

Weather and Security

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This section of the Fabrication manual covers BS EN 6375 and PAS24 testing. This section should be used in conjunction with the previous sections of the manual.

BS EN 6375 is made up of three parts. These are:

Part 1 - Classification for weather tightness.

Part 2 - Classification for operation & strength characteristics.

(Operation, cycle testing, racking, torsion & load bearing capacity for safety devices.)

Part 3 - Basic security Only

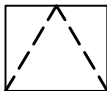

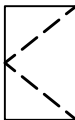
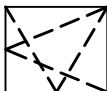
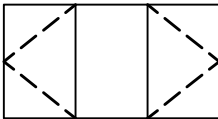
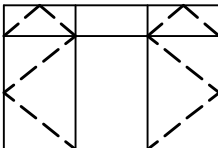
PAS24 Testing includes Mechanical Loading and Manual Intervention tests.

This section of the manual covers the exact specifications tested by Eurocell (Type Testing). It then moves onto fabrication advice including Reinforcement and Hardware options.

Before undertaking any testing, you should contact the Eurocell Technical team who can advise you on best practice, hardware specifications and support you in the manufacture of your test windows / doors to help achieve the best possible results. Where possible we will also attend the tests with you.

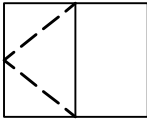
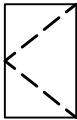
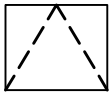
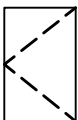
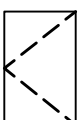

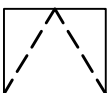
BS EN 6375 - Windows

The results below are taken from the BSI Test Report 261/7046622

TYPE	SIZE	PART 1			PART 2	PART 3
		Air	Water	Exposure Cat		
Fixed Light	1500w x 2100h	600Pa	1050Pa	1600Pa	Pass	Pass
Top hung (unreinforced) 	1000w x 1000h	600Pa	750Pa	2400Pa	Pass	Pass
Top hung (sash steel reinforced) 	1200w x 1350h	600Pa	750Pa	1600Pa	Pass	Pass
Side hung (sash steel reinforced) 	750w x 1350h	600Pa	1050Pa	1600Pa	Pass	Pass
Tilt & Turn (Steel reinforced) 	1500w x 1500h	600Pa	450Pa	1200Pa	Pass	Pass
Multilight (Steel reinforced) 	2400w x 1000h	600Pa	1050Pa	2400Pa	Pass	Pass
Multilight (Steel reinforced) 	2400w x 1600h	600Pa	600Pa	800Pa	Pass	Pass

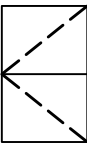
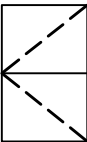
BS EN 6375 - Windows

The results below are taken from the BBA Test Report 5574A

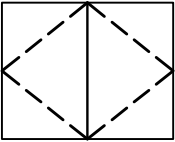
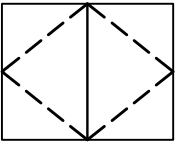
TYPE	SIZE	PART 1			PART 2	PART 3
		Air	Water	Exposure Cat		
Side next to fixed (Thermal Inserts) 	1500w x 1500h	600Pa	600Pa No Leakage occurred	1200Pa	N/A	N/A
Side hung (Thermal Inserts) 	755w x 1350h	600Pa	600Pa No Leakage occurred	2000Pa	N/A	N/A
Top hung (Thermal Inserts) 	1200w x 1350h	300Pa	600Pa No Leakage occurred	1600Pa	N/A	N/A
FLUSH SASH - Side hung (Unreinforced) 	750w x 1500h	600Pa	600Pa	1200Pa	Pass	Pass
FLUSH SASH - Side hung (Sash Steel Reinforced) 	750w x 1500h	600Pa	600Pa	2000Pa	Pass	Pass
FLUSH SASH - Top hung (Unreinforced) 	1200w x 1350h	600Pa	600Pa	1200Pa	Pass	Pass
FLUSH SASH - Top hung (Sash Steel Reinforced) 	1200w x 1350h	600Pa	600Pa	1600Pa	Pass	Pass

BS EN 6375 - Doors

The results below are taken from the BSI Test Report 8575957A1

TYPE	SIZE	PART 1			PART 2	PART 3
		Air	Water	Exposure Cat		
Residential Door - Standard Threshold (Steel Reinforced Sash Thermal Outer) 	1050w x 2300h	Class 3 600Pa	Class 7A 300Pa	Class A3 1200Pa	PASS	PASS
Residential Door - Low Threshold (Steel Reinforced Sash, Thermal Outer) 	1050w x 2300h	Class 3 600Pa	Class 7A 300Pa	Class A3 1200Pa	PASS	PASS

The results below are taken from the BSI Test Report 8575958A1

TYPE	SIZE	PART 1			PART 2	PART 3
		Air	Water	Exposure Cat		
French Door - Standard Threshold (Steel Reinforced Sash Thermal Outer & Aluminium Mullion) 	2000w x 2300h	Class 4 600Pa	Class 6A 250Pa	Class A3 1200Pa	PASS	PASS
French Door - Low Threshold (Steel Reinforced Sash Thermal Outer & Aluminium Mullion) 	2000w x 2300h	Class 2 300Pa	Class 6A 250Pa	Class A3 1200Pa	PASS	PASS

All the above testing has been done on Open In Doors. BSI deem that Open In is worst case and therefore request Open in doors to cover both Open In and Open Out doors.