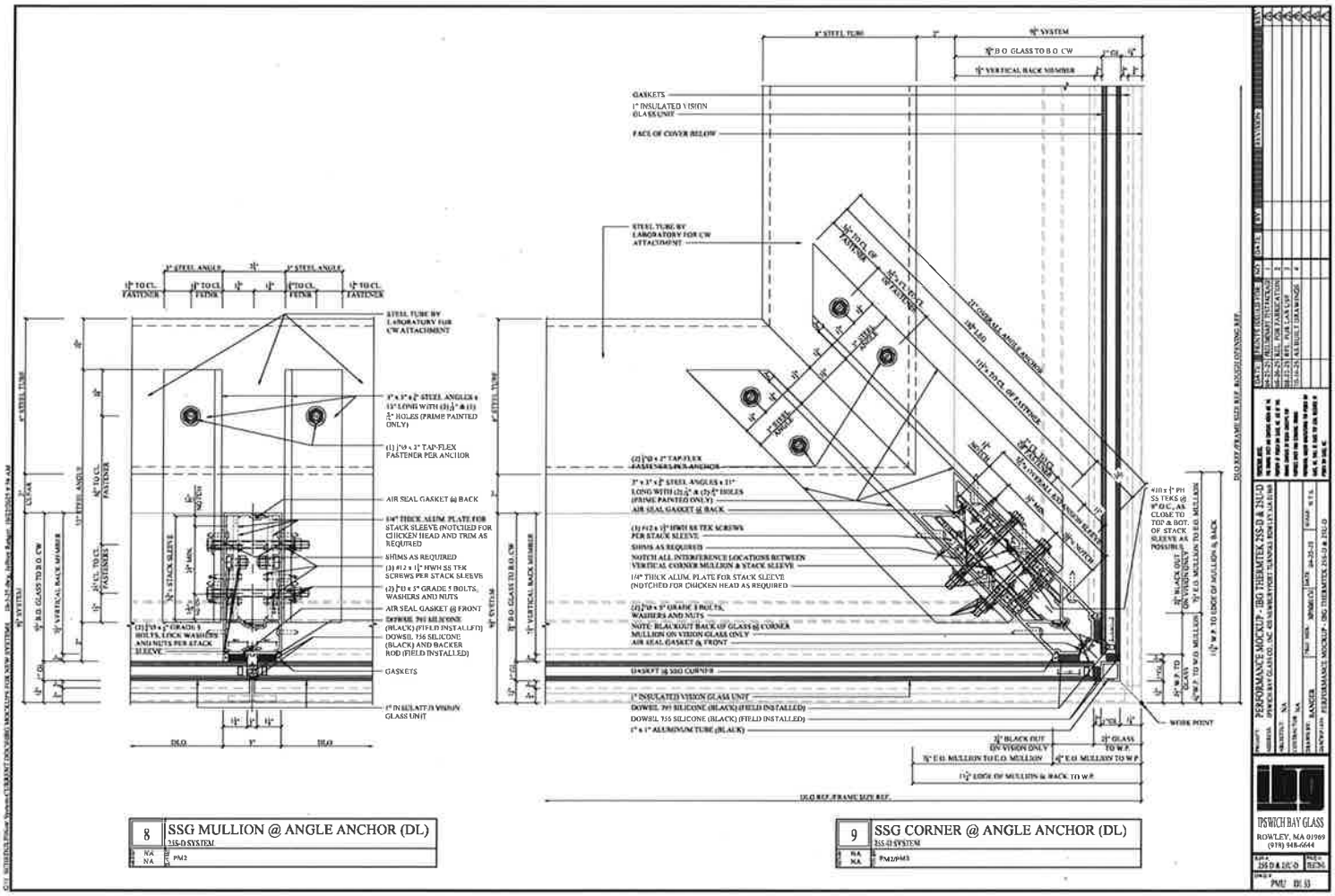

PSH PERFORMANCE MOCKUP STEEL PLAN @ HEAD
JH JAMB HEAD ANGLE TO STEEL TUBE
25S-D SYSTEM
PMH & PMH
CH CORNER HEAD ANGLES TO STEEL TUBE
25S-D SYSTEM
PMH, PMH & PMD
MH MULLION HEAD ANGLE TO STEEL TUBE
25S-D SYSTEM
PMH
PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D
IPSWICH BAY GLASS
ROWLEY, MA 01969
(978) 948-6668
PMH D1.04


1 CAPTURED CORNER
2 SSG CORNER
3 JAMB DETAIL
4 SSG MULLION
5 CAPTURED MULLION
PERFORMANCE MOCKUP - ISO THERMTEK 2SS-D & 2SU-D
IPSWICH BAY GLASS
IPSWICH, MA
(978) 948-6644



6 CAPTURED CORNER @ ANGLE ANCHOR (DL)
255 D SYSTEM
PMU-P-M2

7 CAPTURED MULLION @ ANGLE ANCHOR (DL)
255 D SYSTEM
PMU



8	SSG MULLION @ ANGLE ANCHOR (DL)
NA NA	2SS-D SYSTEM PM2

9	SSG CORNER @ ANGLE ANCHOR (DL)
NA NA	2SS-D SYSTEM PM2/PM3

PERFORMANCE MOCKUP - IBG THERMTEK 2SS-D & 2SU-D

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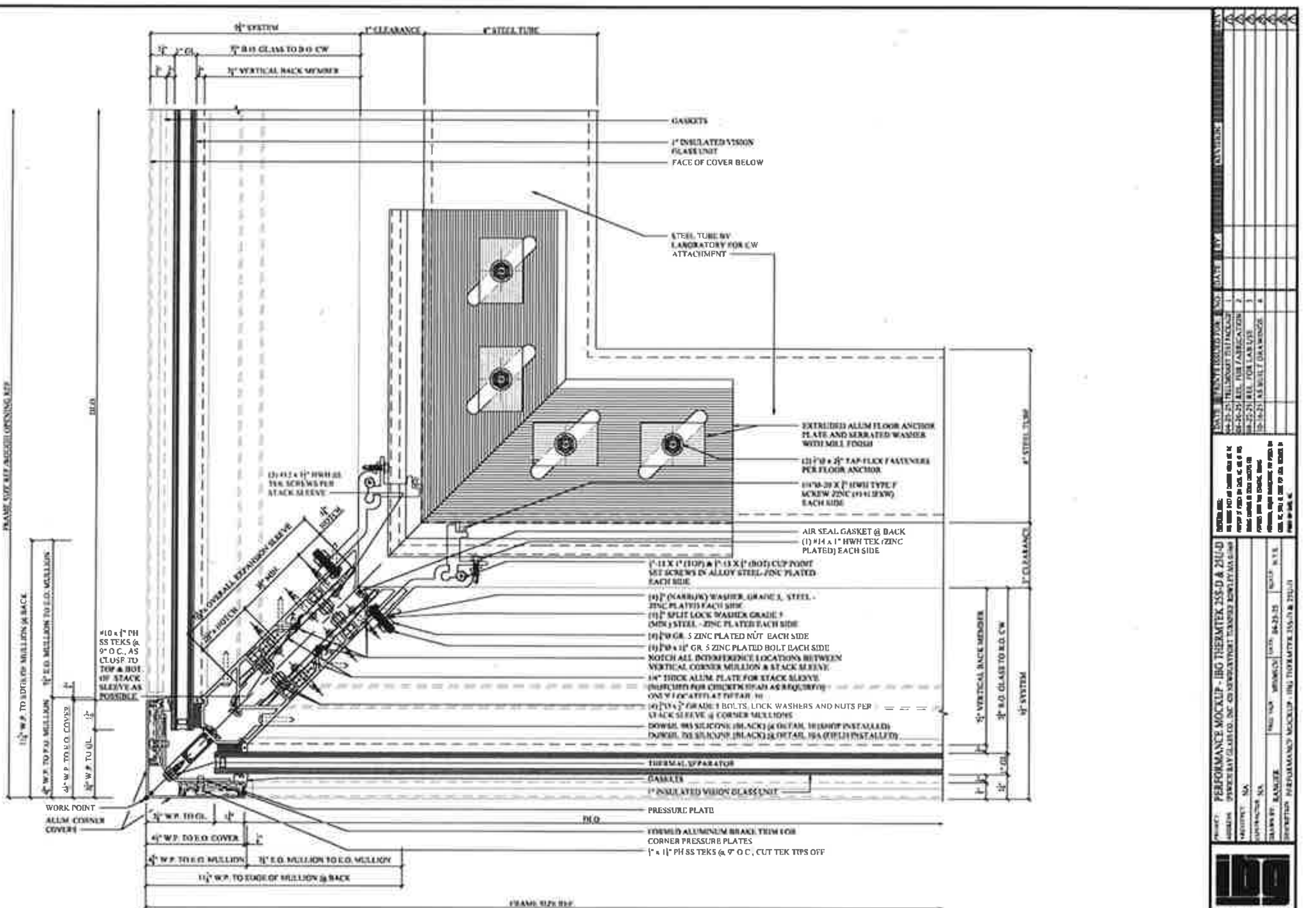
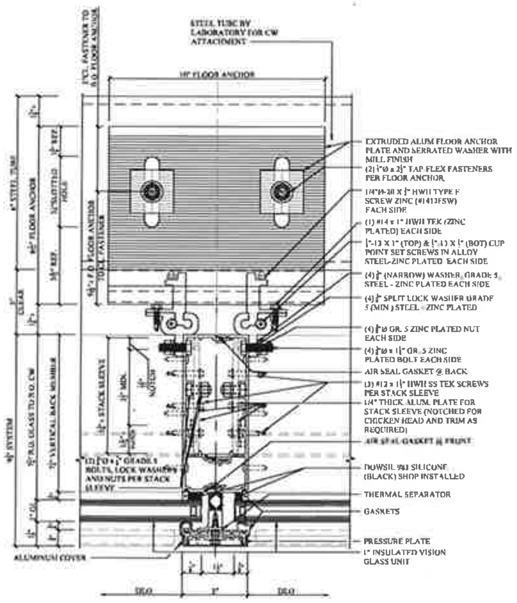
PMU DL 53

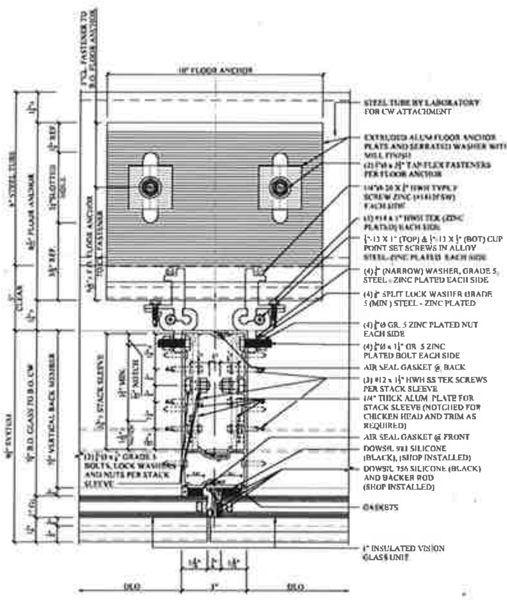


10	CAPTURED CORNER @ FLOOR ANCHOR (DL-MIDDLE)
NA NA	PM1/PM2

10A	CAPTURED CORNER @ FLOOR ANCHOR (DL-UPPER) 25S-D SYSTEM
NA NA	PM1/PM2



11	CAPTURED MULLION @ FLOOR ANCHOR (DL-MIDDLE)
	25U-D SYSTEM
NA NA	PM2



12	SSG MULLION @ FLOOR ANCHOR (DL-MIDDLE)
	25U-D SYSTEM
NA NA	PM2

PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

DATE	PRINTS ISSUED FOR	NO.
	PRELIMINARY ESTIMATE	1
	REL. FOR FABRICATION	2
	REL. FOR LAB USE	3
	AS BUILT DRAWINGS	4

ARCHITECT: NA
CONTRACTOR: NA
DRAWN BY: RANGER
SCALE: N.T.S.

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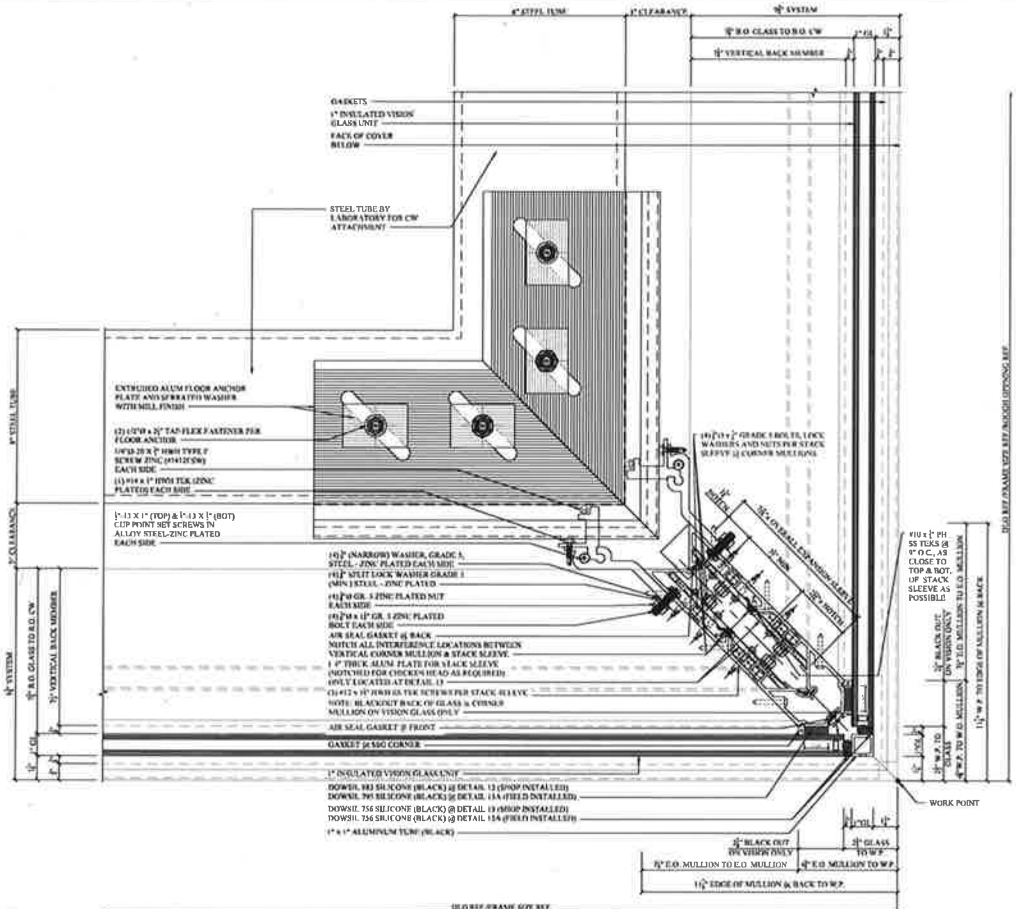

13	SSG CORNER @ FLOOR ANCHOR (DL-MIDDLE)
	2SU-D SYSTEM
NA NA	PM2/PM3

13A	SSG CORNER @ FLOOR ANCHOR (DL-UPPER)
	2SS-D SYSTEM
NA NA	PM2/PM1

PERFORMANCE MOCKUP - IBG THERMTEK 2SS-D & 2SU-D

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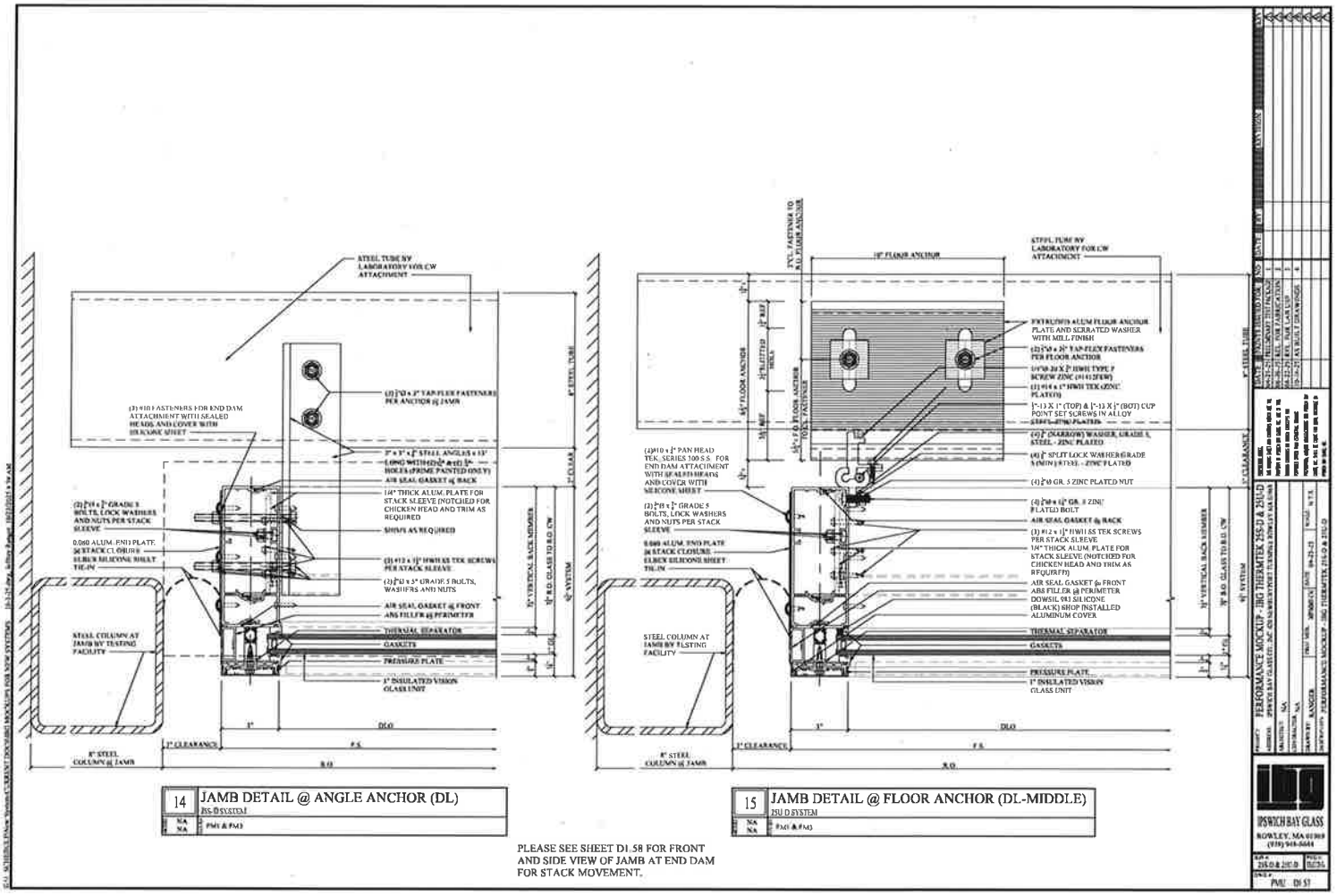
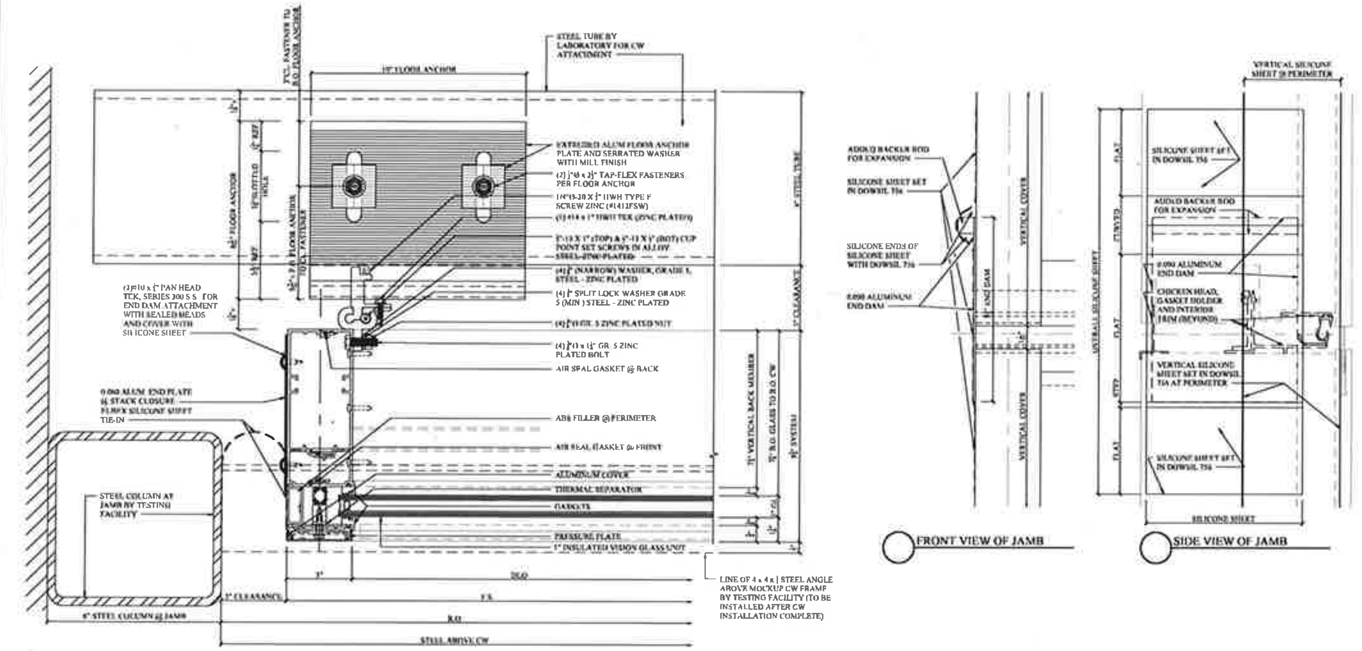
PMU 01.36



PLEASE SEE SHEET DI.58 FOR FRONT AND SIDE VIEW OF JAMB AT END DAM FOR STACK MOVEMENT.


STEEL TUBE BY LABORATORY FOR CW ATTACHMENT
10" FLOOR ANCHOR
EXTRUDED ALUM FLOOR ANCHOR PLATE AND SERRATED WASHER WITH MILL FINISH
TAP-FLEX FASTENERS PER FLOOR ANCHOR
AIR SEAL GASKET @ BACK
AIR SEAL GASKET @ FRONT
ALUMINUM COVER
THERMAL SEPARATOR
GASKETS
PRESSURE PLATE
1" INSULATED VISION GLASS UNIT
STEEL COLUMN AT JAMB BY TESTING FACILITY
6" STEEL COLUMN @ JAMB
1" CLEARANCE
R.O.
STEEL ABOVE CW
LINE OF 4 x 4 x ¼ STEEL ANGLE ABOVE MOCKUP CW FRAME BY TESTING FACILITY (TO BE INSTALLED AFTER CW INSTALLATION COMPLETE)
FRONT VIEW OF JAMB
SIDE VIEW OF JAMB
ADDED BACKER ROD FOR EXPANSION
0.090 ALUMINUM END DAM
VERTICAL SILICONE SHEET @ PERIMETER
SILICONE SHEET

16	JAMB DETAIL @ FLOOR ANCHOR (DL-UPPER) 25S-D SYSTEM
NA NA	PM1 & PM3

PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

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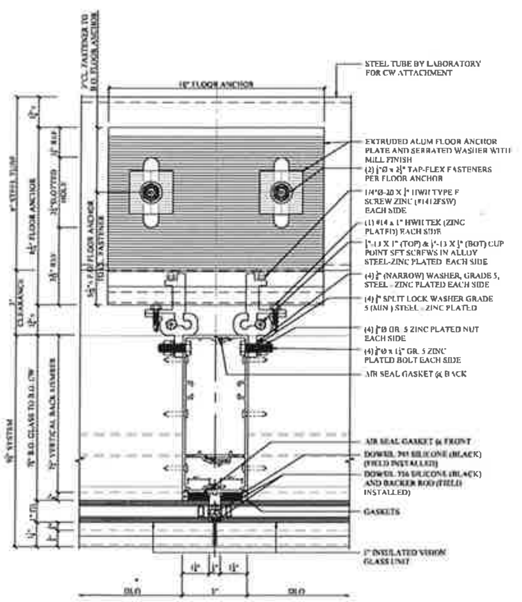
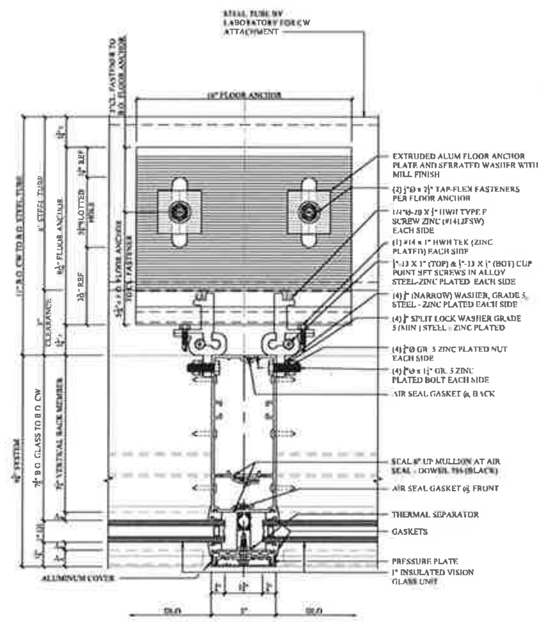
25S-D & 25U-D

PMU D1.16



17	SSG MULLION @ FLOOR ANCHOR (DL-UPPER)
	25S-D SYSTEM
NA NA	PM2

DETAIL MOVED FROM PAGE DI.58



18	CAPTURED MULLION @ FLOOR ANCHOR (DL-UPPER)
	25S-D SYSTEM
NA NA	PM2

DATE	PRINT ISSUED FOR	NO.
	PRELIMINARY DWG	1
	REL. FOR FABRICATION	2
	REL. FOR LAB USE	3
	AS BUILT DRAWINGS	4

PROJECT: PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

ARCHITECT: NA

CONTRACTOR: NA

DRAWN BY: RANGER

DESCRIPTION: PERFORMANCE MOCKUP - IBG THERMTEK 25S-D & 25U-D

SCALE: N.T.S.

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25S-D & 25U-D

PMU DI.59