



4705

Certificate for the UL Mark – Enhanced Security Performance of Windows PAS 24:2016

Section 1 – Certification details:

Customer Name:	Alumil S.A.	Certification Body:	UL International (UK) Ltd
Fabrication Address:	Kilkis Industrial Area, 61100, Kilkis, Greece	Certification Body Address:	Halesfield 2, Telford, Shropshire, TF7 4QH, United Kingdom
Certification Scheme:	Enhanced Security Performance of Windows PAS 24:2016	Certificate Number:	BP21293-1
Date of Commencement:	17/01/2022	Date of Expiry:	16/01/2025
Certificate Compiled by:	Mark Swanborough Certification Leader	Certificate Approved by:	Michael Wass Engineering Manager
Signed:		Signed:	

Section 2 - Products covered by this certificate:

System type and configurations:

System	Range of Configurations	Opening Direction	Maximum Size (HxW)
Alumil S67 and S77 window systems	Tilt before turn Window Tilt & Turn Window Side Hung	Open In Open In Open In	2200 mm x 1100 mm 2200 mm x 1100 mm 2200 mm x 1100 mm

Extrapolation rules - Assuming identical hardware is fitted as specified in this certificate, the products listed are covered up to the maximum sizes stated above and down to a 50% reduction in height and/or width.

Section 3 - Supporting test documentation:

Initial Type Testing:

Product	Variant tested	BS 6375-1:2009		BS 6375-2:2009		BS 6375-3:2009		PAS 24:2016	
Alumil S67 and S77 window systems	Tilt before turn Window	Test	Class	Test	Class	Test	Class	Test	Class
		Weathertightness	2000+	Mechanical Cyclic operation	4 2	N/A	-	Annex C	W
	S77 Low threshold	Weathertightness	1200	Operating forces	1				
	S67 Low threshold	Weathertightness	2000						

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Annex A – Alumil S.A. – S77 Window Product Details

Outer Frame		
	Part No. / Material	Dimension (H x W mm)
Frame Profile	Aluminium profiles with thermal break	51, 61, 71, 81.5, 99, 113 mm x 77 mm
	Top - S77508, S77510, S77514, S77814, S77886, S77906	-
	Bottom - S77508, S77510, S77514, S77814, S77886, S77906	-
	Lock side - S77508, S77510, S77514, S77814, S77886, S77906	-
	Hinge side - S77508, S77510, S77514, S77814, S77886, S77906	-
Reinforcing	-	-
Threshold	(Low Threshold Profile) S77684	-
Gasket	Co-extruded EPDM- EPDM foam and Epdm - Central gasket, External frame gasket - 210-77-223-03, 220-11-001-01	-
Jointing Method	Mitred and bonded using corner cleats	-

Leaf		
	Part No. / Material	Dimension (H x W mm)
Leaf Profile	Aluminium	73, 95.8, 110 mm x 85 mm
	Top - S77544, S77552, S77936, S77938	-
	Bottom - S77544, S77552, S77936, S77938	-
	Lock side - S77544, S77552, S77936, S77938	-
	Hinge side - S77544, S77552, S77936, S77938	-
Reinforcing	-	-
Midrail	-	-
Gasket	EPDM - Sash gasket - 220-60-002-01	-
Jointing Method	Mitred and bonded using corner cleats	-

Glazing & Infill		
	Description / Part No. / Material	-
Glass Configuration	At least 1 pane must be class P1A according to BS EN 356	-
Bead	Alumil SA - Safety glazing bead - S60433	26.4 x 34.5 mm
Gasket	EPDM - External glass gasket – 200-06-860-01	-
Glazing Clip	Internal glass gasket - 200-08-005-01	-

Hardware		
	Part No. / Material	Fixings
Handle	Handle with spindle and key – 416-07-529-02	2 x screws M10 x 32
Hinges	415-19772	As supplied
Drip Bar	Alumil - Drip bar - S61317	4,2 x 19 self-tapping screws
Lock	Security strike plate - 415-37-254-00	4 x self- tapping screws

Annex B – Alumil S.A. – S67 Window Product Details

Outer Frame		
	Part No. / Material	Dimension (H x W mm)
Frame Profile	Aluminium profiles with thermal break	51, 61, 71, 81.5, 99, 113 mm x 67 mm
	Top - S67508, S67510, S67514, S67814, S67886, S67906, S67908	-
	Bottom - S67508, S67510, S67514, S67814, S67886, S67906, S67908	-
	Lock side - S67508, S67510, S67514, S67814, S67886, S67906, S67908	-
	Hinge side - S67508, S67510, S67514, S67814, S67886, S67906, S67908	-
Reinforcing	-	-
Threshold	(Low Threshold Profile) S67684	-
Gasket	Co-extruded EPDM- EPDM foam and Epdm - Central gasket, External frame gasket - 210-77-223-03, 220-11-001-01	-
Jointing Method	Mitred and bonded using corner cleats	-

Leaf		
	Part No. / Material	Dimension (H x W mm)
Leaf Profile	Aluminium	73, 95.8, 110 mm x 75 mm
	Top - S67544, S67552, S67936, S67938, S67994	-
	Bottom - S67544, S67552, S67936, S67938, S67994	-
	Lock side - S67544, S67552, S67936, S67938, S67994	-
	Hinge side - S67544, S67552, S67936, S67938, S67994	-
Reinforcing	-	-
Midrail	-	-
Gasket	EPDM - Sash gasket - 220-60-002-01	-
Jointing Method	Mitred and bonded using corner cleats	-

Glazing & Infill		
	Description / Part No. / Material	-
Glass Configuration	At least 1 pane must be class P1A according to BS EN 356	-
Bead	Alumil SA - Safety glazing bead - S60433	26.4 x 34.5 mm
Gasket	EPDM - External glass gasket – 200-06-860-01	-
Glazing Clip	Internal glass gasket - 200-08-005-01	-

Hardware		
	Part No. / Material	Fixings
Handle	Handle with spindle and key – 416-07-529-02	2 x screws M10 x 32
Hinges	Alumil - 415-19772-00	As supplied
Drip Bar	Alumil - Drip bar - S61317	4,2 x 19 self-tapping screws
Lock	Security strike plate - 415-37-254-00	4 x self- tapping screws