Canadian Building Envelope Science and Technology
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Established 1985

TEST REPORT

Performance Evaluation of
Vinyl Sliding Glass Door
"Aria"
Performed in Accordance with:
AAMA/WDMA/CSA101/I.S.2/A440-22 (NAFS-22)
& CSA A440S1-19

Report No.: L25-926-7423r1
Report Date: July 14, 2025

Prepared for:
Vista Patio Doors
69 Jardin Dr
Concord, ON L4K 1X5
Canada

Overall Performance Rating **Test Completion Date: May 29, 2025**

Class R-PG1680, Test Size: 2580 mm x 1980 mm*-Type SD
Class R-PG35, Test Size: 101.57 in x 77.95 in*-Type SD
Positive Design Pressure: 1680 Pa (35.00 psf)
Negative Design Pressure: 1680 Pa (35.00 psf)
Water Penetration Resistance: 200 Pa (4.18 psf)
Canadian Air Infiltration/Exfiltration: A2
Forced Entry Resistance: Grade 10

Respectfully submitted by:

CANADIAN BUILDING ENVELOPE
Science and Technology (CAN-BEST)

Tests Performed by:

Sandi Abdelrehim, E.I.T.
Project Manager

Person in Responsible Charge:

Elie Alkhoury, M.Eng. (Building Science), P.Eng.
Director, Research and Testing Services

1. *This report does not constitute certification of the test product. The reported test results refer only to the specimen tested. No representation is made that other samples of similar design will feature like performance.*
2. *This report was prepared for the consideration of the addressee only. It shall not be used by any other party without the written consent of CAN-BEST.*
3. *This report may not be reproduced or quoted in partial form without the approval of CAN-BEST.*

1. INTRODUCTION

Canadian Building Envelope Science and Technology (CAN-BEST) was retained by Vista Patio Doors to test one Sliding Glass Door. Testing was conducted in accordance with the performance requirements outlined in AAMA/WDMA/CSA101/I.S.2/A440-22 'North American Fenestration Standard/Specification for Windows, Doors, and Skylights' and its Canadian Supplement CSA A440 S1-19. Where applicable, testing was carried out in accordance with the corresponding ASTM standard test method.

This report covers tests carried out on one specimen of specific dimensions. Product performance is affected by variations in its dimensions, assembly details and installation method. The reader is advised to ensure product conformity with all the details of the test sample described in the following section.

No conclusions regarding glass structural performance may be drawn from the reported results.

2. SAMPLE DESCRIPTION

Designation: "Aria"

Type: Vinyl Sliding Glass Door, 2580 mm wide by 1980 mm high (101.57 in by 77.95 in)

Sampling: Sampling of the test specimen was carried out by the Client.

Specimen Details: Details of specimen construction and installation, as provided by the client and verified by CAN-BEST, are provided in the following drawings:

Drawings:		
	Description Table	*2 pages*
	Vertical and horizontal sections	*2 pages*
	Bill of Materials	*1 page*
	Die Drawings	*8 pages*

Copy of the above drawing(s), stamped “Canadian Building Envelope Science and Technology”, is enclosed with this report.

3. TEST RESULTS

Detailed test results are presented in Tables (1.1) and (1.2) for the Gateway and Optional Performance requirements respectively.

Notes:

1. This report does not constitute certification of this product, which may only be granted by an Accredited Certification Agency.

2. The reported results were secured by using the designated test methods and they (DO) indicate compliance with the performance requirements of the referenced publication.

3. The product tested is detailed in drawings, which were supplied by the manufacturer and annexed to this report. Any other descriptions were supplied verbally by the manufacturer. The general descriptions in this report are for reference only.

Table (1.1): Test Results, Gateway Performance Requirements
Test Size: 2580 mm x 1980 mm (101.57 in x 77.95 in)
Test Start Date: May 29, 2025 — Test Finish Date: May 29, 2025

Test	Specifications	Test Results	Rating
Operating Force **8.3.1** *ASTM E2068*	Maximum allowable forces, N (lb): *Initiate:* 155 (34.88) *Maintain:* 155 (34.88) *Lock/Latch:* 100 (22.50)	Measured Operation Forces, N (lb): *Initiate:* 102 (23.00) *Maintain:* 22 (5.00) *Lock:* 53 (12.00)	**PASS**
Air Leakage Resistance **8.3.2** *ASTM E283*	Rate of air leakage (Infiltration/ Exfiltration) shall be less than or equal to the following: ***l/s/m² (cfm/ft²)*** *Canadian A2:* 1.5 (0.30) *Canadian A3:* 0.5 (0.10) *Canadian Fixed:* 0.2 (0.04) Test Pressure, Pa (psf): 75 (1.57)	Surface Area, m² (ft²): 5.108 (54.99) Measured Air Flow, l/s (cfm): *Infiltration:* 1.06 (2.25) *Exfiltration:* 3.49 (7.39) Rates of Air Flow, l/s/m² (cfm/ft²): *Infiltration:* 0.21 (0.04) *Exfiltration:* 0.68 (0.13)	**PASS** Canadian A2
Water Resistance **8.3.3** *ASTM E 547*	No leakage past innermost plane following four pressure cycles, each five minutes "ON" and one minute "OFF". Test Pressure, Pa (psf): 140 (2.92) *(Equivalent to wind speed of 34 mph)*	No leakage past innermost plane was observed. *Test* — *Result* *With Screen,* — *N/A* *Without Screen,* — *OK, 4 Cycles*	**PASS**
Uniform Load Deflection **8.3.4.2** *ASTM E 330*	Report the net deflections at the following test pressure: Test Pressure, Pa (psf): 720 (15.03) *(Equivalent to wind speed of 77 mph)*	Span: 1900 mm (74.80 in) Measured net deflection of Meeting Stile: *Deflection, mm (in)* *Inward:* 5.33 (0.210) *Outward:* 6.19 (0.244)	**Report Only**
Uniform Load Structural **8.3.4.3** *ASTM E 330*	No glass breakage or permanent damage to window components at the following test pressure, Pa (psf). Net Permanent Deflection to be less than 0.4% of span, or 7.6 mm (0.299 in). Test Pressure, Pa (psf): 1080 (22.55) *(Equivalent to wind speed of 94 mph)*	Span: 1900 mm (74.80 in) Measured net permanent deflection of Meeting Stile, mm (in): *Deflection* — *% Span* *Inward:* 0.34 (0.013) — 0.02 *Outward:* 0.37 (0.015) — 0.02	**PASS**

Table (1.1): Test Results, Gateway Performance Requirements, Continued
Test Size: 2580 mm x 1980 mm (101.57 in x 77.95 in)

Test Start Date: May 29, 2025 Test Finish Date: May 29, 2025

Test	Specifications	Test Results	Rating
Forced Entry Resistance **8.3.5** *ASTM F 842*	No entry shall be gained during the following sequence of disassembly, load tests and hardware and sash manipulation tests: Disassembly T1: 5 minutes Hardware Loads: N (lbf) L1: 1334 (300) L2: 778 (175) L3: 133 (30) L4: 222 (50) Manipulation T1: 5 minutes	No entry was gained following the specified sequence of testing. *Test* — *Results* Disassembly T1: OK Hardware Loads: N (lbf) L1: OK L2: OK L3: OK L4: OK Manipulation T1: OK	**Grade 10**
Deglazing Test *ASTM E 987*	Sash members shall not move from their original position by more than 90% of the original glazing bite under the following applied loads, N (lbf): Stiles: 320 (71.94) Rails: 230 (51.70)	Measured Sash Deglazing (mm): 41.5 *Member* — *Deglazing* — *%* Left Stile: 1.66 (0.065) 4% Right Stile: 1.63 (0.064) 4% Top Rail: 1.19 (0.047) 3% Bottom Rail: 1.16 (0.046) 3%	**PASS**

Table (1.2): Test Results, Optional Performance Requirements **Class R-PG35-SD**
Test Size: 2580 mm x 1980 mm (101.57 in x 77.95 in)

Test Start Date: May 29, 2025 Test Finish Date: May 29, 2025

Test	Specifications	Test Results	Rating
Water Resistance **8.3.3** *ASTM E 547*	No leakage past innermost plane following four pressure cycles, each five minutes "ON" and one minute "OFF". Test Pressure, Pa (psf): 200 (4.18) *(Equivalent to wind speed of 40 mph)*	No leakage past innermost plane was observed. *Test* — *Result* *With Screen,* — *N/A* *Without Screen,* — *OK, 4 Cycles*	**PASS**
Uniform Load Deflection **8.3.4.2** *ASTM E 330*	Maximum net deflection shall not be more than 1/175 of its span, or 14.3 mm (0.56 in) under the following design pressure: Inward Pressure: 1680 (35.08) Outward Pressure: 1680 (35.08) *(Equivalent to wind speed of 117 mph)*	Meeting Stile Span, mm (in): 1900 (74.80) Measured net deflections, mm (in): *Inward:* 12.07 (0.475) *Outward:* 14.29 (0.563)	**Report Only**
Uniform Load Structural **8.3.4.3** *ASTM E 330*	No glass breakage or permanent damage to window components, at Test Pressures, Pa (psf). Net Permanent Deflection to be less than 0.4% of span, or 7.6 mm (0.299 in). Inward Pressure: 2520 (52.62) Outward Pressure: 2520 (52.62) *(Equivalent to wind speed of 176 mph)*	Measured net permanent deflection of Meeting Stile, mm (in): Span = 1900 (74.80) ***Deflection*** — ***% Span*** *Inward:* 0.50 (0.020) 0.03 *Outward:* 0.87 (0.034) 0.05	**PASS**

Revision Log

Rev. No	Change	Date	Apprv. By
-	Original report issued	Jun. 11, 2025	EA
r1	Product designation changed	Jul. 14, 2025	EA

This description table is an example for a typical description.

Item	Type, Material, Part #	Qty*	Size (W x H x D)	Location, Fastening, Seals, Comments
Frame	Sliding door, Extruded PVC	1	2628.9mm x 2012.95mm	Two operable and one stationary panel
Panel	Lift-out, Extruded PVC	3	911.225mm x 1920.875mm	Stationary panel mechanically fastened to the jamb with clips and #8 x 1 ½" (4.2mm x 38.1mm) screws
Joinery	Thermally Welded, Mitered corners			Welded corners – temperature 250 Celsius, melt time 30 seconds, weld time 40 seconds
Installation	Wood buck	1	2717.8mm x 2098.675mm	Fastened with #8 x 3 ½" (4.2mm x 88.9mm) screws (10 per jamb), perimeter sealed w/ silicone sealant
Glazing	Double-pane IGU, Tempered glass	3	Overall thickness: 25.4 mm	Glass thickness: 4 mm
Glazing Method	Laid in glazed			
	Glazing tape, foam	12	60.325mm x 1.5875mm	Exterior perimeter
	Corner Bead, sealant	0		Interior and exterior perimeter
	Glazing stops	12	9.525mm x 19.05mm	Interior perimeter
Thermal Break	None			
Reinforcement	Shape section	12	38.1mm x 34.925mm	Thickness 3.175mm
Weatherstrips				
Panel	Pile with high fin	8	Height: 4.572mm	Meeting stiles
	Pile	6	Height: 4.064 mm	Operable panel
Frame	Pile	4	Height: 5.588 mm	Jambs and head
Screen	Pile	0	Height:	
Drainage				
Sash	Drain slots/ Holes	6	Diameter: 6.35mm	Glazing cavity, bottom from the ends
Frame	Drain slots	6	Diameter: 25.4mm	Sill, ends of panel support interior face
Add-Ons				
Panel Support	Extruded PVC	1	Length: 923.925mm	Sill, exterior channel
Screen track	Snap-On/In, Aluminum	0	Length:	
Roller track	Snap-On/In, Aluminum	1	Length: 2571.75mm	Sill, interior channel, full length
Sill Cap	Snap-On/In, Aluminum	1	Length: 2571.75	Sill nosing, exterior channel

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Verified By:
Date: JUNE 11, 2025

The above descriptions were provided by the manufacturer. Items and/or material properties were verified by CAN-BEST for general conformity only.

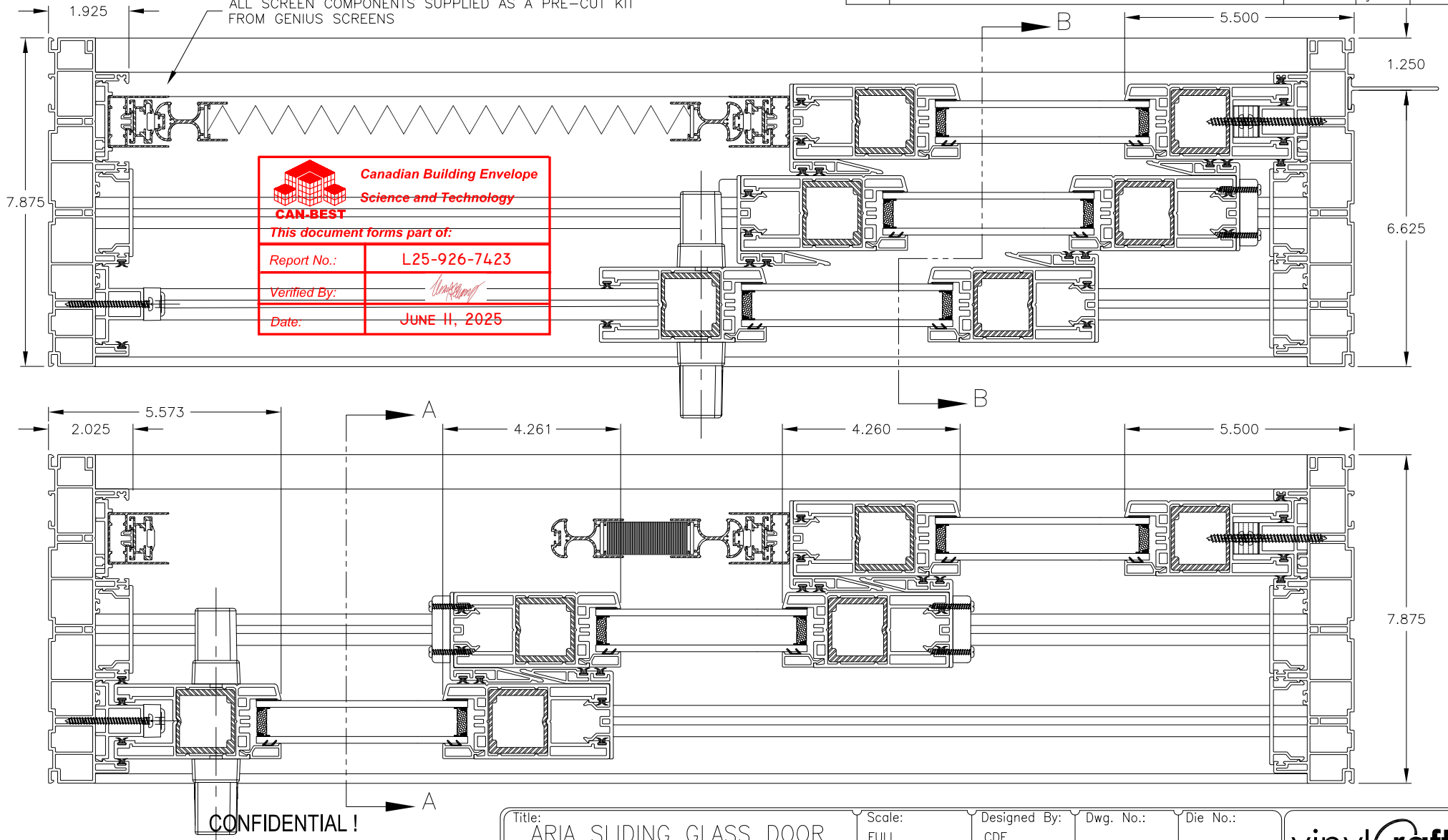
* Quantity is total unless otherwise specified

This description table is an example for a typical description.

Item	Type, Material, Part #	Qty*	Size (W x H x D)	Location, Fastening, Seals, Comments
Interlocks	Snap-On/In, Extruded PVC	4	1924.05mm	Snap on no screw
Travel Limiter	Extruded PVC	2	Length: 139.7mm	Ends of stationary jambs
Hardware				
Lock	Three-Point Lock, Metal	1	Length: 1111.25mm	Lock stile, center, mechanically fastened with 4.2mm x 19.05mm screws
Handle	Metal	1	Length: 328.6125	Pull stile, center, fastened with 4.2mm x 53.975mm screws and 4.2mm x 25.4mm
Keepers	3 points engagement system, metal	1	Lenth: 1069.975mm	Lock jamb, interior channel, center, fastened with 4.2mm x 63.5mm screws
Rollers	Tandem nylon rollers	4	Length: 168.275mm	End of bottom rail, operable panel, each fastened with 4.2mm x 12.7mm screws
Screen	N/A		N/A	

* Quantity is total unless otherwise specified

RevNo	Revision note	Date	Signature	Checked



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CAN-BEST
This document forms part of:

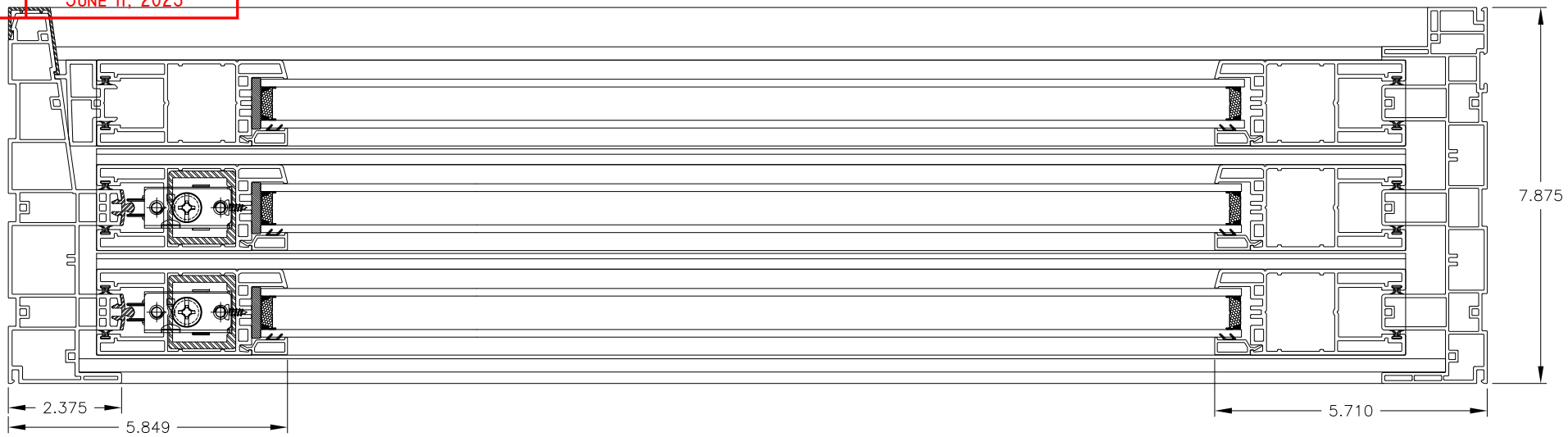
Report No.:	L25-926-7423
Verified By:	
Date:	JUNE 11, 2025

Title:	Scale:	Designed By:	Dwg. No.:	Die No.:
ARIA SLIDING GLASS DOOR	FULL	CDF		
Customer:	Date:	Drawn By:	Material:	Prog .No.:
HORIZONTAL SECTION	12-MAY-25	CDF	PVC	

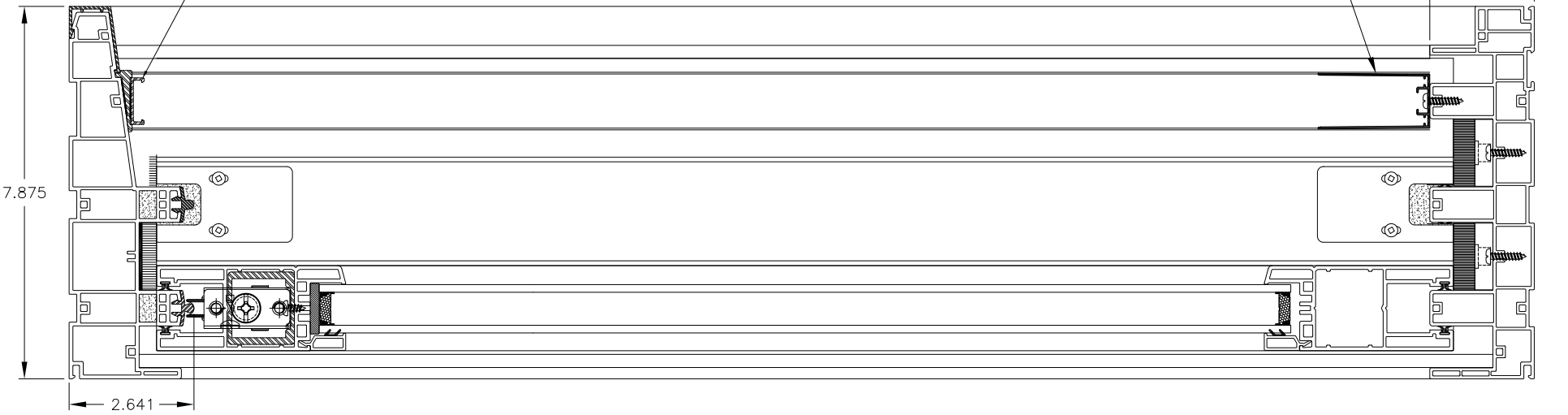
vinylcraft extrusions

RevNo	Revision note	Date	Signature	Checked

SECTION B–B



SECTION A–A



Title: ARIA SLIDING GLASS DOOR	Scale: FULL	Designed By: CDF	Dwg. No.:	Die No.:
Customer: VERTICAL SECTION	Date: 12–MAY–25	Drawn By: CDF	Material: PVC	Prog .No.:

vinylcraft extrusions

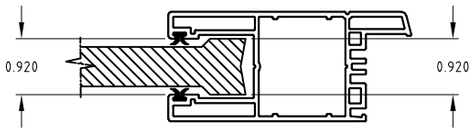
Bill of Materials

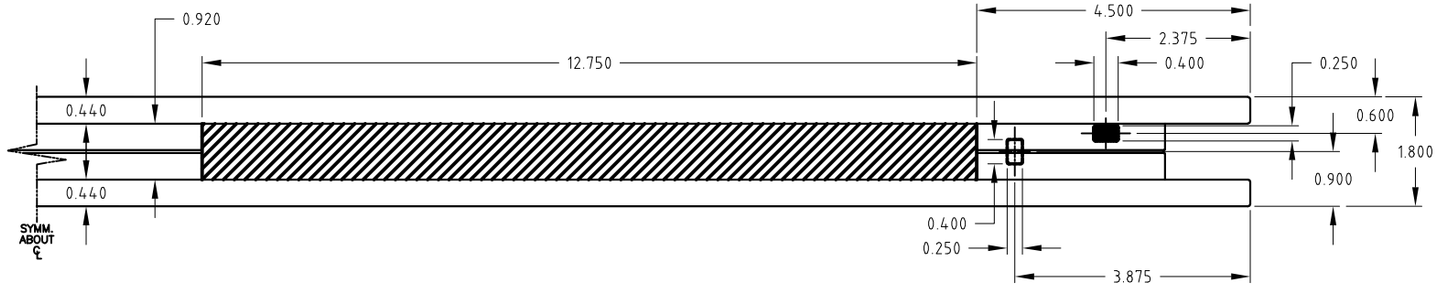
PART NUMBER	PART NAME
VC483	JAMB
VC482	HEADER
VC481	SILL
VC838	FIXED PANEL SUPPORT
VC941	JAMB ADAPTER
VC936	INTERLOCK
VC058	SASH
5638-SH	ALUMINUM REINFORCEMENT
DC939	JAMB CAP
VC916	GLASS STOP
SS-4162	ALUMINUM ROLLER TRACK
SS-4536	ALUMINUM SILL NOSING
JAMB WEATHERSTRIP	187 BACKING / 220 PILE
SASH WEATHERSTRIP	187 BACKING / 160 PILE
INTERLOCK WEATHERSTRIP	187 BACKING / 180 PILE

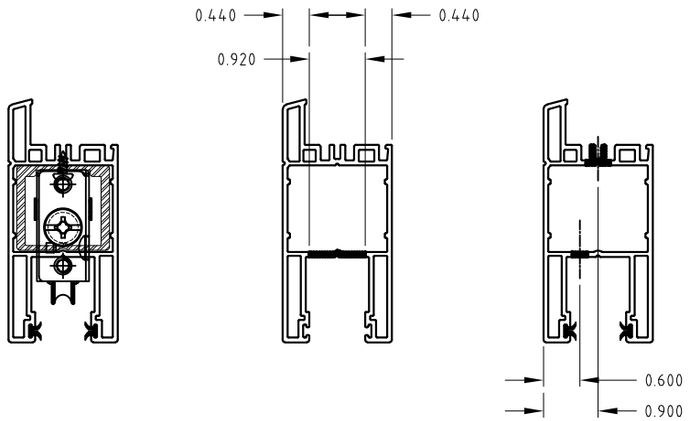
RevNo	Revision note	Date	Signature	Checked

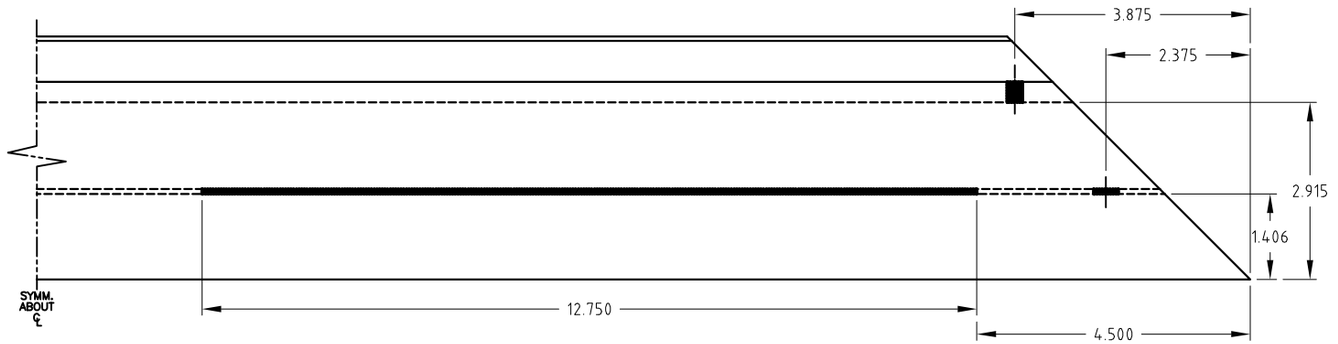
IMPORTANT NOTE!

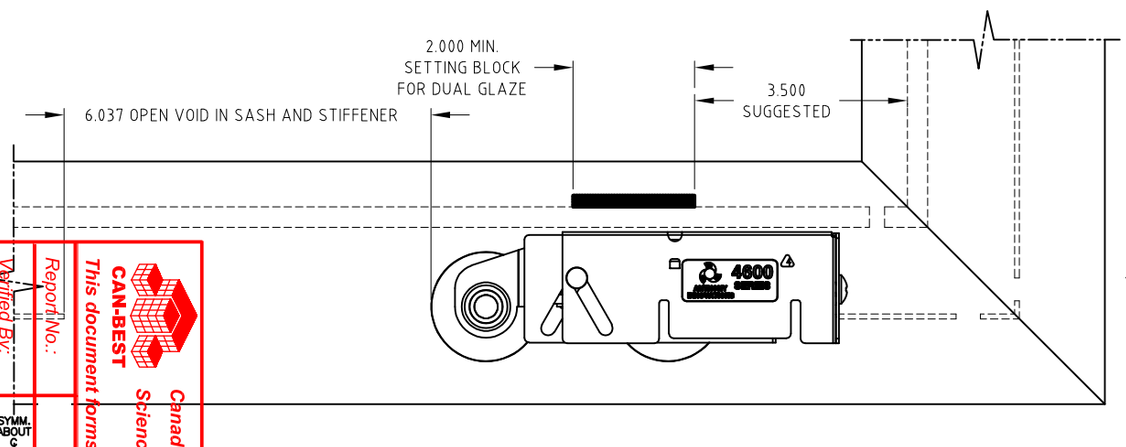
SASH PROFILE WILL BE FILLED WITH WEATHER STRIP.
PUNCH TOOLS SHOULD BE BUILT ACCORDINGLY.

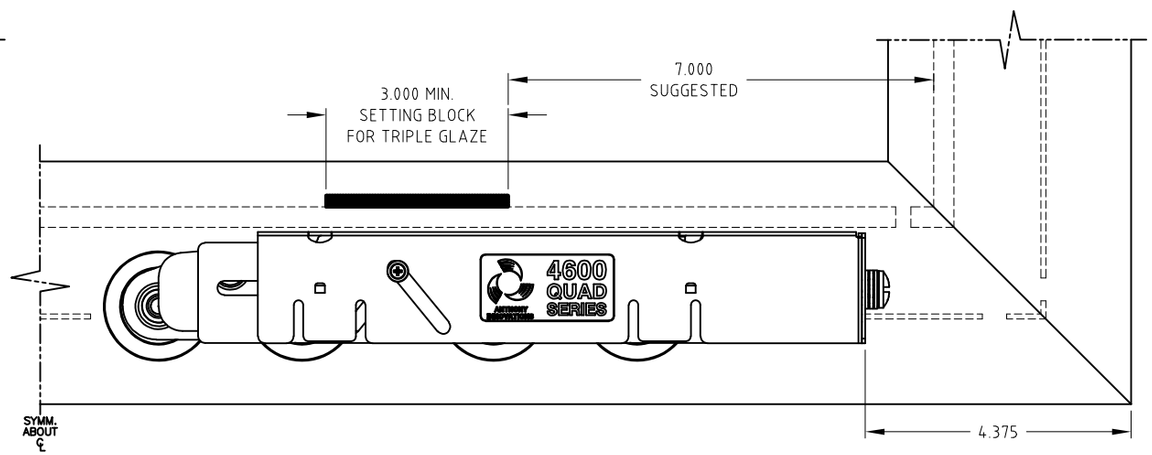












1/4" WELD BURN INCLUDED

Date: JUNE 11, 2025

Verified By:

Report No.: L25-926-7423

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Title:	Scale:	Designed By:	Dwg. No.:	Die No.:
SASH BOTTOM RAIL FOR 4600 ROLLER	FULL	CDF	XXXX	
Customer:	Date: 21-APR-25	Drawn By: CDF	Material: PVC	Prog .No.:

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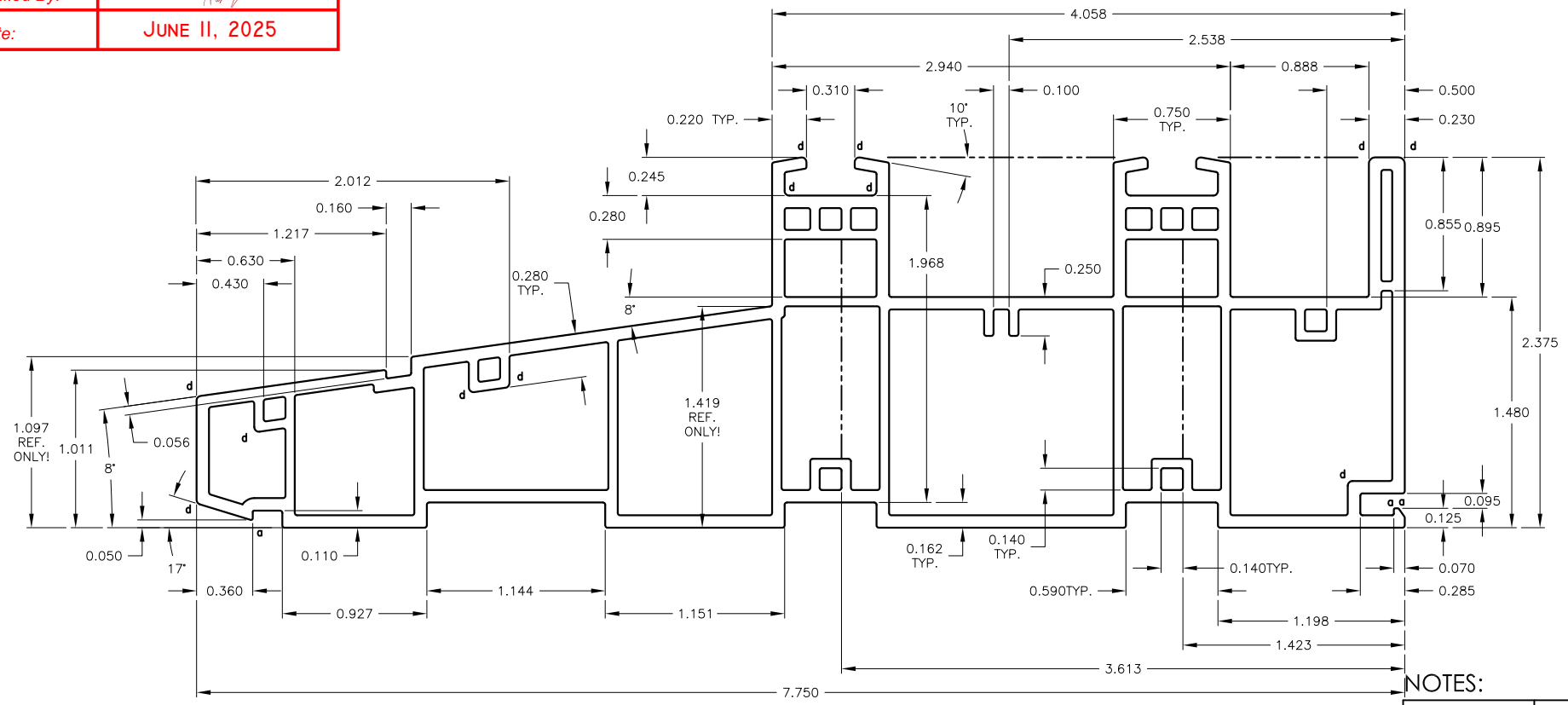
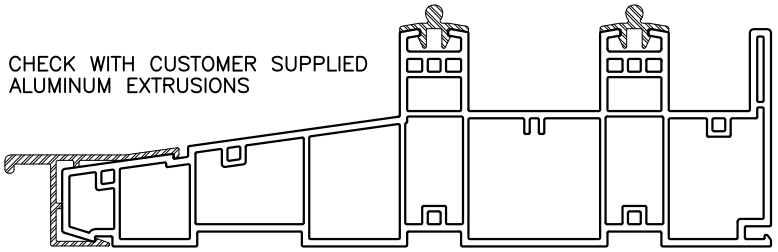


NOTES:

WALL THICKNESS:		RADII: UNMRAKED 0.015	
EXT.	0.080	a 0.010	f FULL
INT.	0.060	b 0.015	g 0.060
▲	----	c 0.020	h ----
•	----	d 0.030	i ----
		e 0.040	m MINIMUM RAD

CHECK WITH CUSTOMER SUPPLIED ALUMINUM EXTRUSIONS



TOLERANCES:		SECTION DETAILS:	
DIMENSIONS:	+/- 0.015 UNLESS SPECIFIED	AREA (RIGID):	----
WALL THICKNESS:	+/- 0.005 UNLESS SPECIFIED	AREA (FLEX):	N/A
COMPONENT WEIGHT:	+/- 5%	WIEGHT (TOTAL):	----
⌖	INTERSECTION	MATERIAL:	
	CRITICAL +/- 0.010	HATCHED AREA:	RIGID PVC
		FILLED AREA:	FLEX PVC

Title: 3 TRACK DOOR SILL	Scale: 2:1	Designed By: CDF	Dwg. No.:	Die No.: V481
Customer:	Date: 27-MAY-20	Drawn By: CDF	Material: PVC	Prog .No.:

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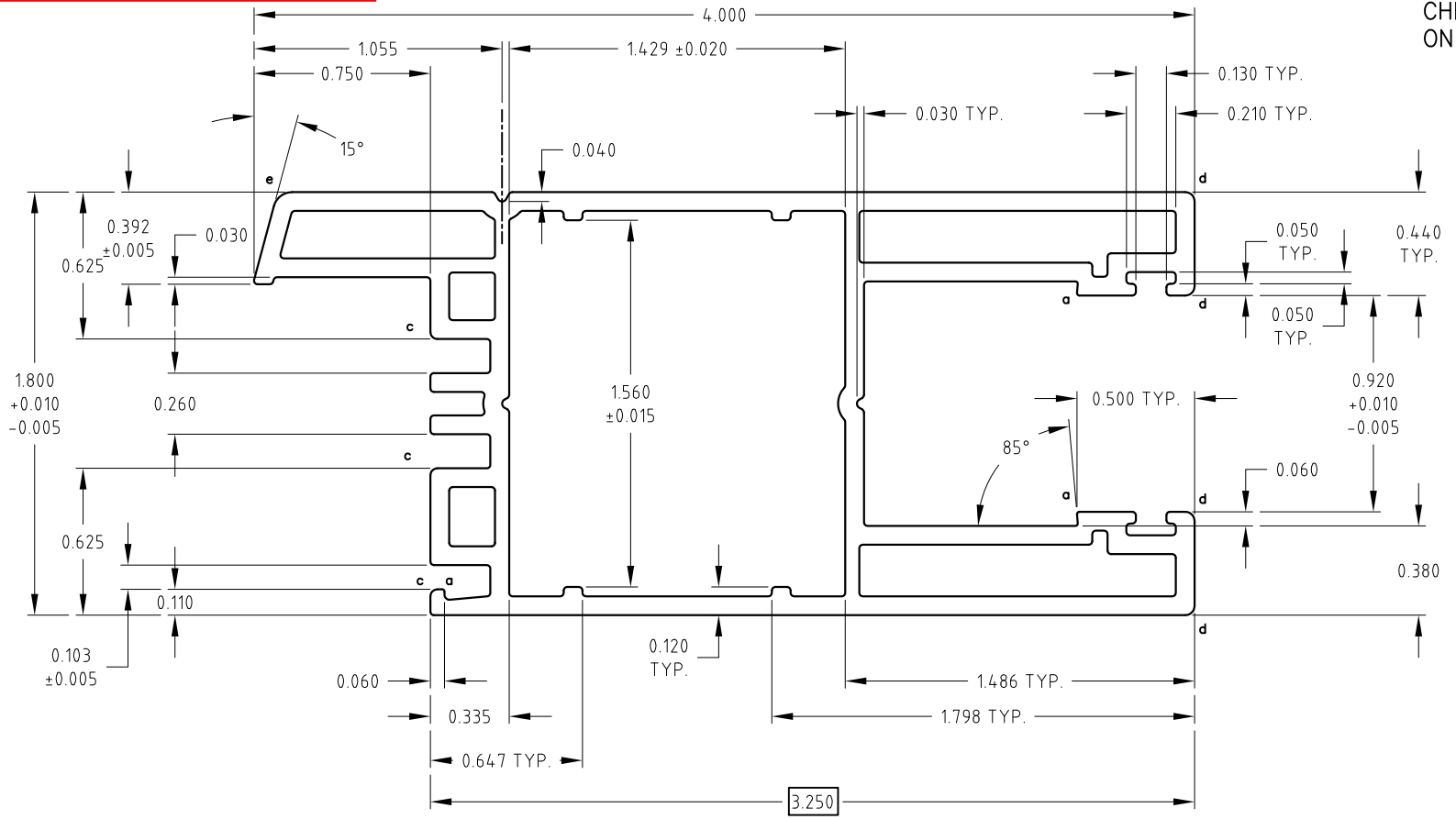
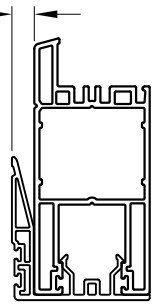
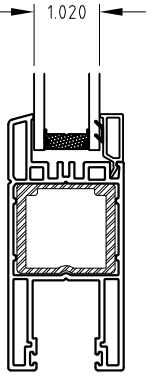


CHECK WITH V936 ON BOTH SIDES



CHECK WITH V916 & CUSTOMER SUPPLIED ALUMINUM STIFFENER



NOTES:

WALL THICKNESS:	RADII: UNMRAKED 0.015	
EXT. 0.080	a 0.010	f FULL
INT. 0.060	b 0.015	g ----
▲ ----	c 0.030	h ----
	d 0.040	i ----
	e 0.080	m MINIMUM RAD

TOLERANCES:

DIMENSIONS: +/- 0.015 UNLESS SPECIFIED
WALL THICKNESS: +/- 0.005 UNLESS SPECIFIED
COMPONENT WEIGHT: +/- 5%
⌖ INTERSECTION
▭ CRITICAL +/- 0.010

Title:	Scale:	Designed By:	Dwg. No.:	Die No.:
PATIO DOOR SASH	2:1	CDF		V058
Customer:	Date: 22-MAR-21	Drawn By: CDF	Material: PVC	Prog .No.:

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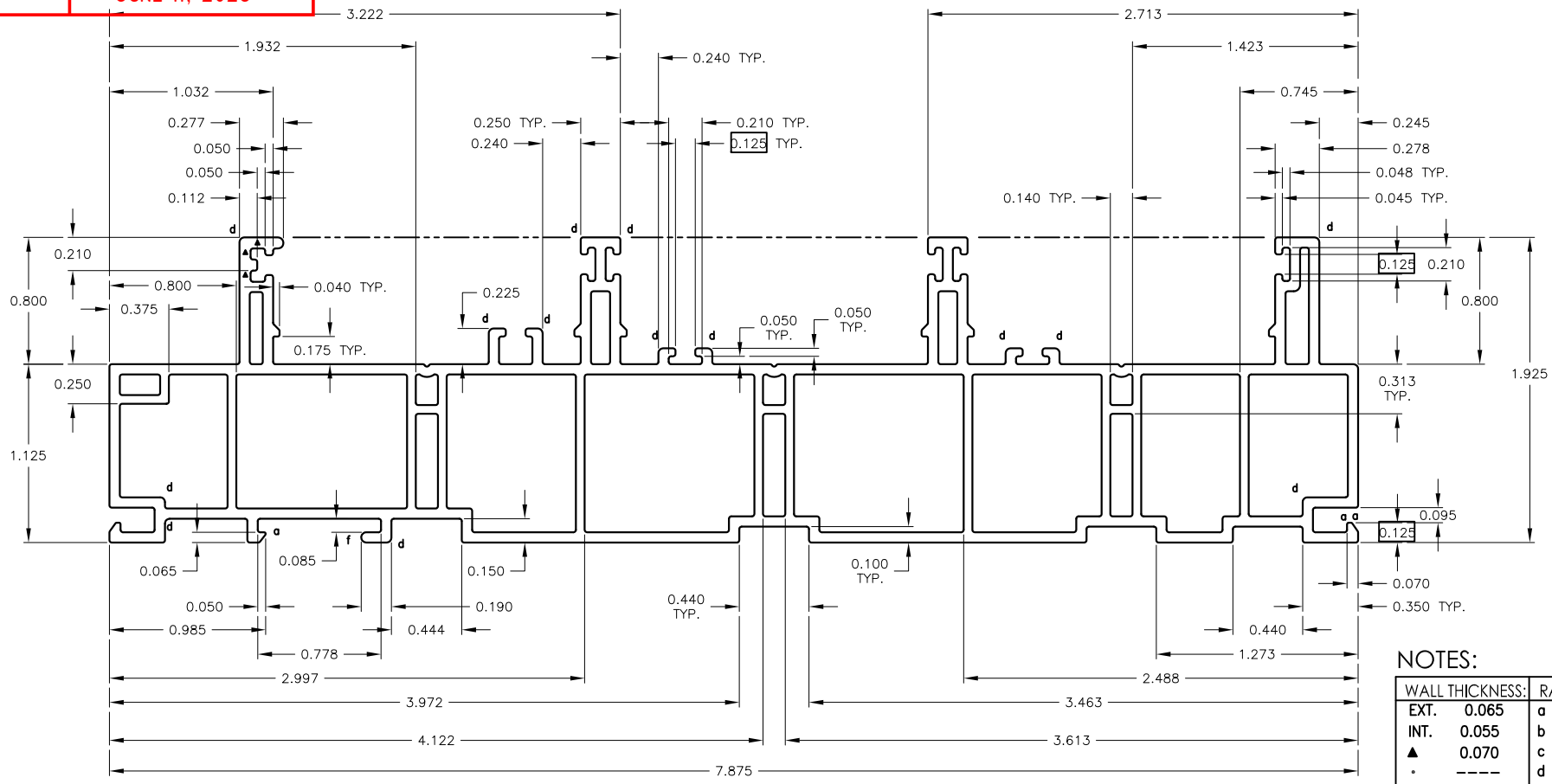


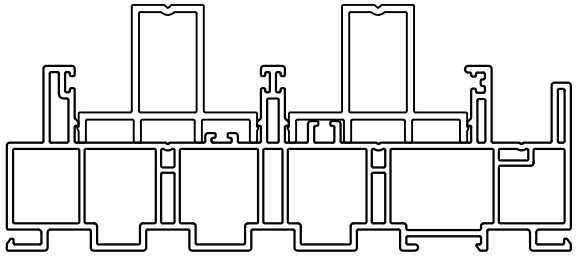
NOTES:

WALL THICKNESS:		RADII: UNMRAKED 0.015	
EXT.	0.065	a 0.010	f FULL
INT.	0.055	b 0.015	g 0.060
▲	0.070	c 0.020	h ----
•	----	d 0.030	i ----
		e 0.040	m MINIMUM RAD

TOLERANCES:		SECTION DETAILS:	
DIMENSIONS:	+/- 0.015 UNLESS SPECIFIED	AREA (RIGID):	----
WALL THICKNESS:	+/- 0.005 UNLESS SPECIFIED	AREA (FLEX):	N/A
COMPONENT WEIGHT:	+/- 5%	WIEGHT (TOTAL):	----
⌖	INTERSECTION	MATERIAL:	
	CRITICAL +/- 0.010	HATCHED AREA:	RIGID PVC
		FILLED AREA:	FLEX PVC

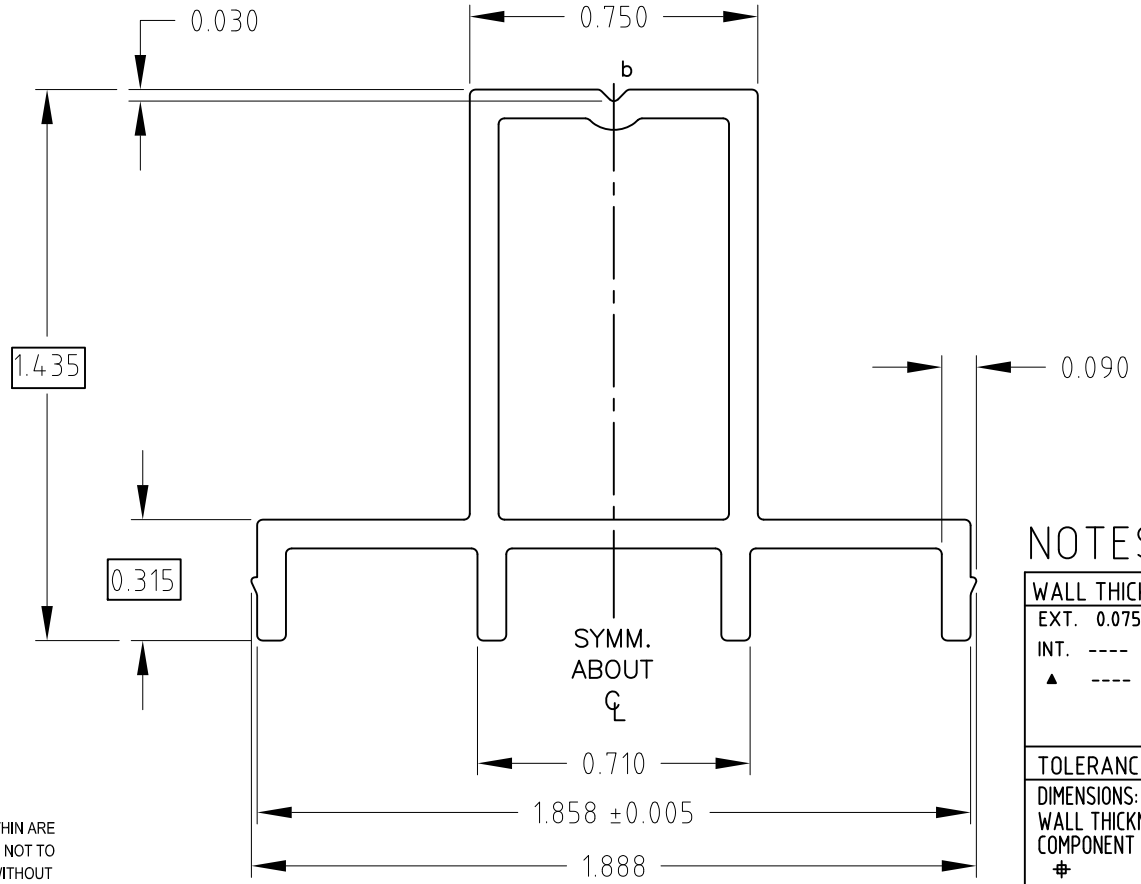
Title: 3 TRACK DOOR JAMB	Scale: 2:1	Designed By: CDF	Dwg. No.:	Die No.: V483
Customer:	Date: 27-MAY-20	Drawn By: CDF	Material: PVC	Prog .No.:

vinylcraft extrusions



RevNo	Revision note	Date	Signature	Checked
1	HEIGHT INCREASED TO SUIT TRUTH HARDWARE 3 PT. LOCK	31-AUG-22		
2	SCREW BOSS LEGS REMOVED	9-NOV-22		
3	SNAP HOOK WIDTH REDUCED	28-APR-23		
3	SNAP HOOK WIDTH REDUCED	7-MAY-24		

CHECK WITH V475 & V483
ON ALL TRACKS – EASY FIT



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Verified By:	
Date:	JUNE 11, 2025

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NOTES:

WALL THICKNESS:	RADII: UNMRAKED 0.015	
EXT. 0.075	a 0.010	f FULL
INT. ----	b 0.020	g ----
▲ ----	c 0.030	h ----
	d 0.060	i ----
	e ----	m MIN RAD

TOLERANCES:
DIMENSIONS: +/- 0.015 UNLESS SPECIFIED
WALL THICKNESS: +/- 0.005 UNLESS SPECIFIED
COMPONENT WEIGHT: +/- 5%
⌖ INTERSECTION
▭ CRITICAL +/- 0.010

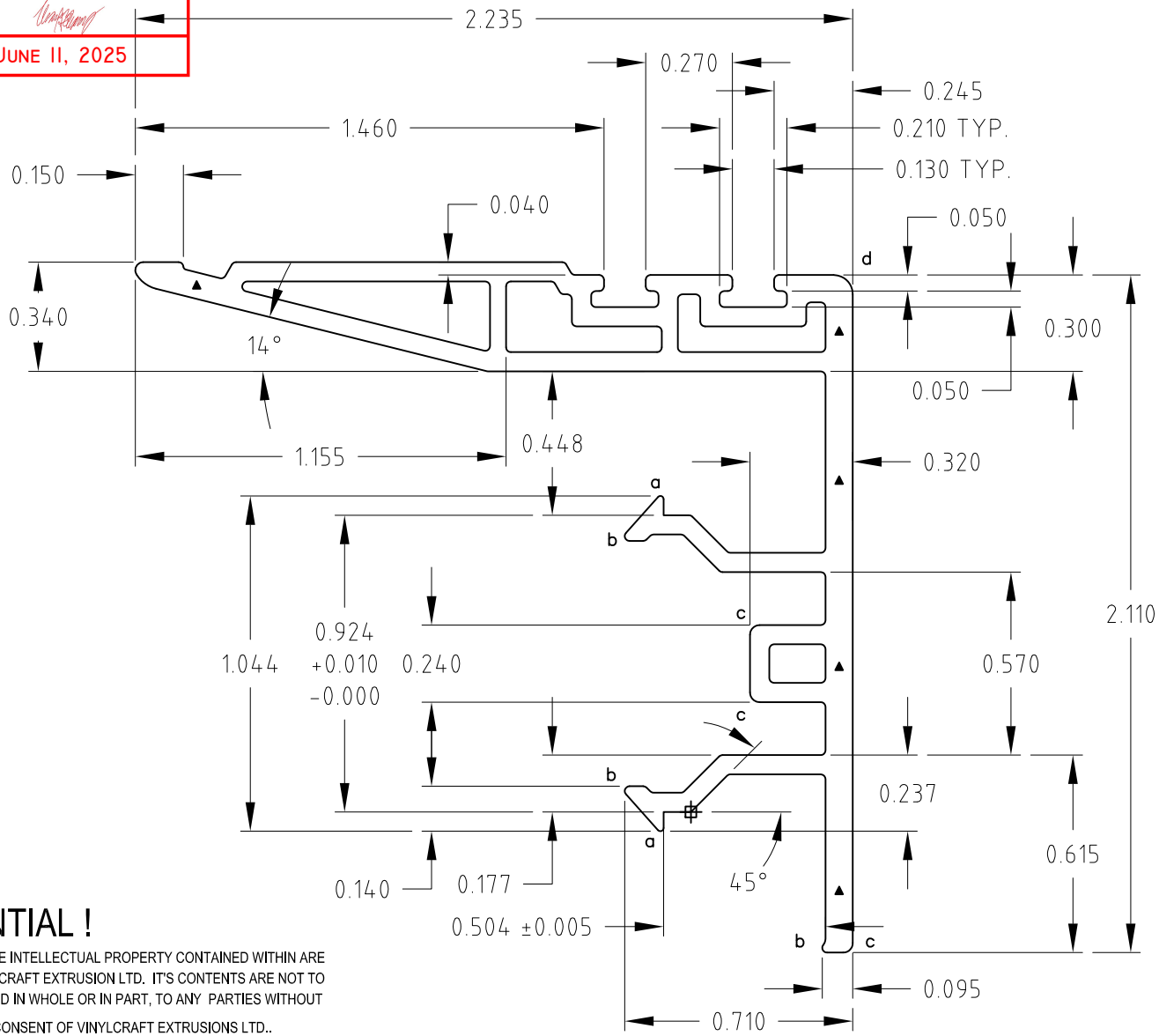
Title: JAMB ADAPTOR	Scale: 2:1	Designed By: CDF	Dwg. No.:	Die No.: V941
Customer:	Date: 23–MAR–21	Drawn By: CDF	Material: PVC	Prog .No.:

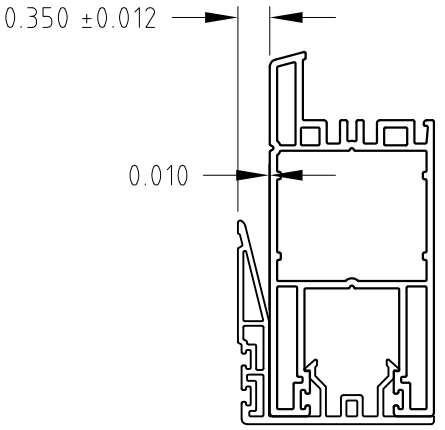
vinylcraft extrusions

Canadian Building Envelope Science and Technology
CAN-BEST
This document forms part of:

Report No.:	L25-926-7423
Verified By:	
Date:	JUNE 11, 2025

RevNo	Revision note	Date	Signature	Checked
1	SNAP HOOKS INCREASED 0.015 FOR BETTER RETENTION	31-JULY-24		





CHECK WITH V058
ON BOTH SIDES

NOTES:

WALL THICKNESS:	RADII: UNMRAKED 0.015	
EXT. 0.060	a 0.010	f FULL
INT. 0.050	b 0.015	g ----
▲ 0.080	c 0.030	h ----
	d 0.060	i ----
	e ----	m MINIMUM RAD

TOLERANCES:

DIMENSIONS: +/- 0.015 UNLESS SPECIFIED
WALL THICKNESS: +/- 0.005 UNLESS SPECIFIED
COMPONENT WEIGHT: +/- 5%
⌖ INTERSECTION
CRITICAL +/- 0.010

CONFIDENTIAL !

Title:	Scale:	Designed By:	Dwg. No.:	Die No.:
INTERLOCK	2:1	CDF		V936
Customer:	Date:	Drawn By:	Material:	Prog .No.:
	23-MAR-21	CDF	PVC	

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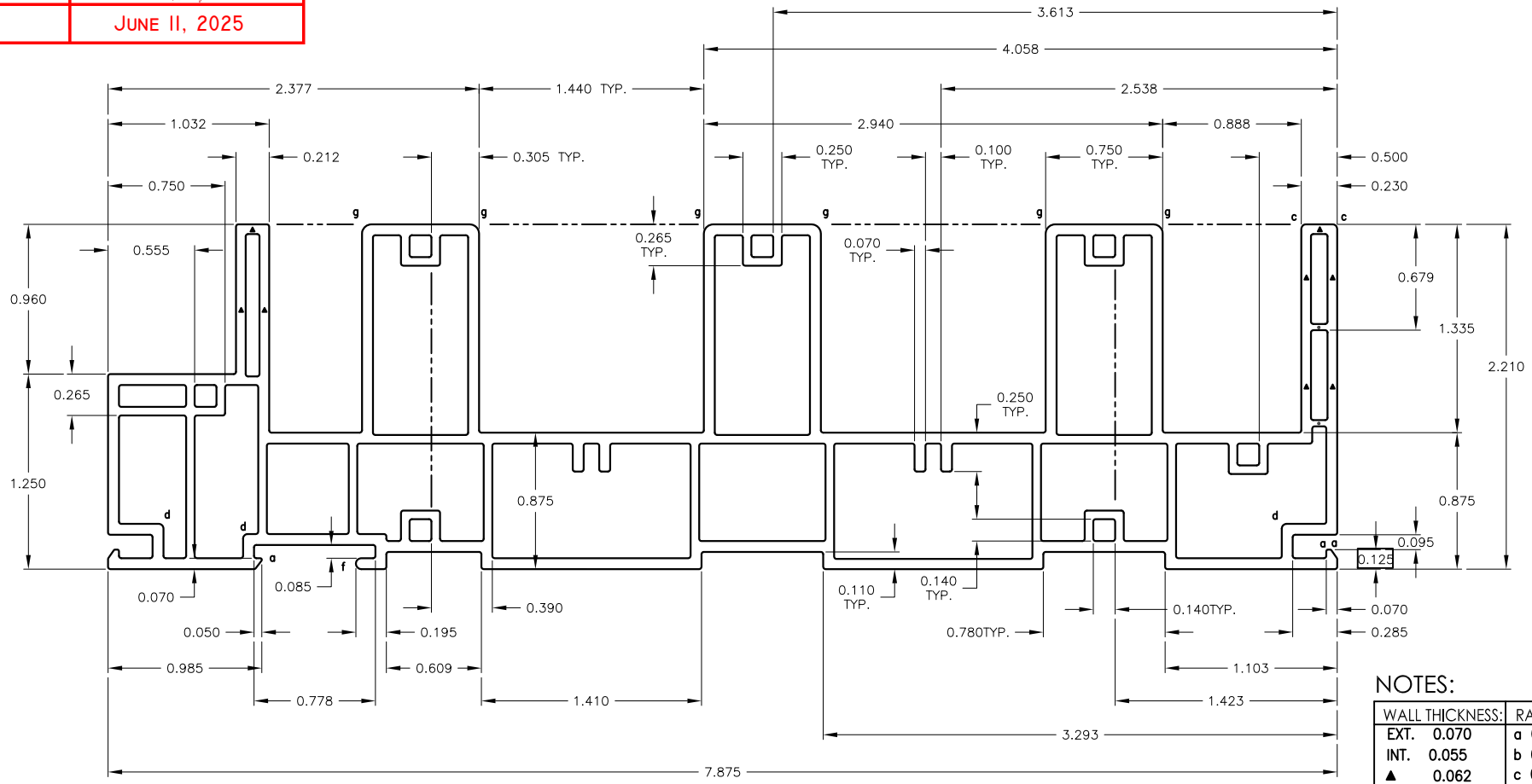


NOTES:

WALL THICKNESS:		RADII: UNMRAKED 0.015	
EXT.	0.070	a 0.010	f FULL
INT.	0.055	b 0.015	g 0.060
▲	0.062	c 0.020	h -----
•	0.040	d 0.030	i ----
		e 0.040	m MINIMUM RAD

TOLERANCES:		SECTION DETAILS:	
DIMENSIONS:	+/- 0.015 UNLESS SPECIFIED	AREA (RIGID):	----
WALL THICKNESS:	+/- 0.005 UNLESS SPECIFIED	AREA (FLEX):	N/A
COMPONENT WEIGHT:	+/- 5%	WIEGHT (TOTAL):	----
⌖	INTERSECTION	MATERIAL:	
	CRITICAL +/- 0.010	HATCHED AREA:	RIGID PVC
		FILLED AREA:	FLEX PVC

Title: 3 TRACK DOOR HEAD	Scale: 2:1	Designed By: CDF	Dwg. No.:	Die No.: V482
Customer:	Date: 5-JUNE-20	Drawn By: CDF	Material: PVC	Prog .No.:

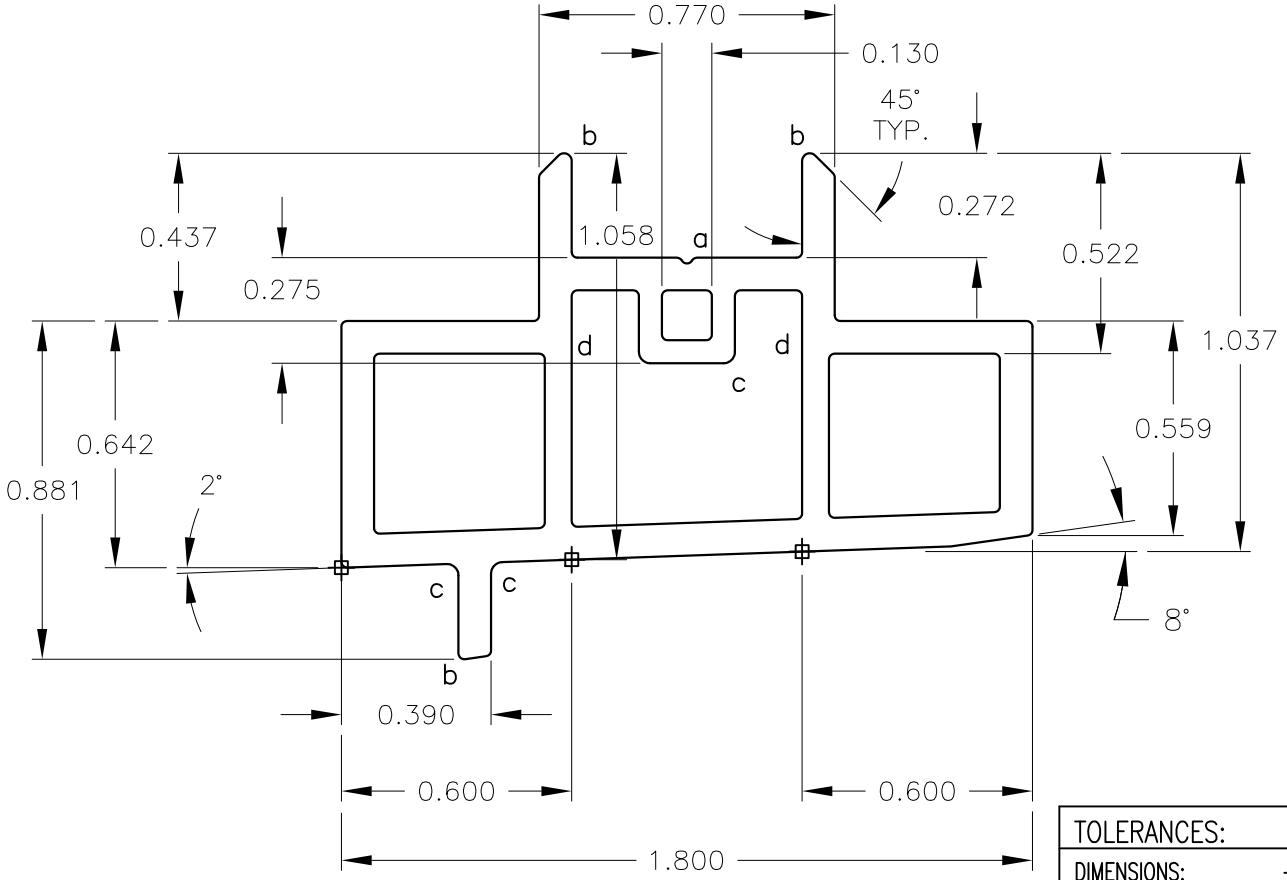
vinylcraft extrusions

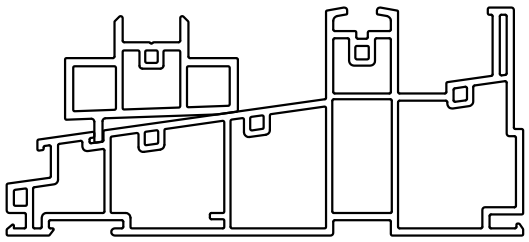
Canadian Building Envelope Science and Technology
CAN-BEST

This document forms part of:

Report No.:	L25-926-7423
Verified By:	
Date:	JUNE 11, 2025

RevNo	Revision note	Date	Signature	Checked
1	DIMENSION ADDED FOR CHECKING CLEARANCE WITH PUNCH TOOL	13-MAY-19		
2	INTERNAL WALLS REVISED FOR BETTER WEIGHT SUPPORT	13-JUNE-24		





CHECK FIT WITH V476

NOTES:

WALL THICKNESS:		RADII: UNMRAKED 0.015	
EXT.	0.085	a 0.015	f FULL
INT.	0.070	b 0.020	g ----
▲	----	c 0.030	h ----
		d 0.050	i ----
		e ----	m MINIMUM RAD

TOLERANCES:		SECTION DETAILS:	
DIMENSIONS:	+/- 0.015 UNLESS SPECIFIED	AREA (RIGID):	----
WALL THICKNESS:	+/- 0.005 UNLESS SPECIFIED	AREA (FLEX):	----
COMPONENT WEIGHT:	+/- 5%	WIEGHT (TOTAL):	----
⌖	INTERSECTION	MATERIAL:	
▭	CRITICAL +/- 0.005	HATECHED AREA:	RIGID PVC
		FILLED AREA:	FLEX PVC

CONFIDENTIAL !

Title:	Scale:	Designed By:	Dwg. No.:	Die No.:
FIXED PANEL SUPPORT	2:1	CDF		V838
Customer:	Date:	Drawn By:	Material:	Prog .No.:
	16-NOV-16	CDF	PVC	

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