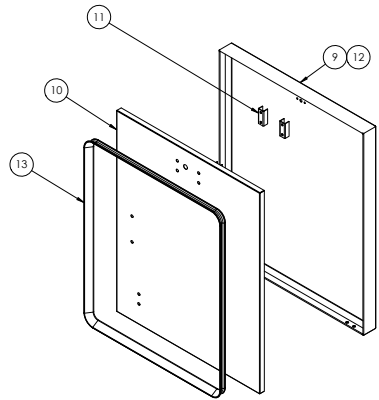
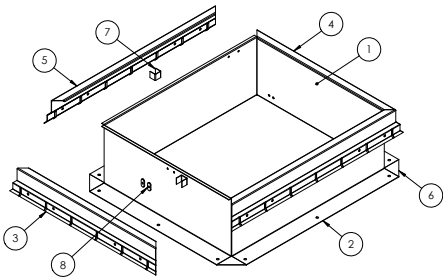


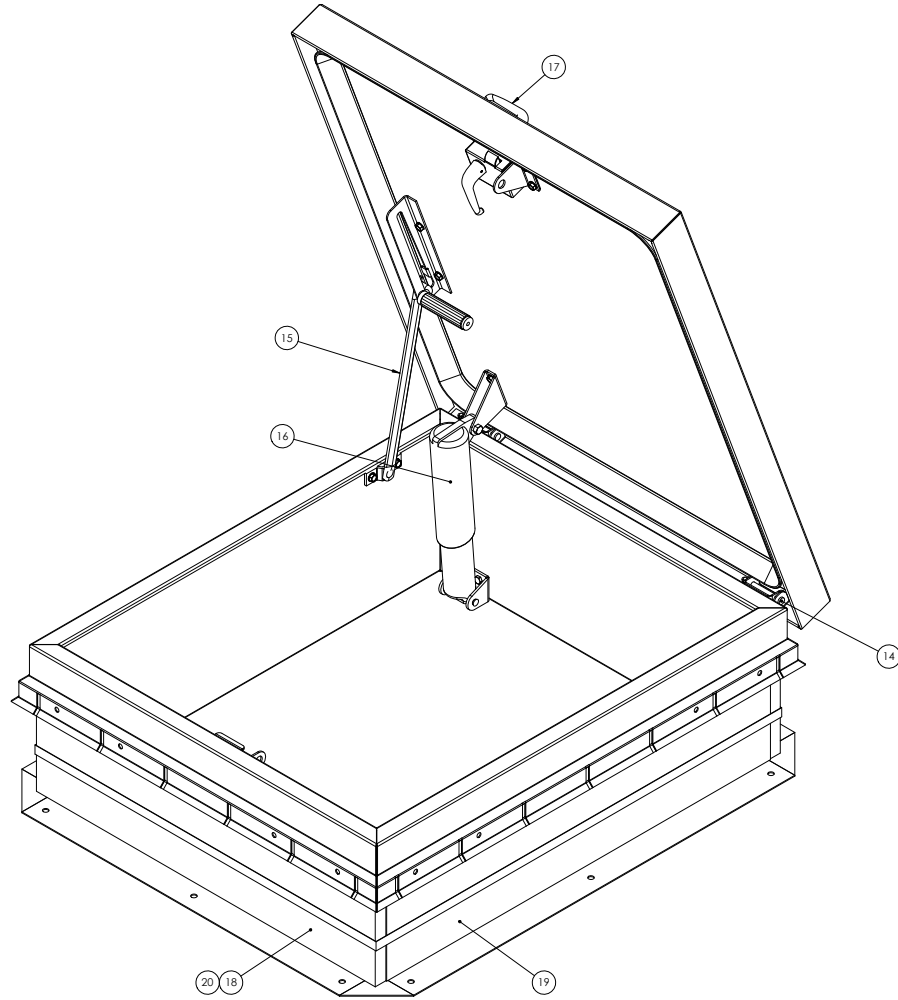
ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A	FRAME-RS, 30" STEEL [15 13/16" x 30"]	2
2	SD505A	FRAME-RS, 36" STEEL [15 13/16" x 36"]	2
3	SD506	FLASHING-RS, 30" STEEL [6 5/8" x 36"]	1
4	SD506P	FLASHING-RS, 30" STEEL PUNCH [6 5/8" x 36"]	1
5	SD507	FLASHING-RS, 36" STEEL [6 5/8" x 42"]	2
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER FRAME & FLASHING STEEL	5
8	SD165	NUT-WELD, 5/16"-18 STEEL	2
COVER			
9	SD502	COVER-RS, S-20 [3630], STEEL [49 3/4" x 42 1/2"]	1
10	SD521	LINER-COVER RS, S-20 [3630], STEEL [43 1/8" X 35 27/32"]	1
11	SD36	SPACER-COVER 1" STEEL	5
12	SD2	INSULATION-FIBERGLASS	10.5 SQ. FT
13	SD4026	GASKET-EPDM	11 FT
HARDWARE & ACCESSORIES			
14	KT13-P	KIT-HINGE RS, PLATED	2
15	KT562L-P	KIT-HOJA, RS LH 1 1/4", STEEL FRAME, 70"	1
16	KT369N	KIT-SPRING 360#; RS, 1 EAR, COMPOSITE TUBES	1
17	KTSLAM	KIT-SLAM LOCK, RS	1
18	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
19	SD16-2	FIBERBOARD 1" X 9 1/2" X 36 1/4"	2
20	SD125	TAPE-FIBERGLASS 3/4" X 12"	A/R
ITEMS NOT SHOWN			
21	KTBL-RS	KIT-LABELS, RS	1
22	SD1030	PRIMER-RED OXIDE	A/R



COVER PARTS



FRAME PARTS



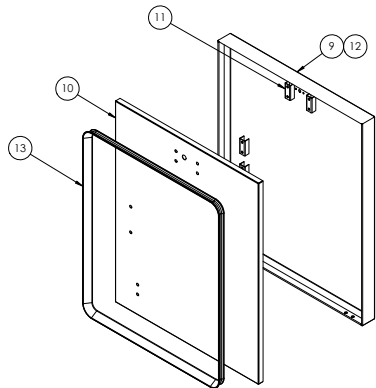
S-20

REV.	DESCRIPTION	BY	DATE
P	REPLACED KT562L W/ KT562L-P & KT562AL-P	32646	ATR 11/14/13
N	REDUCED THE AMOUNT OF WELD ON COVER	31247	ATR 08/20/12
M	ADDED KITS TO BOM, CHANGED SPRING LOAD, HOJA, FRAME CORNER, SPRING HOUSING BRACKET, TURN HANDLE ASSY, COVER DESIGN & HINGE WELD NUTS	29476	ATR 06/01/12
J	CHANGED SD125 LABEL TO SD125AMD	28125	ATR 05/22/10
K	RECREATED IN SOLIDWORKS & ADDED WELD CALLOUTS	21665	DMP 06/05/07

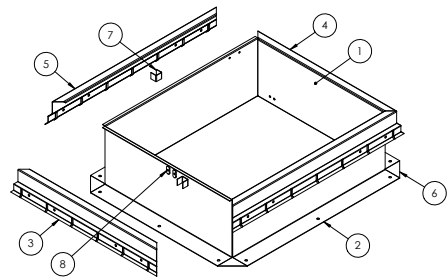
DESIGN CHECKED BY: []	DATE: []	THE BILCO COMPANY
DRAWN BY: []	DATE: []	
DESIGNED BY: []	DATE: []	TITLE: S DOOR ASSY
CHECKED BY: []	DATE: []	SIZE: DWG. NO. D S-DOOR REV P SCALE: 1:4 WEIGHT: SHEET 1 OF 7

RELEASED TO MANUFACTURING
DATE: 11/14/13
APPROVED BY: D.J.C.

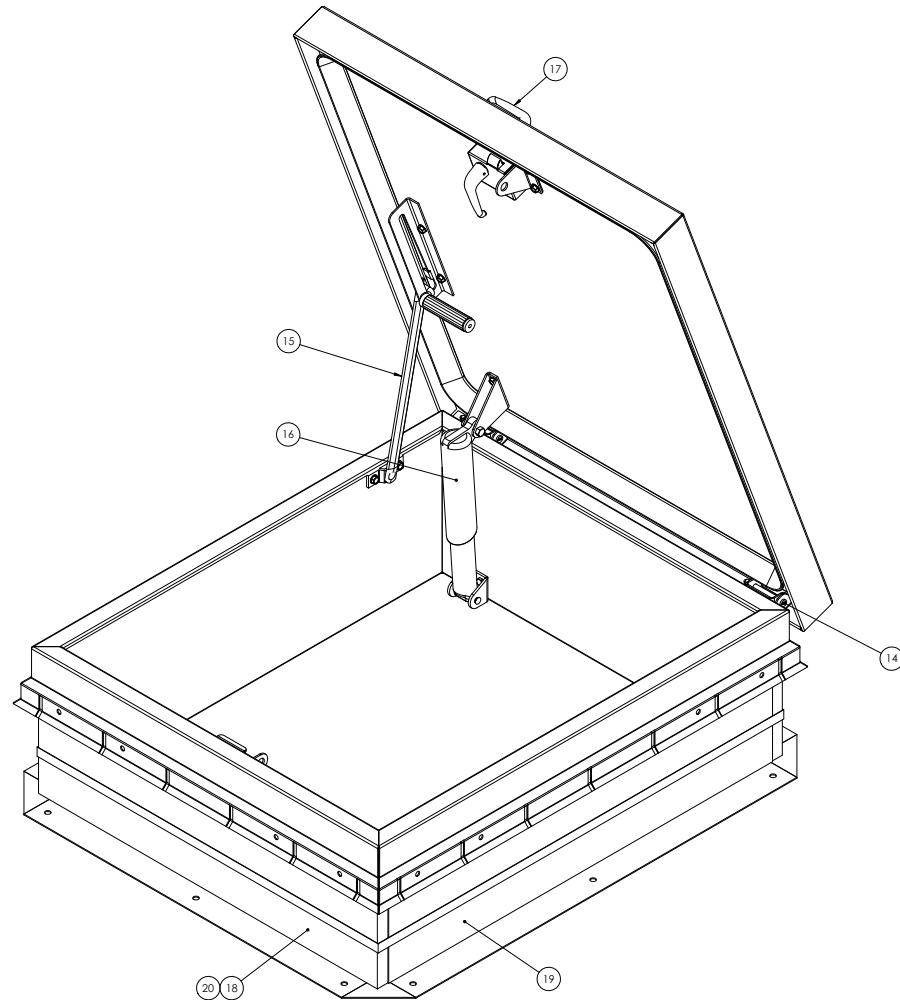
ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A	FRAME-RS, 30" STEEL [15 13/16" x 30"]	2
2	SD505A	FRAME-RS, 36" STEEL [15 13/16" x 36"]	2
3	SD506	FLASHING-RS, 30" STEEL [6 5/8" x 36"]	1
4	SD506P	FLASHING-RS, 30" STEEL PUNCH [6 5/8" x 36"]	1
5	SD507	FLASHING-RS, 36" STEEL [6 5/8" x 42"]	2
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER FRAME & FLASHING STEEL	5
8	SD165	NUT-WELD, 5/16"-18 STEEL	2
COVER			
9	SD502AL	COVER-RS, S-50 [3630], ALUM [49 3/4" x 42 1/2"]	1
10	SD521AL	LINER-COVER RS, S-50 [3630], ALUM [43 1/8" X 35 27/32"]	1
11	SD36AL	SPACER-COVER 1" ALUM	5
12	SD2	INSULATION-FIBERGLASS	10.5 SQ. FT.
13	SD4026	GASKET-EPDM	11 FT.
HARDWARE & ACCESSORIES			
14	KT13SS	KIT-HINGE RS, SS	2
15	KT162L-P	KIT-HOJA, RS LH 1 1/4", STEEL FRAME, 70"	1
16	KT190N	KIT-SPRING 190#; RS, 1 EAR, COMPOSITE TUBES	1
17	KTSLAM	KIT-SLAM LOCK, RS	1
18	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
19	SD16-2	FIBERBOARD 1" X 9 1/2" X 36 1/4"	2
20	SD125	TAPE-FIBERGLASS 3/4" X 12"	A/R
ITEMS NOT SHOWN			
21	KTLBL-RS	KIT-LABELS, RS	1
22	SD1030	PRIMER-RED OXIDE (FRAME ONLY)	A/R



COVER PARTS



FRAME PARTS



S-40

RELEASED TO
MANUFACTURING
DATE: 11/14/13
APPROVED BY: D.J.C.

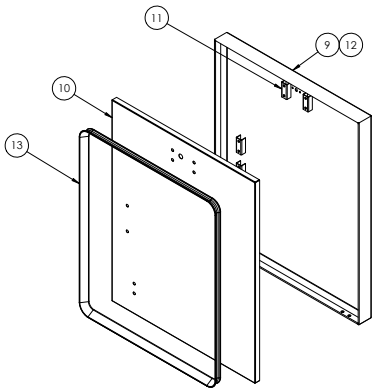
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DRAWN:		ATR	03/07/13
CHECKED:		TITLE:	
DESIGN AUTHOR:		ES	
DESIGN DATE:		11/14/13	
DESIGN SCALE:		SP21	02/14/00
PROJECT/PROGRAM:		SCALE:	
SUBPROJECT/REQ:		3RD ANGLE PROJECTION	
SPECIFICATIONS:		DO NOT SCALE DRAWING	

THE BELCO COMPANY

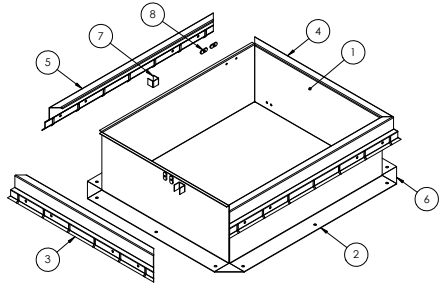
S DOOR ASSY

SIZE: DWG. NO. REV
D S-DOOR P
SCALE: 1:4 WEIGHT: SHEET 2 OF 7

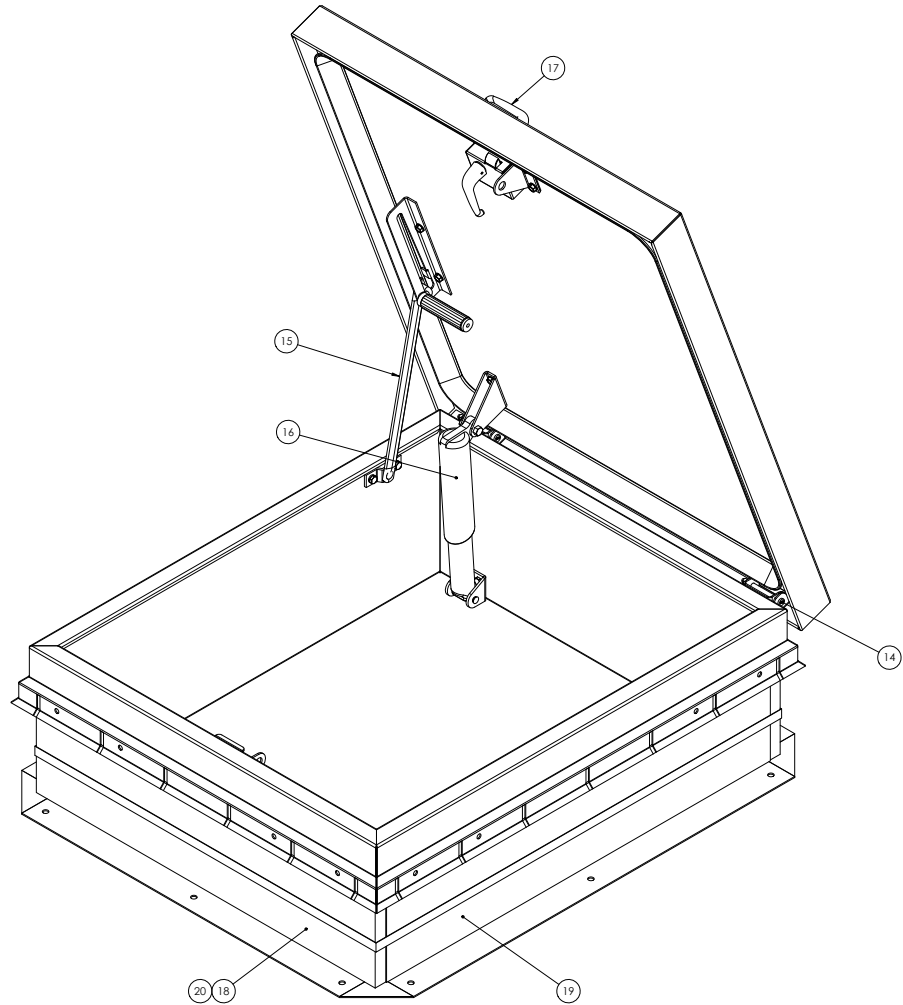
ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A-AL	FRAME-RS, 30" ALUM (15 13/16" x 30")	2
2	SD505A-AL	FRAME-RS, 36" ALUM (15 13/16" x 36")	2
3	SD506AL-1	FLASHING-RS, 30" ALUM (6 5/8" x 36")	1
4	SD506ALP1	FLASHING-RS, 30" ALUM, PUNCH (6 5/8" x 36")	1
5	SD507AL	FLASHING-RS, 36" ALUM (6 5/8" x 42")	2
6	SD1649AL	FRAME-CORNER, ALUM	4
7	SD15AL	SPACER FRAME & FLASHING ALUM	5
8	SD165AL	NUT-WELD, 5/16"-18 ALUM	4
COVER			
9	SD502AL	COVER-RS, S-50 (3630), ALUM (49 3/4" x 42 1/2")	1
10	SD521AL	LINER-COVER RS, S-50 (3630), ALUM (43 1/8" X 35 27/32")	1
11	SD36AL	SPACER-COVER 1" ALUM	5
12	SQ2	INSULATION-FIBERGLASS	10.5 SQ. FT
13	SD4026	GASKET-EPDM	11 FT
HARDWARE & ACCESSORIES			
14	KT13SS	KIT-HINGE RS, SS	2
15	KT162AL-P	KIT-HOJA, RS LH 1 1/4" ALUMINUM FRAME, 70"	1
16	KT19N	KIT-SPRING 190#; RS, 1 EAR, COMPOSITE TUBES	1
17	KTSLAM	KIT-SLAM LOCK, RS	1
18	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
19	SD16-2	FIBERBOARD 1" X 9 1/2" X 36 1/4"	2
20	SD125	TAPE-FIBERGLASS 3/4" X 12"	A/R
ITEMS NOT SHOWN			
21	KTLBL-RS	KIT-LABELS, RS	1



COVER PARTS



FRAME PARTS

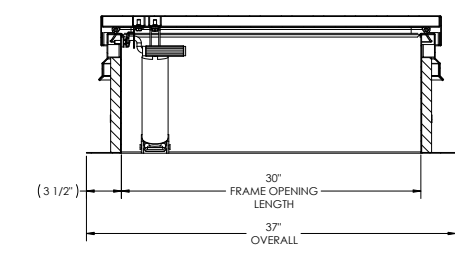
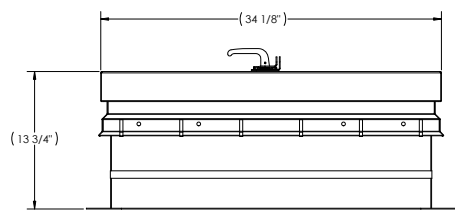
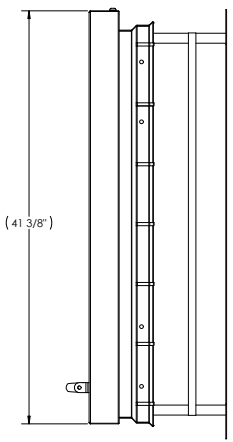
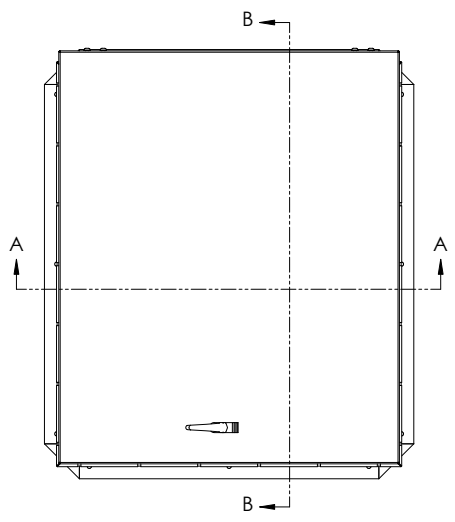


S-50

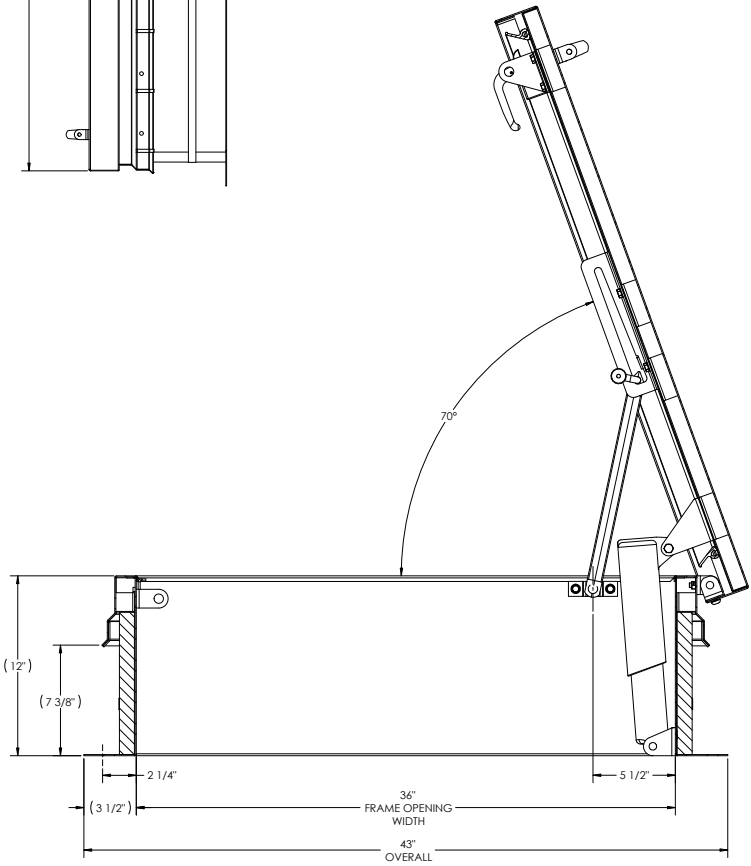
RELEASED TO
MANUFACTURING
DATE: 11/14/13
APPROVED BY: D.J.C.

<small>UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES DIMENSIONS IN PARENTHESIS ARE IN MILLIMETERS FINISHES: A - ALUMINUM S - STEEL SS - STAINLESS STEEL P - POLYESTER FRONT SURFACE FINISH: S - SATIN P - POLISHED DO NOT SCALE DRAWING</small>	<small>DESIGNED BY: DRAWN BY: DATE: CHECKED BY: DATE: APPROVED BY: DATE:</small>	<small>NAME: DATE: TITLE: SCALE: SHEET NO. OF TOTAL SHEETS:</small>	<small>THE BELCO COMPANY</small> S DOOR ASSY SIZE: D DWG. NO.: S-DOOR REV: P SCALE: 1:4 WEIGHT: SHEET 3 OF 7
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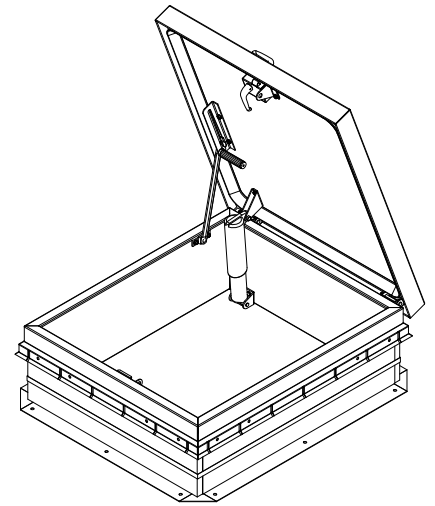
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SECTION A-A



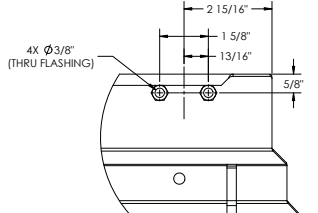
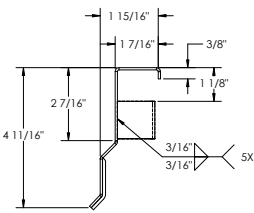
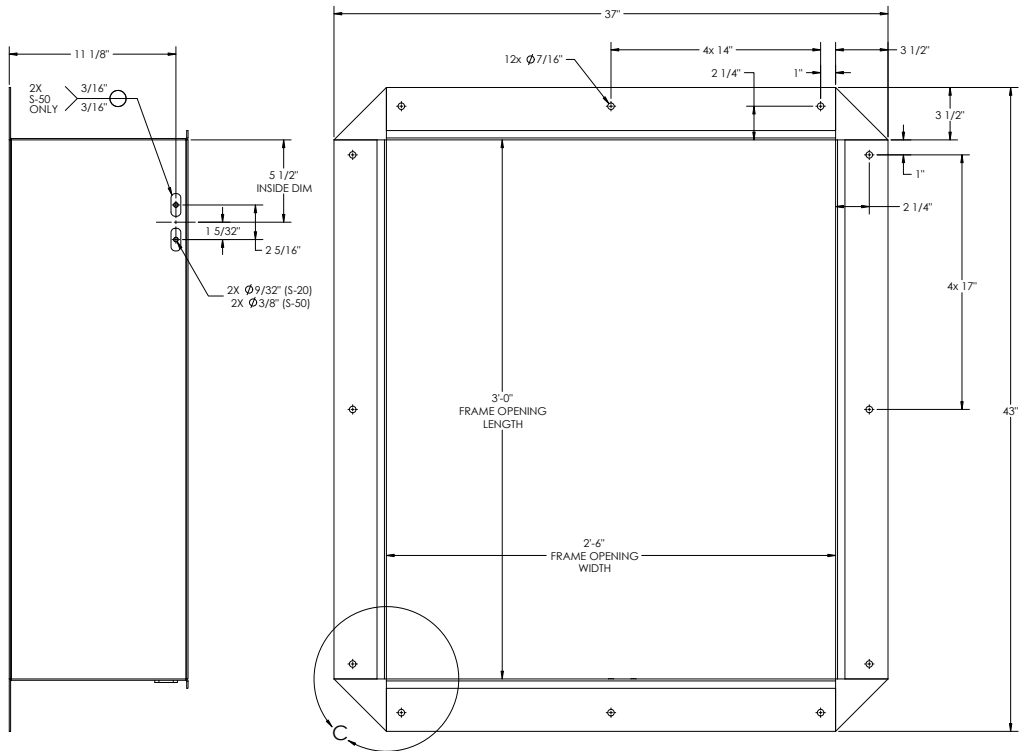
SECTION B-B



RELEASED TO
MANUFACTURING
DATE: 11/14/13
APPROVED BY: D.J.C.

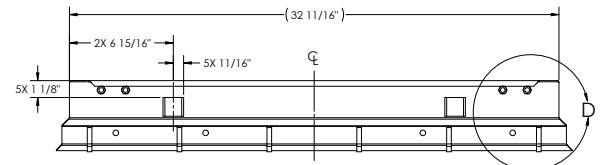
UNLESS OTHERWISE SPECIFIED:	NAME:	DATE:	THE BILCO COMPANY
ALL DIMENSIONS ARE IN INCHES AND FRACTIONS THEREOF. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE.	DRAWN:	DATE:	
DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE.	DESIGNED BY:	DATE:	TITLE:
DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE.	DRG. AUTHOR: TJ DRG. CHECK: SP21 DATE: 02/14/00	DRG. NO.: 02/00712 DRG. REV.: 02/14/00	S DOOR ASSY
DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE.	3RD ANGLE PROJECTION	SIZE: DWG. NO.: D S-DOOR	REV: P
DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE. DIMENSIONS IN PARENTHESES ARE APPROXIMATE.	DO NOT SCALE DRAWING	SCALE: 1:1	WEIGHT: SHEET 4 OF 7

8 7 6 5 4 3 2 1

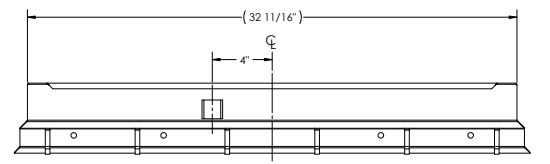


FLASHING SECTION (TYP)

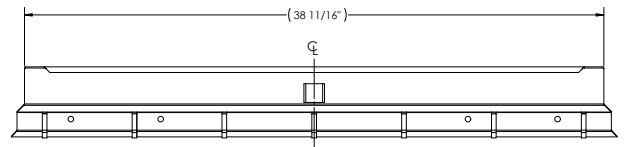
DETAIL D



HINGE SIDE

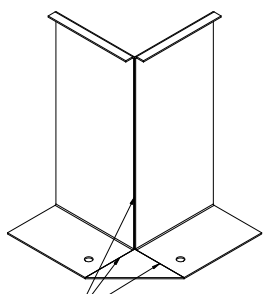


LATCH SIDE

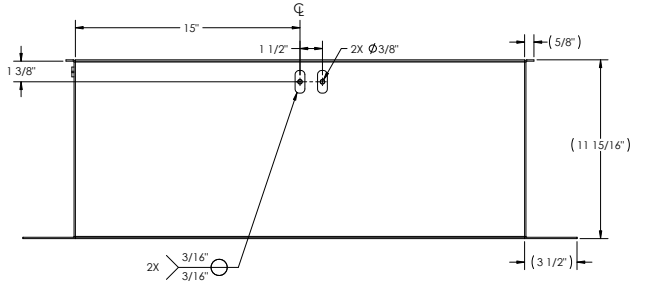


NON-HINGE SIDES

FLASHING WELDMENT



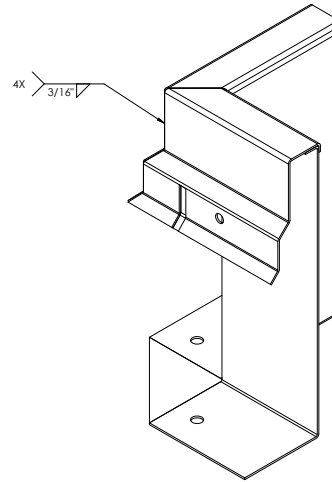
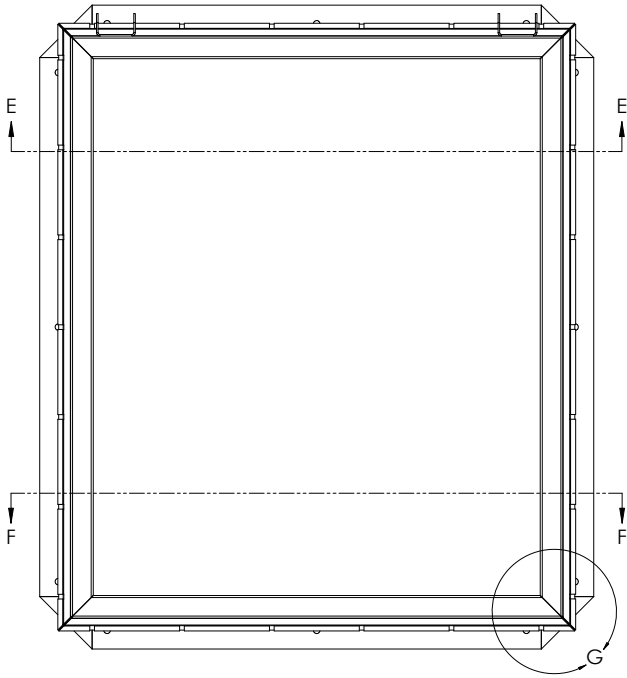
DETAIL C



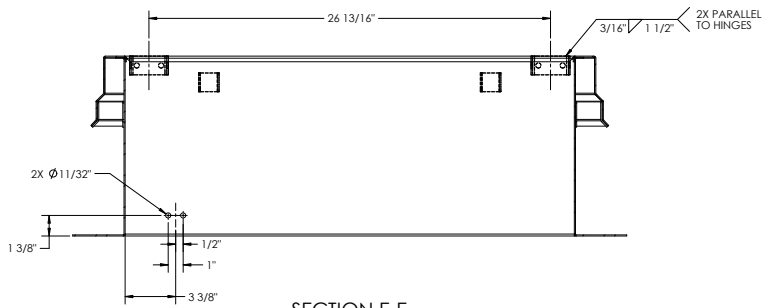
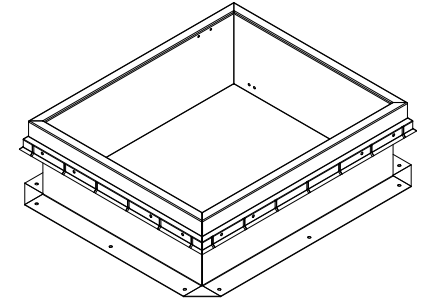
FRAME WELDMENT

RELEASED TO
MANUFACTURING
DATE: 11/14/13
APPROVED BY: D.J.C.

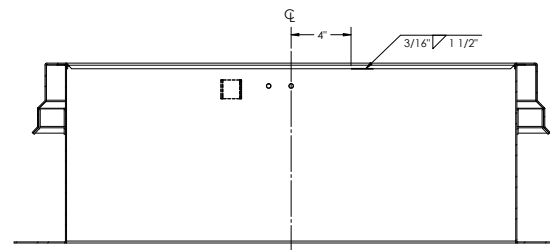
UNLESS OTHERWISE SPECIFIED:	NAME:	DATE:	THE BILCO COMPANY
ALL DIMENSIONS ARE IN INCHES DIMENSIONS IN PARENTHESIS ARE DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS ARE APPROXIMATE DIMENSIONS IN MILLIMETERS ARE APPROXIMATE DIMENSIONS IN MILLIMETERS ARE APPROXIMATE	DRAWN:	DATE:	
DIMENSIONS IN PARENTHESIS ARE DIMENSIONS IN MILLIMETERS DIMENSIONS IN MILLIMETERS ARE APPROXIMATE DIMENSIONS IN MILLIMETERS ARE APPROXIMATE DIMENSIONS IN MILLIMETERS ARE APPROXIMATE	DESIGNED BY: T.J. CHECKED BY: S.P.21 DATE: 11/14/13	TITLE: S DOOR ASSY	SIZE: DWG. NO. S-DOOR SCALE: 1:4 WEIGHT: SHEET 5 OF 7



DETAIL G



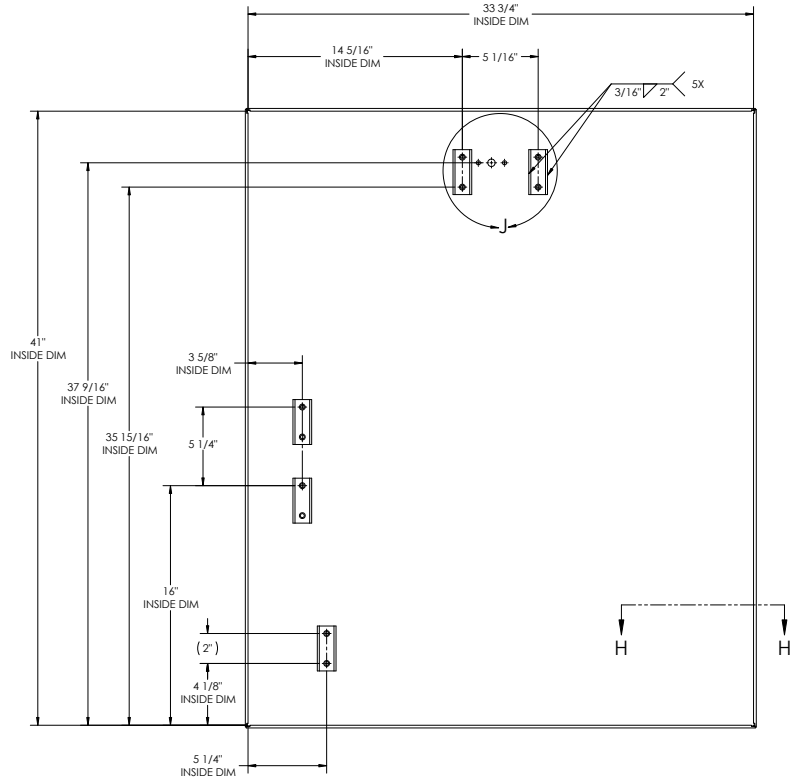
**SECTION E-E
HINGE SIDE**



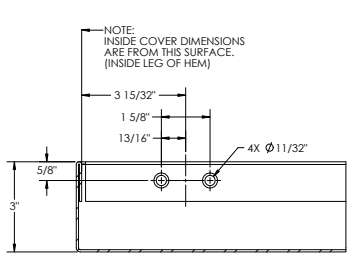
**SECTION F-F
LATCH SIDE**

FRAME/FLASHING WELDMENT

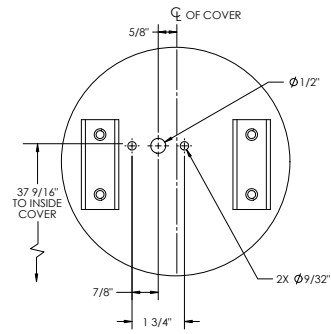
RELEASED TO MANUFACTURING DATE: 11/14/13 APPROVED BY: D.J.C.		THE BILCO COMPANY	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES FINISHES ARE AS NOTED DIMENSIONS TO FACE UNLESS NOTED OTHERWISE	DRAWN: ATR DATE: 03/20/13 CHECKED: T3 DATE: 03/20/13 DESIGNED: SP21 DATE: 02/14/00	TITLE: S DOOR ASSY	SIZE: DWG. NO. REV D S-DOOR P SCALE: 1:4 WEIGHT: SHEET 6 OF 7
3RD ANGLE PROJECTION		DO NOT SCALE DRAWING	



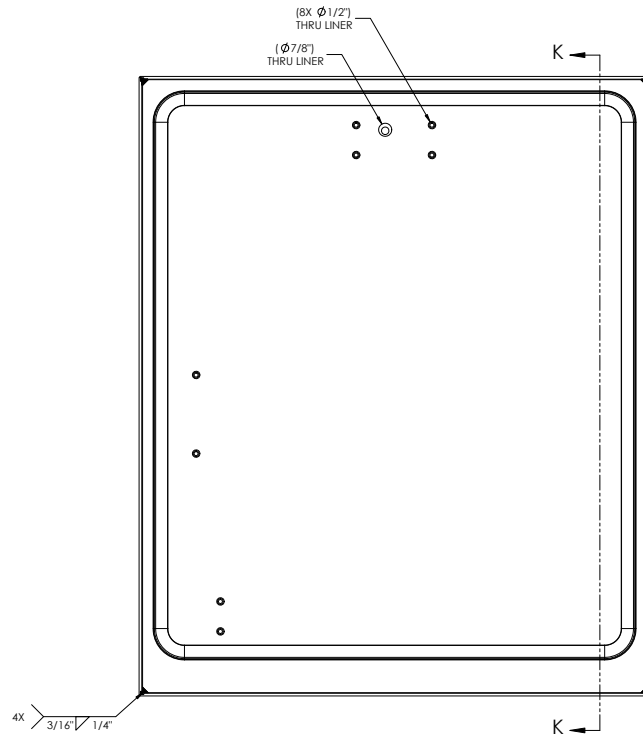
COVER SPACER LAYOUT



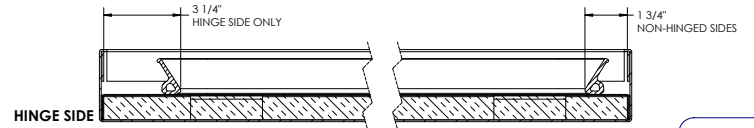
SECTION H-H



DETAIL J




COVER LINER WELDMENT & GASKET LOCATION



SECTION K-K

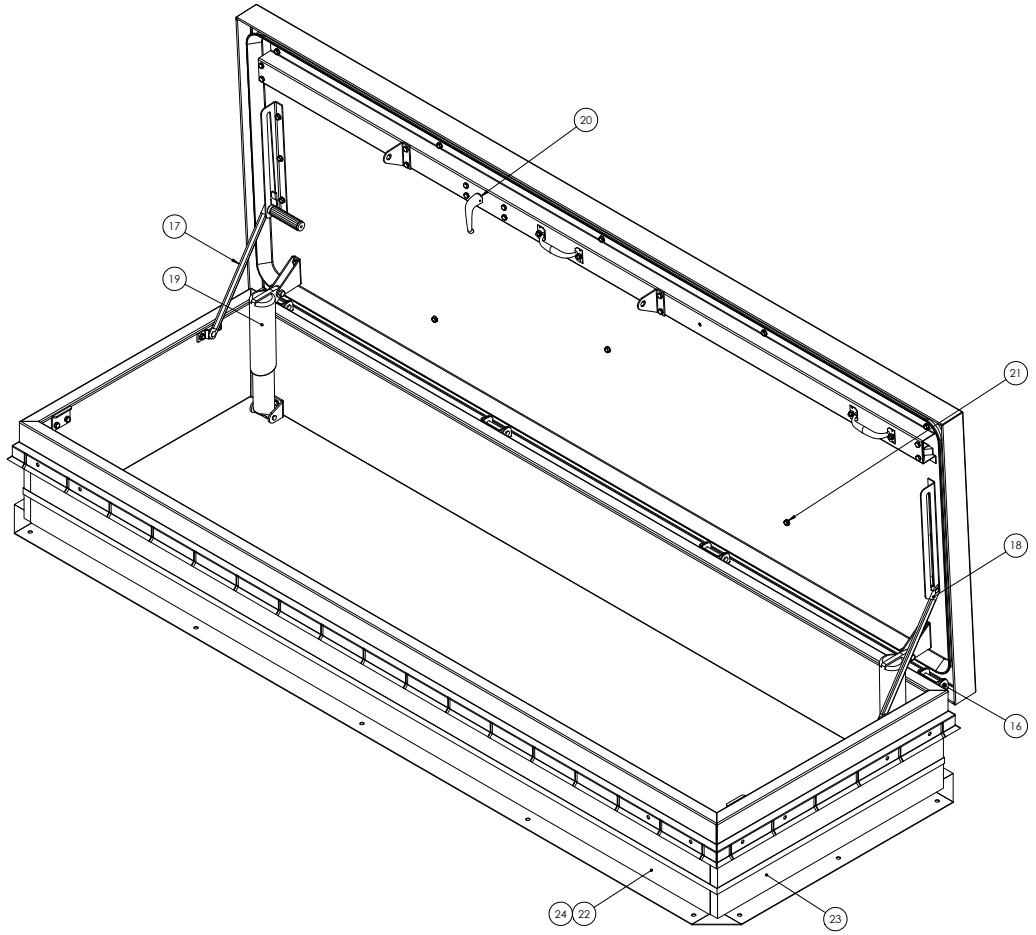
RELEASED TO
MANUFACTURING
 DATE: 11/14/13
 APPROVED BY: D.J.C.

DESIGN CHECKS/SPECIFICATIONS		NAME	DATE
DESIGNED BY	DATE	ATR	03/07/13
DRAWN BY	DATE		
CHECKED BY	DATE		
APPROVED BY	DATE		
DESIGN AUTHORITY		TJ	
DESIGN SCALE		SP21	02/14/00
SCALE			
PROJECT	3RD ANGLE PROJECTION		
DO NOT SCALE DRAWING			

Bilco THE BILCO COMPANY
 TITLE: S DOOR ASSY

SIZE: DWG. NO.: **D** S-DOOR REVISION: **P**
 SCALE: 1:4 WEIGHT: SHEET 7 OF 7

ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A	FRAME-RS, 30" STEEL (15 13/16" X 30")	2
2	SD523	FRAME-RS, 96" STEEL (15 13/16" X 96")	2
3	SD506	FLASHING-RS, 30" STEEL (6 5/8" X 36")	2
4	SD525	FLASHING-RS, 96" STEEL (6 5/8" X 102")	1
5	SD525P	FLASHING-RS, 96" STEEL, PUNCH (6 5/8" X 102")	1
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER FRAME & FLASHING STEEL	9
8	SD549	STIFF-FRAME FORMED 1 1/4" X 2 1/2" X 11" STEEL	2
9	SD165	NUT-WELD, 5/16"-18 STEEL	4
COVER			
10	SD516	COVER-RS, L-20 (3096), STEEL (46" X 110 3/4")	1
11	SD577	LINER-COVER RS, L-20 (3096), STEEL (34 9/16" X 99 9/32")	1
12	SD36	SPACER-COVER 1" STEEL	11
13	SD527	BUPL-LOCK BOX, 1" X 98 1/4", STEEL	1
14	SD2	INSULATION-FIBERGLASS	15 SQ. FT
15	SD4026	GASKET-EPDM	22 FT
HARDWARE & ACCESSORIES			
16	KT13-P	KIT-HINGE RS, PLATED	4
17	KT3445-P	KIT-HOA, RS LH, 14 1/4", STEEL FRAME	1
18	KT4820-P	KIT-GUIDE ARM, RS 14 1/4", STEEL FRAME	1
19	KT480N	KIT-SPRING 480# RS, 1 EAR, COMPOSITE TUBES	2
20	KT18X120	KIT-LOCK 2PT, L-20	1
21	SD3-Y	SCREW-TAPTITE 5/16"-18 X 7/8" YELLOW CHRMT	3
22	SD16	FIBERBOARD 1" X 9 1/2" X 96"	2
23	SD16-L	FIBERBOARD 1" X 9 1/2" X 32"	2
24	SD125	TAPE-FIBERGLASS 3/4" X 12"	A/R
ITEMS NOT SHOWN			
25	KT18L-RS	KIT-LABELS, RS	1
26	SD1030	PRIMER-RED OXIDE	A/R



COVER PARTS

FRAME PARTS

L-20

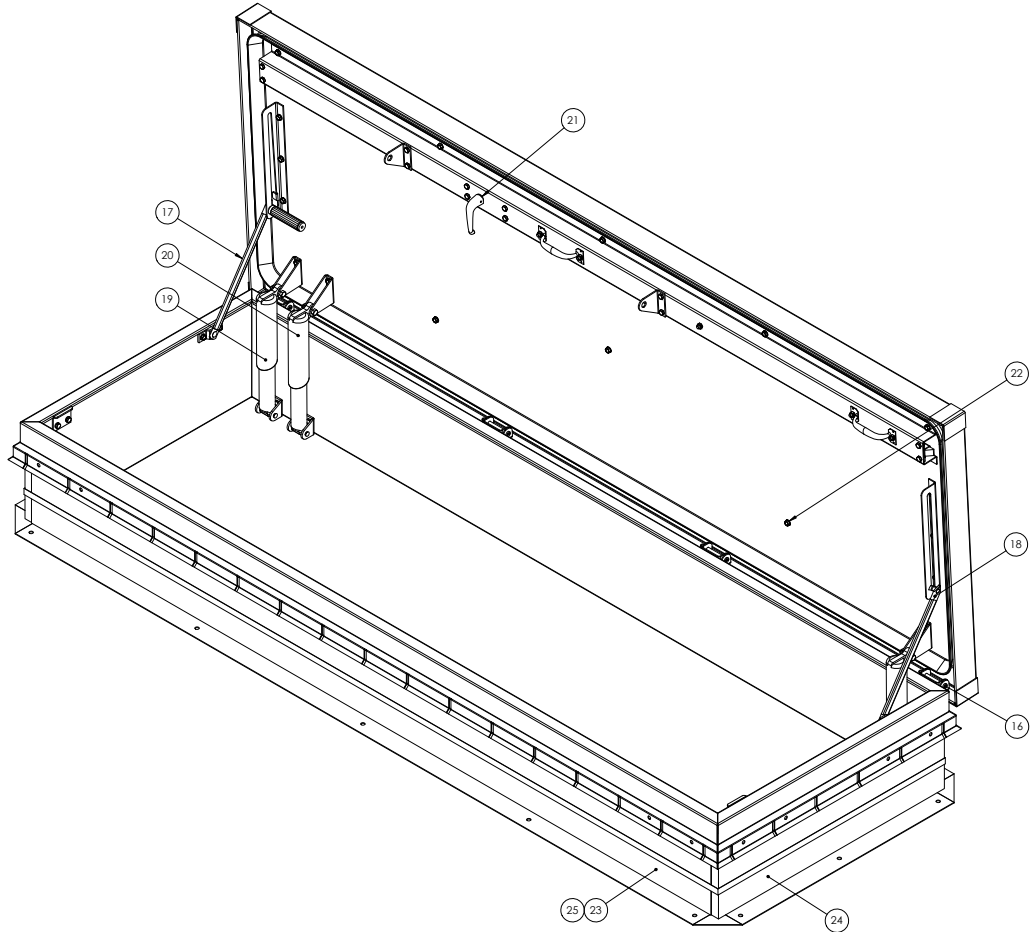
RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

REV.	DESCRIPTION	ECR	BY	DATE
N	REPLACED SD577AL W/ SD584 ON L-40 & L-50	32768	ATR	12/31/13
M	REPLACED KT3445-P & KT4820-P W/ KT3445A-P & KT4820A-P ON L-50	32822	ATR	11/21/13
L	ADDED KT100N (100# SPRING) TO L-40 & L-50	31597	ATR	01/08/13
K	ADDED KITS TO ROOM, CHANGED SPRING LOAD, HOA, FRAME CORNER, SPRING HOUSING BRACKET, TURN HANDLE ASSY & HINGE WELD NUT	29540	ATR	06/01/12

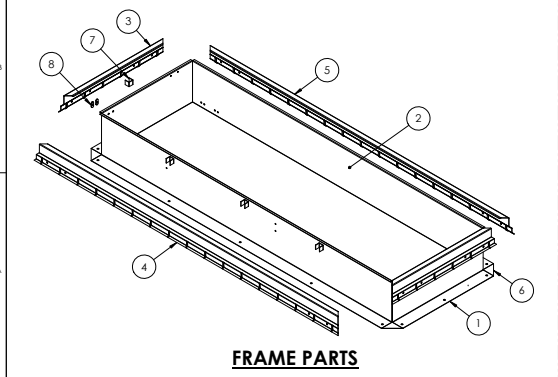
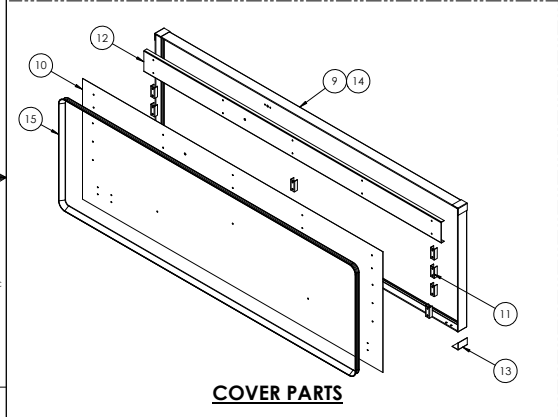
DESIGN CHANGES SPECIFIED	REVISION	DATE
1. REVISION 1 TO DRAWING 2. REVISION 2 TO DRAWING 3. REVISION 3 TO DRAWING 4. REVISION 4 TO DRAWING 5. REVISION 5 TO DRAWING 6. REVISION 6 TO DRAWING 7. REVISION 7 TO DRAWING 8. REVISION 8 TO DRAWING 9. REVISION 9 TO DRAWING 10. REVISION 10 TO DRAWING 11. REVISION 11 TO DRAWING 12. REVISION 12 TO DRAWING 13. REVISION 13 TO DRAWING 14. REVISION 14 TO DRAWING 15. REVISION 15 TO DRAWING 16. REVISION 16 TO DRAWING 17. REVISION 17 TO DRAWING 18. REVISION 18 TO DRAWING 19. REVISION 19 TO DRAWING 20. REVISION 20 TO DRAWING 21. REVISION 21 TO DRAWING 22. REVISION 22 TO DRAWING 23. REVISION 23 TO DRAWING 24. REVISION 24 TO DRAWING 25. REVISION 25 TO DRAWING 26. REVISION 26 TO DRAWING 27. REVISION 27 TO DRAWING 28. REVISION 28 TO DRAWING 29. REVISION 29 TO DRAWING 30. REVISION 30 TO DRAWING 31. REVISION 31 TO DRAWING 32. REVISION 32 TO DRAWING 33. REVISION 33 TO DRAWING 34. REVISION 34 TO DRAWING 35. REVISION 35 TO DRAWING 36. REVISION 36 TO DRAWING 37. REVISION 37 TO DRAWING 38. REVISION 38 TO DRAWING 39. REVISION 39 TO DRAWING 40. REVISION 40 TO DRAWING 41. REVISION 41 TO DRAWING 42. REVISION 42 TO DRAWING 43. REVISION 43 TO DRAWING 44. REVISION 44 TO DRAWING 45. REVISION 45 TO DRAWING 46. REVISION 46 TO DRAWING 47. REVISION 47 TO DRAWING 48. REVISION 48 TO DRAWING 49. REVISION 49 TO DRAWING 50. REVISION 50 TO DRAWING 51. REVISION 51 TO DRAWING 52. REVISION 52 TO DRAWING 53. REVISION 53 TO DRAWING 54. REVISION 54 TO DRAWING 55. REVISION 55 TO DRAWING 56. REVISION 56 TO DRAWING 57. REVISION 57 TO DRAWING 58. REVISION 58 TO DRAWING 59. REVISION 59 TO DRAWING 60. REVISION 60 TO DRAWING 61. REVISION 61 TO DRAWING 62. REVISION 62 TO DRAWING 63. REVISION 63 TO DRAWING 64. REVISION 64 TO DRAWING 65. REVISION 65 TO DRAWING 66. REVISION 66 TO DRAWING 67. REVISION 67 TO DRAWING 68. REVISION 68 TO DRAWING 69. REVISION 69 TO DRAWING 70. REVISION 70 TO DRAWING 71. REVISION 71 TO DRAWING 72. REVISION 72 TO DRAWING 73. REVISION 73 TO DRAWING 74. REVISION 74 TO DRAWING 75. REVISION 75 TO DRAWING 76. REVISION 76 TO DRAWING 77. REVISION 77 TO DRAWING 78. REVISION 78 TO DRAWING 79. REVISION 79 TO DRAWING 80. REVISION 80 TO DRAWING 81. REVISION 81 TO DRAWING 82. REVISION 82 TO DRAWING 83. REVISION 83 TO DRAWING 84. REVISION 84 TO DRAWING 85. REVISION 85 TO DRAWING 86. REVISION 86 TO DRAWING 87. REVISION 87 TO DRAWING 88. REVISION 88 TO DRAWING 89. REVISION 89 TO DRAWING 90. REVISION 90 TO DRAWING 91. REVISION 91 TO DRAWING 92. REVISION 92 TO DRAWING 93. REVISION 93 TO DRAWING 94. REVISION 94 TO DRAWING 95. REVISION 95 TO DRAWING 96. REVISION 96 TO DRAWING 97. REVISION 97 TO DRAWING 98. REVISION 98 TO DRAWING 99. REVISION 99 TO DRAWING 100. REVISION 100 TO DRAWING	ATR	01/02/14

TITLE: L DOOR ASSY
 SIZE: DWG. NO. D L-DOOR REV N
 SCALE: 1:6 WEIGHT: SHEET 1 OF 9

ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A	FRAME-RS, 30" STEEL (15 13/16" X 30")	2
2	SD523	FRAME-RS, 24" STEEL (15 13/16" X 96")	2
3	SD506	FLASHING-RS, 30" STEEL (6 5/8" X 36")	2
4	SD525	FLASHING-RS, 96" STEEL (6 5/8" X 102")	1
5	SD525P	FLASHING-RS, 96" STEEL, PUNCH (6 5/8" X 102")	1
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER-FRAME & FLASHING STEEL	11
8	SD165	NUT-WELD, 5/16"-18 STEEL	4
COVER			
9	SD516AL	COVER-RS, L-50 (3096), ALUM (46" X 110 3/4")	1
10	SD584	LINER-COVER RS, L-50 (3096), ALUM (34 9/16" X 99 9/32")	1
11	SD36AL	SPACER-COVER 1" ALUM	12
12	SD527AL	RIP-LOCK BOX, 1" X 98 1/4", ALUM	1
13	SD206	CORNER-COVER STIFFENER 2", ALUM	4
14	SD2	INSULATION-FIBERGLASS	15 SQ. FT
15	SD4026	GASKET-EPDM	22 FT
HARDWARE & ACCESSORIES			
16	KT13SS	KIT-HINGE RS, SS	4
17	KT3445-P	KIT-HOA, RS LH 1/4 1/4", STEEL FRAME	1
18	KT4820-P	KIT-GUIDE ARM, RS 1/4 1/4", STEEL FRAME	1
19	KT220N	KIT-SPRING 220#, RS, 1 EAR, COMPOSITE TUBES	2
20	KT100N	KIT-SPRING 100#, RS, 1 EAR, COMPOSITE TUBES	1
21	KITLXL50	KIT-LOCK 2PT, L-50	1
22	S33-Y	SCREW-TAPTITE 5/16-18 X 7/8" YELLOW CHRMT	3
23	SD16	FIBERBOARD 1" X 9 1/2" X 96"	2
24	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
25	SD125	TAPE-FIBERGLASS 3/4" X 12"	1
ITEMS NOT SHOWN			
26	KITLRLS	KIT-LABELS, RS	1
27	SD1030	PRIMER-RED OXIDE (FRAME ONLY)	A/R



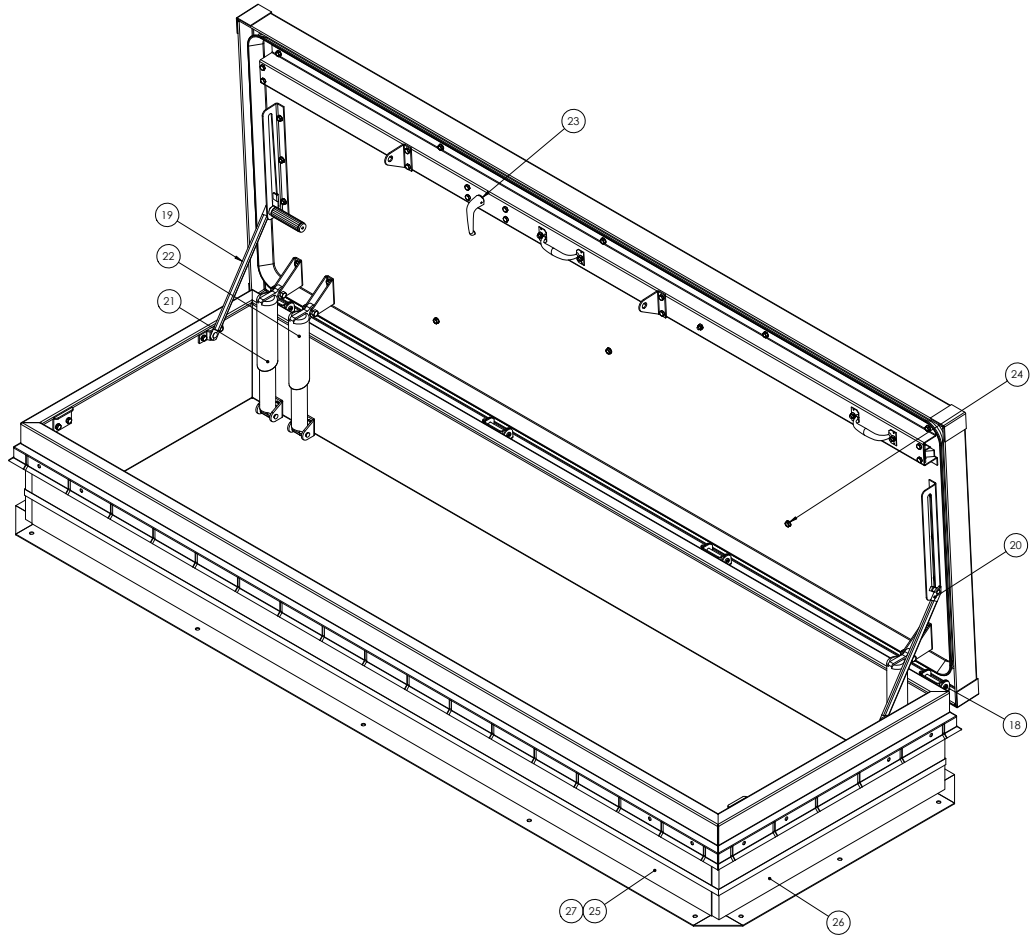
L-40



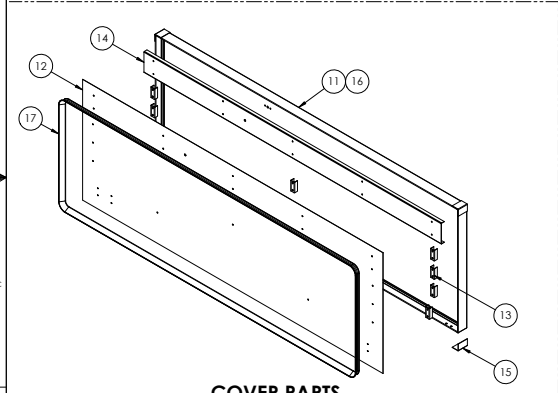
**RELEASED TO
MANUFACTURING**
DATE: 01/02/14
APPROVED BY: D.J.C.

<small>DO NOT SCALE DRAWING</small> <small>3RD ANGLE PROJECTION</small>	<small>DESIGN CHECKED BY:</small> <small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14	<small>NAME:</small> ATR <small>DATE:</small> 01/02/14	<small>THE BELCO COMPANY</small>
	<small>DESIGN AUTHORITY:</small> TJ <small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14	<small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14	<small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14 <small>DATE:</small> 01/02/14
L DOOR ASSY			
<small>SCALE: 1:16</small>	<small>REV</small> N	<small>SCALE: 1:16</small>	<small>REV</small> N

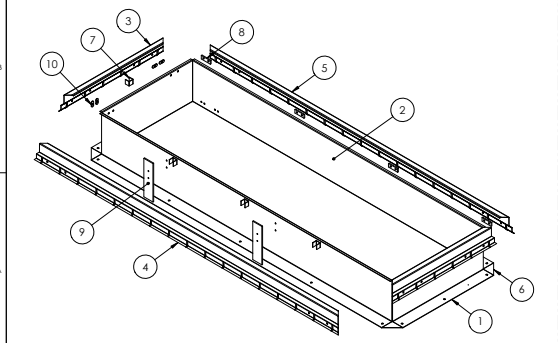
ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A-AL	FRAME-RS, 30" ALUM [15 13/16" x 30"]	2
2	SD523AL	FRAME-RS, 96" ALUM [15 13/16" x 96"]	2
3	SD506AL-1	FLASHING-RS, 30" ALUM, (6 5/8" x 36")	2
4	SD525AL	FLASHING-RS, 96" ALUM, (6 5/8" x 102")	1
5	SD525ALP	FLASHING-RS, 96" ALUM, PUNCH (6 5/8" x 102")	1
6	SD1649AL	FRAME-CORNER, ALUM	4
7	SD154L	SPACER-FRAME & FLASHING ALUM	11
8	SD1196	BUP-HINGE 1/4" X 1" X 3", ALUM	4
9	SD536AL	PLATE-REINF 1/4" X 3" X 11" ALUM	2
10	SD165AL	NUT-WELD, 5/16"-18 ALUM	8
COVER			
11	SD516AL	COVER-RS, L-50 (3096), ALUM (46" x 110 3/4")	1
12	SD584	LINER-COVER RS, L-50 (3096), ALUM (34 9/16" X 99 9/32")	1
13	SD36AL	SPACER-COVER 1" ALUM	12
14	SD527AL	BUP-LOCK BOX, 1" X 98 1/4", ALUM	1
15	SD206	CORNER-COVER STIFFENER 2", ALUM	4
16	SD2	INSULATION-FIBERGLASS	15 SQ. FT
17	SD4026	GASKET-EPDM	22 FT
HARDWARE & ACCESSORIES			
18	KT135SBF	KIT-HINGE RS SS, BUP FRAME	4
19	KT3445A-P	KIT-HOA, RS LH 1/4", ALUMINUM FRAME	1
20	KT4820A-P	KIT-GUIDE ARM, RS 1/4", ALUMINUM FRAME	1
21	KT220N	KIT-SPRING 220#, RS, 1 EAR, COMPOSITE TUBES	2
22	KT100N	KIT-SPRING 100#, RS, 1 EAR, COMPOSITE TUBES	1
23	KITLXL50	KIT-LOCK 2PT, L-50	1
24	SD3-Y	SCREW-TAPTITE 5/16-18 X 7/8" YELLOW CHRMT	3
25	SD16	FIBERBOARD 1" X 9 1/2" X 96"	2
26	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
27	SD125	TAPE-FIBERGLASS 3/4" X 12"	A/R
ITEMS NOT SHOWN			
28	KITLRLS	KIT-LABELS, RS	1



L-50



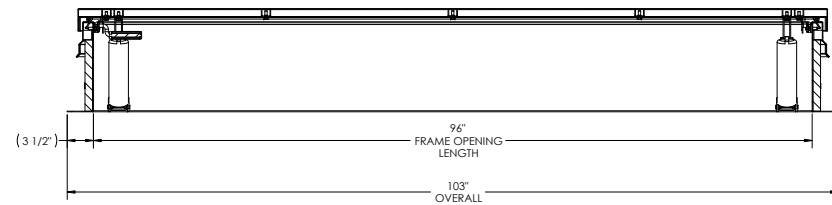
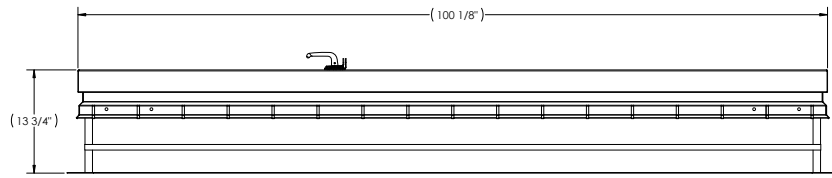
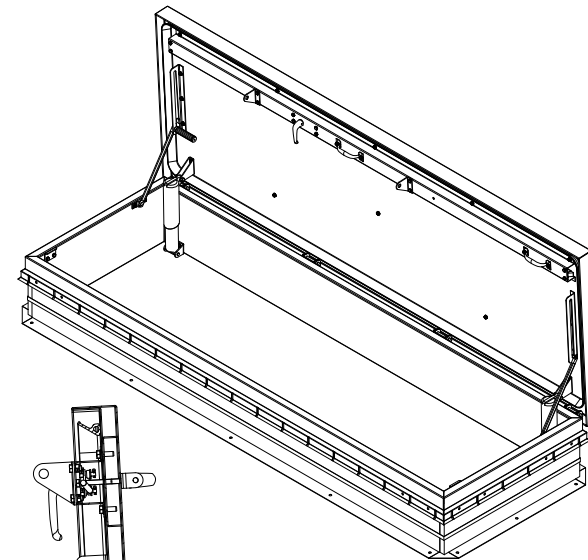
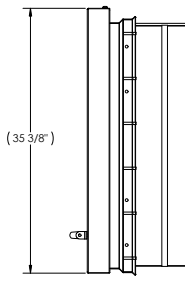
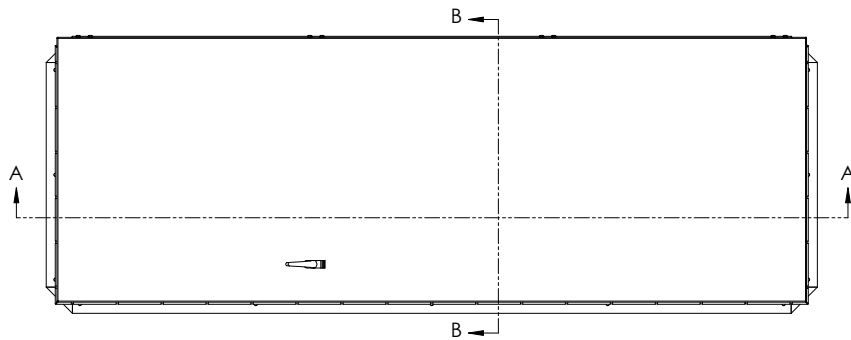
COVER PARTS



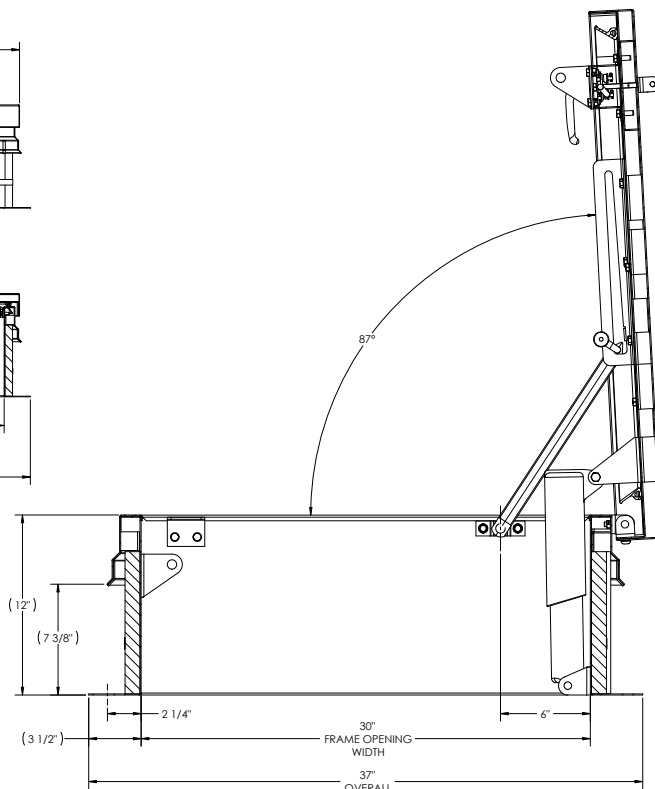
FRAME PARTS

RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED:		DATE: 01/02/14	THE BELCO COMPANY
STANDARD: UNLESS OTHERWISE SPECIFIED:	DESIGN: ATR	DATE: 01/02/14	TITLE: L DOOR ASSY
ASSEMBLY: UNLESS OTHERWISE SPECIFIED:	DESIGN AUTHOR: TJ	DATE: 02/08/00	
FINISH: UNLESS OTHERWISE SPECIFIED:	DESIGN CHECK: SP21	DATE: 02/08/00	REV: N
PROTECTIVE COATING: UNLESS OTHERWISE SPECIFIED:	CLASS: 1		SCALE: 1:4
PROTECTIVE COATING: UNLESS OTHERWISE SPECIFIED:	CLASS: 1		WEIGHT:
PROTECTIVE COATING: UNLESS OTHERWISE SPECIFIED:	CLASS: 1		SHEET 3 OF 9



SECTION A-A



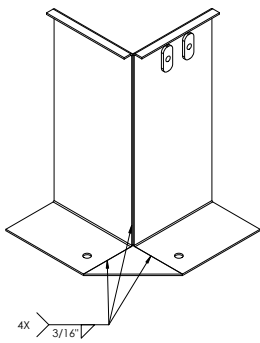
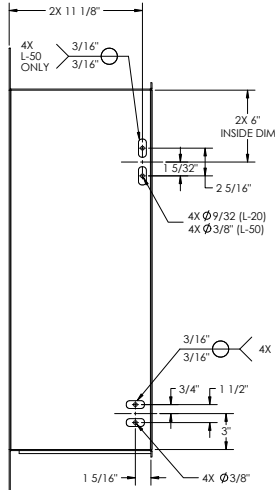
SECTION B-B

RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

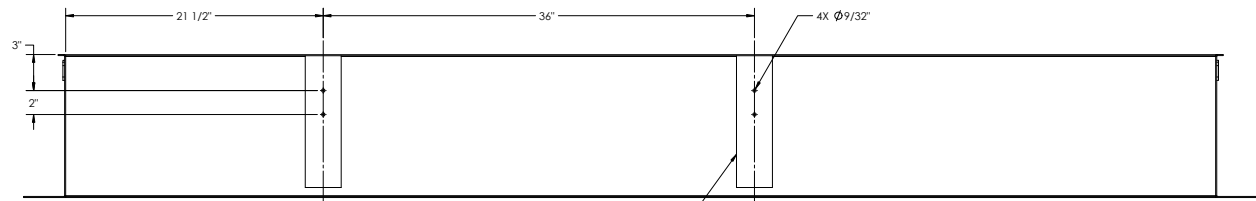
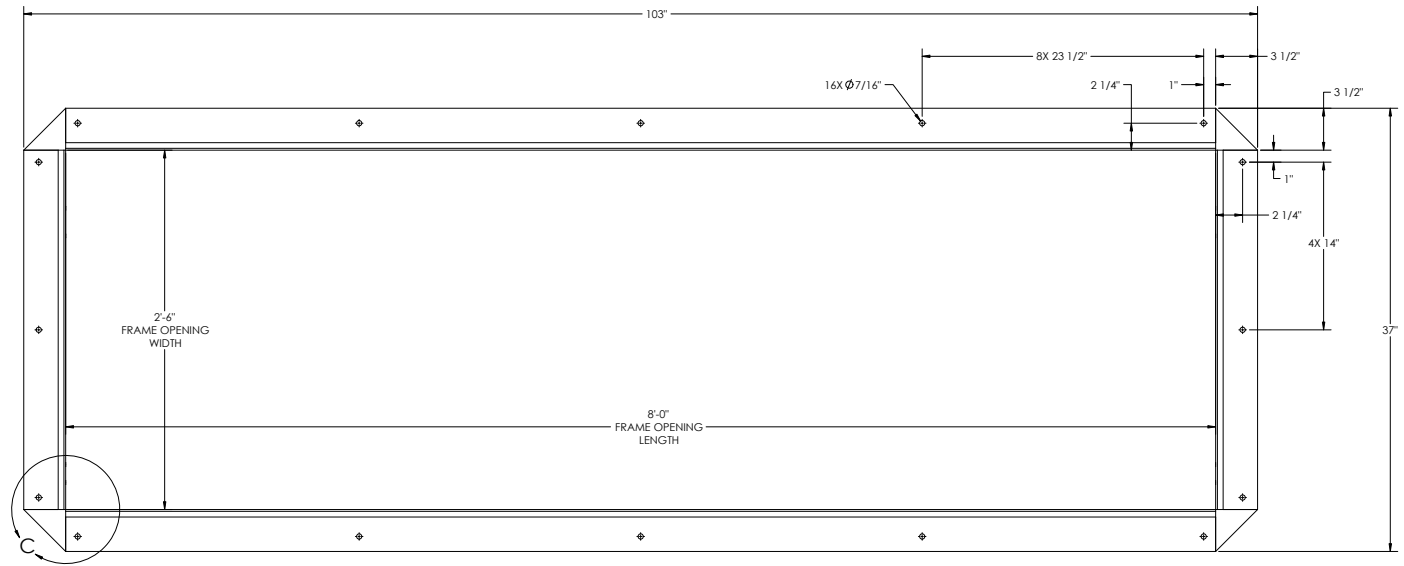
UNLESS OTHERWISE SPECIFIED:	MATERIAL	DATE	THE BILCO COMPANY
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	DRAWN	ATR	01/02/14
FINISHES ARE TO BE AS SHOWN ON THE DRAWING	DESIGNED BY	TR	
ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	CHKD BY	SP21	02/08/00
ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED	SCALE		
DO NOT SCALE DRAWING	3RD ANGLE PROJECTION		

L DOOR ASSY

SIZE DWG. NO. REV
D L-DOOR N
SCALE: 1:8 WEIGHT: SHEET 4 OF 9



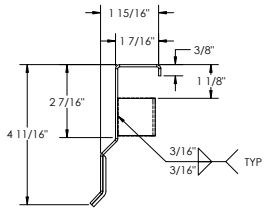
DETAIL C



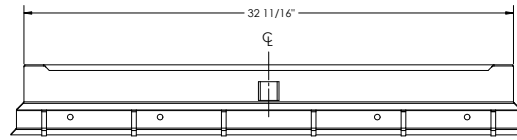
FRAME WELDMENT

<small> THE DIMENSIONS AND TOLERANCES ON THIS DRAWING ARE TO BE USED IN CONJUNCTION WITH THE DIMENSIONAL CONTROL PLAN FOR THIS PRODUCT. THE DIMENSIONAL CONTROL PLAN IS AVAILABLE FROM THE QUALITY DEPARTMENT. THE DIMENSIONS ON THIS DRAWING ARE NOT TO BE USED AS A BASIS FOR THE DESIGN OF THE PRODUCT OR FOR THE FABRICATION OF THE PRODUCT. THE DIMENSIONS ON THIS DRAWING ARE NOT TO BE USED AS A BASIS FOR THE DESIGN OF THE PRODUCT OR FOR THE FABRICATION OF THE PRODUCT. </small>	UNLESS OTHERWISE SPECIFIED: MATERIALS SHALL BE AS SHOWN FINISHES SHALL BE AS SHOWN	DRAWN: ATR DATE: 01/20/11	TITLE: L DOOR ASSY
	DESIGN AUTHORITY: TJ DESIGN CHECK: SPT/BJD/08/00 SCALE:	APPROVED BY: D.J.C.	
SIZE: D DWG. NO.: L-DOOR SCALE: 1:1 WEIGHT:	3RD ANGLE PROJECTION	REV: N SHEET 5 OF 9	THE BILCO COMPANY

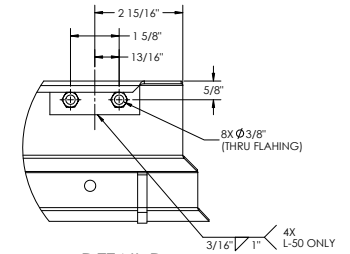
RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.



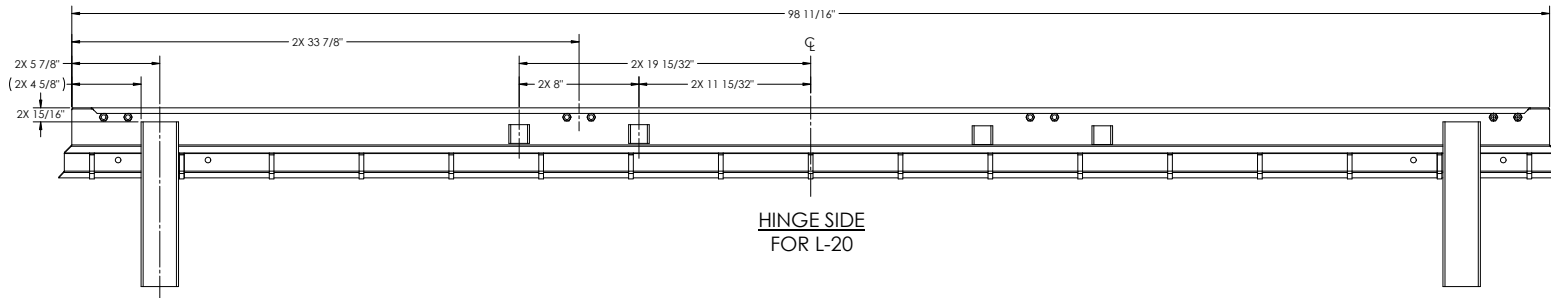
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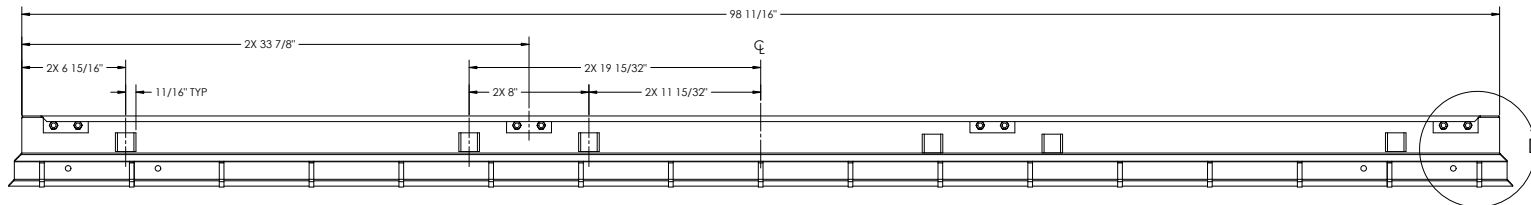
NON-HINGE SIDES



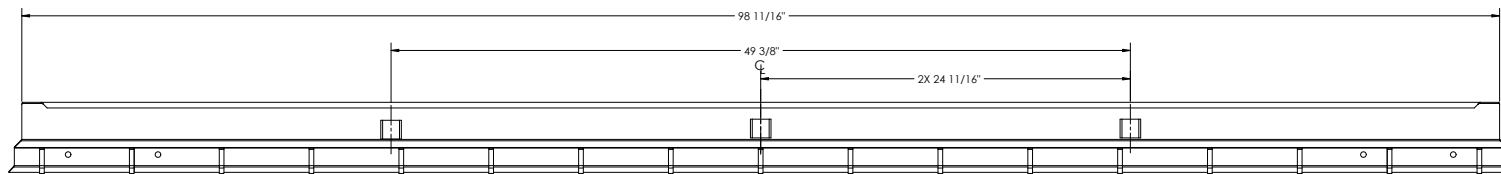
DETAIL D



HINGE SIDE
FOR L-20



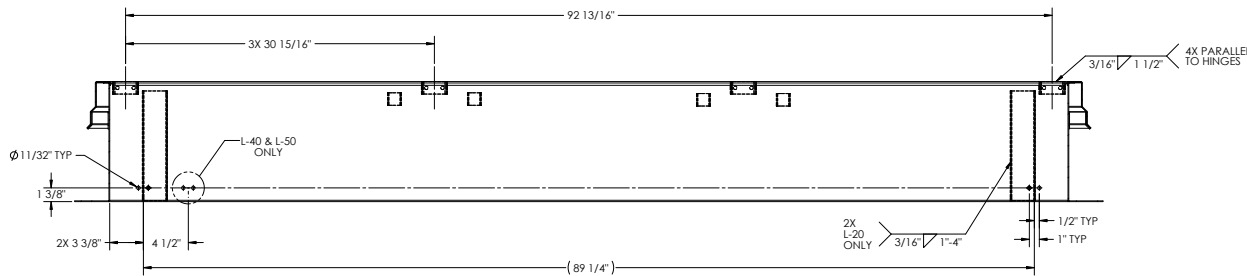
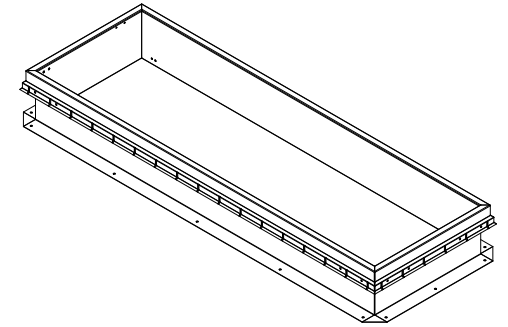
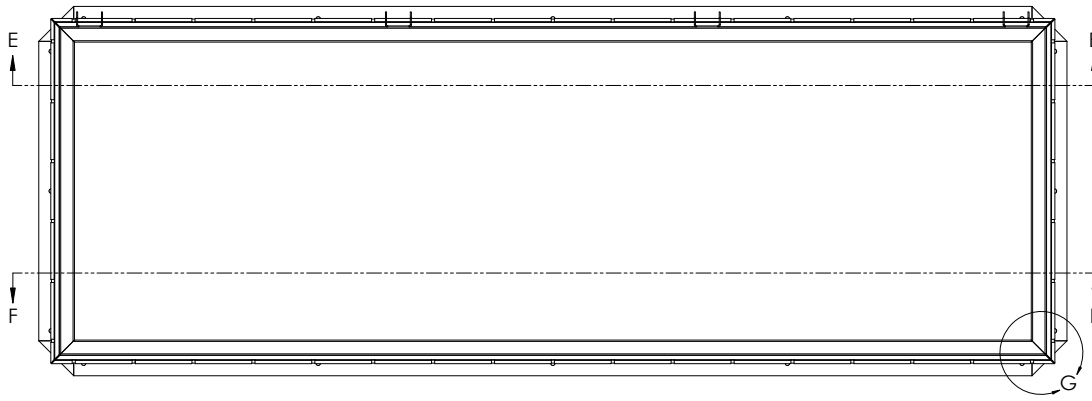
HINGE SIDE
FOR L-40 & L-50



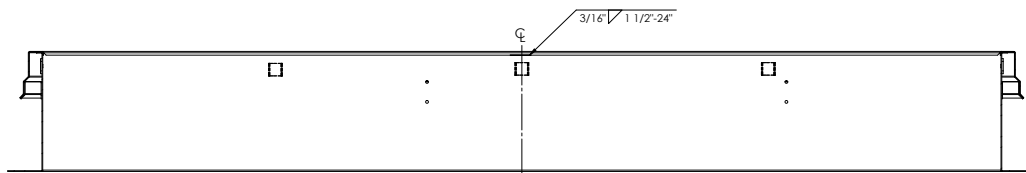
LATCH SIDE
FLASHING WELDMENT

RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES AND DECIMALS THEREOF. DIMENSIONS ARE TO BE TAKEN TO THE CENTERLINE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO BE TAKEN TO THE SURFACE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO BE TAKEN TO THE CENTERLINE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO BE TAKEN TO THE SURFACE UNLESS OTHERWISE SPECIFIED.	DATE: 01/02/14	THE BILCO COMPANY
DRAWN: ATR	DESIGNED: T3	TITLE: L DOOR ASSY
CHECKED: SP21	DATE: 02/05/00	SCALE: 1:4
3RD ANGLE PROJECTION	SIZE: D	DWG. NO.: L-DOOR
DO NOT SCALE DRAWING	REV: N	WEIGHT: SHEET 6 OF 9

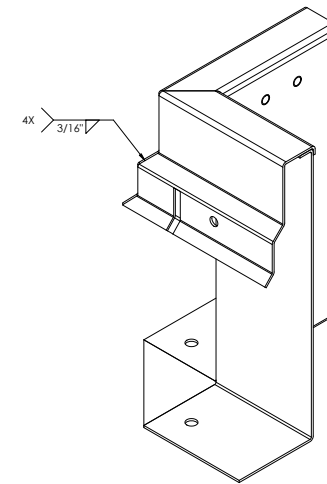


SECTION E-E
HINGE SIDE



SECTION F-F
LATCH SIDE

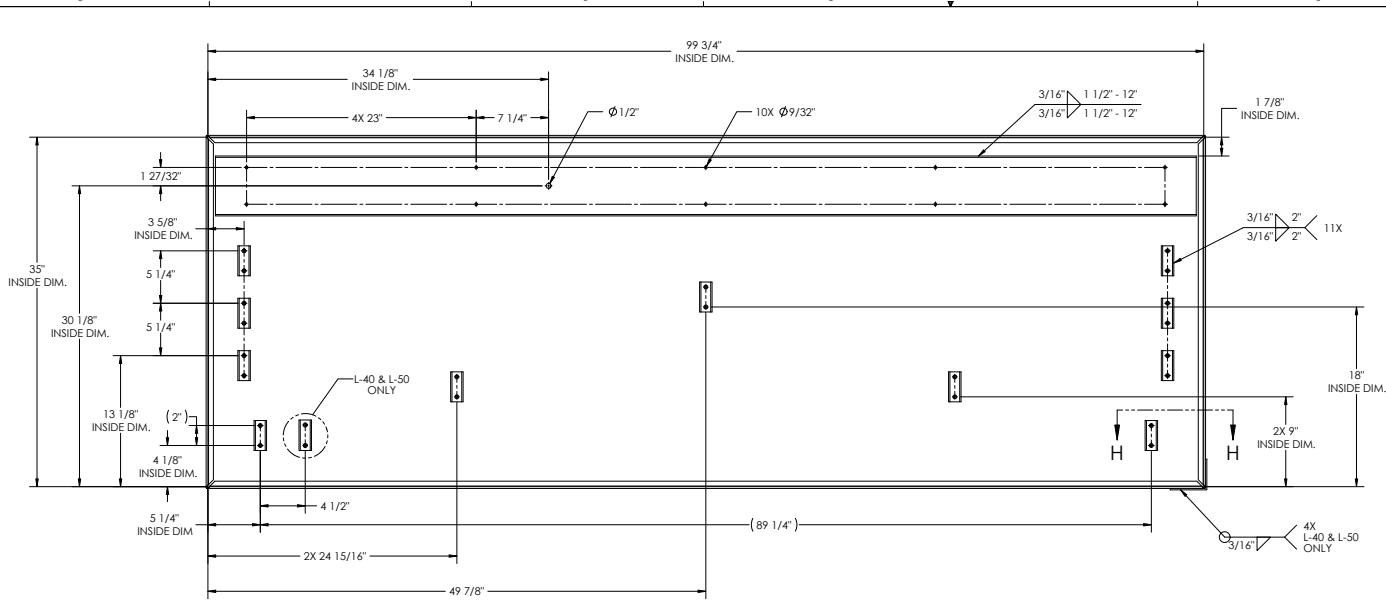
FRAME/FLASHING WELDMENT



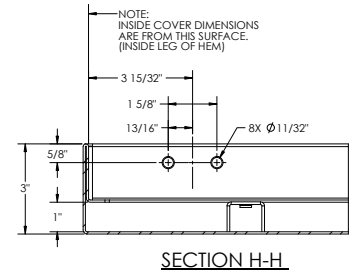
DETAIL G

RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

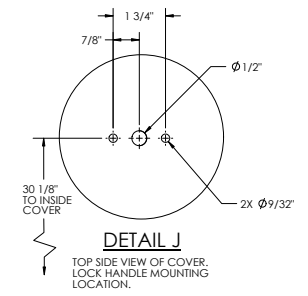
UNLESS OTHERWISE SPECIFIED:		NAME: ATR	DATE: 01/02/14	THE BILCO COMPANY
DRAWING: ATR		DATE: 01/02/14	TITLE: L DOOR ASSY	
DESIGNED BY: TJ		DESIGNED DATE: 02/26/00	SCALE: 1:1	SIZE: D DWG. NO.: L-DOOR SCALE: 1:1 WEIGHT: N SHEET 7 OF 9
CHECKED BY: SPZ		DATE: 02/26/00	3RD ANGLE PROJECTION	
APPROVED BY: D.J.C.				
DO NOT SCALE DRAWING				



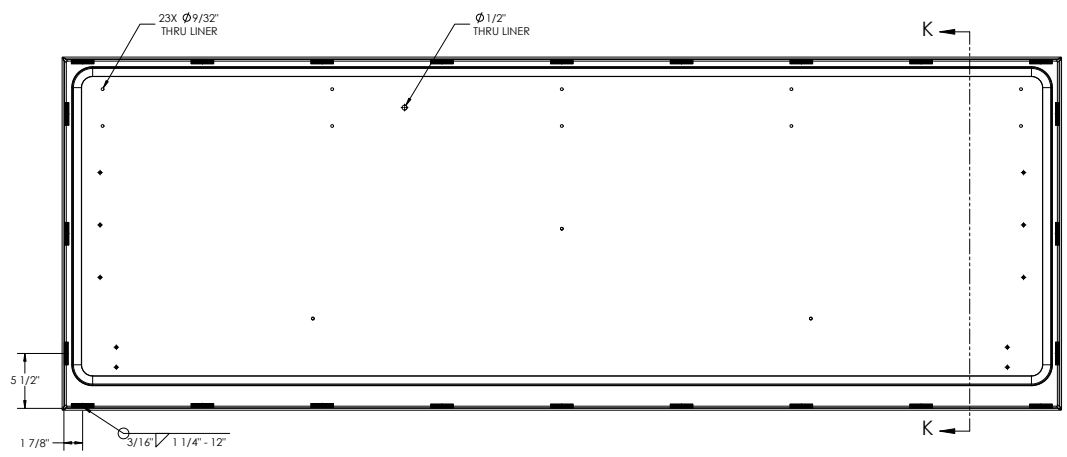
COVER SPACER LAYOUT



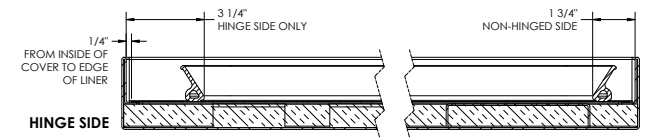
SECTION H-H



DETAIL J



COVER LINER WELDMENT & GASKET LOCATIONS

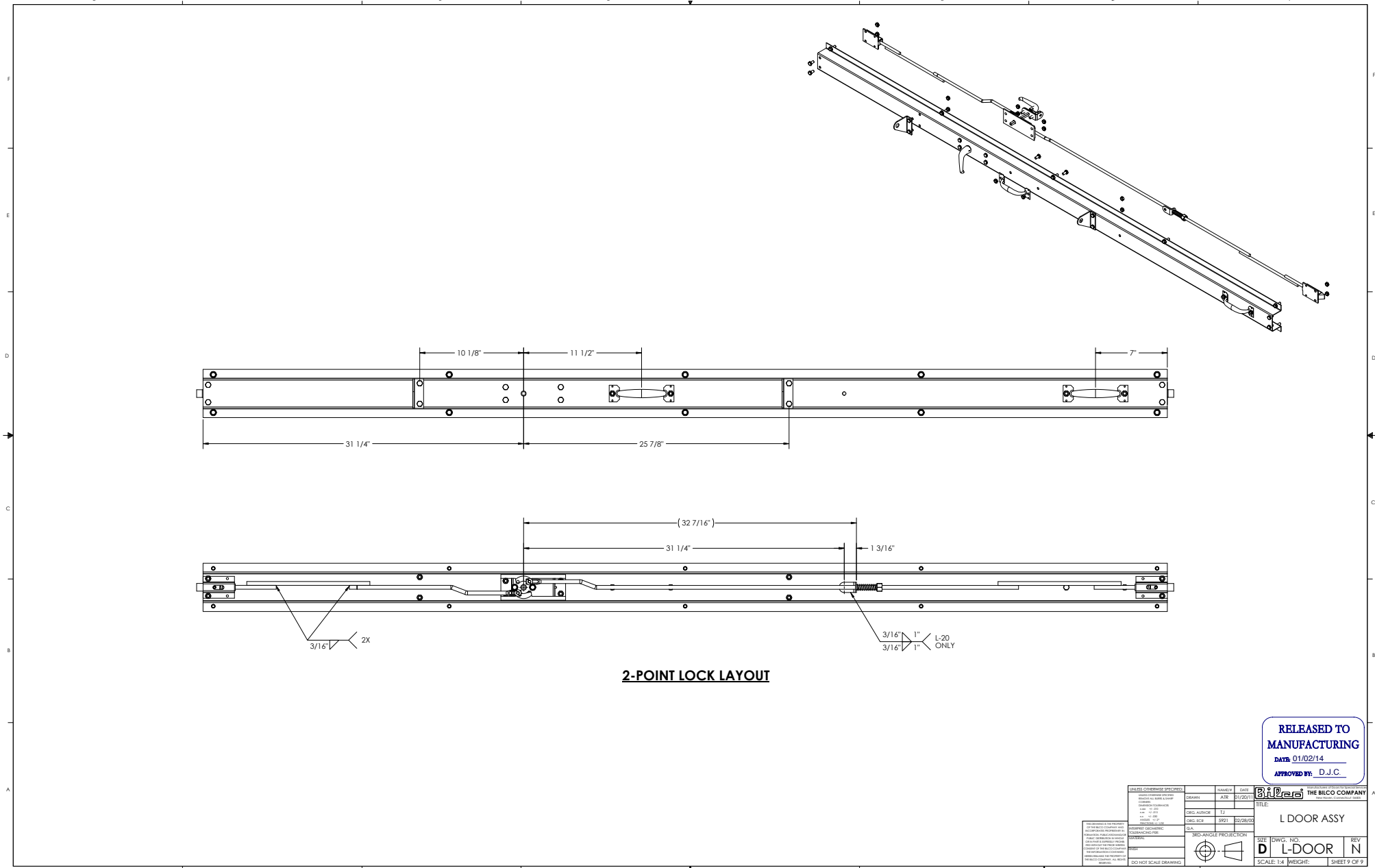


SECTION K-K

RELEASED TO
MANUFACTURING
DATE: 01/02/14
APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED:	DATE: 01/02/14	THE BILCO COMPANY
DESIGNED BY: ATR	DRAWN BY: ATR	TITLE: L DOOR ASSY
CHECKED BY: SPZ	DATE: 02/05/00	SIZE: D
APPROVED BY: D.J.C.	DATE: 01/02/14	SCALE: 1:1
REV: N	REV: N	WEIGHT: SHEET 8 OF 9

8 7 6 5 4 3 2 1



2-POINT LOCK LAYOUT

RELEASED TO MANUFACTURING
 DATE: 01/02/14
 APPROVED BY: D.J.C.

THE BILCO COMPANY

TITLE: **L DOOR ASSY**

DESIGNER: J. J. J.	DATE: 01/02/14
DRAWN: ATR	DATE: 01/02/14
CHECKED: J. J. J.	
DESIGN AUTHORITY: J. J. J.	
DESIGN DATE: 01/02/14	
DESIGN BY: J. J. J.	
DESIGN NO: 5921	02/08/00
SCALE:	
3RD ANGLE PROJECTION	
DO NOT SCALE DRAWING	

SIZE: DWG. NO. **D** L-DOOR REV **N**
 SCALE: 1:4 WEIGHT: SHEET 9 OF 9