Test Report

AZUMA

WIND AND WATER TEST TO THE REQUIREMENTS OF AS2047

CLIENT – CIVRO Building Technology (Guangdong) Co., Ltd

PRODUCT – XD63LS Lift Sliding Door

TESTED AT – AZUMA JIANGMEN BRANCH LABORATORY

REPORTED BY – AZUMA TESTING LIMITED

REPORT NO. – AZHK251209

Issue Date: 29th December 2025

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東方檢測有限公司
Azuma Testing Limited
香港新界沙田火炭山尾街 43-47 號環球工業中心地下 6 號
Workshop No. 6, G/F, World-wide Industrial Centre,
43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
W: www.azumatesting.com P: +852 2494 7370

澳思万 (江门市) 测试有限公司
Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

1 Customer Requirements

Customer requires all applicable tests to the performance requirements of AS2047, using the test procedures from AS/NZS 4420.1.

2 Reference Standard

- AS2047 – 2014 Windows and External Glazed Doors in Buildings
- AS/NZS 4420.1 – 2016 Windows external glazed timber and composite doors - Methods of test - Test sequence, sampling and test methods

3 General Information

Test Lab/ Site No.	Azuma (Jiangmen) Testing Limited/ 26054
Address	Room 101, Building 4, 80 Longxi Road, Jianghai District, Jiangmen City, China
Date(s) of Test	25th November 2025
Test Job Number	AZJM251127
Report Issuing Lab	Azuma Testing Limited
Test Report Number	AZHK251209

3.1 Customer & Sample Information

Customer	CIVRO Building Technology(Guangdong) Co.,Ltd）
Customer's Address	No. 3, Guandi Area, Fanhu, Leping, Sanshui Central Technology Park, Sanshui District, Foshan City.
Window/Door Type	Aluminium Sliding Door
Model	XD63LS
Test Sample Description	Aluminium Sliding Door
Number of Sample Testing	1
Manufacturer (s)	CIVRO Building Technology(Guangdong) Co.,Ltd
Manufacturer's Address	No. 3, Guandi Area, Fanhu, Leping, Sanshui Central Technology Park, Sanshui District, Foshan City.

The above information is provided by the client. Azuma does not take liability to the accuracy of this information

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Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

4 Test Result Summary

Test Method per AS/NZS 4420.1	Figures Recorded	Result for compliance with AS2047
Deflection Test	Positive – 2100 Pa	Pass
	Negative – 2100 Pa	Pass
Operating Force Test	180N / 110N	Pass
Air Infiltration Test	Low	Pass
Water Penetration Resistance Test	700 Pa	Pass
Ultimate Strength Test	Positive – 2100 Pa	Pass
	Negative – 2100 Pa	Pass

* N/A: Not Applicable
** N/T : Not Tested

5 Test Sample Description

Product Name	XD63LS Lift Sliding Door
Model	XD63LS
Dimension of Frame	2700 mm (Height) x 4000mm (Width) x 140 mm (Thickness)
Dimension of Sashes	Operable Sash 1: 2614 mm (Height) x 1987mm (Width) Operable Sash 2: 2614 mm (Height) x 1987mm (Width)
Glazing – Size/Type	Operable Sash 1: 2512 mm (Height) x 1908 mm (Width) Glass Thickness: (8mm /12A/8mm) Glass Type: Toughened Insulating Glass Unit (IGU) Supplier: SUNGLAS TECHNICS CO., LTD. Operable Sash 2: 2512 mm (Height) x 1908 mm (Width)) Glass Thickness: (8mm /12A/8mm) Glass Type: Toughened Insulating Glass Unit (IGU) Supplier: SUNGLAS TECHNICS CO., LTD.
Hardware	Name: Transmission box Model No.: C721034-2600 Quantity: 2 pcs Supplier: Sobinco Name: Front pulley Model No.: C733036 Quantity: 2 pcs Supplier: Sobinco

	Name: Rear Pulley Model No.: C733037 Quantity: 2 pcs Supplier: Sobinco Name: Lock Bracket Model No.: C742082 Quantity: 2 pcs Supplier: Sobinco Name: Handle Model No.: C710127 Quantity: 2 Supplier: Sobinco Name: Clasping Handle Model No.: C710025 Quantity: 2 Supplier: Sobinco
Drawing Identification	XD63LS, M1, HD-03, J02, C01, C01, C02, C03, D01, D02, D03, D04, D05, D06, D07, C01, H02, H13, I01, I04, DY-2
Profile Section	Model: 6060T6 Manufacturer: FOSHAN YINGHUI ALUMINUM PROFILES CO., LTD. See Drawings for Details
Frame Corner Construction Details	See Drawings for Details
Drain holes	Size (Width x Height): 20mm x 8mm Quantity: 5 ea See Drawings for Details
Weep holes	Size (Width x Height): 30mm x 8 mm Spacing: 500 mm Quantity: 6 ea See Drawings for Details
Gasket/Seals/Hairs	Model No.: C3311006 5x8 wool Material: siliconized pile weatherstrip with fabric backing Supplier: CIVRO Model No.: C358010 external glazing gasket Material: Foam + EPDM Supplier: CIVRO

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	Model No.: C358011 gasket Material: EPDM Supplier: CIVRO
Weather Strip	Model No.: C358012 gasket Material: EPDM Supplier: CIVRO Model No.: C358013 gasket Material: EPDM Supplier: CIVRO Model No.: C358014 gasket Material: EPDM Supplier: CIVRO Model No.: C358016 gasket Material: EPDM Supplier: CIVRO Model No.: C358017 gasket Material: EPDM Supplier: CIVRO Model No.: C358039 hook-type glazing gasket Material: Foam + EPDM Supplier: CIVRO Model No.: C331025 Material: siliconized pile weatherstrip with non-woven backing Supplier: CIVRO
Glass Retention	Model No.: C358010 external glazing gasket Material: Foam + EPDM Supplier: CIVRO Model No.: C358012 gasket Material: EPDM Supplier: CIVRO Model No.: C358013 gasket Material: EPDM Supplier: CIVRO Model No.: C358014 gasket Material: EPDM Supplier: CIVRO

	Model No.: C358016 gasket Material: EPDM Supplier: CIVRO Model No.: C358017 gasket Material: EPDM Supplier: CIVRO
Thermal Break	Yes Model No.: C422201 Model No.: C423201 Model No.: C422501 Supplier: Technoform
Sub Head and Sub Sill Used	None
Reinforcement	None
Installation	The exterior perimeter of the test specimen was sealed with silicon sealant
Support Fixings	The test specimen and frame were fixed securely onto the test rig using screws.

6 Procedures

6.1 Deflection Test

1. The test sample shall be operative and pre-loaded as described in AS 4420.1.

2. The pre-load pressure shall be removed and the zero position of the displacement measuring devices recorded.

3. Differential pressures in the same direction shall then be applied across the test sample in not less than four approximately equal increments until the test pressure is reached. The pressure shall be held for at least 1 min at each pressure increment, and the readings of the displacement measuring devices recorded before the pressure is increased.

4. The differential pressure shall be removed and after 2 min the zero displacement readings shall be taken.

5. The direction of the air pump or test sample shall be reversed and Steps (1) to (4) shall be repeated using the opposite test loading.

6.2 Operating Force Test

1. With the window closed, but unlocked, an operating force shall be applied, without shock, in the plane and direction of the sash operation.

2. For both directions of sash travel, the following forces shall be noted and recorded:

(a) That capable of setting the sash in motion.

(b) That capable of maintaining the motion after the sash frame is clear of the perimeter frame of the test sample.

3. Each sliding sash of the test sample is tested separately.

4. For horizontally sliding sashes, the force shall be applied either at the position of a fixed handle, or at one-third of the height of the pull stile above the sill for continuous or adjustable handgrips.

5. For vertically sliding sashes, the force shall be applied at the sash pulls or at the midpoint of the bottom rail, or at the position nominated by the manufacturer.

6.3 Air Infiltration Test

1. Operation and pre-loading as described in AS 4420.1.

2. The face of the test sample shall then be sealed airtight by covering it with an impervious film. If this is not practicable, all joints, weep holes, and glazing or sealant lines of the test sample shall be sealed with impervious adhesive tape.

3. Positive and negative test pressures shall then be applied, and the base air infiltration rates through the test apparatus shall be determined by air flow meter.

4. The sealing film or tape shall be removed from the test sample and the air infiltration rates determined. The air infiltration through the test sample shall be the difference between the base and total readings.

6.4 Water Penetration Resistance Test

1. The test sample shall be subjected to water sprayed uniformly and continuously over the exterior face of the test sample at a rate not less than 0.05 L/m^{2}s. At the start of the test, the water sprays shall operate for 5 min with zero air pressure differential on the test sample.

2. The test pressure shall be applied and maintained for 15 min with the water sprays still operating. The visible internal surfaces of the test sample shall be inspected throughout the water spray operation.

3. Any water appearing on the inside surfaces of the test sample shall be noted and recorded, with the extent and, if possible, the source of penetration of uncontrolled water. Uncontrolled water shall be as defined in AS 2047.

4. The pressure and water sprays shall then be removed from the test sample.

6.5 Ultimate Strength Test

1. The test sample shall be subjected to a smoothly increasing differential pressure up to the test pressure determined in Clause 6.1, conducted individually in both positive and negative directions.

2. The time taken to reach the structural test pressure shall be approximately 1 min. Test pressure shall be maintained on the test sample for a period of 10 s.

3. If a sponsor requires incremental tests, each increment shall represent a separate test requiring 10 s duration.

4. At the conclusion of the test at each loading, the test sample shall be inspected and any signs of deformity or damage or collapse of the test sample noted and recorded.

7 Results

7.1 Test for Operation

☑ The test specimen has been opened and closed for 5 times and operates well.

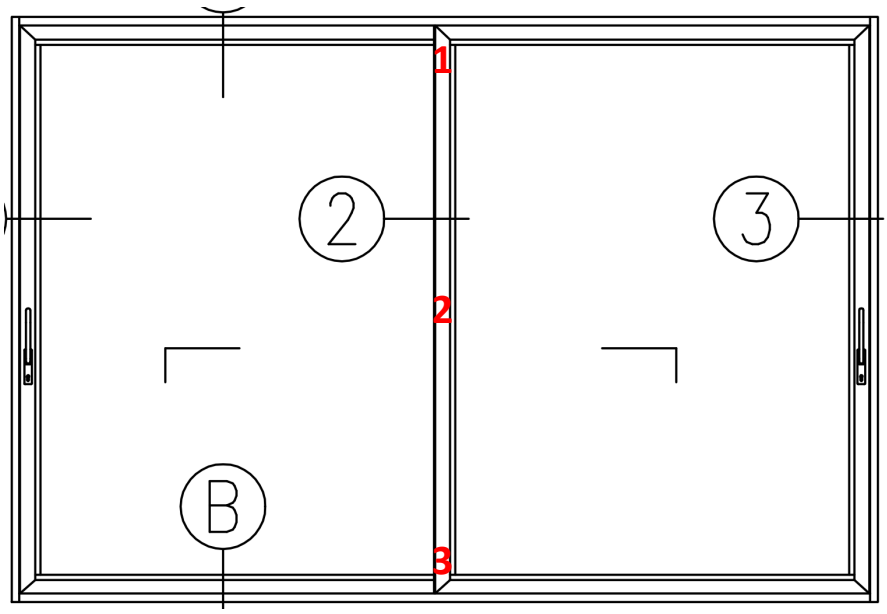

Figure 1 Transducer Locations

7.2 Deflection Test

Setup 1				
Structural Member	Interlock 1, 2, 3			
Span Length	2520 mm			
Transducers Used	1, 2, 3			
Maximum Allowable Deflection	10.08 mm			
Test Defection Ratio of Sample	**1 (mm)**	**2 (mm)**	**3 (mm)**	**Net Deflection (mm)**
Positive 350 Pa	2.91	4.05	1.33	1.93
Negative 350 Pa	-2.64	-3.42	-1.30	1.45
Positive 700 Pa	5.20	8.05	4.08	3.41
Negative 700 Pa	-4.90	-7.43	-3.87	3.05
Positive 1050 Pa	7.51	12.07	6.89	4.87
Negative 1050 Pa	-6.45	-10.54	-5.69	4.47

Positive 1400 Pa	10.19	16.41	9.62	6.51
Negative 1400 Pa	-8.09	-13.57	-7.17	5.94
Positive 1750 Pa	13.05	20.84	12.46	8.09
Negative 1750 Pa	-10.10	-16.85	-8.86	7.37
Positive 2100 Pa	15.92	25.11	15.34	9.48
Negative 2100 Pa	-12.22	-20.21	-10.73	8.74
Span Ratio	Positive – 266			
	Negative – 288			
Result	Positive – Pass			
	Negative – Pass			

7.3 Operating Force Test

Movement Type	Door	Opening Force (N)	Closing Force (N)	Allowable (N)	Result
Initiating	1*	99.9	98.7	≤ 180	Pass
Maintain	1*	88.9	87.8	≤ 110	Pass
Initiating	2**	78.6	84.4	≤ 180	Pass
Maintain	2**	85.3	92.4	≤ 110	Pass

*Door 1 = Left Panel (View from interior)
**Door 2 = Right Panel (View from interior

7.4 Air Infiltration Test

Barometric Pressure	102860 Pa
Air Temperature	23.9 °C
Overall Area	10.8 m^2

Pressure	Sealed	Unsealed	Net Leakage
Positive - 75 Pa	28.01 Ls^{-1}	29.52 Ls^{-1}	1.51 Ls^{-1}
Negative - 75 Pa	26.60 Ls^{-1}	31.19 Ls^{-1}	4.59 Ls^{-1}

Air Infiltration Level	Direction	Allowable	Actual	Result
Low	Positive Negative	≤ 1 $Ls^{-1}m^{-2}$	0.14 $Ls^{-1}m^{-2}$ 0.43 $Ls^{-1}m^{-2}$	Pass
High	Positive Only	≤ 5 $Ls^{-1}m^{-2}$	0.14 $Ls^{-1}m^{-2}$	Pass

7.5 Water Penetration Resistance Test

Wet Down Complete – 5 minutes	Yes
Maximum Pressure Applied to Sample	700 Pa
Time Pressure Held for	15 minutes
Leakages Observed	Nil
Observations	No Observable Water Leakages Transparent Sealant applied on site on exterior and interior surfaces of Window Assembly (See Figures 10, 11, 12 & 17)

7.6 Ultimate Strength Test

Maximum Pressure Applied to Sample	Positive – 2100 Pa Negative – 2100 Pa
Time Pressure Held for	60 seconds
Compliant with AS2047 Clause 2.3.1.7	Yes
Observations	No Observable Damage

7.7 Photos

Figure 2 Photo of the test specimen Before testing (Fully Closed)

Figure 3 Photo of the test specimen After testing (Fully Closed)

東方檢測有限公司
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43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
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Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

Figure 4 Photo of the test specimen After testing (Fully Opened)

Figure 5 Photo of the Hardware (Handle)

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Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

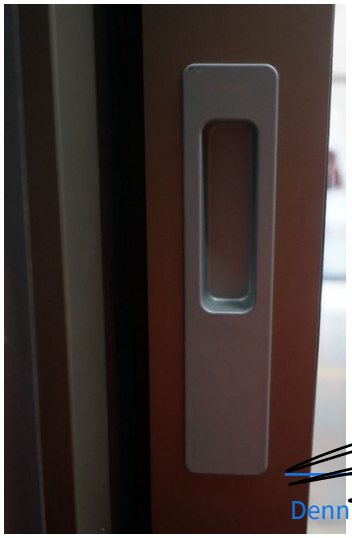

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Figure 6 Photo of the Hardware (Recessed Pull)

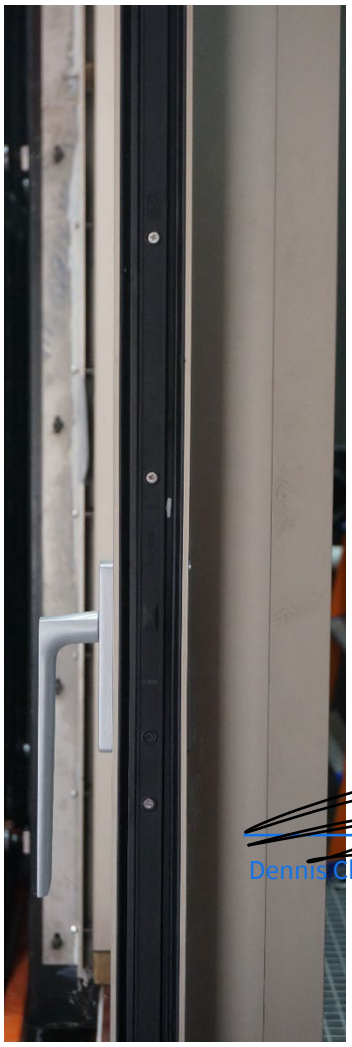

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Figure 7 Photo of Interlock Stile & Handle

東方檢測有限公司
Azuma Testing Limited
香港新界沙田火炭山尾街 43-47 號環球工業中心地下 6 號
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Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

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Figure 8 Connection Detail Between Left Side Jamb, Bottom Sill, Lock Stile and Bottom Rail

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Figure 9 Connection Detail Between Bottom Sill, Interlock Stile, Door Track, Bottom Rail and Left Panel

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Figure 10 Connection Detail Between Bottom Sill, Interlock Stile, Door Track. Bottom Rail and Right Panel (Showing White Traces Left by Transparent Waterproof Coating on Surface)

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Figure 11 Connection Detail Between Right Side Jamb, Bottom Sill, Bottom Rail and Right Lock Stile (Showing White Traces Left by Transparent Waterproof Coating on Surface)

東方檢測有限公司
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Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

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Figure 12 Connection Detail Between Right Side Jamb, Head, Top Rail, and Right Lock Stile (Showing White Traces Left by Transparent Waterproof Coating on Surface)

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Figure 13 Connection Detail Between Head and Interlock Stile

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Figure 14 Door Bumper Stop Installed on Top Rail of Left Panel

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Figure 15 Connection Detail Between Bottom Sill, Lock Stile, Door Track. Bottom Rail and Jamb (View from Exterior)

東方檢測有限公司
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Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

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Figure 16 Connection Detail Between Top Rail, Lock Stile, Door Track, Bottom Rail and Left-Side Jamb (View from Exterior)

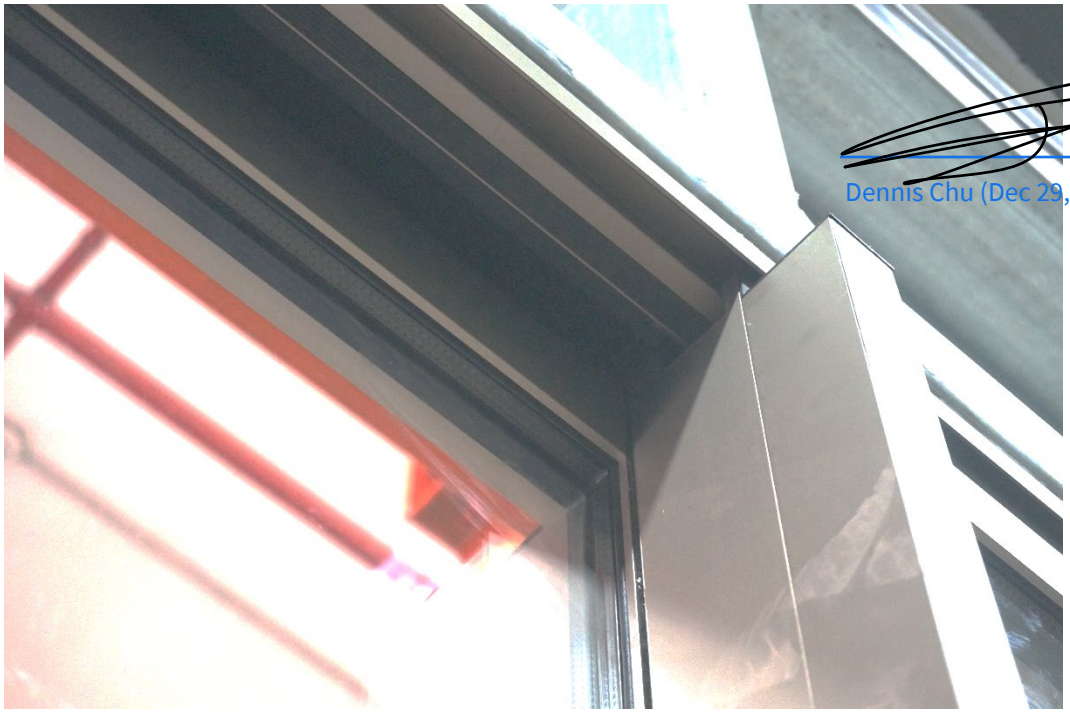

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Figure 17 Connection Detail Between Top Rail, Interlock Stile and Head (Showing White Traces Left by Transparent Waterproof Coating on Surface)

東方檢測有限公司
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香港新界沙田火炭山尾街 43-47 號環球工業中心地下 6 號
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Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

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Figure 18 Connection Detail Between Two Panels

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Figure 19 Connection Detail Between Top Rail, Lock Stile, Door Track, Bottom Rail and Right-Side Jamb (View from Exterior)

東方檢測有限公司
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Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

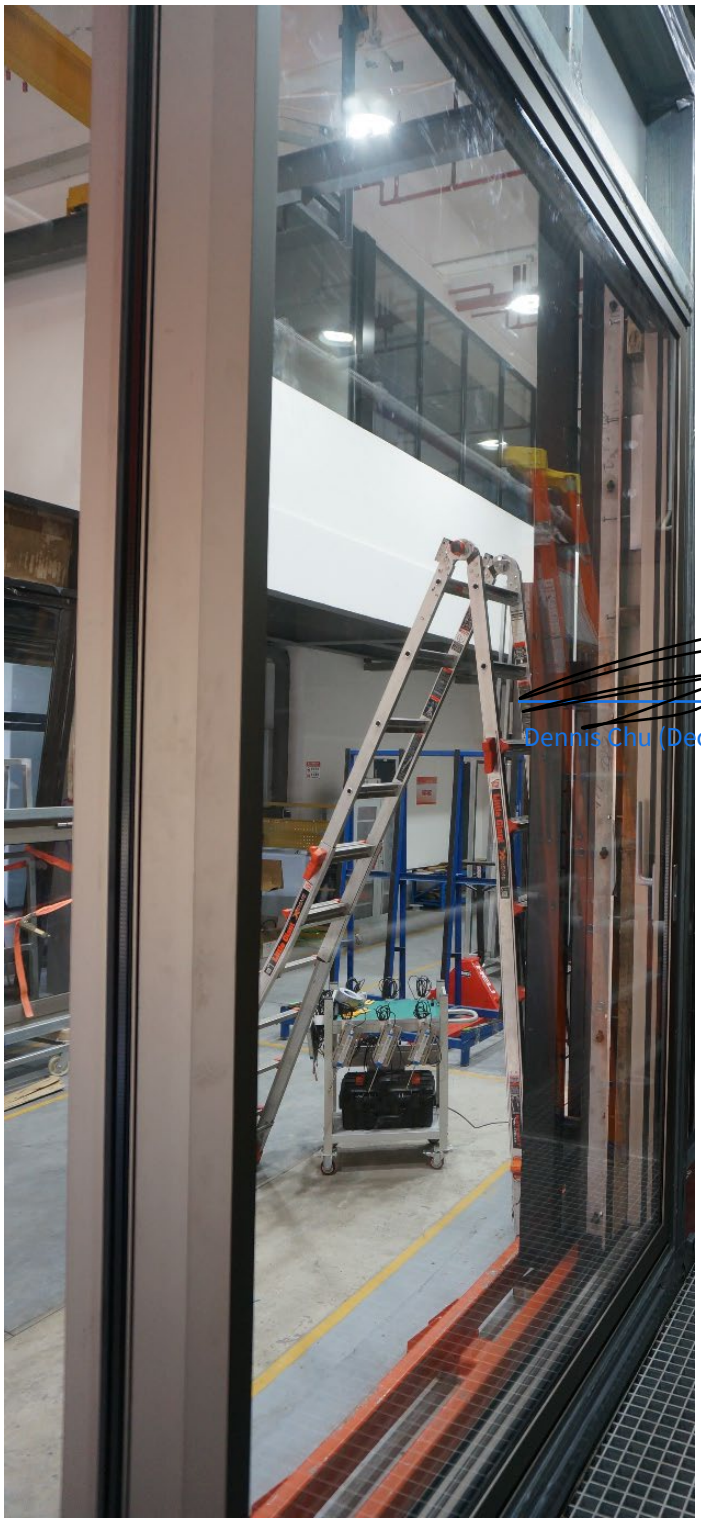

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Figure 20 Right Panel (View from Exterior)

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Figure 21 Upper Section of Left Panel (View from Exterior)

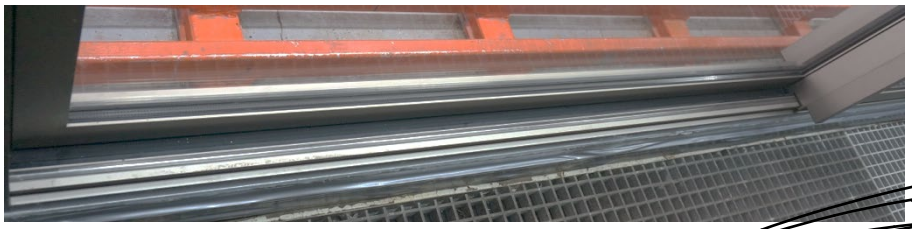

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Figure 22 Door Track of Left Panel (View from Exterior)

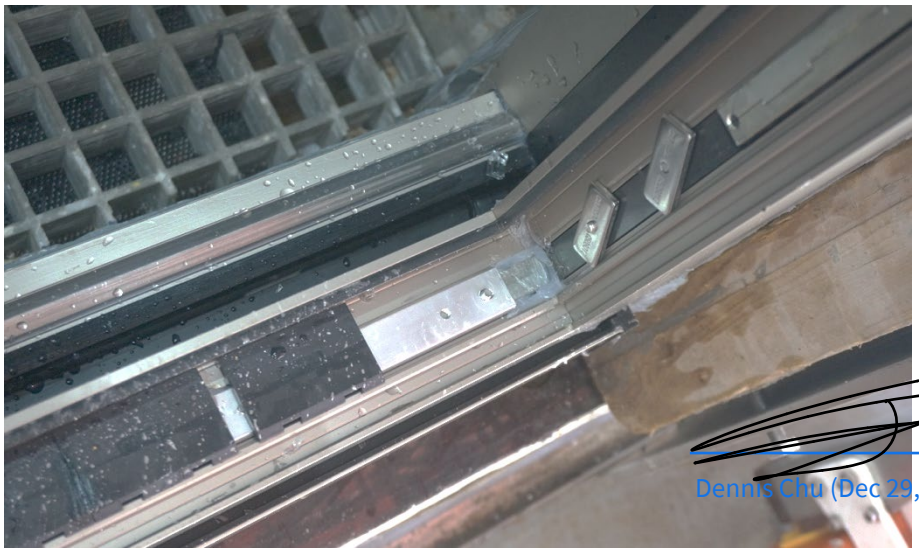

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Figure 23 Door Track of Right Panel (View from Exterior)

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Figure 24 Connection Detail Between Head, Right-Side Jamb and Door Track

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Figure 25 Connection Detail Between Head, Interlock Stile and Door Track (Right Panel)

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Figure 26 Connection Detail Between Head, Interlock Stile and Door Track (Left Panel)

Figure 27 Photo of Main Frame (*Drain Holes on Threshold)*

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Figure 28 Zoom-in of Main Frame (*Drain Holes on Threshold)*

東方檢測有限公司
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澳思万 (江门市) 测试有限公司
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江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

8 Signatories

Tested By:	**Dennis Chu**
Signature:	Dennis Chu (Dec 29, 2025 17:16:51 GMT+8)
Date:	12/29/2025
Checked By:	**George Cheung**
Signature:	Cheung George (Dec 29, 2025 16:44:16 GMT+8)
Date:	12/29/2025

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9 Appendix (Drawings supplied by customer)

Figure 29 XD63LS Scheme Drawing

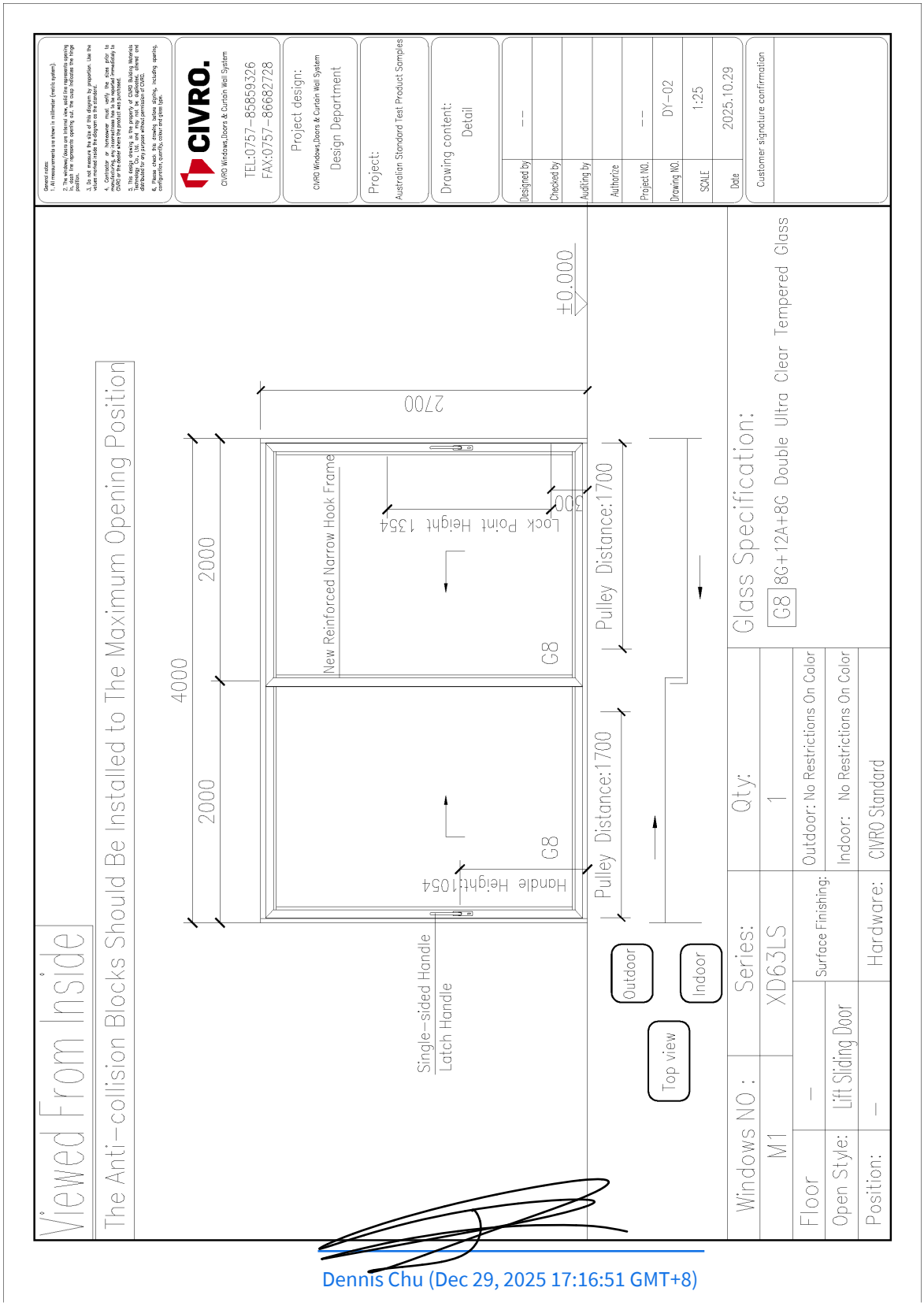

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Figure 30 Drawing of Front View

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Workshop No. 6, G/F, World-wide Industrial Centre,
43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
W: www.azumatesting.com P: +852 2494 7370

澳思万 (江门市) 测试有限公司
Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

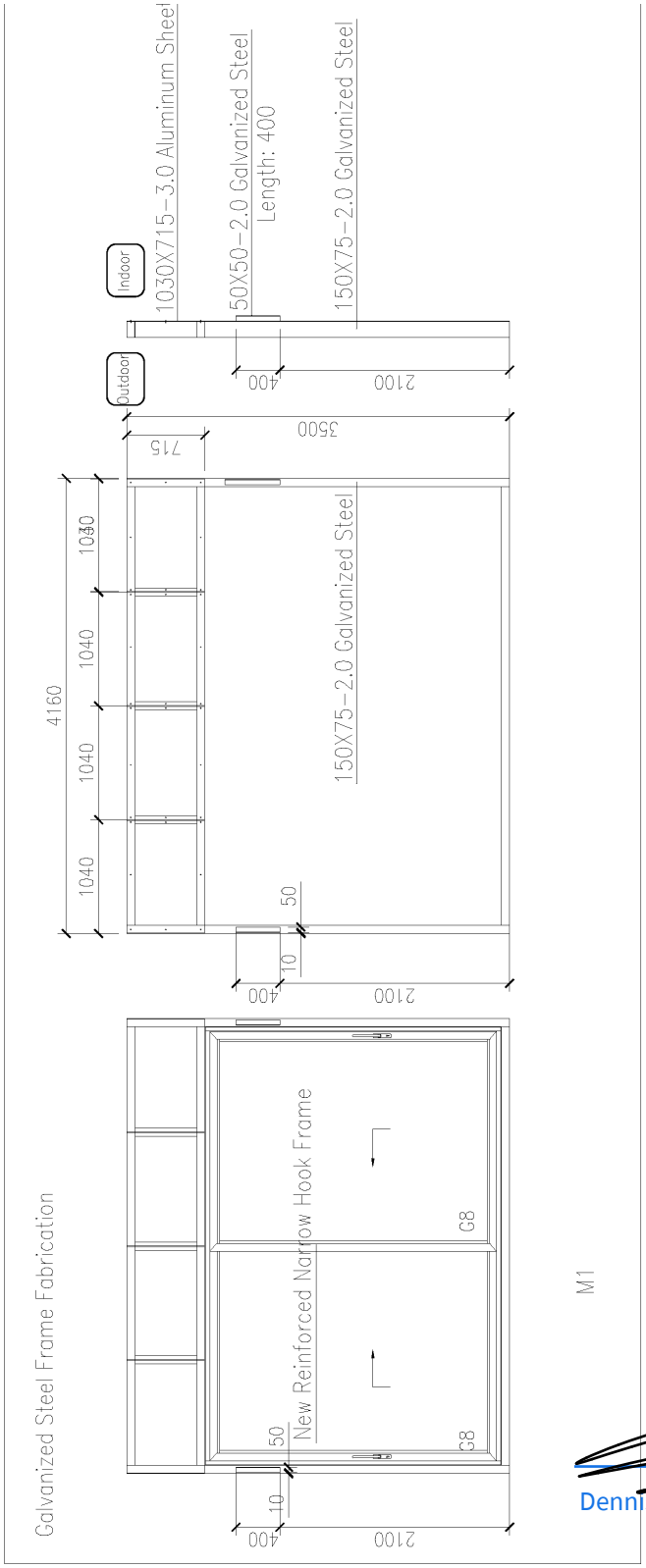

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Figure 31 Drawing of Galvanized Steel Test Frame Fabrication

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W: www.azumatesting.com P: +852 2494 7370

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Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
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Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

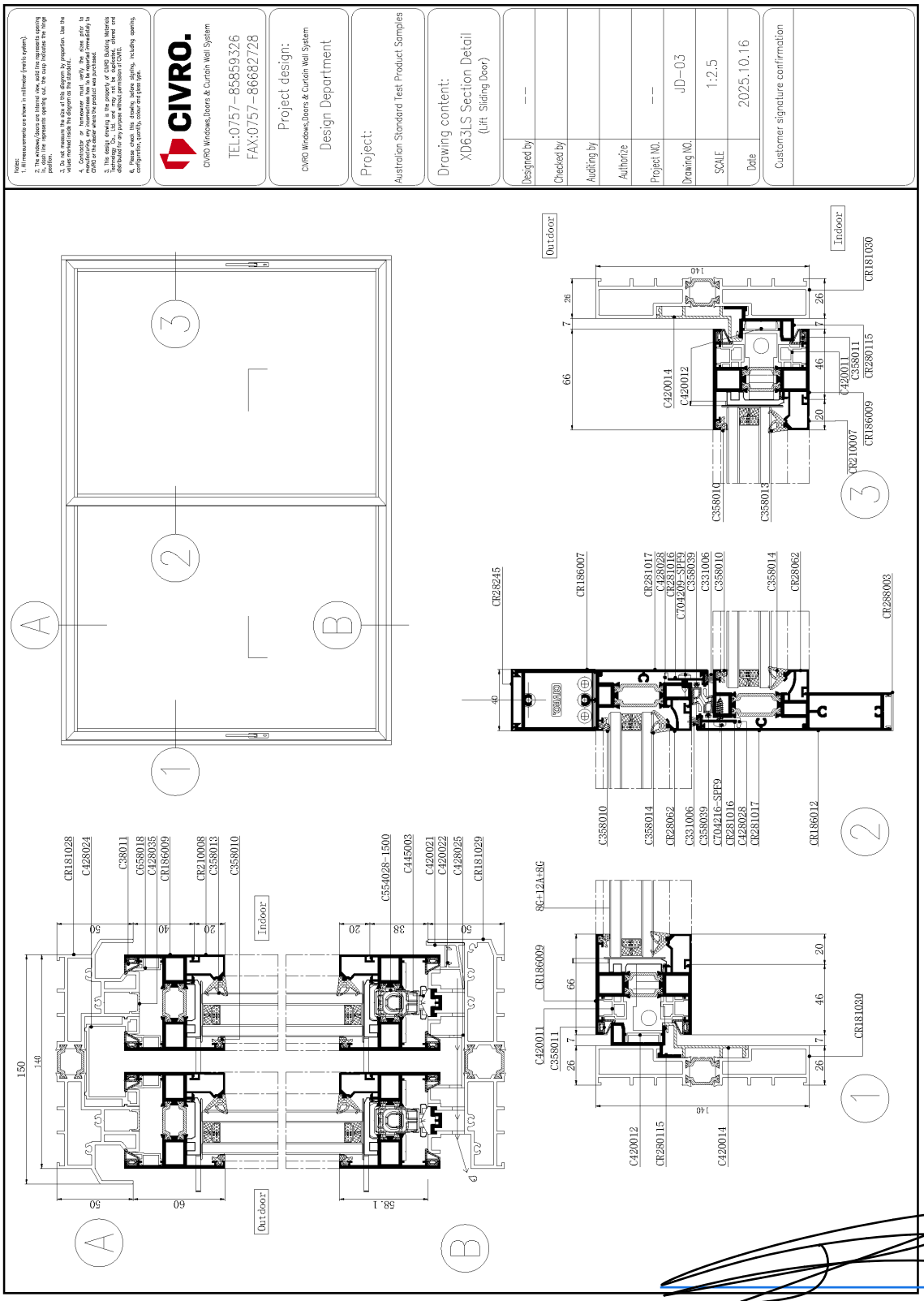

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Figure 32 Drawing of the Representative Sample (view from Interior)

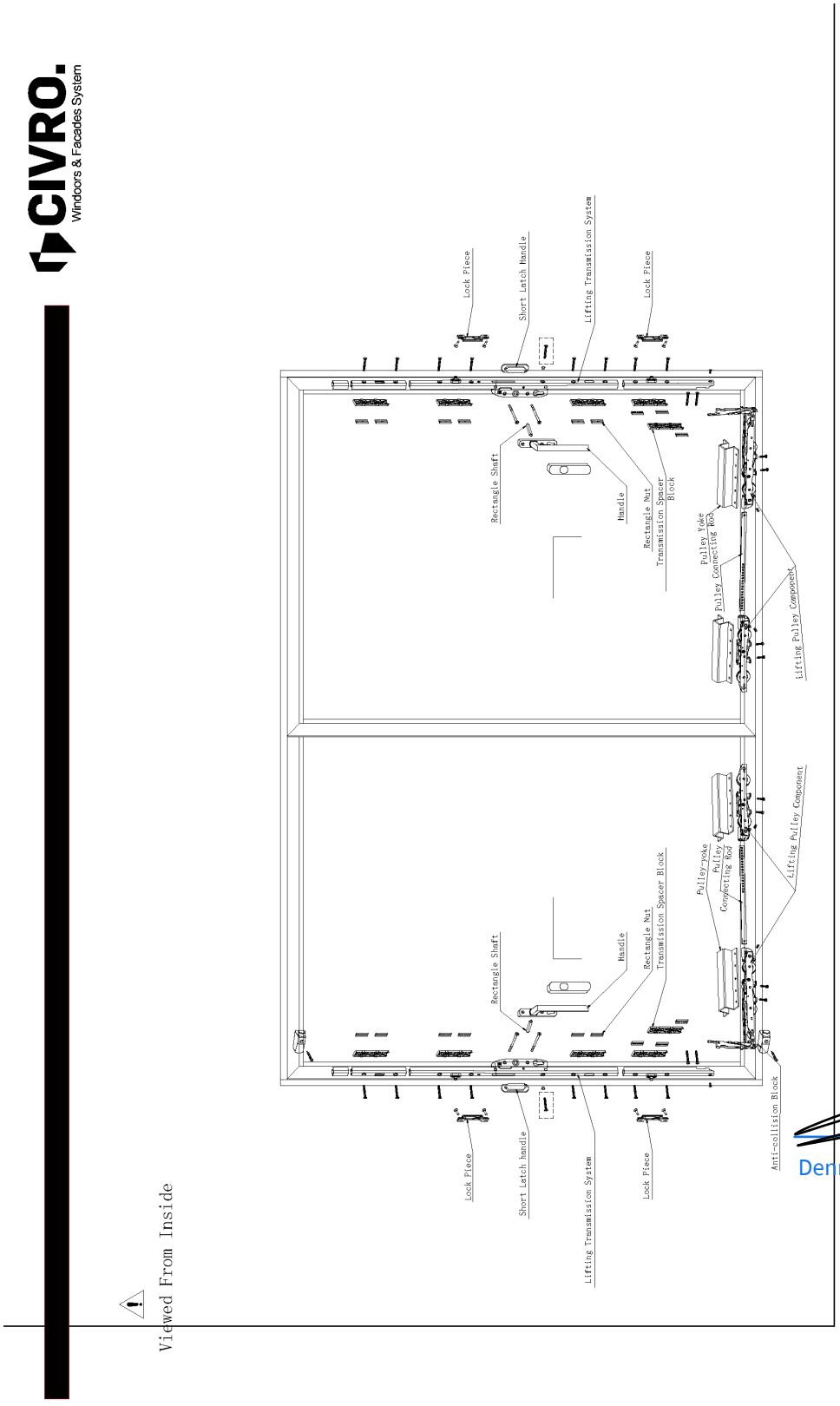

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Figure 33 Drawing of Hardware Fitting

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43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
W: www.azumatesting.com P: +852 2494 7370

澳思万 (江门市) 测试有限公司
Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
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Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

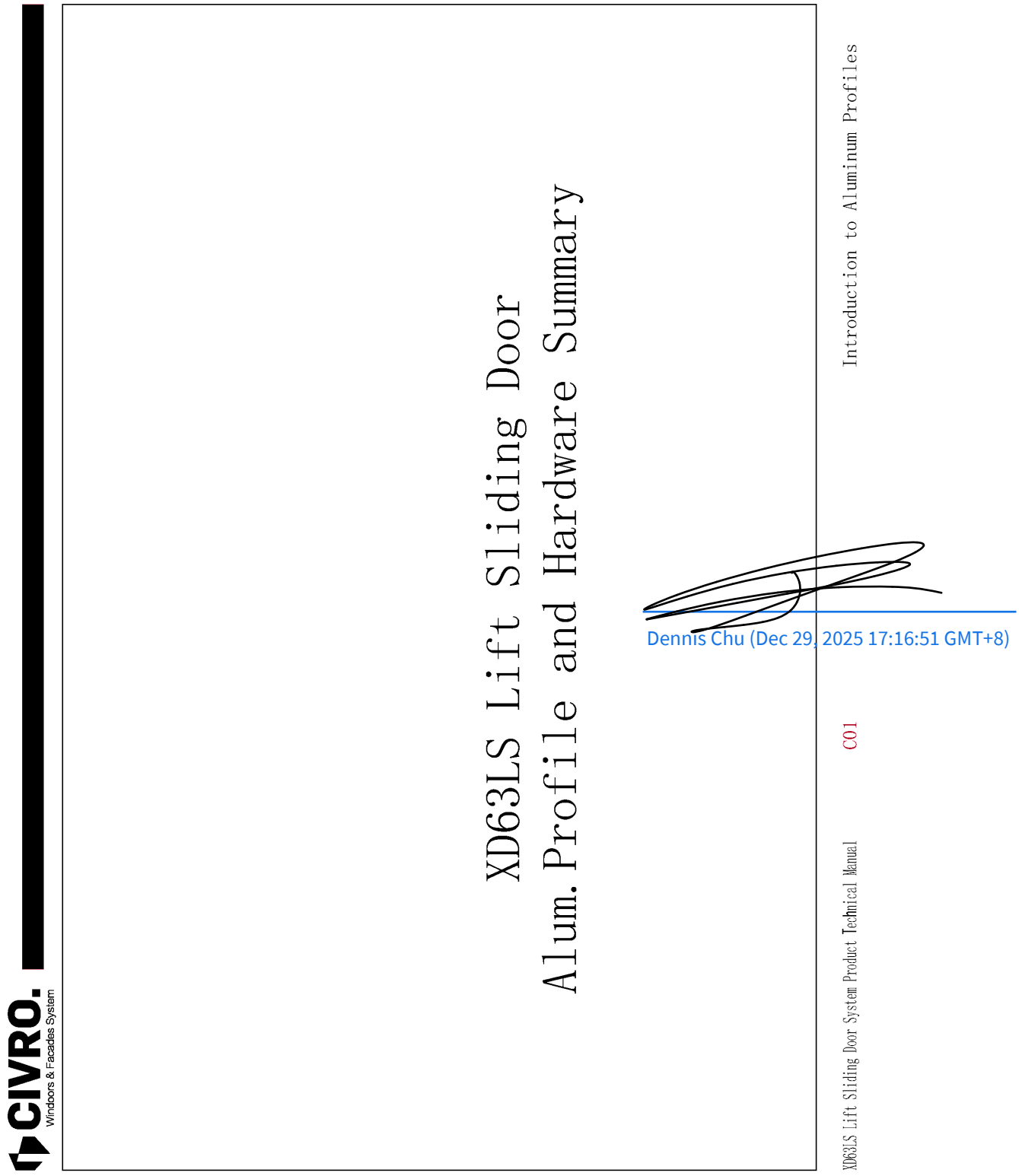

Figure 34 Drawing of XD63 Lift Sliding Door Alum. Profile and Hardware Summary

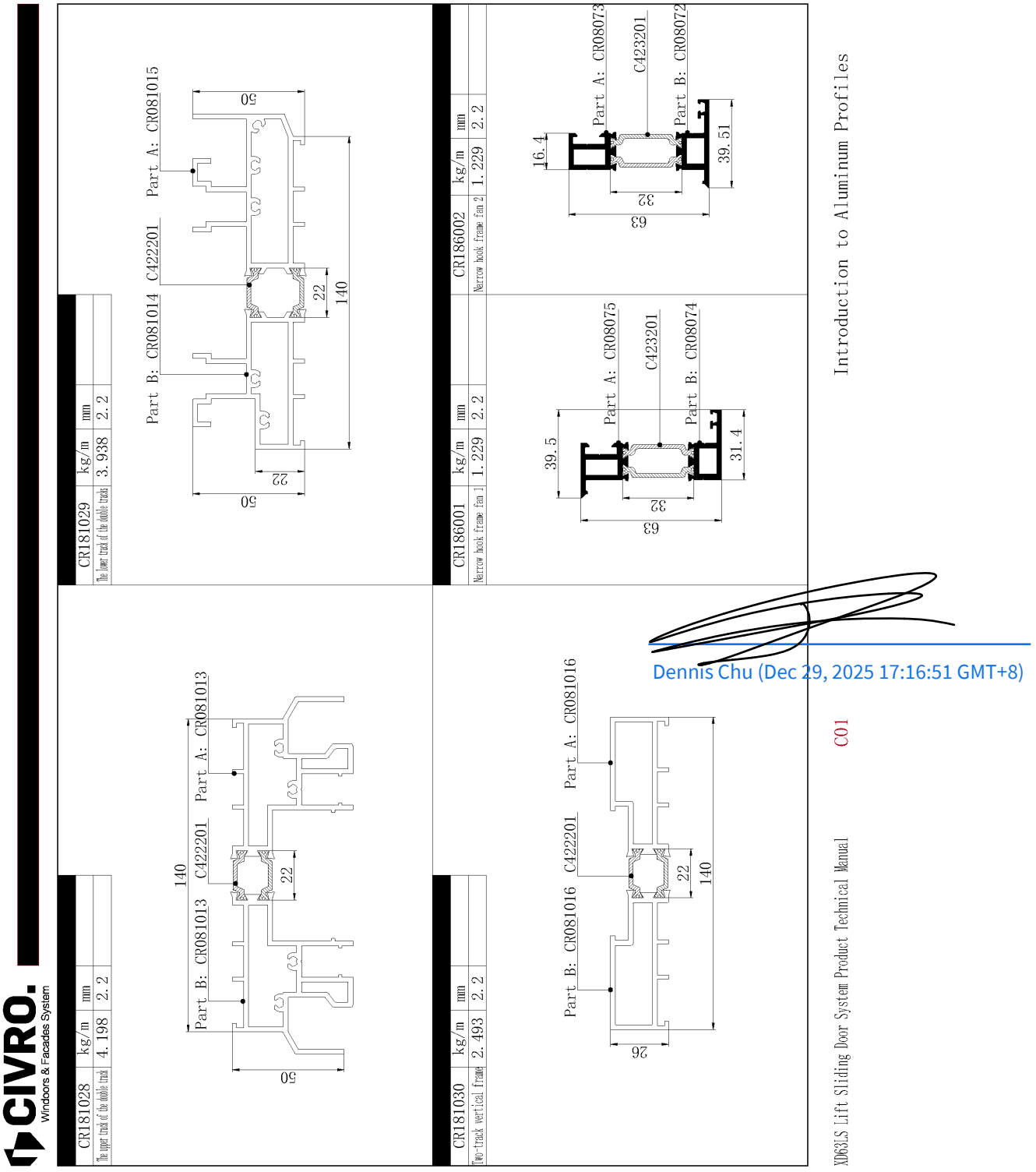

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Figure 35 Drawing of Profile Section Details 1

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W: www.azumatesting.com P: +852 2494 7370

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Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

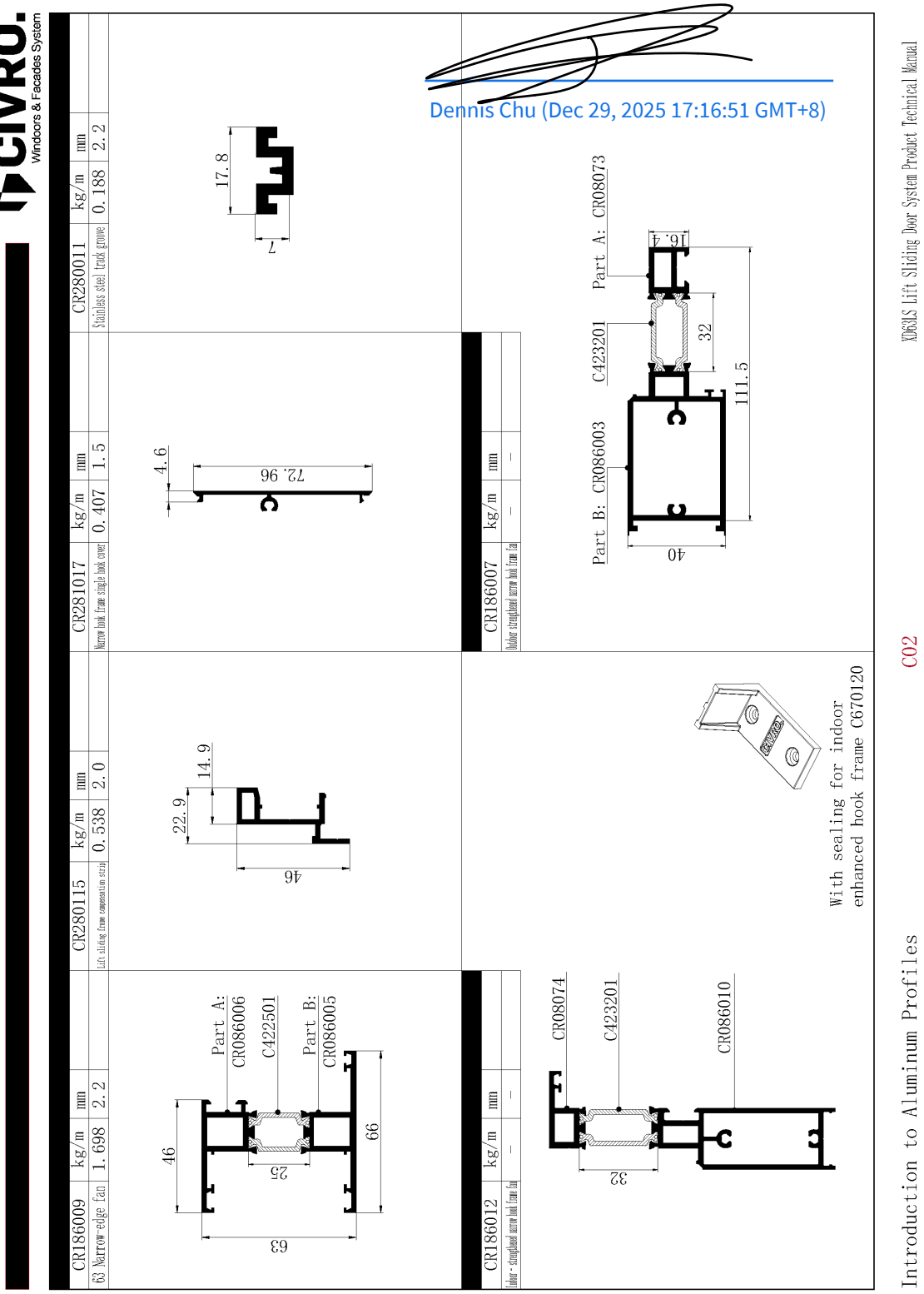

Figure 36 Drawing of Profile Section Details 2

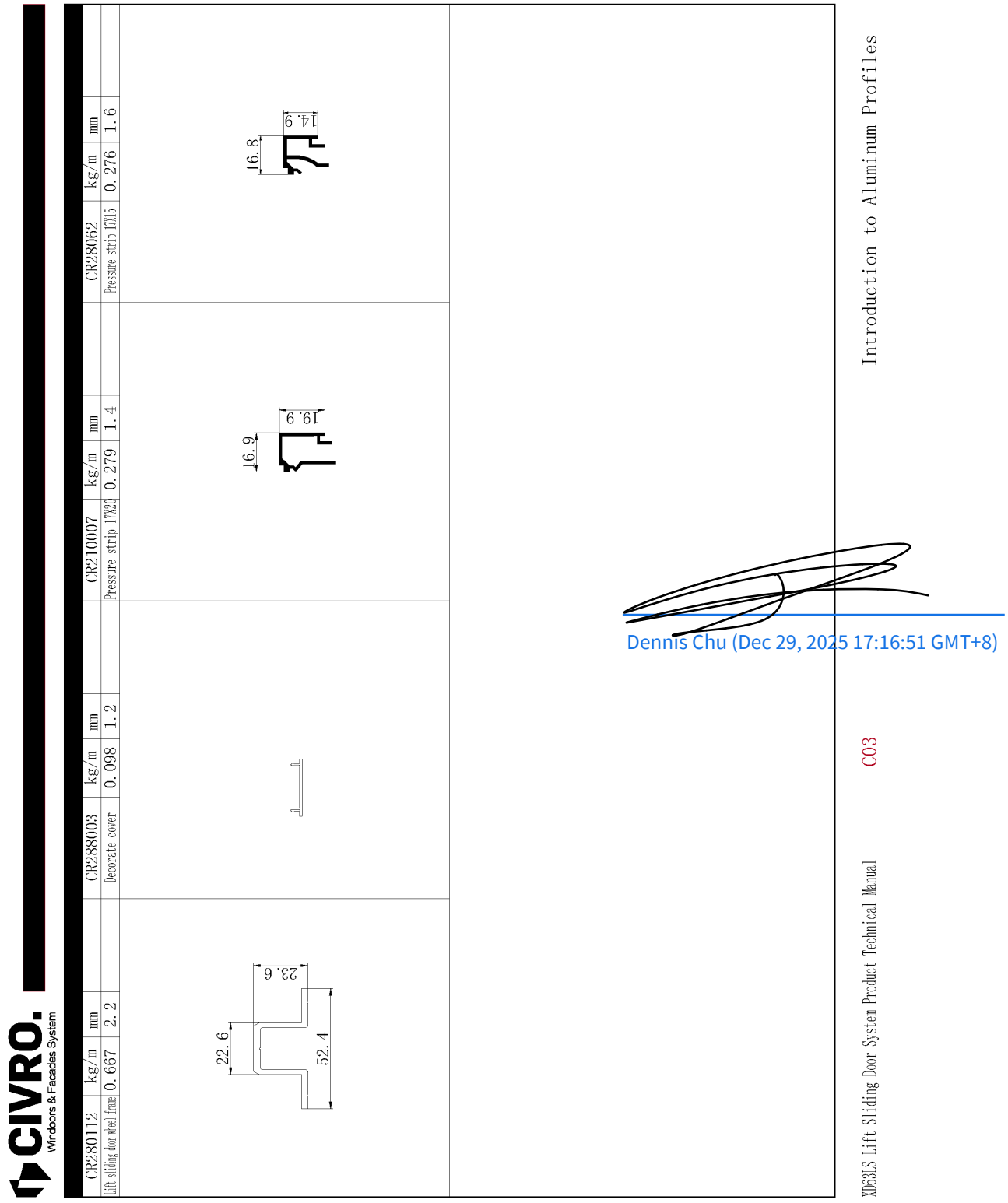

Figure 37 Drawing of Profile Section Details 3

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43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
W: www.azumatesting.com P: +852 2494 7370

澳思万 (江门市) 测试有限公司
Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

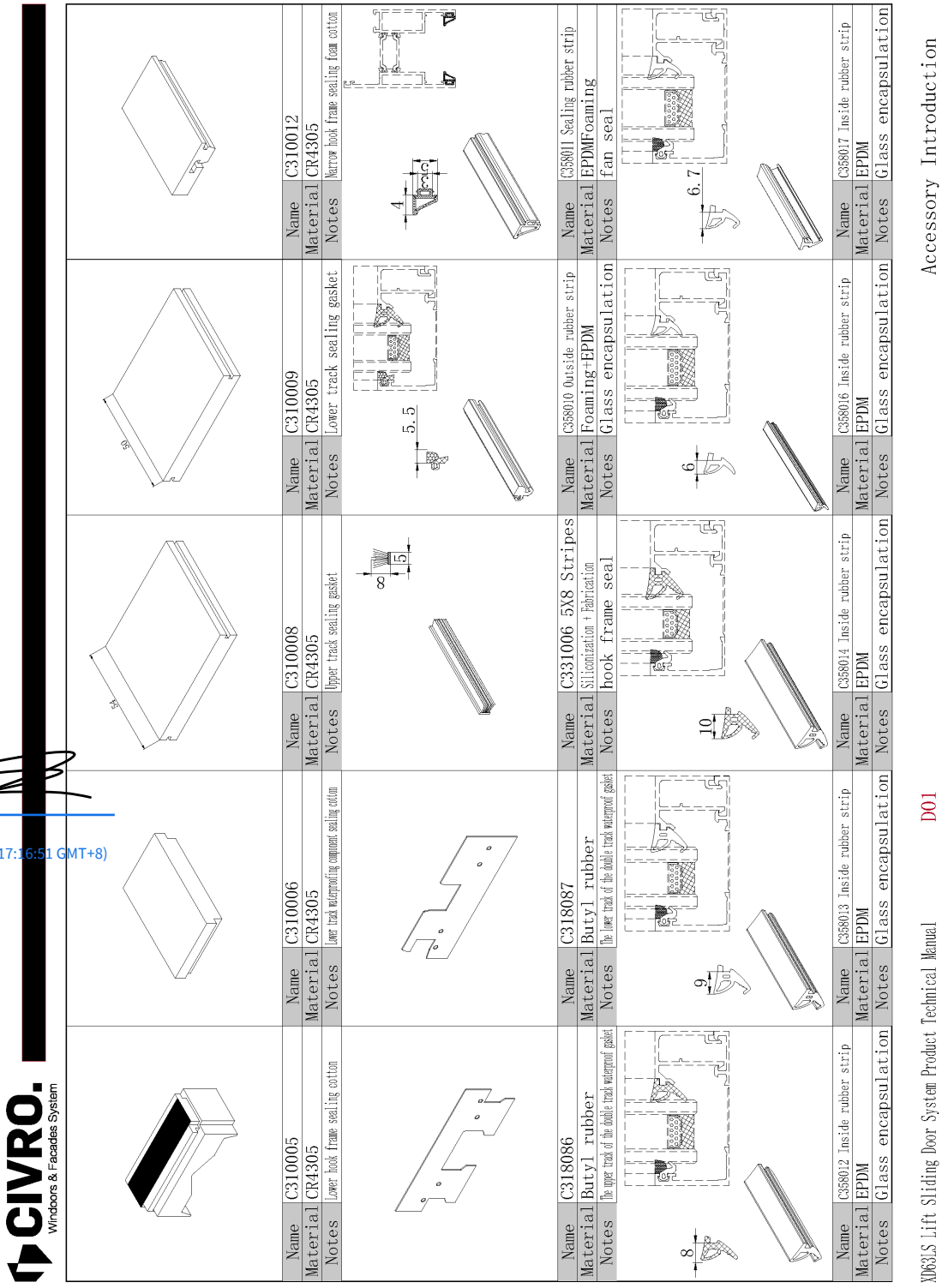

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Figure 38 Drawing of Accessory Components 1 (Details of Gasket & Other components)

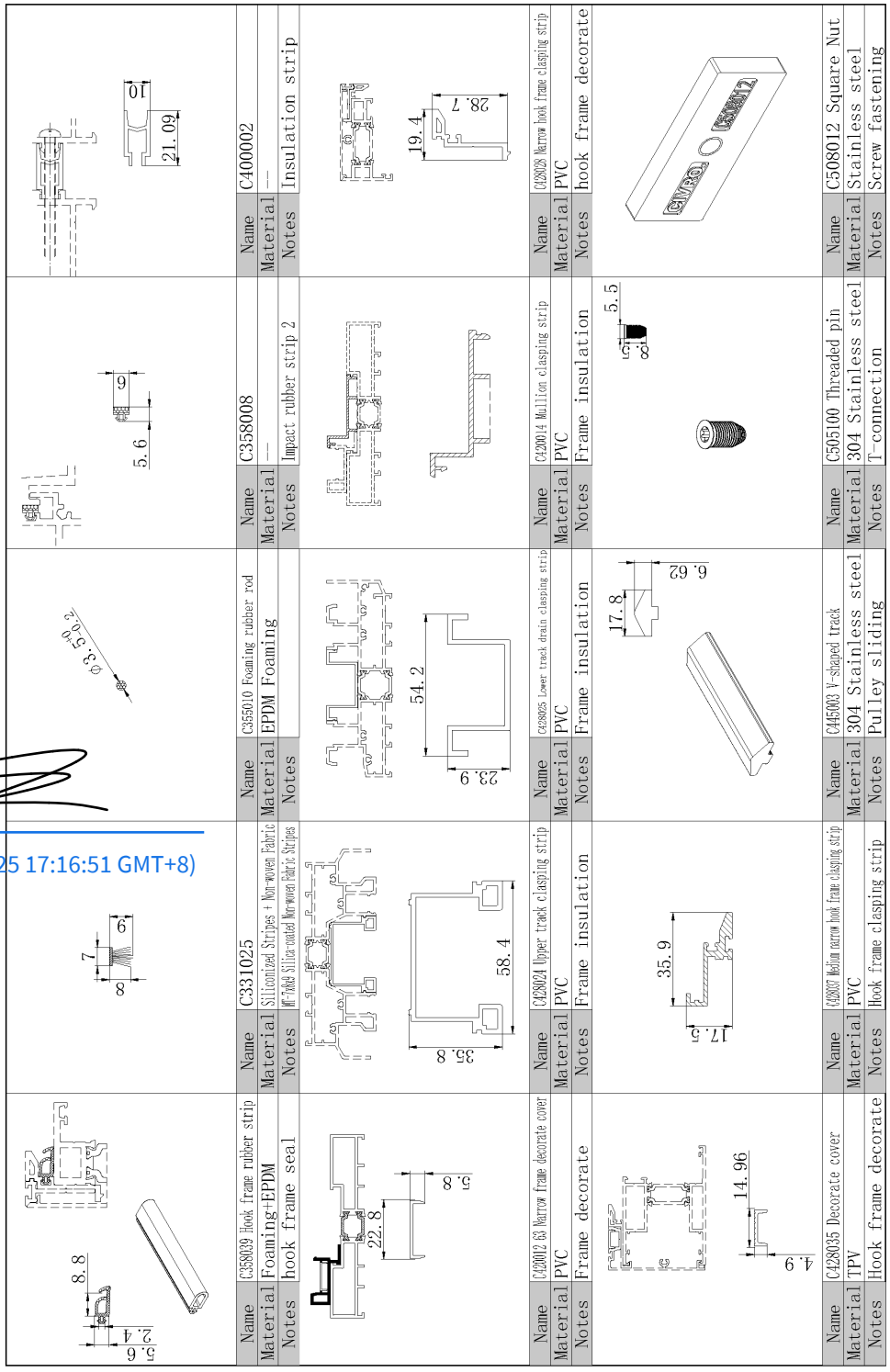

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Figure 39 Drawing of Accessory Components 2 (Details of Gasket & Other components)

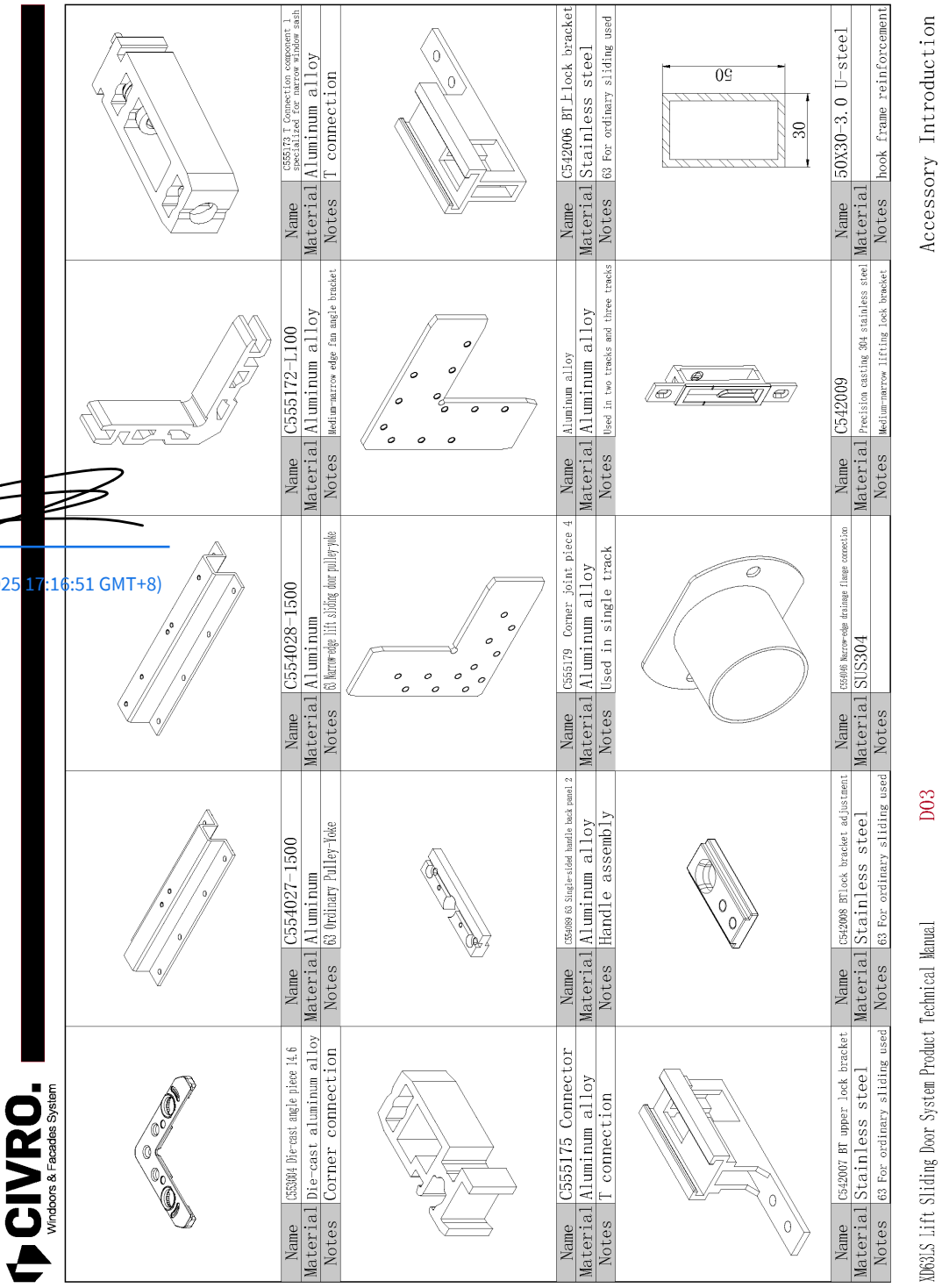

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Figure 40 Drawing of Accessory Components 3 (Details of Hardware & Other Components)

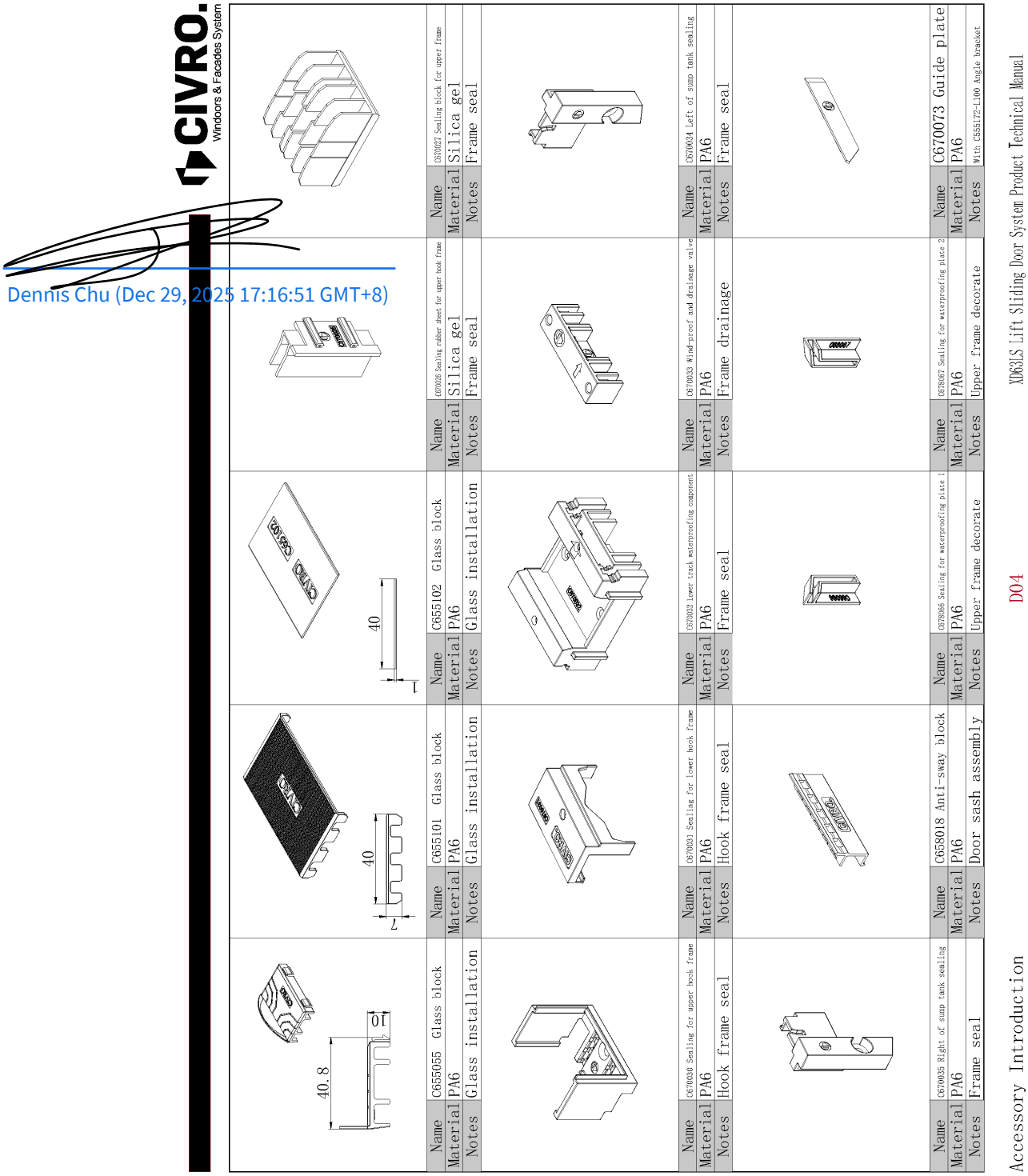

Figure 41 Drawing of Accessory Components 4 (Details of Gasket and Hardware)

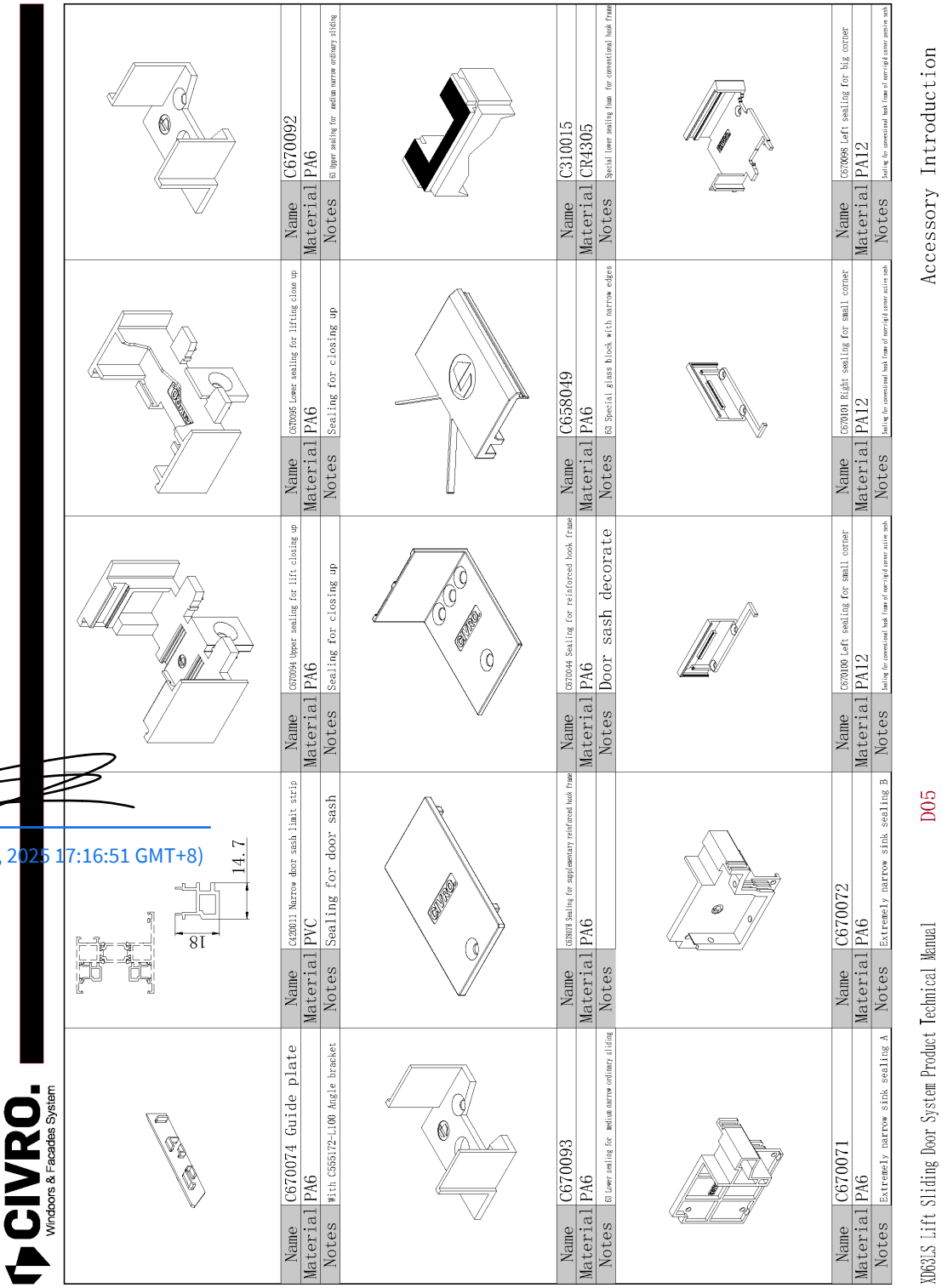

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Figure 42 Drawing of Accessory Components 5 (Details of Hardware Other Components)

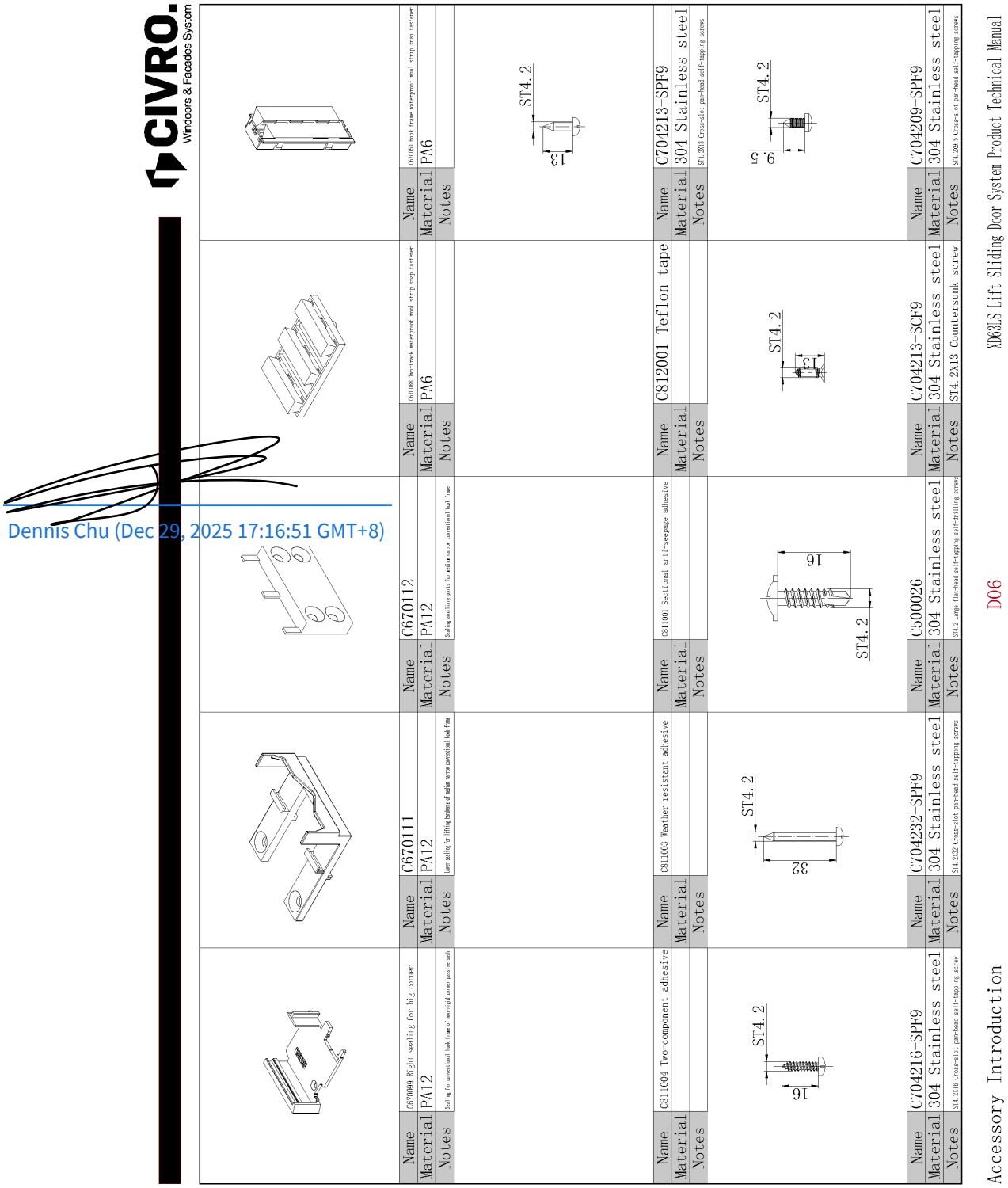

Figure 43 Drawing of Accessory Components 6 (Details of Fastener and Other Components)

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Workshop No. 6, G/F, World-wide Industrial Centre,
43-47 Shan Mei Street, Fotan, Shatin, N.T., Hong Kong
W: www.azumatesting.com P: +852 2494 7370

澳思万 (江门市) 测试有限公司
Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
Room 101, Building 4, 80 Longxi Road
Jianghai District, Jiangmen City, China
M: info@azuma.com.hk

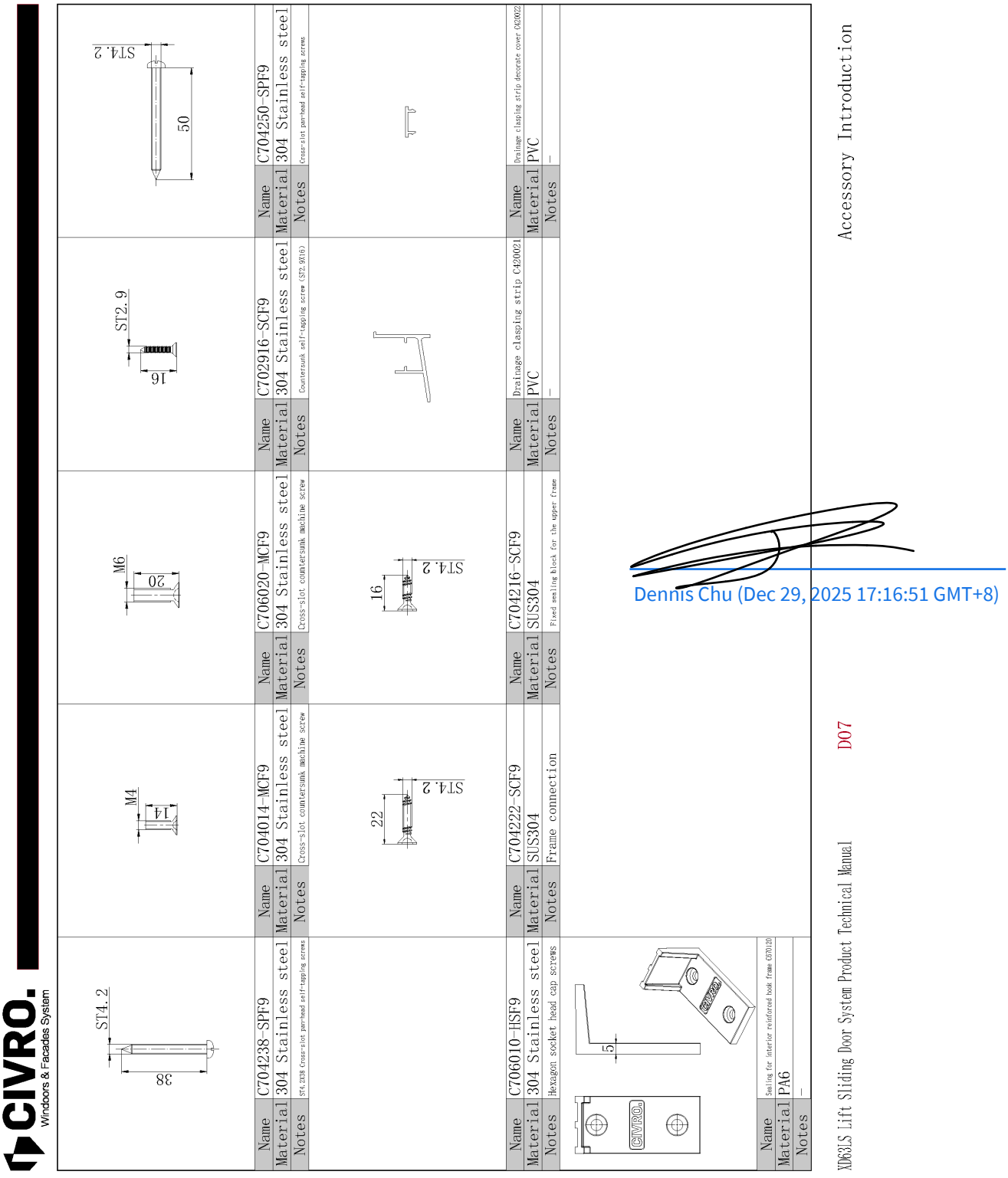

Figure 44 Drawing of Accessory Components 7 (Details of Fastener and Other Components)

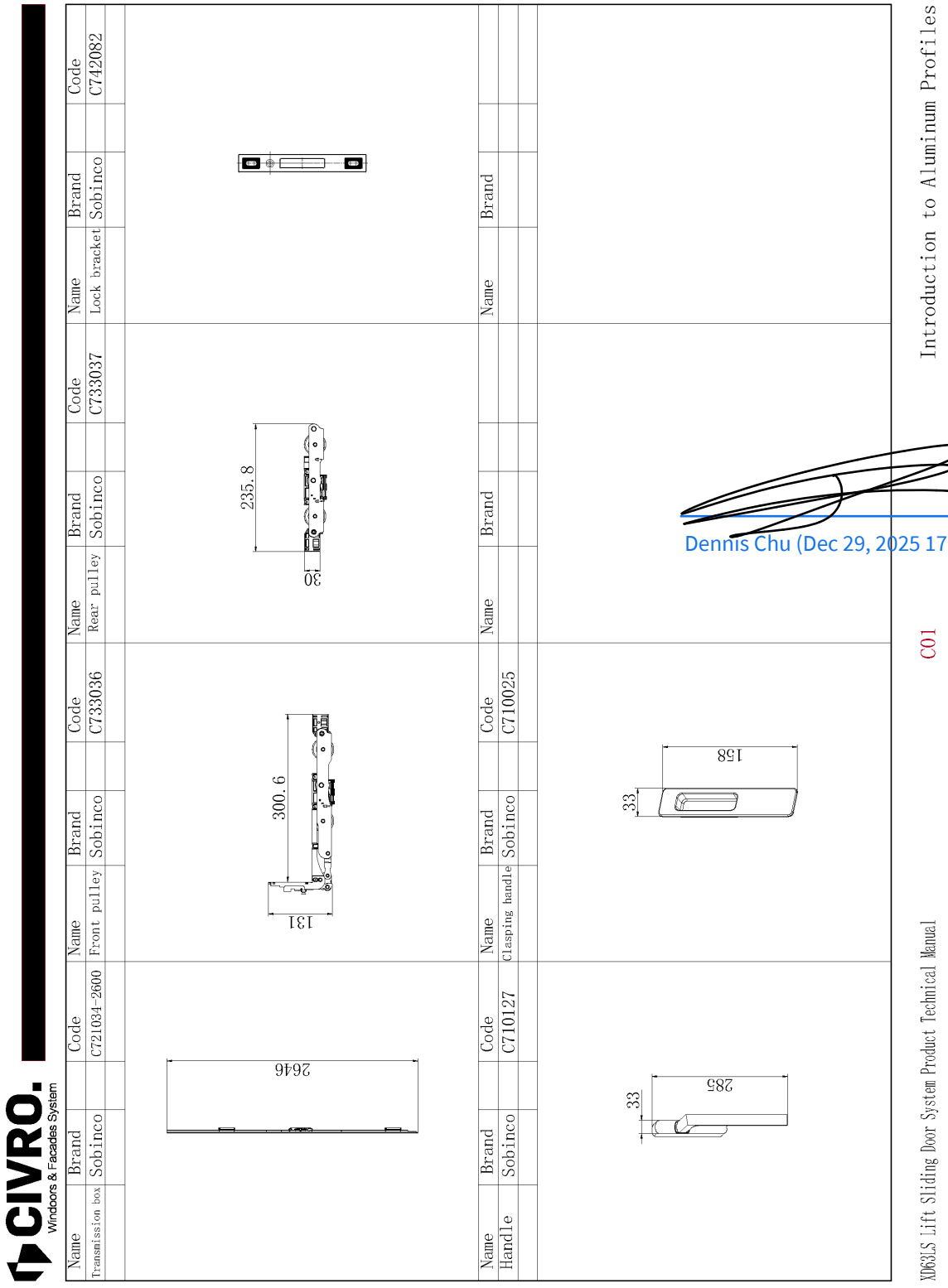

Figure 45 Drawing of Hardware

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W: www.azumatesting.com P: +852 2494 7370

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Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
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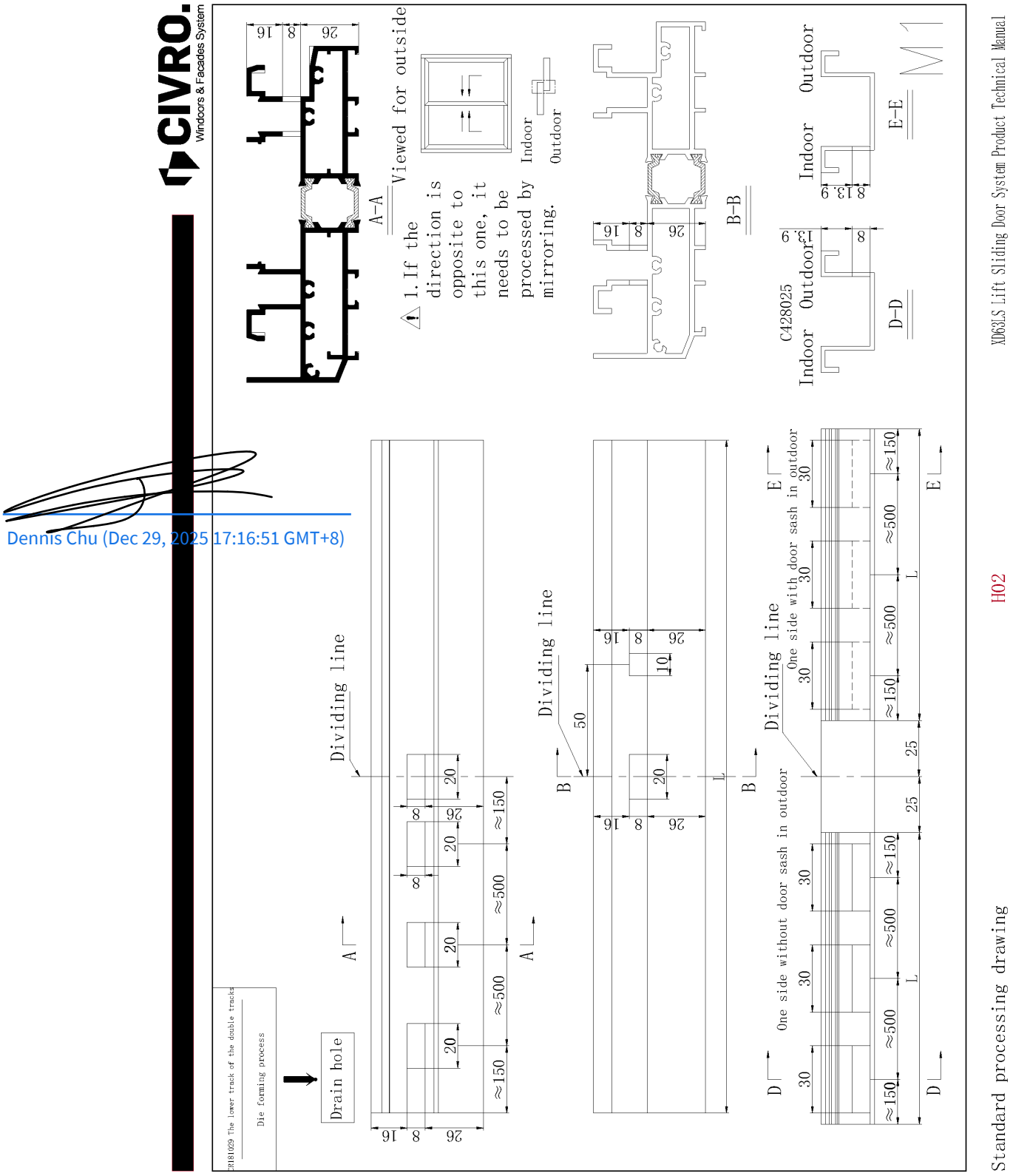

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Figure 46 Drawing of Lower Track of the Double Track with Drainage System Details

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Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
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M: info@azuma.com.hk

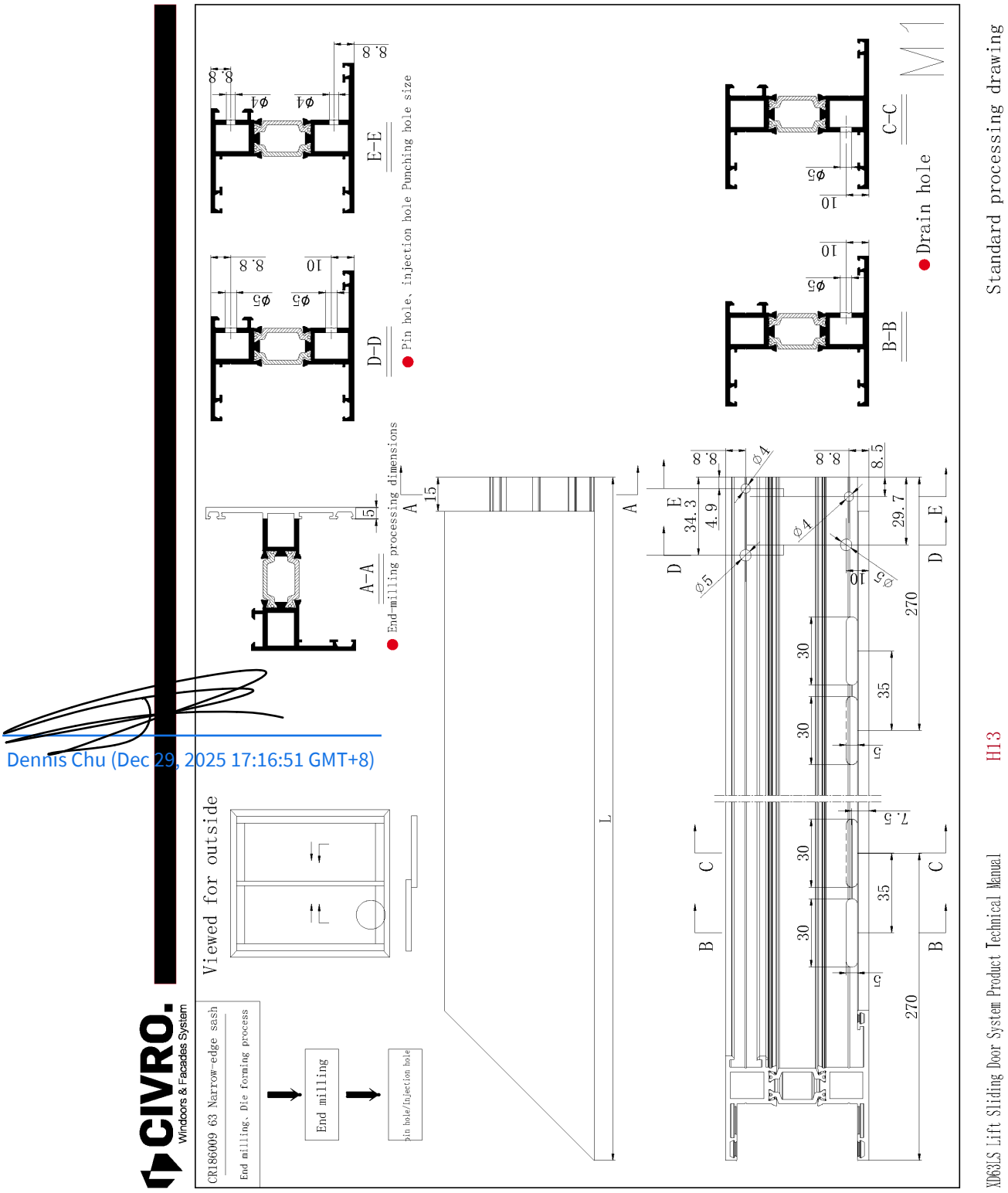

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Figure 47 Drawing of Narrow-edge Sash with Drainage System Details

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W: www.azumatesting.com P: +852 2494 7370

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Azuma (Jiangmen) Testing Limited
江门市江海区龙溪路80号4栋101室
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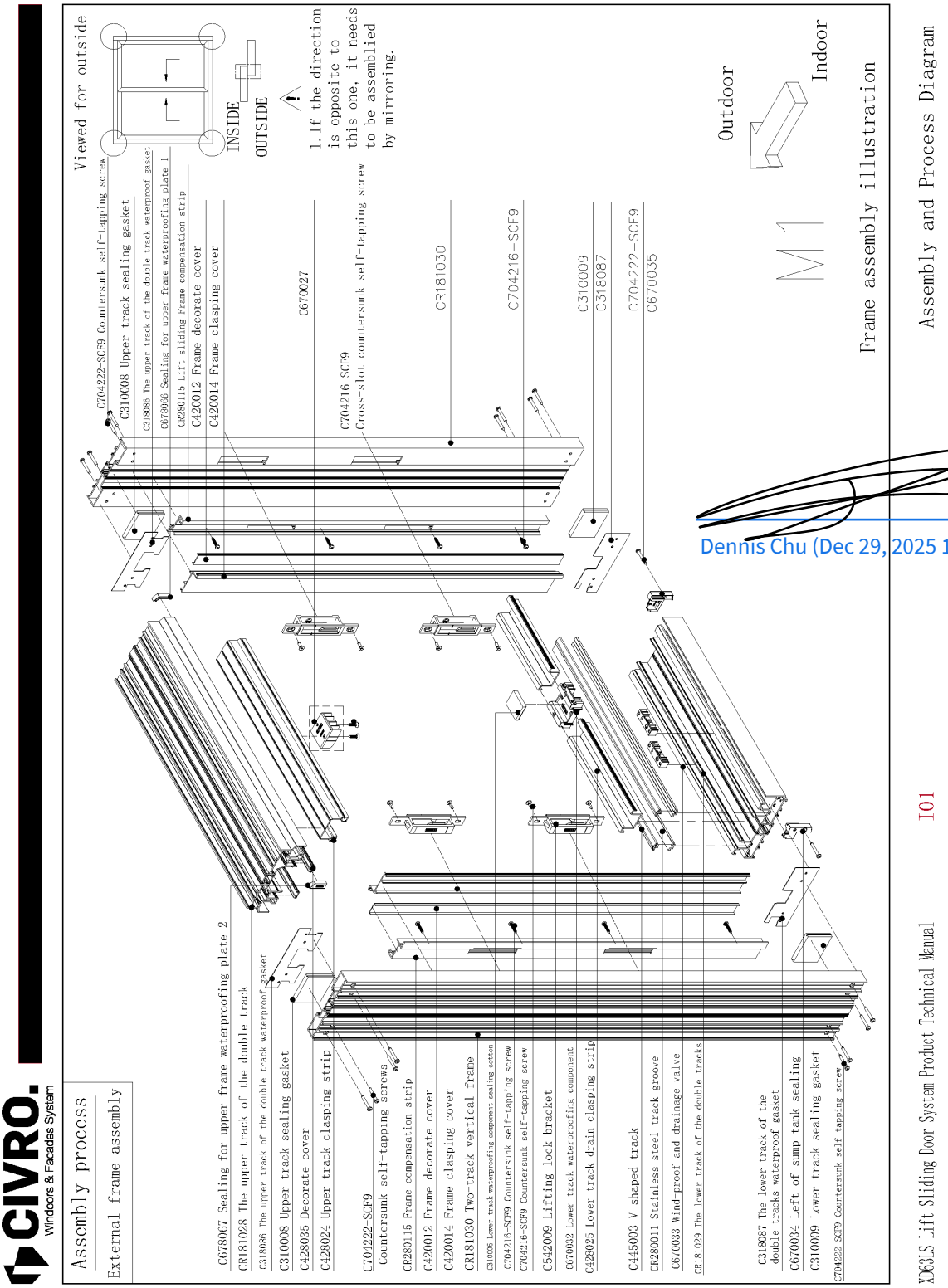

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Figure 48 Drawing of External Frame Assembly Procedure

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W: www.azumatesting.com P: +852 2494 7370

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江门市江海区龙溪路80号4栋101室
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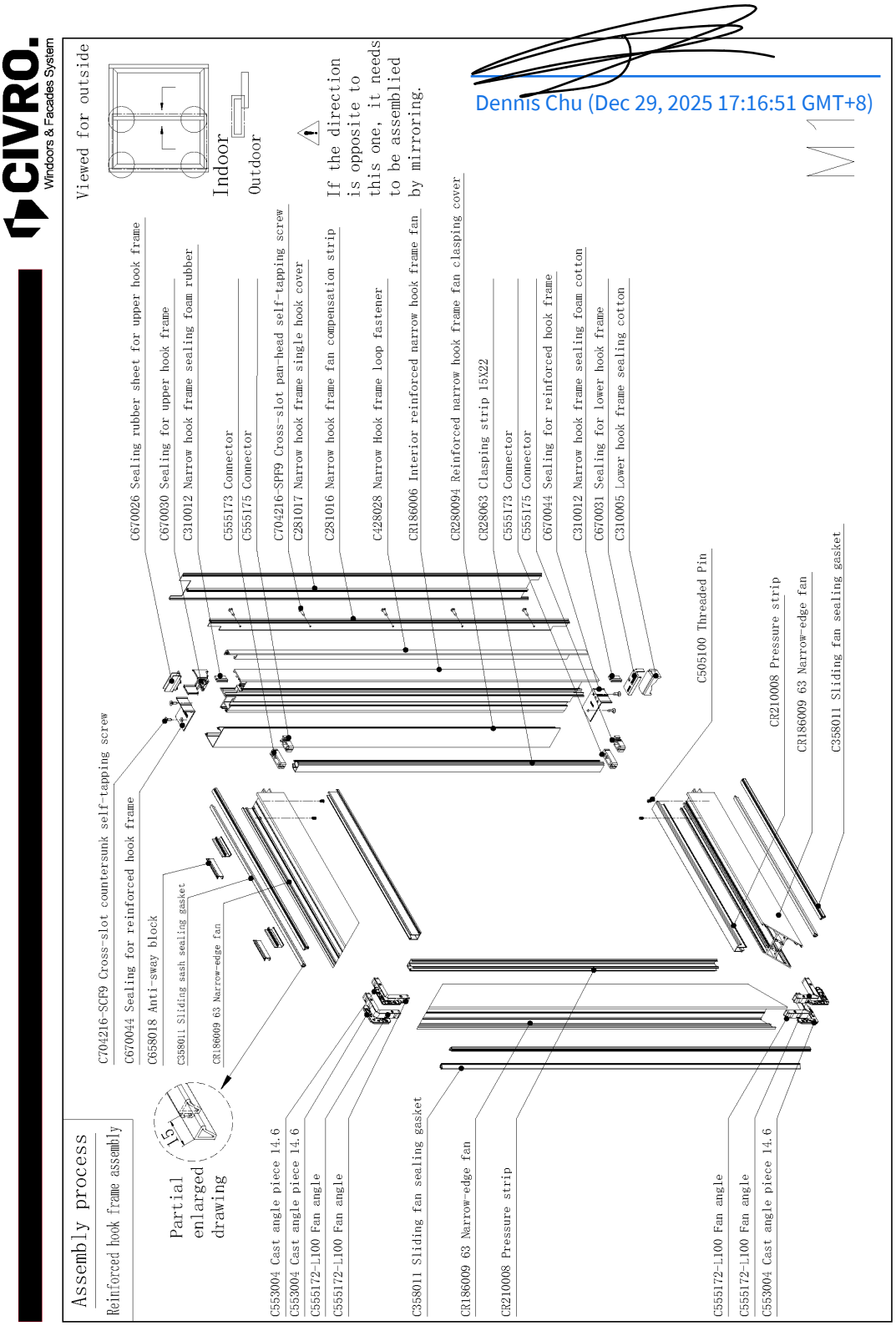

Figure 49 Drawing of Reinforced hook Frame Assembly Procedure

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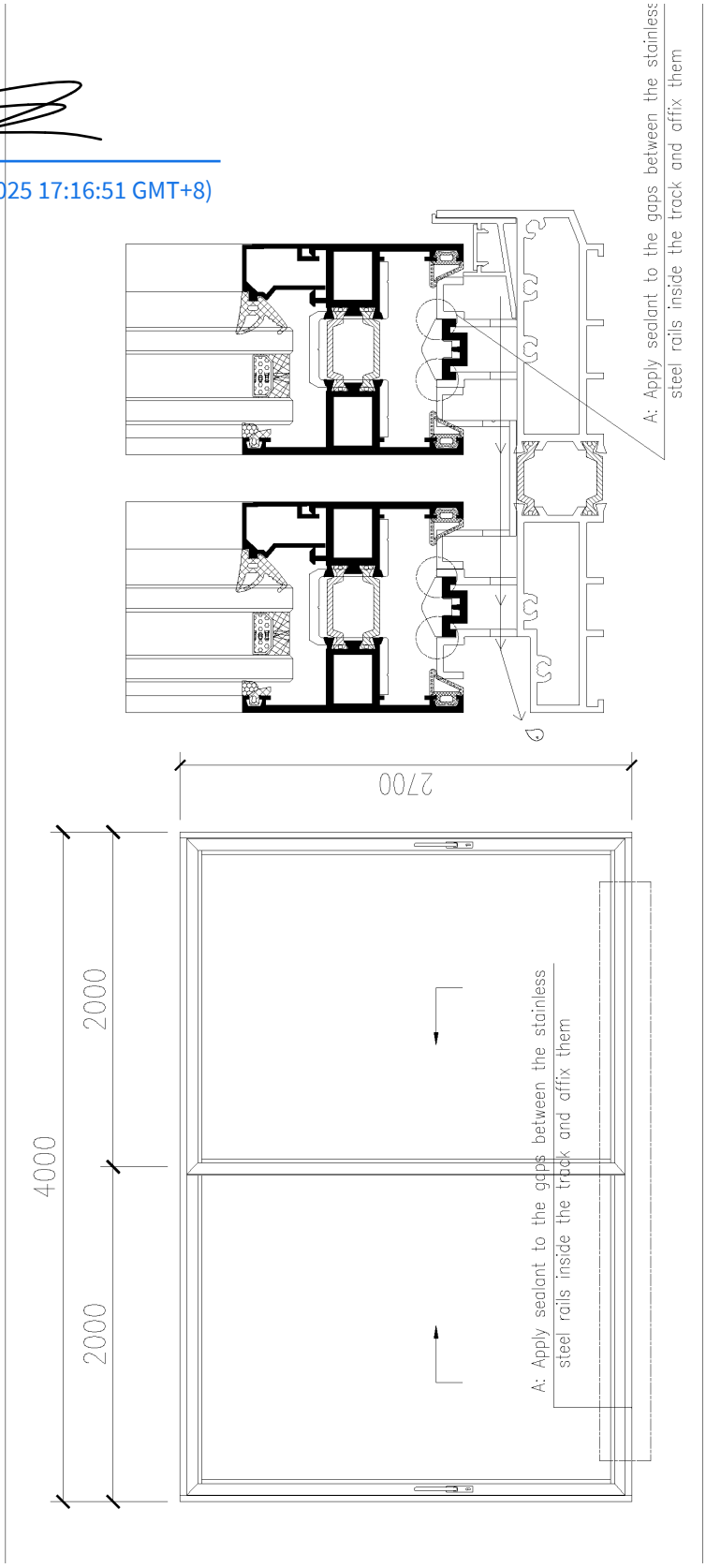

Figure 50 Drawing of Door Track Detail

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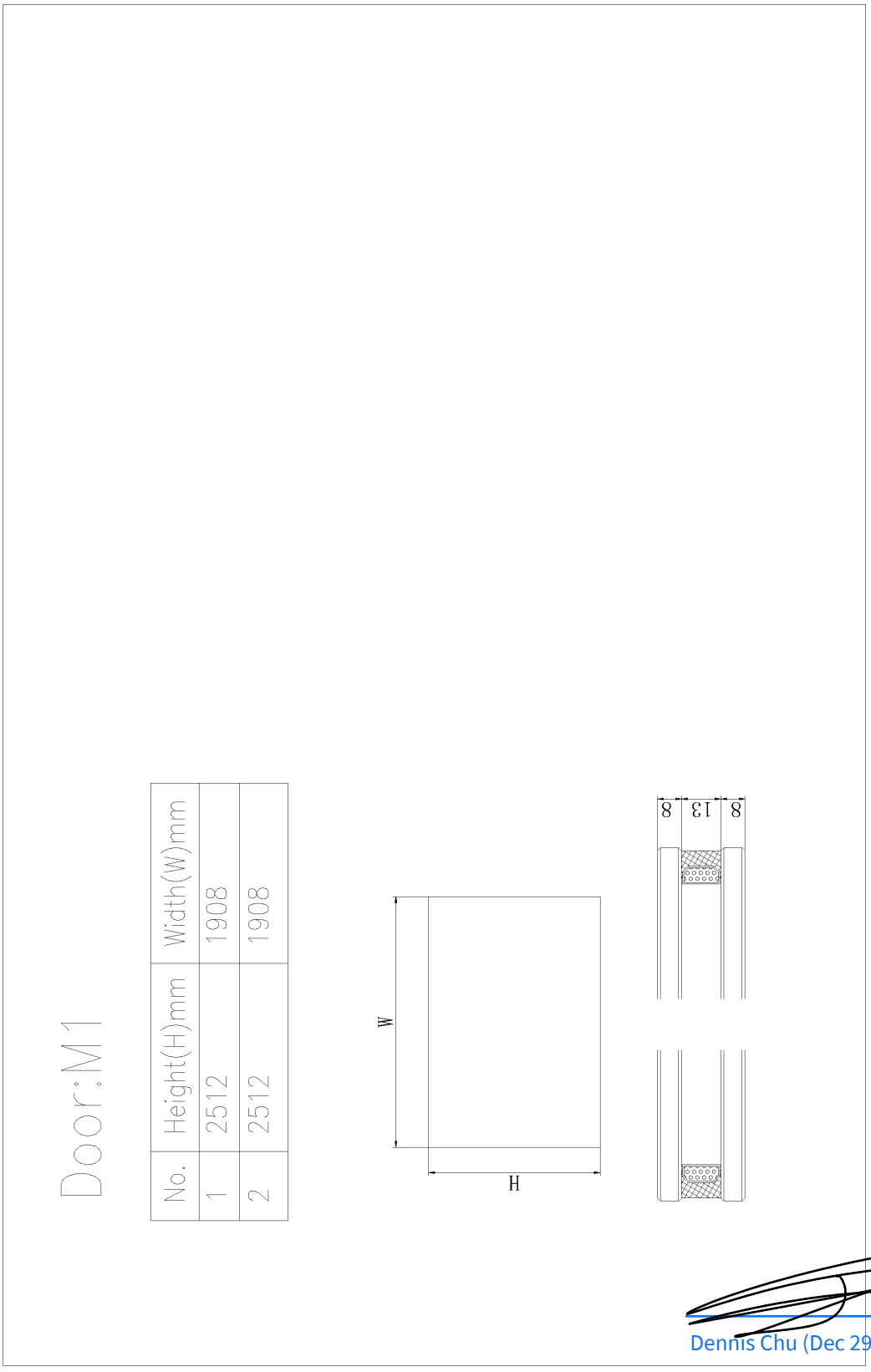

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Figure 51 Drawing of Glazing

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Azuma (Jiangmen) Testing Limited
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