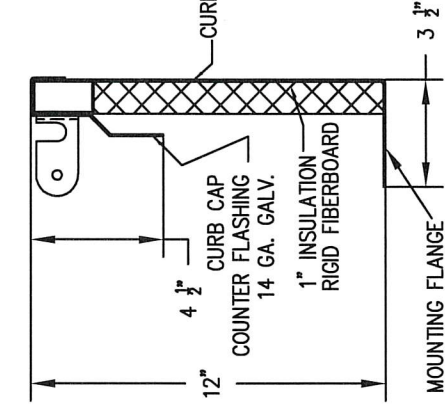
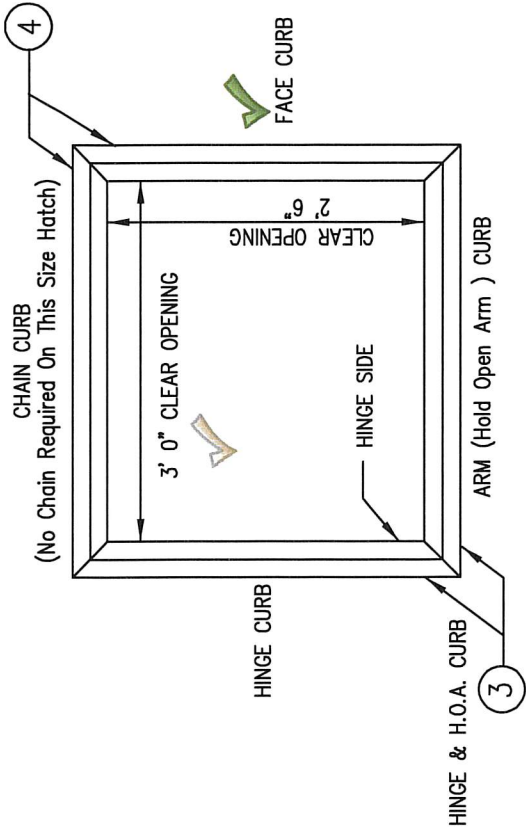


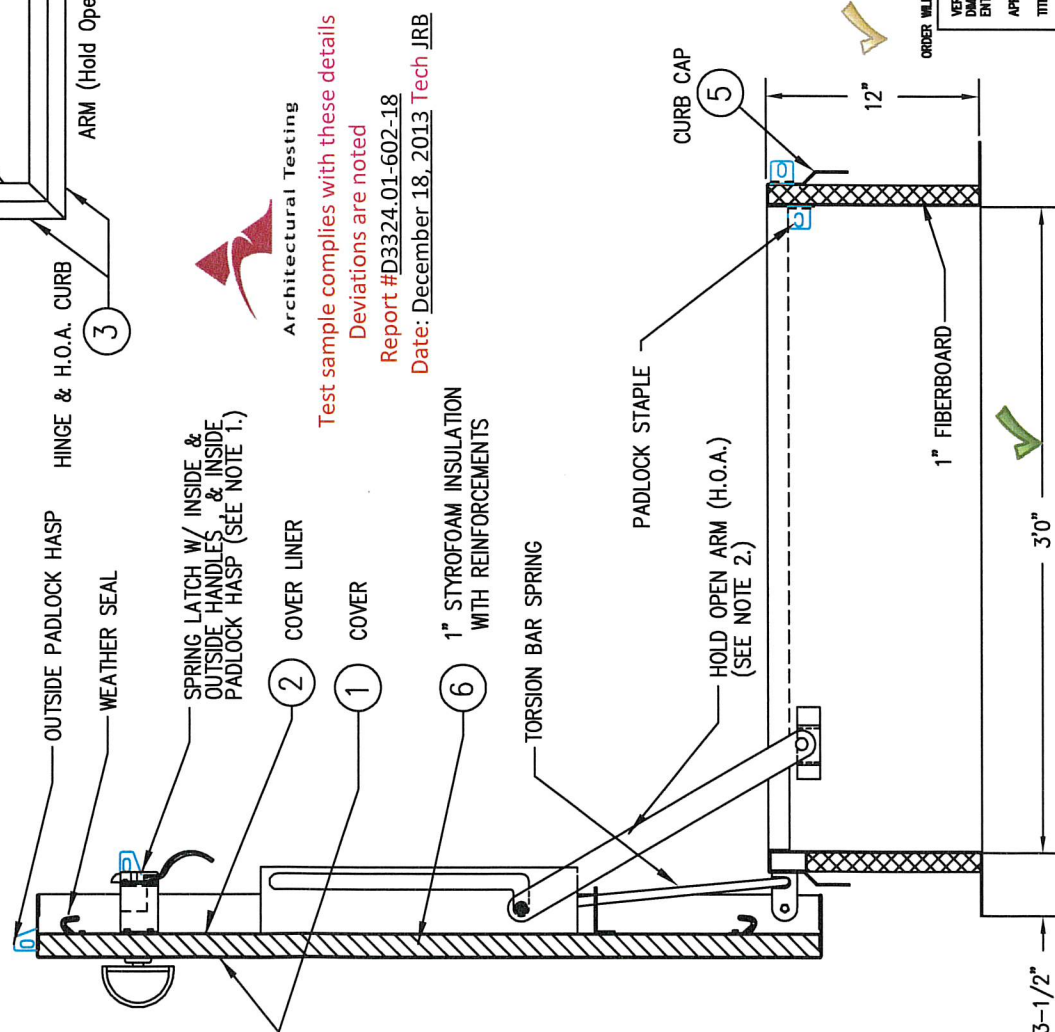
MATERIAL SCHEDULE		
COVER	CURB	PRIMED STEEL
X	X	GALV. PRIMED STEEL
		ALUMINUM

NOTES:

1. LOCATE LATCH & LATCH LOCK SUPPORT UNDER COVER. DRILL (4) LETTER "F" HOLES, ATTACH BRACKET, PRE-DRILL HANDLE GUIDE HOLE FROM OUTSIDE.
2. LINE UP HOLD OPEN ARM AND MECHANISM ON UNIT. MARK AND ATTACH.
3. FOR COVER REINFORCEMENT, SEE SHEAR CARD 7.



SECTIONAL VIEW OF M-1 ROOF HATCH CURB



Architectural Testing
Test sample complies with these details
Deviations are noted
Report #D3324.01-602-18
Date: December 18, 2013 Tech JRB

M-1 ROOF HATCH		
MATERIAL SCHEDULE		
QUANTITY	SIZE	COVER FRAME
	30" X 26"	14 GA. 14 GA.

MILCOR

COMMERCIAL PRODUCTS GROUP
848 Thomas Drive
Bensenville, IL 60108
phone: (630) 624-8642
fax: 1-630-766-5259

ORDER WILL NOT BE RELEASED FOR FABRICATION UNTIL SIGNED COPY IS RECEIVED.

VERIFICATION AND APPROVAL OF GENERAL ARRANGEMENT AND OVERALL DIMENSIONS OF THIS DOCUMENT ARE REQUIRED BEFORE THE ORDER IS ENTERED FOR MANUFACTURING.

APPROVAL SIGNATURE _____

TITLE HELD _____

DATE OF APPROVAL _____

DEALER _____

PROJECT _____

LOCATION _____

ARCH. _____

CONTD _____

DATE: _____

DRAWN BY: LEK

JOB NO. _____

SHEET _____

M-1 ROOF HATCH FASTENER SCHEDULE		
Description of Parts/Location	Fastener type and qty.	Spacing of fasteners
Cover liner to exterior cover	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 8	2 each outside corner
Latch support to cover interior	BOLT, HEX HD 5/16-18X3/4 S-TAP Qty. 4	N/A
Latch to latch support	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 4	N/A
Exterior latch handle to cover	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 4	N/A
Torsion bar to curb & cover	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 12	N/A
Gasket to cover liner	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 15	8"-12"
Hold open arm bracket to curb	BOLT, HEX HD 5/16-18X3/4 S-TAP Qty. 2	N/A
Hold open arm bracket to cover	BOLT, HEX HD 5/16-18X3/4 S-TAP Qty. 3	N/A
Hold open arm to curb bracket	BOLT, HEX HD 5/16-18 X 1 Qty. 1	N/A
Hold open arm to curb bracket	NUT, ESNA HEX 5/16-18 Qty. 1	N/A
Cover to hinge	BOLT, HEX HD 5/16-18 X 1 Qty. 2	N/A
Cover to hinge	WASHER, FLAT 5/16 Qty. 2	N/A
Cover to hinge	NUT, ESNA HEX 5/16-18 Qty. 2	N/A
Padlock staple to curb	SCRW, HX WASH HD TEK 10-16X3/4 Qty. 3	N/A



Architectural Testing

Test sample complies with these details

Deviations are noted

Report #D3324.01-602-18

Date: December 18, 2013 Tech JRB

1

Diagram illustrating a cross-shaped reinforcement layout with dimensions and callouts:

- Top horizontal dimension: $3-1/8"$
- Right vertical dimension: $3-1/8"$
- Bottom horizontal dimension: $3-1/8"$
- Left vertical dimension: $3-1/8"$
- Top horizontal offset: $5/8$
- Right vertical offset: $5/8$
- Bottom horizontal offset: $5/8$
- Left vertical offset: $5/8$
- Top horizontal callout: $41-7/16$ (with a green checkmark)
- Right vertical callout: $34-1/16$ (with a green checkmark)

Architectural Testing

Test sample complies with these details
Deviations are noted
Report # D3324.01-602-18

Technical drawing of a mechanical part, likely a bracket or flange, showing dimensions and tolerances. The drawing includes a side view and a top view.

Dimensions and Tolerances:

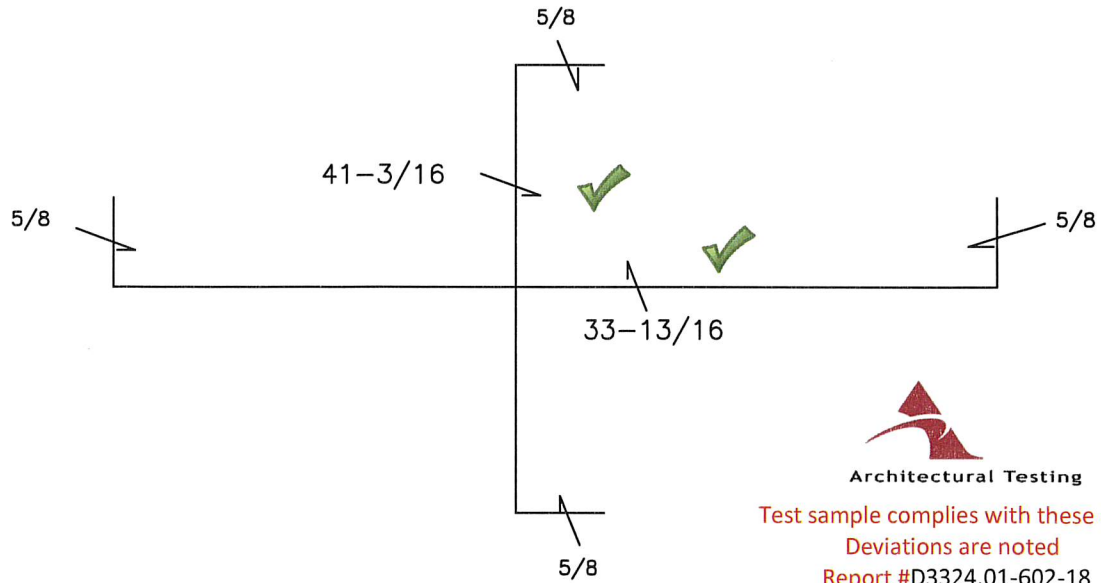
- Top view (horizontal):
 - Overall width: $3\frac{3}{4}$ "
 - Distance from left edge to centerline: $3\frac{3}{4}$ "
 - Distance from centerline to right edge: $3\frac{3}{4}$ "
- Side view (vertical):
 - Overall height: $3\frac{3}{4}$ "
 - Distance from top edge to centerline: $3\frac{3}{4}$ "
 - Distance from centerline to bottom edge: $3\frac{3}{4}$ "
- Internal features:
 - Two vertical slots: 180 UP TYP. (2) and 90 UP TYP. (2)
 - Two horizontal slots: 180 UP TYP. (2) and 90 UP TYP. (2)
- Other dimensions:
 - Distance from left edge to centerline: $5/8$ TYP. (4)
 - Distance from centerline to right edge: $5/8$ TYP. (4)
 - Distance from top edge to centerline: $1/2$

COVER LINER

M-3'x2'6"

HATCH

2



Architectural Testing

Test sample complies with these details

Deviations are noted

Report #D3324.01-602-18

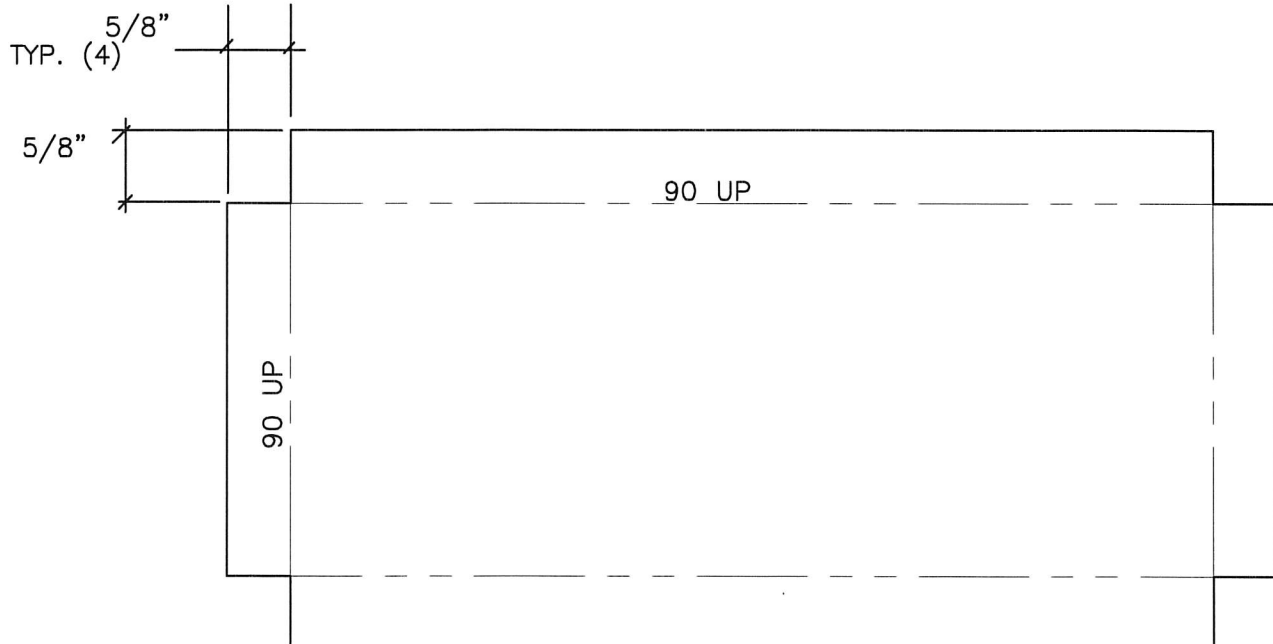
Date: December 18, 2013 Tech JRB

GAGE

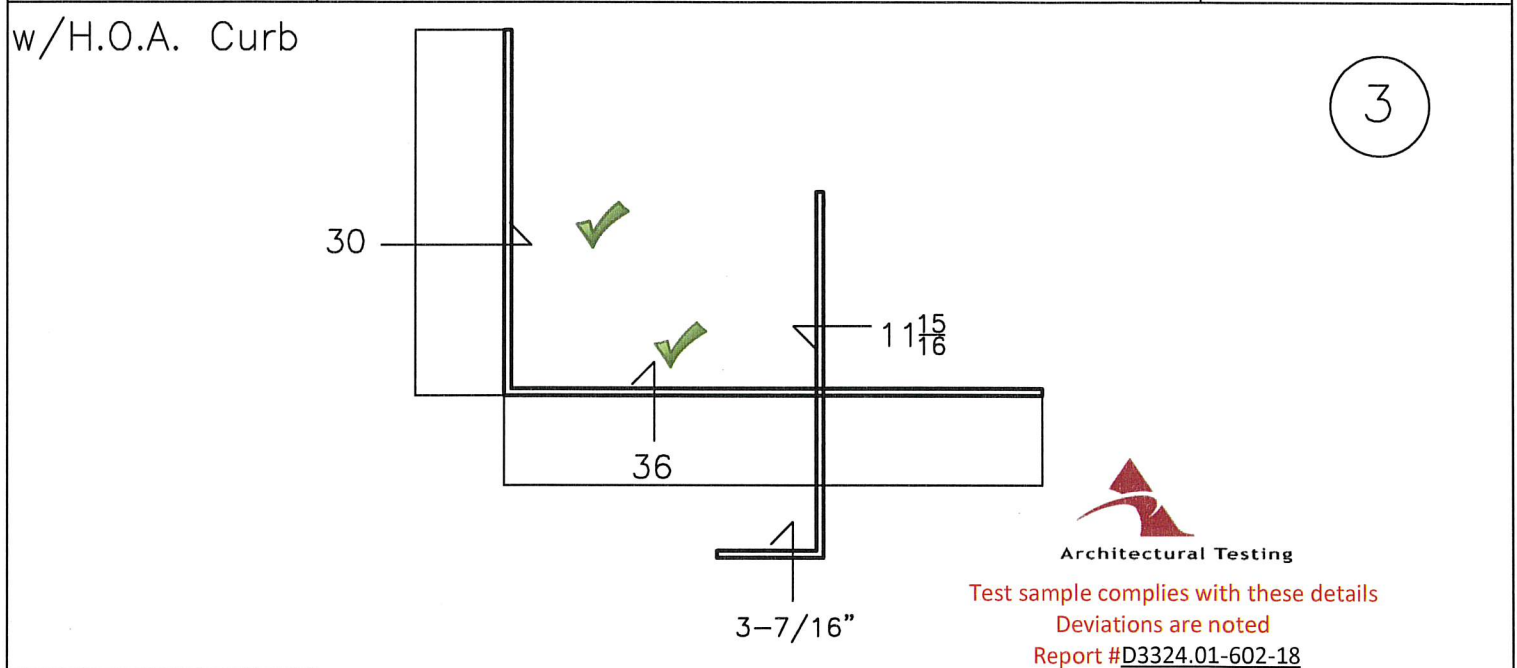
22

GALV.

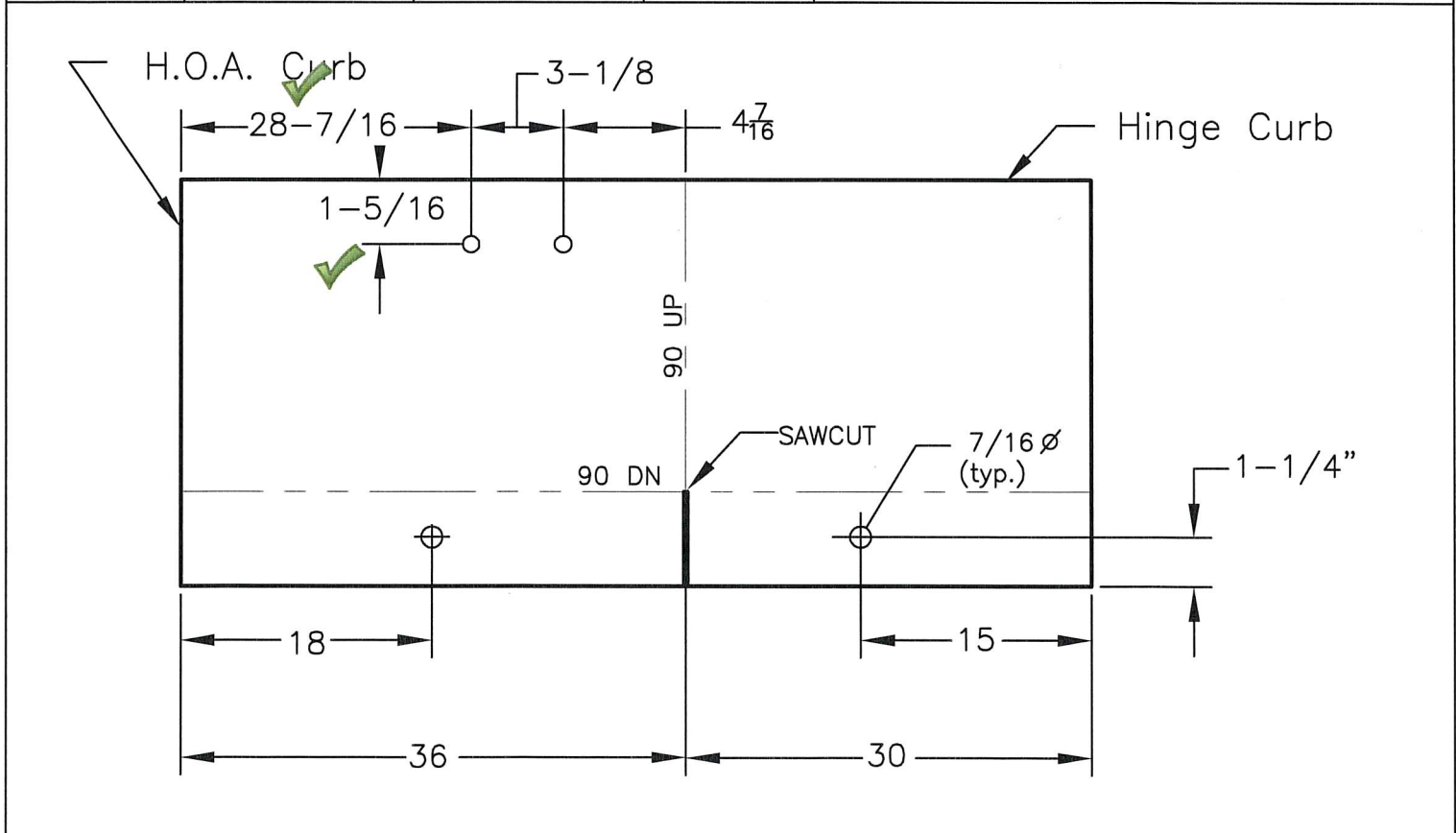
PCS. REQ'D.	SHEAR		ORDER NUMBER	NOTES
	WIDTH	HEIGHT		
1	$35-1/16$	$42-7/16$		



HINGE CURB	M1-3'X2'6"	HATCH
------------	------------	-------



GAGE	14	GALV.		
PCS. REQ'D.	SHEAR		ORDER NUMBER	NOTES
	WIDTH	HEIGHT		
1	66	15-3/8		



w/Side Curb

4

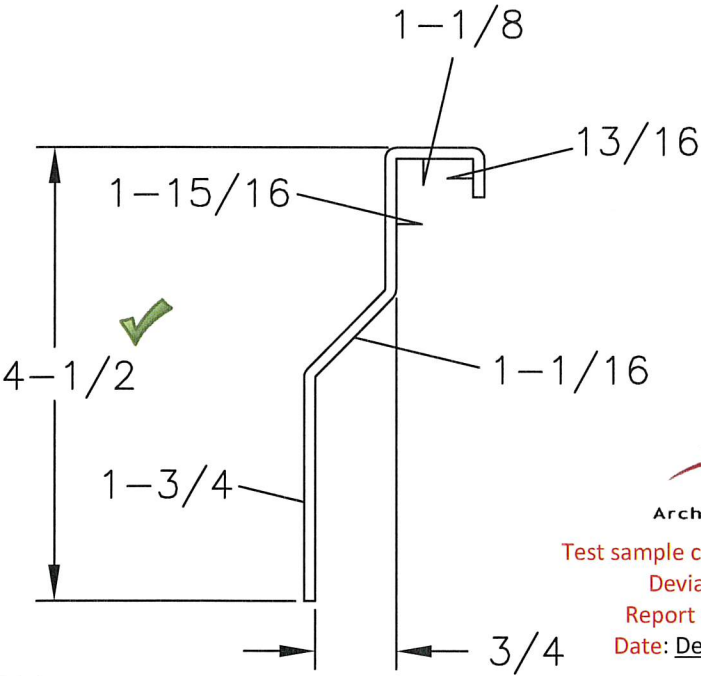
The diagram shows a cross-section of a curb and gutter. The curb height is 30 inches, marked with a green checkmark. The gutter width is 36 inches, also marked with a green checkmark. The gutter depth is 11 15/16 inches. The gutter is shown with a 5/8 inch wide curb. The diagram is labeled 'w/Side Curb'.

Architectural Testing

Test sample complies with these details
Deviations are noted
Report #D3324.01-602-18

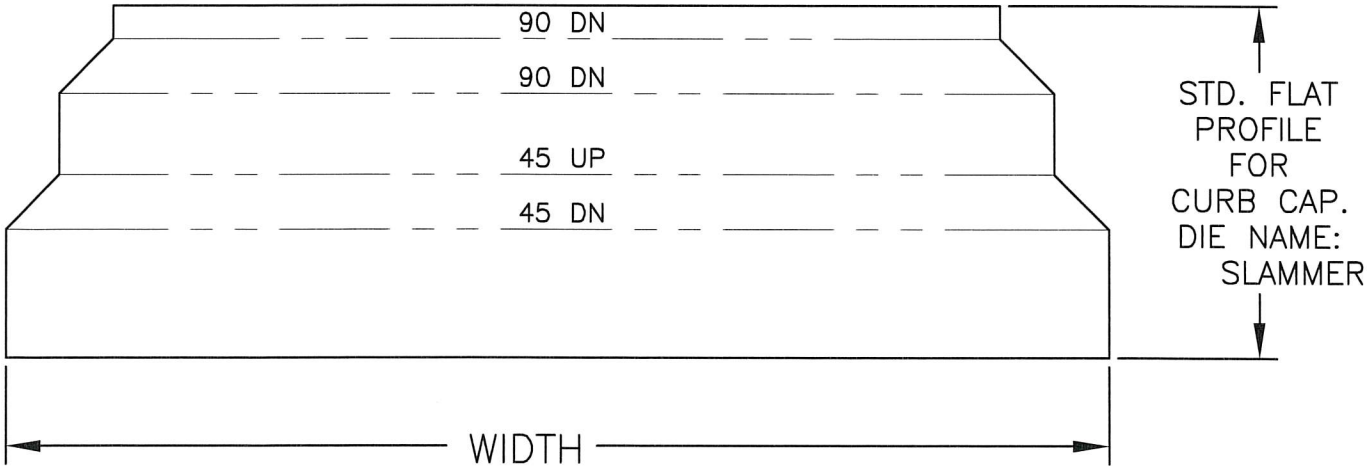
Technical drawing of a concrete curb cross-section. The drawing shows a rectangular curb with a total width of 36 inches and a total height of 1-1/4 inches. The curb is divided into two sections by a vertical line labeled "90 UP" and "90 DN". The left section has a width of 18 inches and a height of 1-1/4 inches. The right section has a width of 15 inches and a height of 1-1/4 inches. The right section has a notch at the top with a width of 1-1/2 inches and a depth of 1-1/8 inches. The notch is labeled "1-1/8" and "9 11/16". The curb is labeled "Side Curb" and "Face Curb". A "SAWCUT" is indicated at the bottom center. Two circular holes are shown, one in each section, with a diameter of 7/16 inches (typical). The distance from the left face to the first hole is 36 inches, and from the second hole to the right face is 30 inches.

5

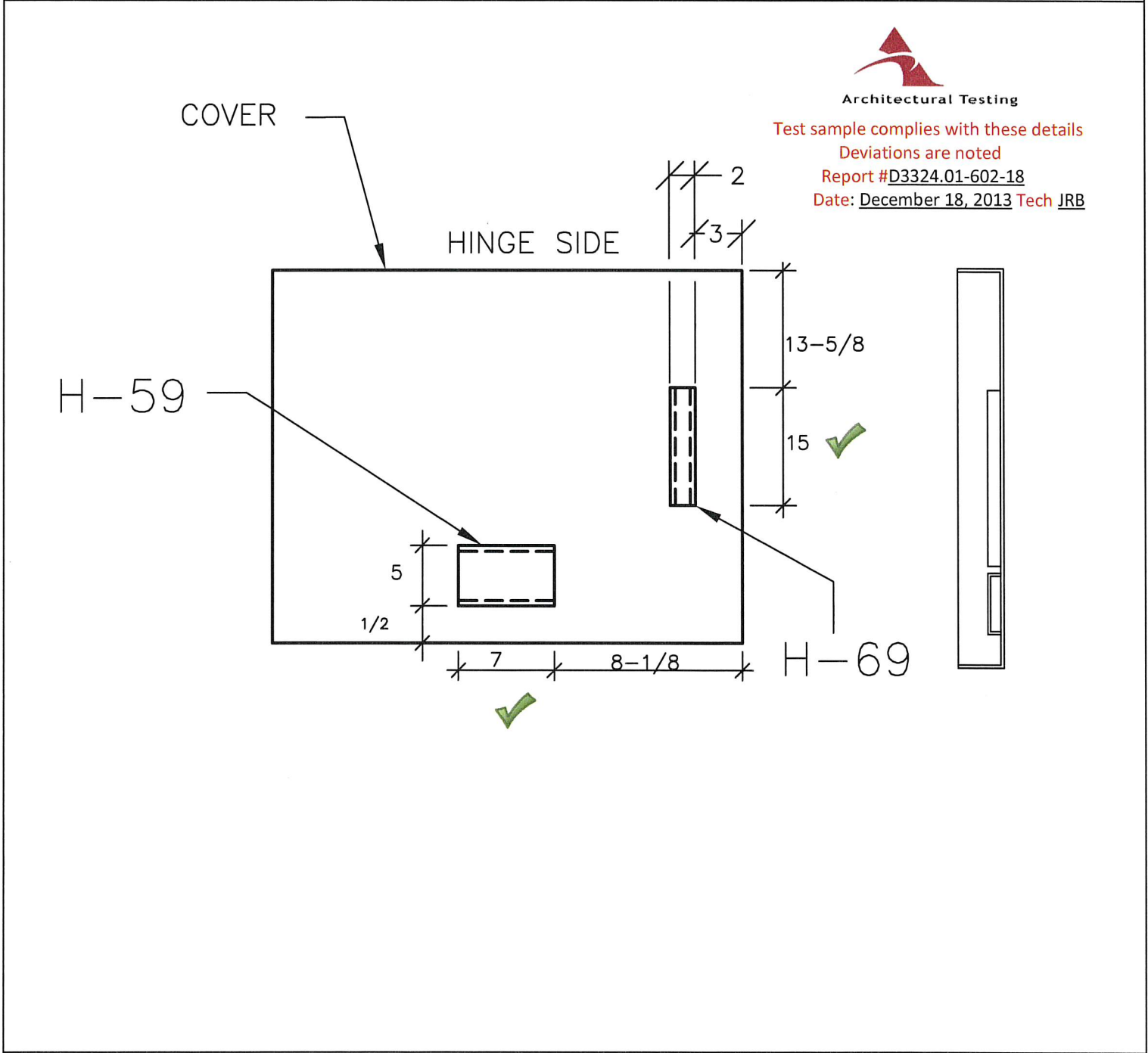


Architectural Testing
 Test sample complies with these details
 Deviations are noted
 Report #D3324.01-602-18
 Date: December 18, 2013 Tech JRB

GAGE	14	GALV.			
PCS. REQ'D.	SHEAR		ORDER NUMBER	NOTES	
	WIDTH	HEIGHT			
2	39-11/16	6-5/8			
2	33-11/16	6-5/8			

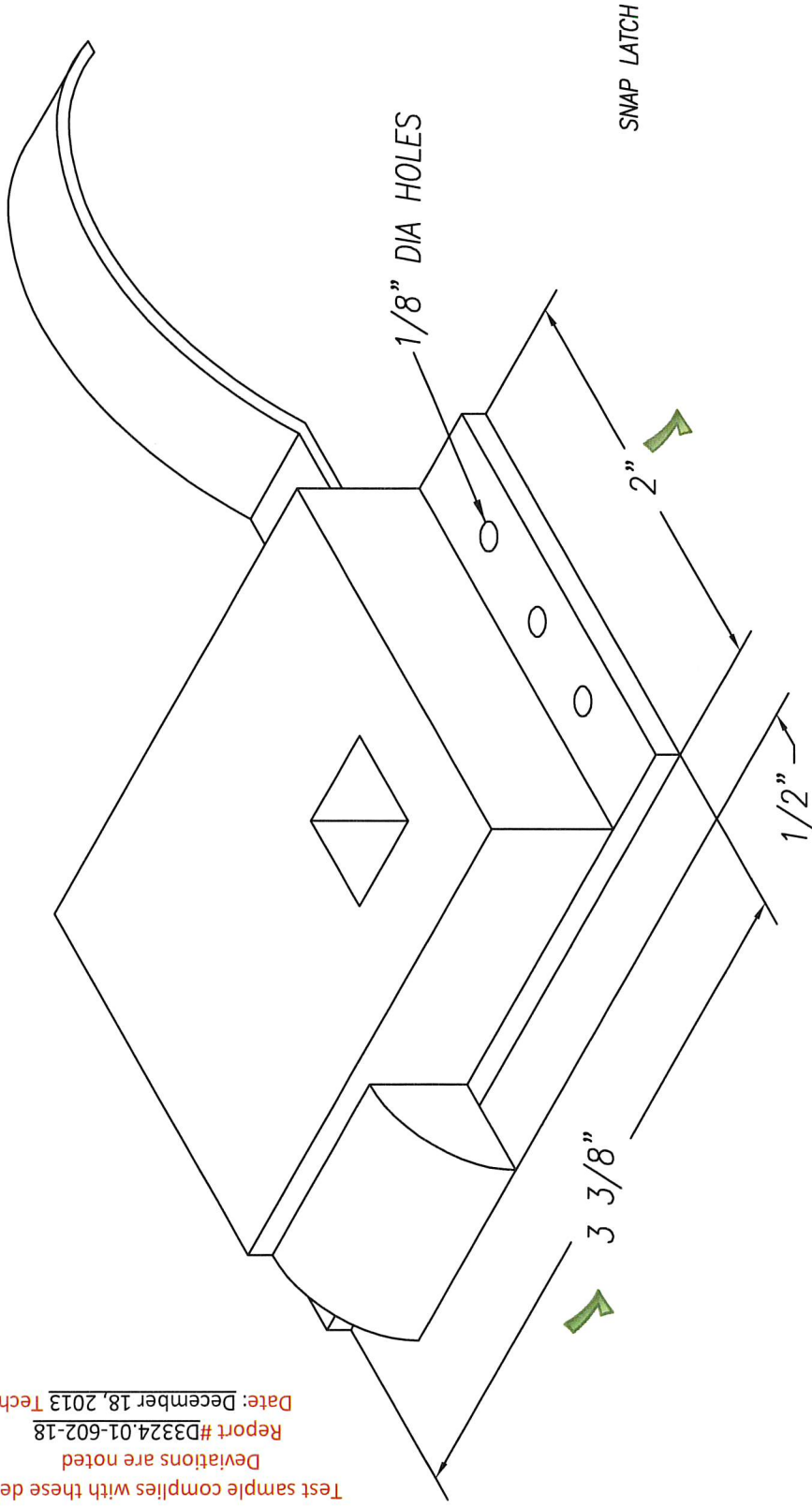


GAGE	14	GALV.			
PCS. REQ'D.	WIDTH	LENGTH	ORDER NUMBER	NOTES	
1				H-69	
1				H-59	



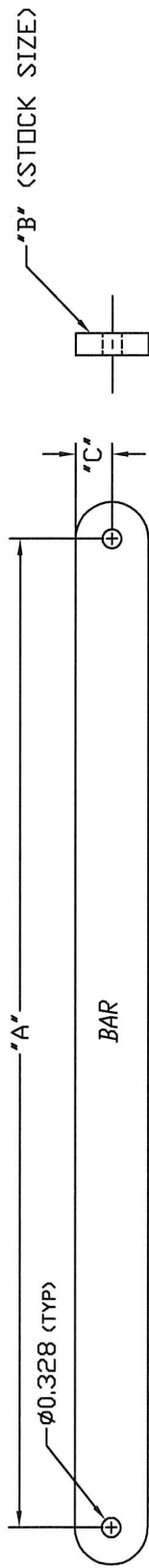
Test sample complies with these details
Deviations are noted
Report #D33324.01-602-18
Date: December 18, 2013 Tech JRB

Architectural Testing



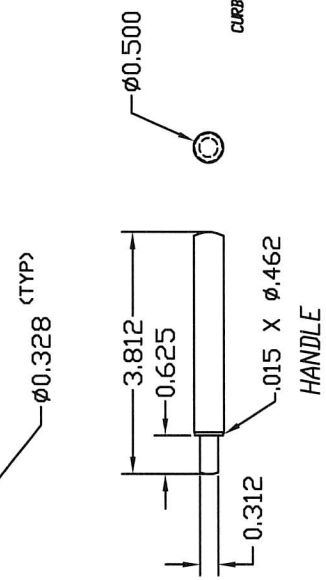
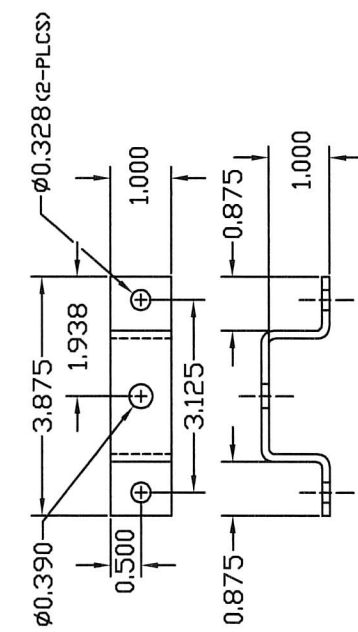
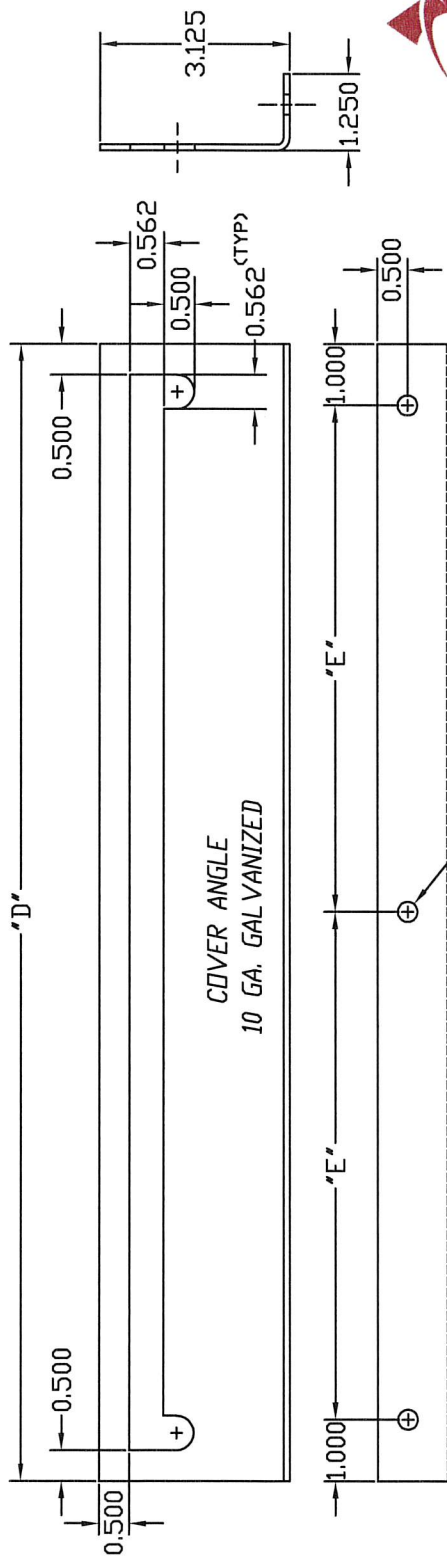
Xref A-MILCOR

31-11-15-040



HOLD OPEN ARM

ASSEMBLY



Architectural Testing

Test sample complies with these details
 Deviations are noted
 Report # D3324-01-602-18
 Date: December 18, 2013 Tech JRB

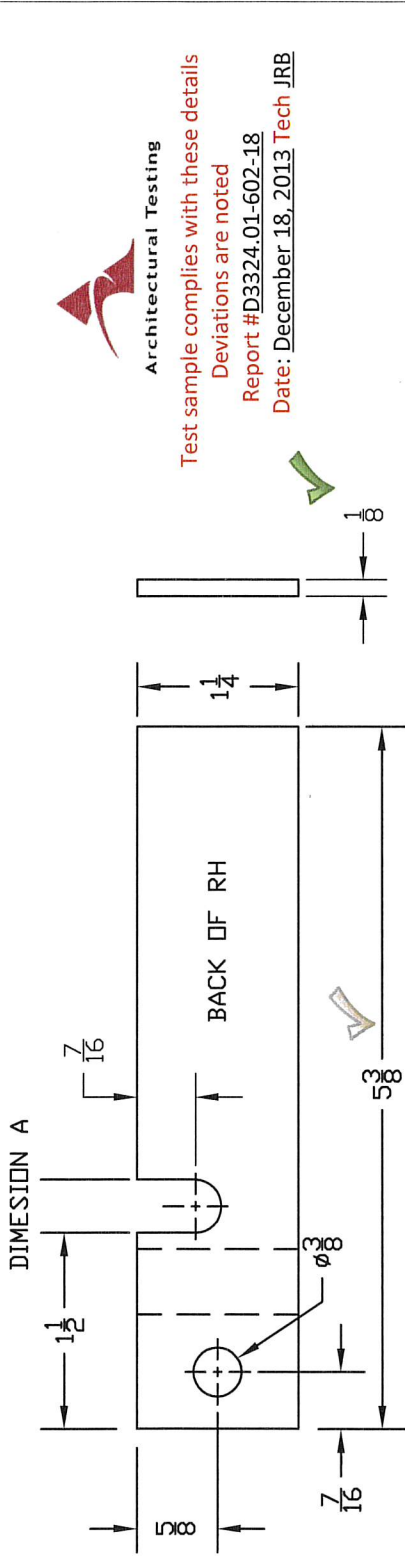


NOTE: ASSEMBLE HANDLE TO BAR AND CHROME PLATE.

PART NUMBER	UNIT WIDTH	BAR				COVER ANGLE			
		DIM 'A'	'B' (S.S.)	DIM 'C'	DIM 'D'	DIM 'E'	DIM 'F'	DIM 'G'	DIM 'H'
31-11-04-025	29"	14 7/8	1/4 X 1"	1/2	13 1/8	5 9/16	SMALL		
31-11-04-030	29"-42"	16 3/4	1/4 X 1"	1/2	13 1/8	5 9/16	STANDARD		
31-11-04-035	>42"	23 1/4	3/8 X 1 1/4	5/8	18 1/2	8 1/4	LONG		

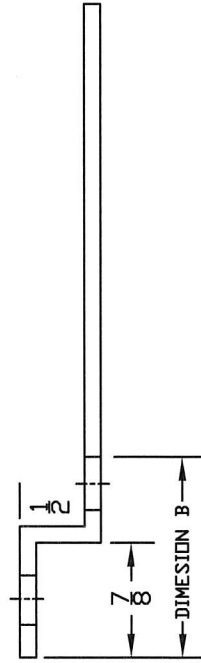
MilcoR Line
 HATCH HOLD OPEN ARM
 PART NO. 31-11-04-030
 SCALE 1/8" = 1'-0"
 SHEET 1 OF 1

REV.	ECN	DESCRIPTION	BY	DATE
A		REMOVED 5/8" RAD. AT HINGE PIVOT END. JMF		6/17/09



FLAT DETAIL: SIDE ELEVATION VIEW

- NOTES:
1. MAT'L: 0.125' LOW CARBON STEEL, HOT ROLLED, PICKLED & OILED, CADMIUM PLATED OR HOT DIP GALVANIZED AFTER FABRICATION.
 2. NO CRACKING OR SPLITTING ALLOWED ON OUTSIDE OF 90 DEG. BENDS.



FORMED DETAIL: PLAN VIEW

MilcoR	
COMMERCIAL PRODUCTS GROUP 848 Thomas Drive Bensenville, IL. 60106 phone: (800) 624-8642 fax: 1-630-766-5259	
TITLE: 4000-105 RH END HINGE	
MATERIAL 1/8" X 1 1/4" STEEL BAR	
DRAWN: DATE:	CHK'D: DATE:
PART NO: 31-12-07-021	REV: A
219695	SHEET 1 of 1

MODEL NO.	DIMENSION A	DIMENSION B
M-1	1/2" +1/32"	1 5/8" +1/32"
	13/32" +1/32"	1 17/32" +1/32"



Architectural Testing

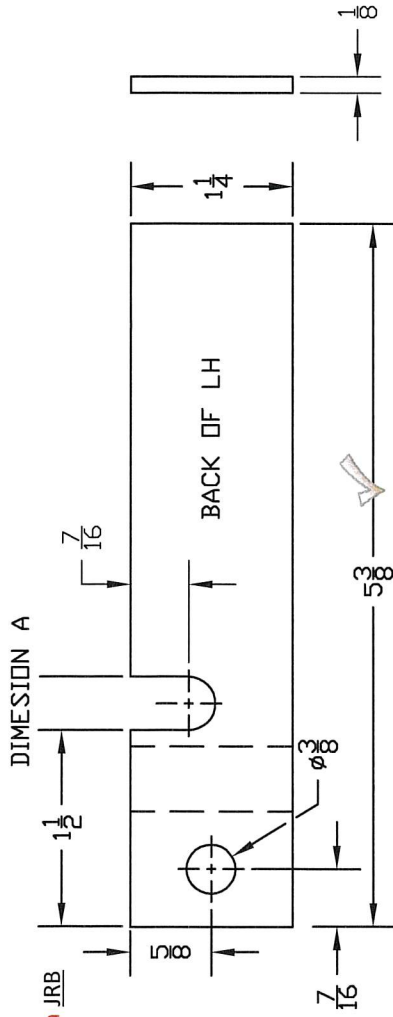
Test sample complies with these details

Deviations are noted

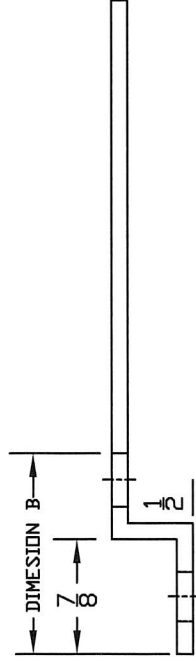
Report #D3324.01-602-18

Date: December 18, 2013 Tech JRB

REV.	ECN	DESCRIPTION	BY	DATE
A		REMOVED 5/8" RAD. AT HINGE PIVOT END. JMF	JMF	6/17/09



FLAT DETAIL: SIDE ELEVATION VIEW



FORMED DETAIL: PLAN VIEW

NOTES:

1. MAT'L: 0.125' LOW CARBON STEEL, HOT ROLLED, PICKLED & OILED, CADMIUM PLATED OR HOT DIP GALVANIZED AFTER FABRICATION.
2. NO CRACKING OR SPLITTING ALLOWED ON OUTSIDE OF 90 DEG. BENDS.

MilcoR

COMMERCIAL PRODUCTS GROUP
848 Thomas Drive
Bensenville, IL. 60106
phone: (800) 624-8642
fax: 1-630-766-5259

TITLE	4000-105 LH END HINGE
MATERIAL	1/8" X 1 1/4" STEEL BAR
DRAWN	CHK'D
DATE	DATE
PART NO	31-12-07-020
REV	A
SHEET	10f1

MODEL NO.	DIMENSION A	DIMENSION B
M-1	1/2" +1/32"	1 5/8" +1/32"
	13/32" +1/32"	1 17/32" +1/32"

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DWG NO.
12092 R-3



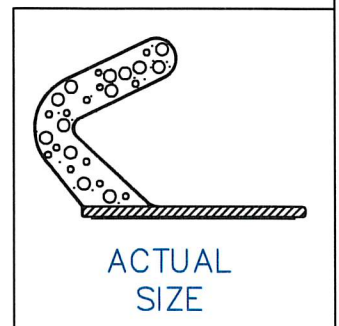
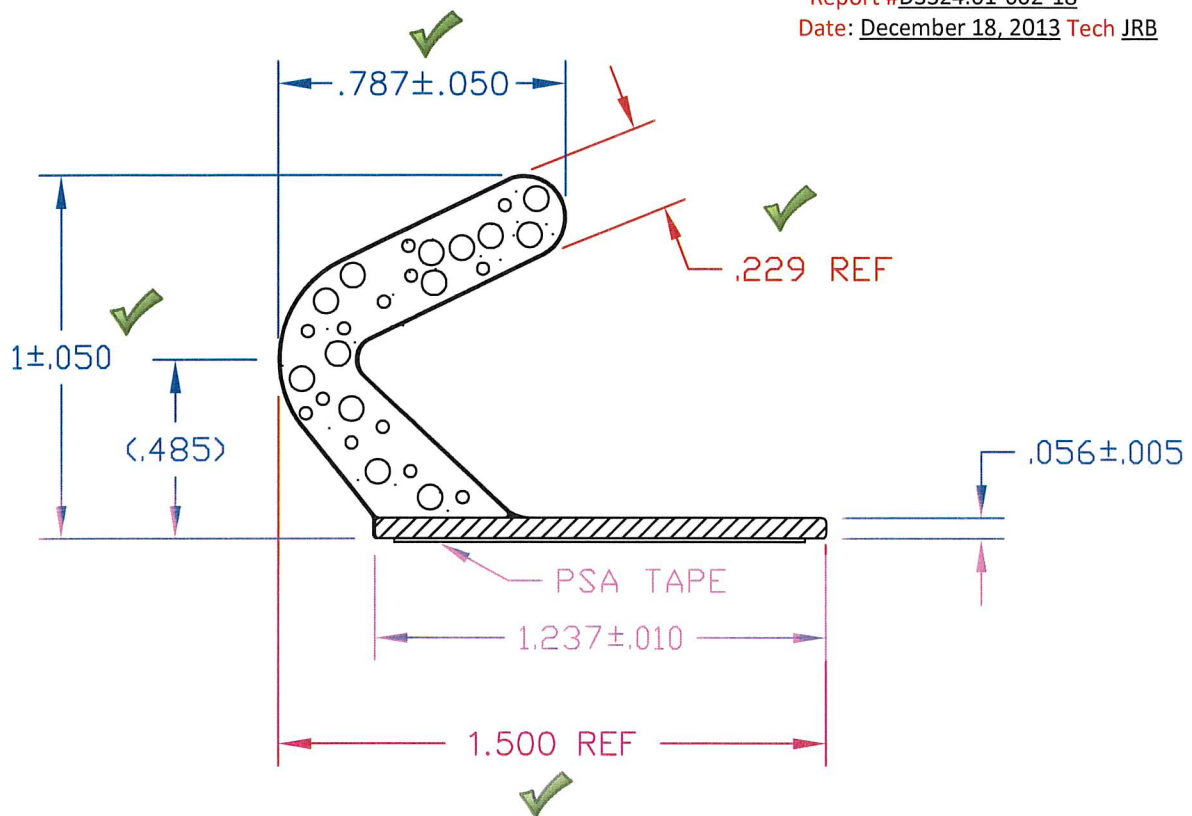
Architectural Testing

Test sample complies with these details

Deviations are noted

Report #D3324.01-602-18

Date: December 18, 2013 Tech JRB



CUSTOMER APPROVAL

DATE

FD104 R-1 SD074 CD123 R-1

REVISIONS

1.Changed Overall Width to Ref Dim	RCH	01/13/94	PM	2:1
2.SEE ECN 034-08	AA	9/26/08		
3.SEE ECN #090-10	AA	08/30/10		
4.				
5.				
6.				

DRAWN

DATE

CHK'D

SCALE:

NOTES:

TITLE:

MILCOR Roof Hatch Seal



FOAM-TITE
AMESBURY GROUP

57 South Hunt Rd.
Amesbury, MA 01913

Dwg. or Part No.

12092

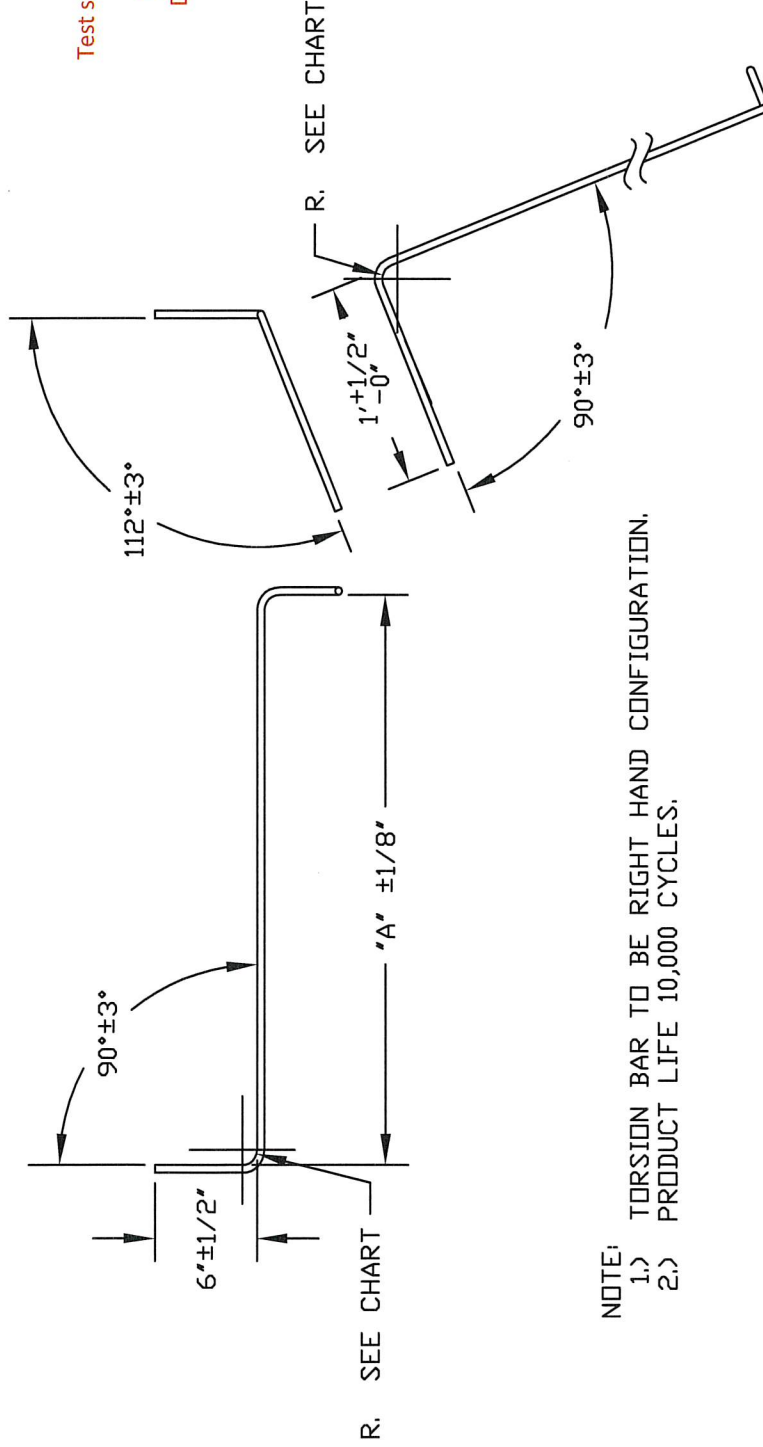
REV.

3

ECN	DESCRIPTION	BY	DATE
	REDRAWN	JEG	8/15/00
A	CHG'D RADIUS TO 1/2"	JEG	2/4/03



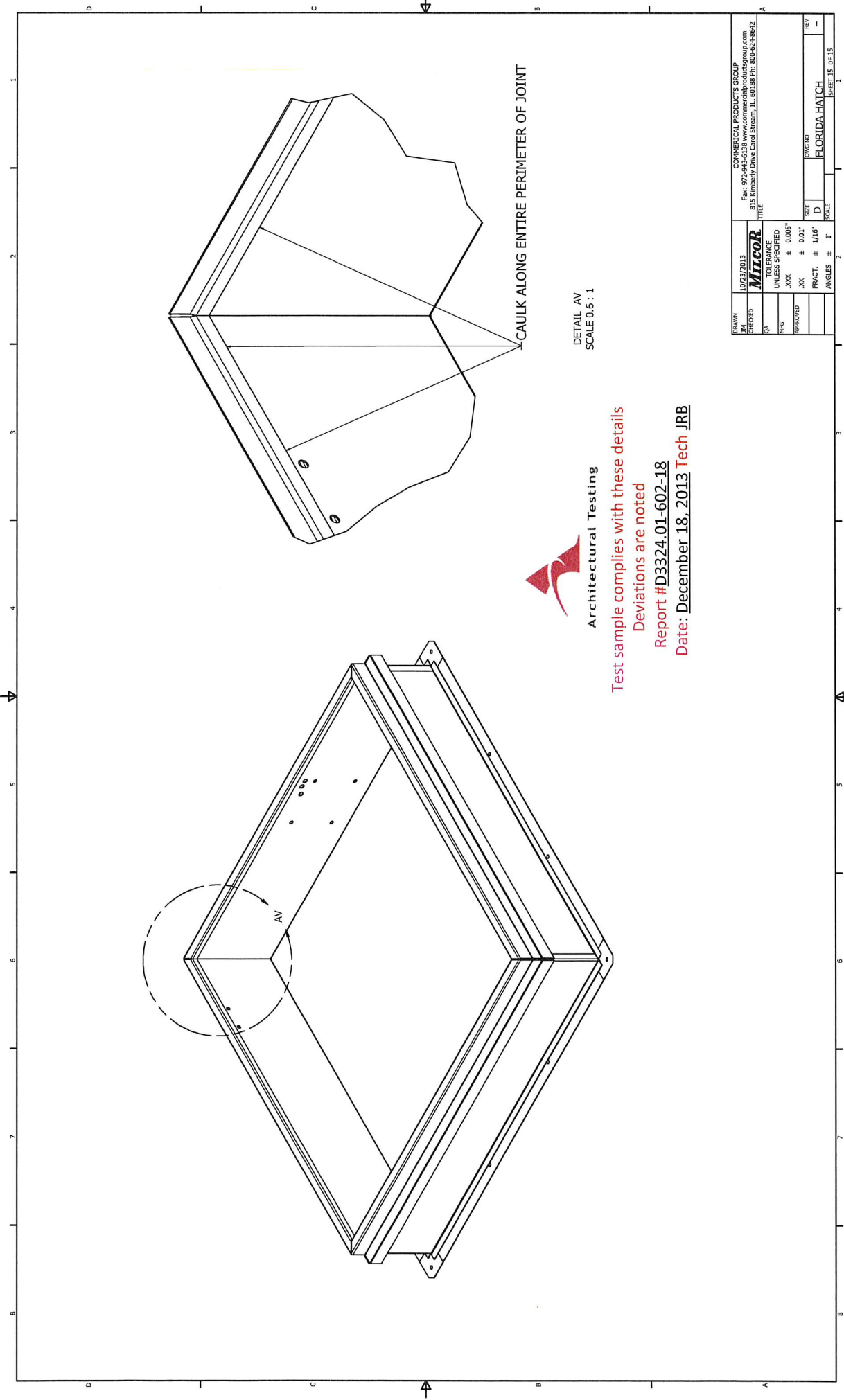
Test sample complies with these details
Deviations are noted
Report #D3324.01-602-18
Date: December 18, 2013 Tech JRB



NOTE:
1.) TORSION BAR TO BE RIGHT HAND CONFIGURATION.
2.) PRODUCT LIFE 10,000 CYCLES.

MILCOR COMMERCIAL PRODUCTS GROUP 484 Thomas Drive Bensenville, IL 60106 phone: (800) 624-8642 fax: 1-630-766-5259		SPRING, TORSION BAR ROOF HATCH	
MATERIAL: OIL-TEMPERED MECHANICAL SPRING WIRE PER ASTM A229		DATE: 8/15/00 REV: 10f1	
DRAWN: JEG	CHK'D:	PART NO: 31-18-14-075 thru 31-18-14-150	

PART NO.	WIRE DIA.	TORQUE @ 112°	CALC. MAX. STRESS	RADIUS	DIM. "A"	IDENTIFICATION COLOR	WHERE USED
31-18-14-150	T7	.500	2245 IN. LB.	000,000 PSI	1/2"	3'-3"	---
31-18-14-145	T6	.400	0000 IN. LB.	000,000 PSI	1/2"	3'-3"	---
31-18-14-130	T5	.435	1850 IN. LB.	000,000 PSI	1/2"	2'-9"	---
31-18-14-125	T4	.400	1410 IN. LB.	000,000 PSI	1/2"	2'-9"	---
31-18-14-120	T3	.362	1048 IN. LB.	112,500 PSI	1/2"	2'-9"	RED
31-18-14-075	T2	.343	790 IN. LB.	99,700 PSI	1/2"	2'-9"	YELLOW



Architectural Testing

Test sample complies with these details

Deviations are noted

Report #D3324.01-602-18

Date: December 18, 2013 Tech JRB

DRAWN	10/23/2013	COMMERCIAL PRODUCTS GROUP
CHECKED		Fax: 972-943-4338 www.commercialproductsgroup.com
QA		8117 Kimberly Drive, Suite 100, Dallas, TX 75248-1000
APPROVED		TITLE
		XXX ± 0.005"
		XX ± 0.01"
		FRAC. ± 1/16"
		ANGLES ± 1°
		SCALE
		FLORIDA HATCH
		REV
		15 OF 15