



REPORT NUMBER: 150327003SHF-BP-1
ORIGINAL ISSUE DATE: April 24, 2015

EVALUATION CENTER

Intertek Testing Services Ltd., Shanghai
No.7 Building, No. 6958 Daye Road, Fengxian District., Shanghai

RENDERED TO

FUZHOU ROPO BUILDING MATERIALS CO., LTD
TIELING INDUSTRIAL ZONE, MINHOU, FUZHOU, FUJIAN,
CHINA

PRODUCT EVALUATED

UPVC Fixed Window
Model: RP006

EVALUATION PROPERTY

Deflection / Span Ratio Test, Operating Force Test,
Air Infiltration Test, Water Penetration Test and Ultimate Strength Test

TEST REPORT

Report of Testing an UPVC Fixed Window (Model: RP006) for compliance with the applicable requirements of the following criteria: AS 2047-2014 “Windows and external glazed doors in buildings”, AS 4420.2-1996 “Windows –Methods of test, Method 2: Deflection test”, AS 4420.3-1996 “Windows –Methods of test, Method 3: Operating force test”, AS 4420.4-1996 “Windows –Methods of test, Method 4: Air infiltration test”, AS 4420.5-1996 “Windows –Methods of test, Method 5: Water penetration resistance test”, AS 4420.6-1996 “Windows –Methods of test, Method 6: Ultimate strength test”.

"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 tested. This report by itself does not imply that the material, product, or service is or has ever been under an Intertek certification program."

1 Table of Contents

1	Table of Contents	2
2	Introduction	3
3	Test Samples	3
3.1.	SAMPLE SELECTION	3
3.2.	SAMPLE AND ASSEMBLY DESCRIPTION	3
4	Testing and Evaluation Methods	4
4.1.	DEFLECTION / SPAN RATIO TEST	4
4.2.	OPERATING FORCE TEST	4
4.3.	AIR INFILTRATION TEST	4
4.4.	WATER PENETRATION TEST	4
4.5.	ULTIMATE STRENGTH TEST	4
5	Testing and Evaluation Results	5
5.1.	RESULTS AND OBSERVATIONS	5
6	Conclusion	6
7	Appendix A: Sample Drawings	7
8	Appendix B: Test Data	10
	Revision Page.....	13

2 Introduction

Intertek has conducted testing for Fuzhou ROPO Building Materials Co., Ltd, on a UPVC Fixed Window (Model: RP006) to evaluate Deflection / Span Test, Operating Force Test, Air Infiltration Test, Water Penetration Test and Ultimate Strength Test. Testing was conducted in accordance with AS 2047-2014 specifications and method standards of:

- AS 4420.2-1996 “Windows –Methods of test, Method 2: Deflection test”
- AS 4420.3-1996 “Windows –Methods of test, Method 3: Operating force test”
- AS 4420.4-1996 “Windows –Methods of test, Method 4: Air infiltration test”
- AS 4420.5-1996 “Windows –Methods of test, Method 5: Water penetration resistance test”
- AS 4420.6-1996 “Windows –Methods of test, Method 6: Ultimate strength test”.

This evaluation began on April 13, 2015 and was completed on April 23, 2015.

3 Test Samples

3.1. SAMPLE SELECTION

Samples were submitted to Intertek directly from the client. Samples were not independently selected for testing. Samples were received at the Evaluation Center on March 25, 2015.

3.2. SAMPLE AND ASSEMBLY DESCRIPTION

A full scale sample of UPVC fixed window (Model: RP006) was provided by the manufacturer that was not weathered nor conditioned.

Table 1 Product Information

Product Name	UPVC fixed window
Model	RP006
Dimension of Window Frame	1600mm×2100mm
Dimension of Window Sash	1600mm×2100mm
UPVC Profile	Model: AD58 Manufacturer: VEKA Plastics (Shanghai) Co. Ltd.
Glazing	Dimension: 717 mm×1994 mm Structure: (5 mm+12 A+5 mm) Supplier: Xinfuxing Glass Co., Ltd
Hardware	Not Applicable
Weather Bar	Not Applicable
Thermal Break	Not Applicable
Drainage	Dimension: 3.5 mm*30 mm, Quantity: 2 pieces
Gasket (between leaf and frame)	Material: EPDM Supplier: Jiangyin Haida Rubber and Plastic Co., Ltd.
Sealant of Glass	Material: Neutral Silicone Sealant Supplier: HangZhou Zhijiang Silicone CO.,LTD.

The sample ID number was S150327003SHF-001. The drawings of the representative sample were referenced in Appendix A.

4 Testing and Evaluation Methods

4.1. DEFLECTION / SPAN RATIO TEST

The Deflection Test was conducted in accordance with AS 4420.2-1996. The pressure was applied to test specimen in not less than four approximately equal increments until the test pressure was reached; first to the exterior surface (positive) and then to the interior surface (negative). The load duration was held for at least 1 minute at each pressure increment. The test specimen was evaluated for deflection during load, and was evaluated for permanent deflection after differential pressure removed for 2 minutes. According to Section 2.3.1.2 in AS 2047-2014 for Housing, no structure members in a completely assembled and window should deflect by an amount greater than span/250 when the specimen was tested at the serviceability design wind pressure specified in Table 2.1 *WINDOW RATING FOR HOUSING* in AS 2047-2014.

4.2. OPERATING FORCE TEST

The Operating Force Test was conducted in accordance with AS 4420.3-1996. For the movable leaf of the window, the force was applied at the fixed handle position; and forces to initiate the sash in motion and to maintain the motion should be recorded. The test force should be not greater than the value for windows given in Table 2.2 *OPERATING FORCE FOR TEST* in AS 2047-2014.

4.3. AIR INFILTRATION TEST

The Air Infiltration Test was conducted in accordance with AS 4420.4-1996. The test was performed using positive and negative differential pressures of 75 Pa. The air infiltration rates through the specimen should be determined. The air infiltration should not exceed the value specified in Table 2.3 *MAXIMUM AIR INFILTRATION* in AS 2047-2014.

4.4. WATER PENETRATION TEST

The Water Penetration Test was conducted in accordance with AS 4420.5-1996. The test specimen was subjected to water spraying uniformly and continuously over the exterior face of the test specimen at a rate not less than 0.05 L/m²·s. At the start of test, the water sprays should operate for 5 minutes with zero air pressure. And then, as for Housing Requirements, the test pressures specified in Table 2.4 *Water Penetration Resistance Test Pressure* in AS 2047-2014 were applied and maintained for 15 minutes with the water sprays still operating. During the test sequence, there should be no uncontrolled water penetration observed.

4.5. ULTIMATE STRENGTH TEST

The Ultimate Strength Test was conducted in accordance with AS 4420.6-1996. As for Housing Requirements, the ultimate strength test pressure specified in Table 2.5 *ULTIMATE STRENGTH TEST PRESSURES* in AS 2047-2014 was increased smoothly and was applied to the test specimen for 10 seconds in both positive and negative direction. The test specimen should not collapse when subjected to the ultimate strength pressure, and was evaluated for permanent damage after loading.

5 Testing and Evaluation Results

5.1. RESULTS AND OBSERVATIONS

The test results are summarized in Table 2 below. A more comprehensive set of test data is included in Appendix B.

Table 2 Test Results

Test Description	Test Result	Verdict
Deflection / Span Ratio Test	Serviceability design wind pressure: 2000 Pa	Pass
Air Infiltration Test	+75 Pa: 0.01 L/s·m ² ; -75 Pa: 0.01 L/s·m ² ; Average air leakage rate: 0.01 L/s·m ² Air Infiltration Level: Low	Pass
Water Penetration Test	Test Pressure: 800 Pa	Pass
Ultimate Strength Test	Test Pressure: 4000 Pa Rating: N6 (General) C2 (Corner Windows)	Pass

6 Conclusion

The UPVC Fixed Window (Model: RP006) identified in this report has been tested in accordance with Deflection / Span Ratio Test, Operating Force Test, Air Infiltration Test, Water Penetration Test and Ultimate Strength Test requirements as per AS 2047-2014.

The test specimen met the requirements for Deflection / Span Ratio Test, Air Infiltration Level of Low for Air Infiltration, for Water Penetration Test and Rating of N6 (General) or C2 (Corner Windows) for ultimate strength test as per AS 2047-2014.

The conclusions of this test report may not be used as part of the requirements for Intertek product certification. Authority to Mark must be issued for a product to become certified.

INTERTEK

Reported by: Alvin Zhu
Alvin Zhu
Engineer

Reviewed by: Fred Bao
Fred Bao
Technical Supervisor

7 Appendix A: Sample Drawings

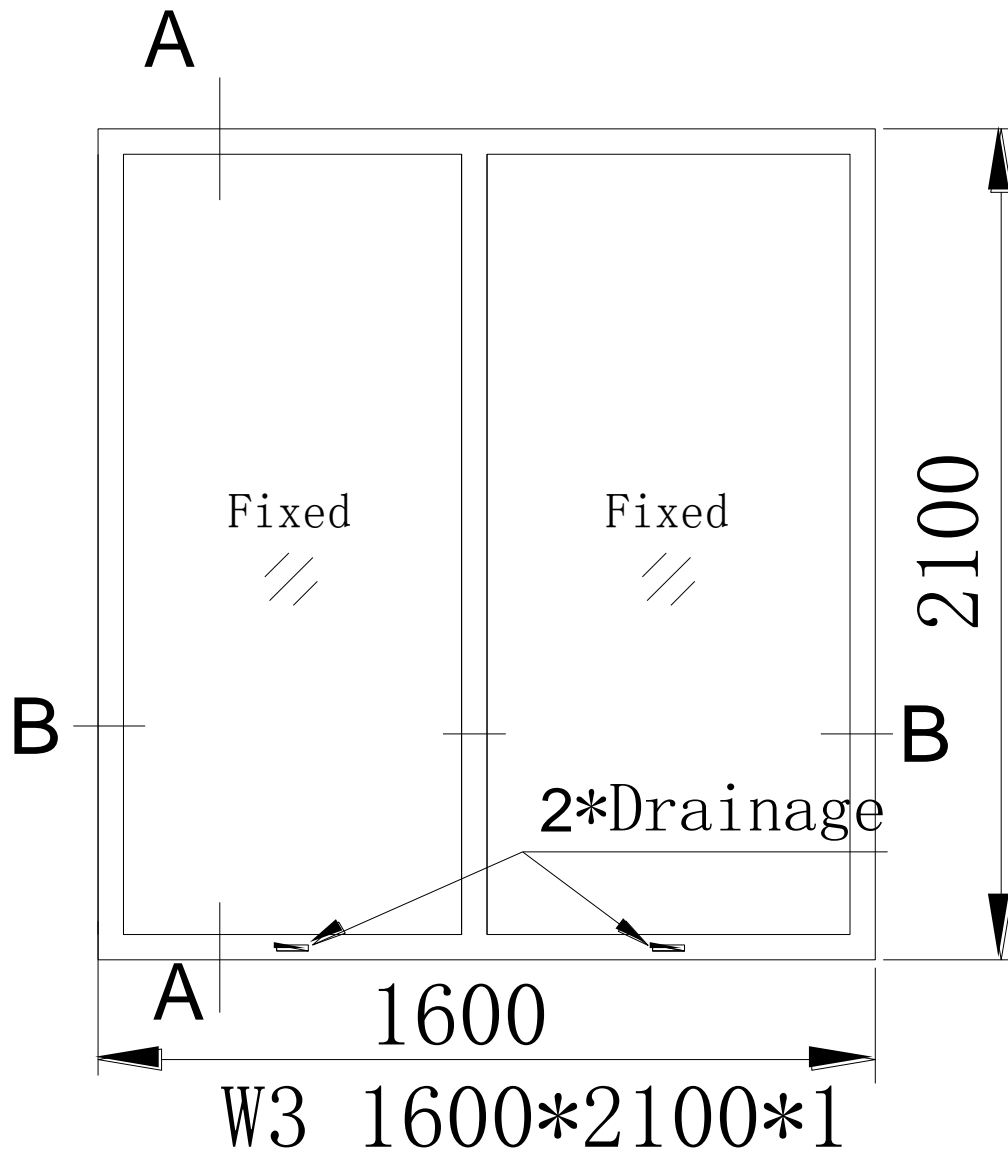


Fig.1 Drawing of Representative Sample

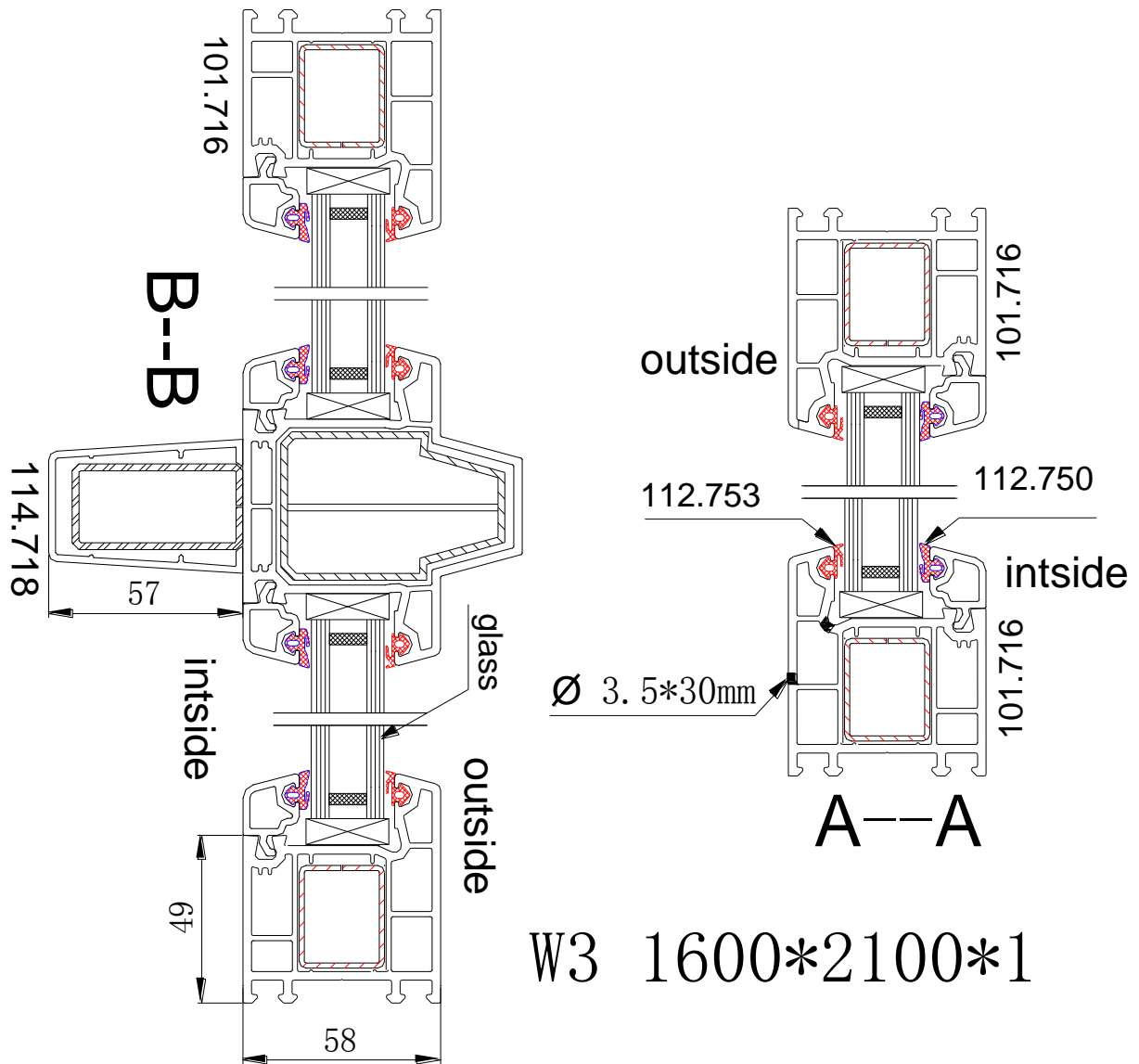


Fig.2 Detail Drawings of Representative Sample

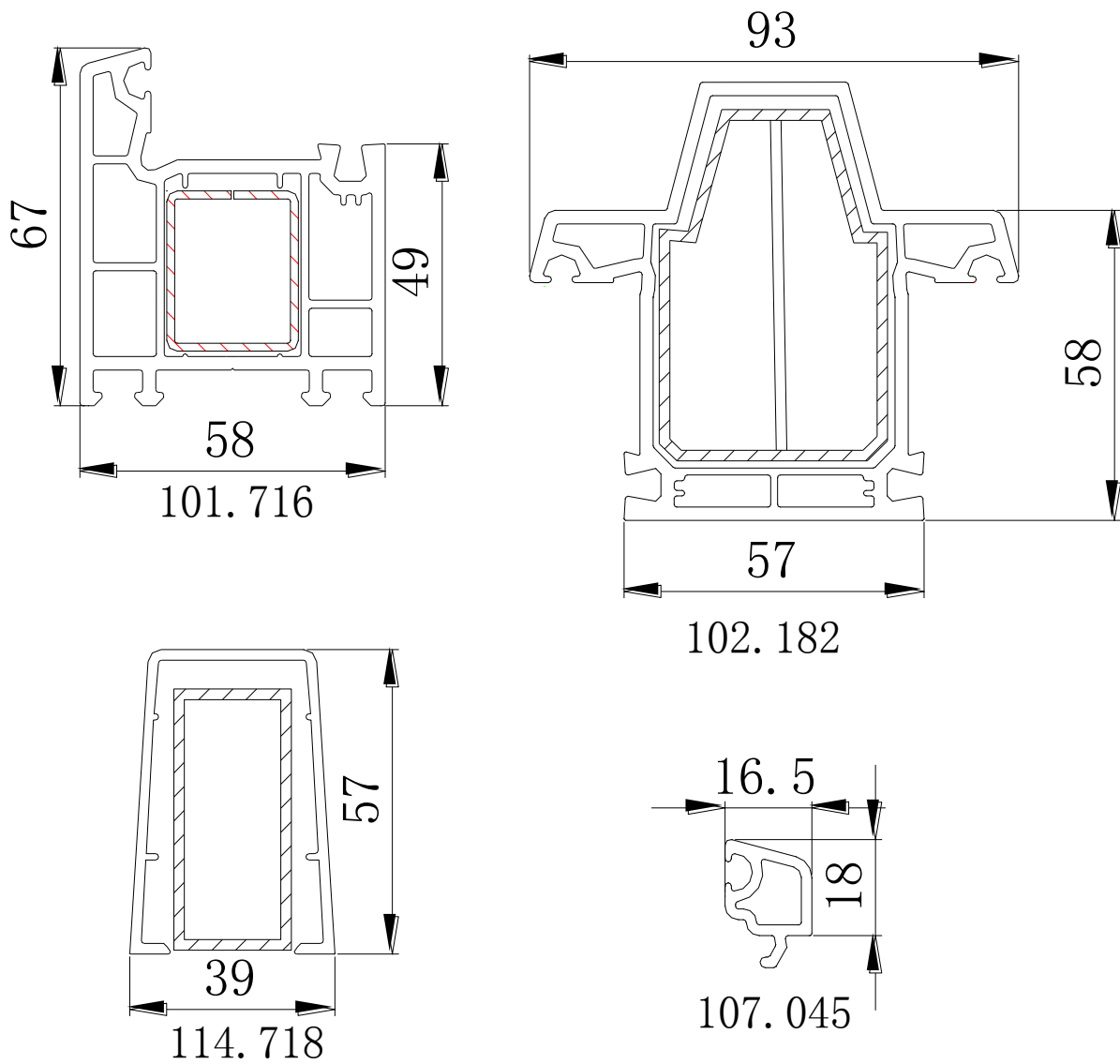


Fig.3 Detail Drawings of Representative Sample

8 Appendix B: Test Data

1. Deflection Test – Test method AS4420.2-1996

- Span length, L(1#~3# on mullion) =1970 mm, L(4#~6# on sash glass) =1950 mm
- Maximum allowable deflection (Mullion) = Span / 250 = 7.9 mm (1#~3# on mullion), Maximum allowable deflection (Sash Glass) = Span / 250 = 7.8 mm (4#~6# on sash glass)
- Test Pressure (Serviceability design wind pressure), P = 2000 Pa.

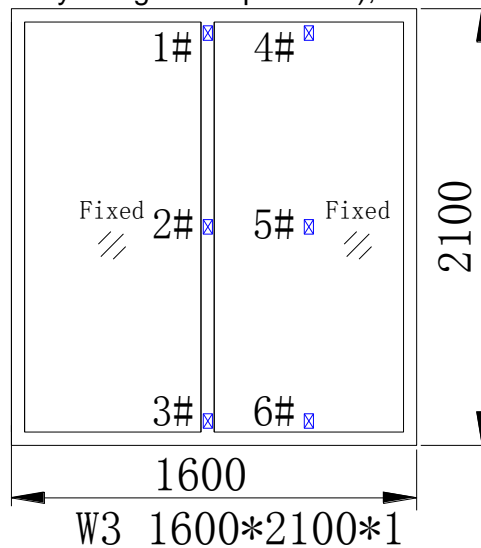


Fig.4 Locations of Displacement Measuring Devices

Table 3 Test Data of Deflection Test

Member (mm)		Test Pressure (Pa)	Deflection (mm)			Deflection/ Span Ratio	Maximum allowable Deflection /Span Ratio	Verdict
Item	Span Length		1	2	3			
Mullion	1970	+P/4 = 500	0.3	1.6	0.3	6.2	7.9	Pass
		+2P/4 = 1000	0.7	3.5	0.7			
		+3P/4 =1500	1.2	5.6	1.2			
		+P = 2000	1.7	7.9	1.7			
		0	0.0	0.1	0.0			
Mullion	1970	-P/4 = 750	-0.4	-2.1	-0.5	6.6	7.9	Pass
		-2P/4 = 1500	-0.9	-4.1	-0.9			
		-3P/4 =2250	-1.4	-6.4	-1.5			
		-P = 3000	-2.0	-8.6	-2.0			
		0	-0.3	-0.8	-0.2			

Table 4 Test Data of Deflection Test

Member (mm)		Test Pressure (Pa)	Deflection (mm)			Deflection/ Span Ratio	Maximum allowable Deflection /Span Ratio	Verdict
Item	Span Length		4	5	6			
Sash Glass	1950	+P/4 = 750	0.3	1.8	0.3	6.6	7.8	Pass
		+2P/4 = 1500	0.7	3.8	0.6			
		+3P/4 = 2250	1.1	5.9	0.9			
		+P = 3000	1.6	8.0	1.3			
		0	0.0	0.1	0.0			
Sash Glass	1950	-P/4 = 750	0.4	2.2	0.4	7.1	7.8	Pass
		-2P/4 = 1500	0.8	4.3	0.7			
		-3P/4 = 2250	1.3	6.4	1.1			
		-P = 3000	1.8	8.7	1.5			
		0	0.2	0.6	0.2			

2. Air infiltration test – Test method AS4420.4-1996

- Overall area: 3.36 m²

Table 5 Test Data of Air Infiltration Test

Test pressure of 75 Pa	Infiltration rate (positive direction)	0.01 L/s·m ²
	Exfiltration rate (negative direction)	0.01 L/s·m ²
	Average air leakage rate	0.01 L/s·m ²
	Maximum allowable air infiltration	1.0 L/s·m ²

3. Water resistance test – Test method AS4420.5-1996

There was no water penetration after water sprayed for 15 minutes at 800 Pa. The pressure of 800 Pa for water penetration was requested by the applicant.

Test result:

P_{max} = 800 Pa

4. Ultimate strength test – Test method AS4420.6-1996

Required ultimate strength test pressure: 4000 Pa
Rating: N6 (General) or C2 (Corner Windows)

Test result:

The window was not collapsed when subjected to ultimate strength of 4000 Pa (N6 (General) or C2 (Corner Windows)).

No significant breakage, permanent deformation or operational malfunction after ultimate strength was released.

Revision Page

Revision No.	Date	Changes	Author	Reviewer
0	April 24, 2015	First issue	Alvin Zhu	Fred Bao

END OF DOCUMENT
