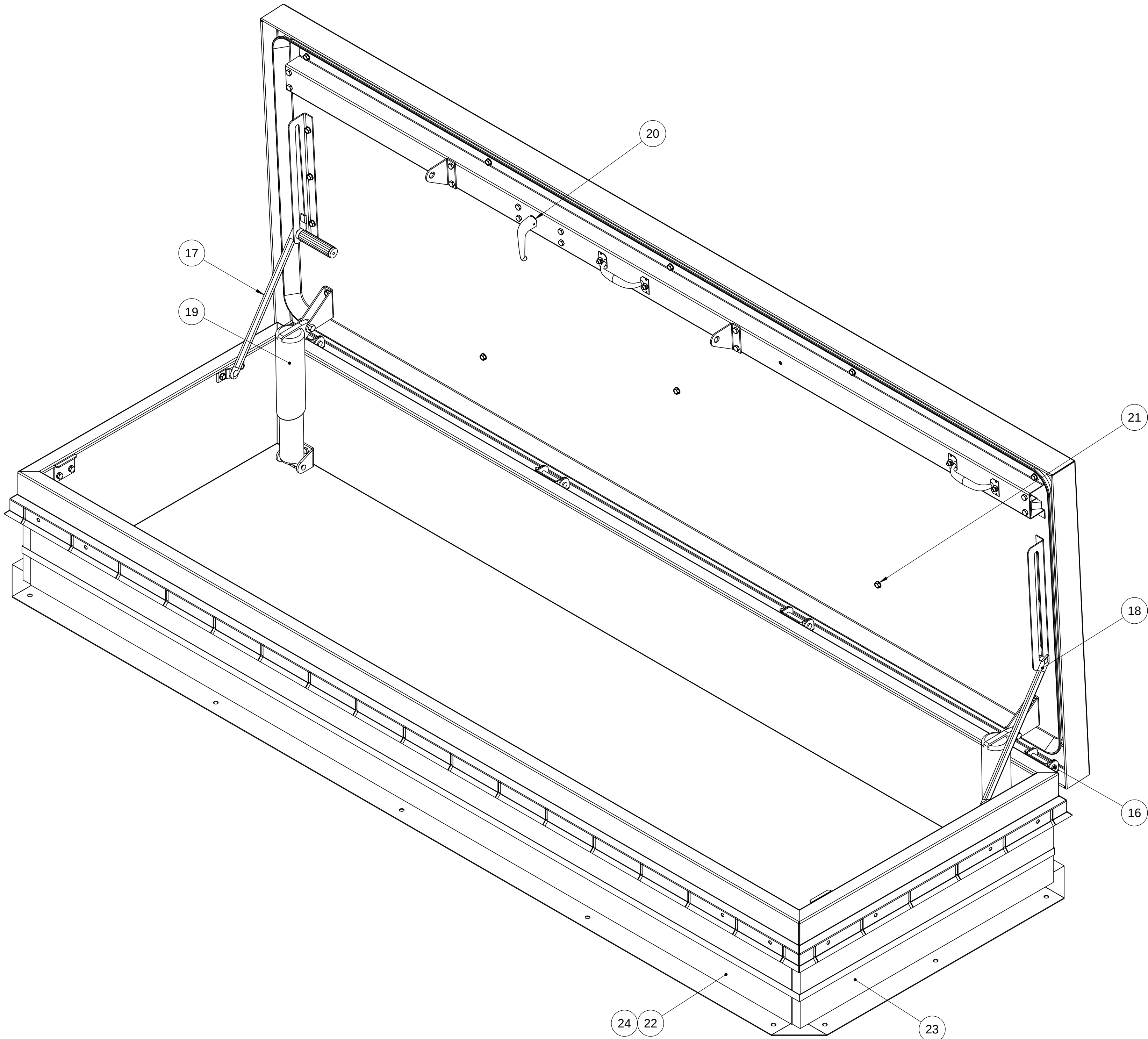
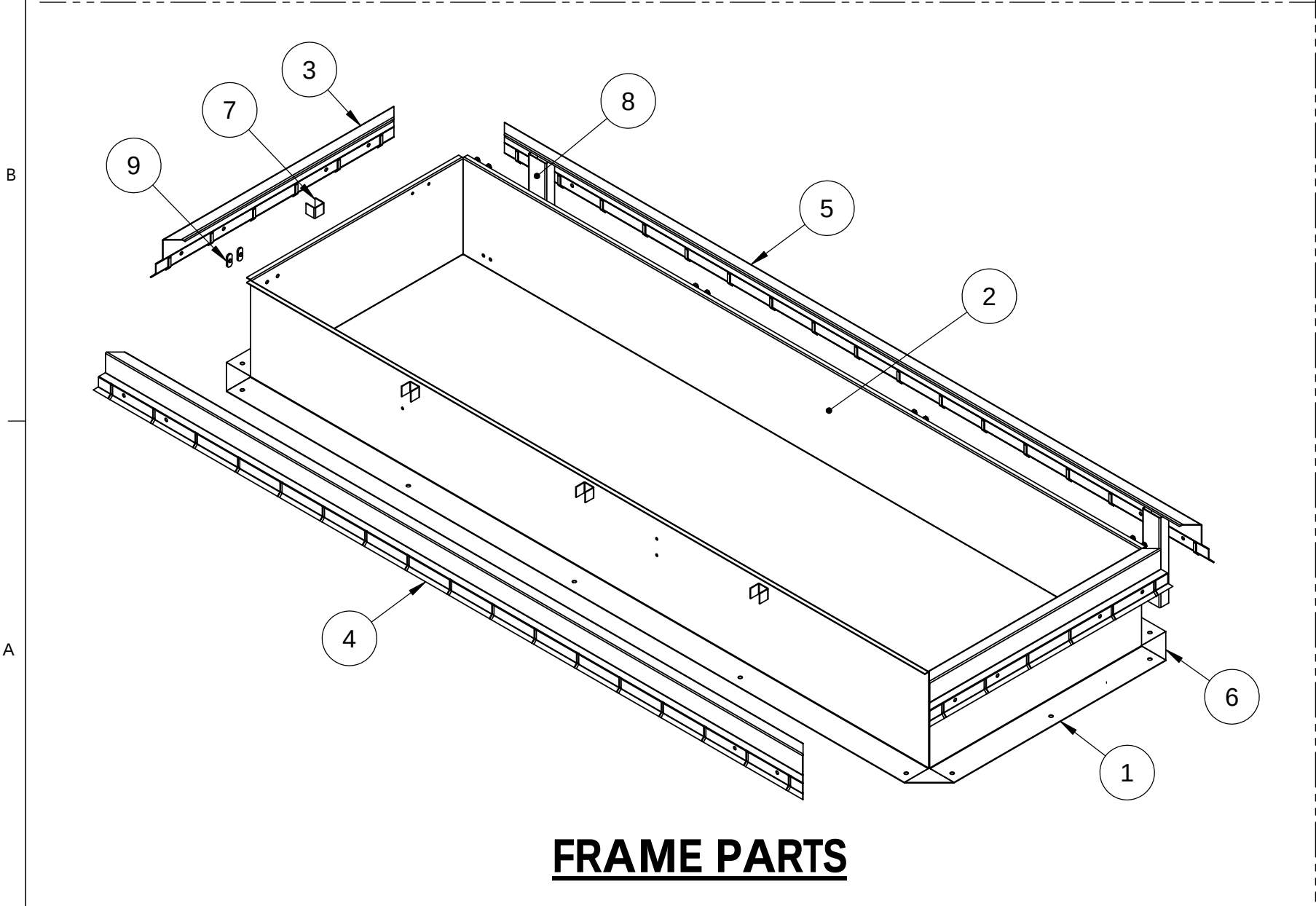
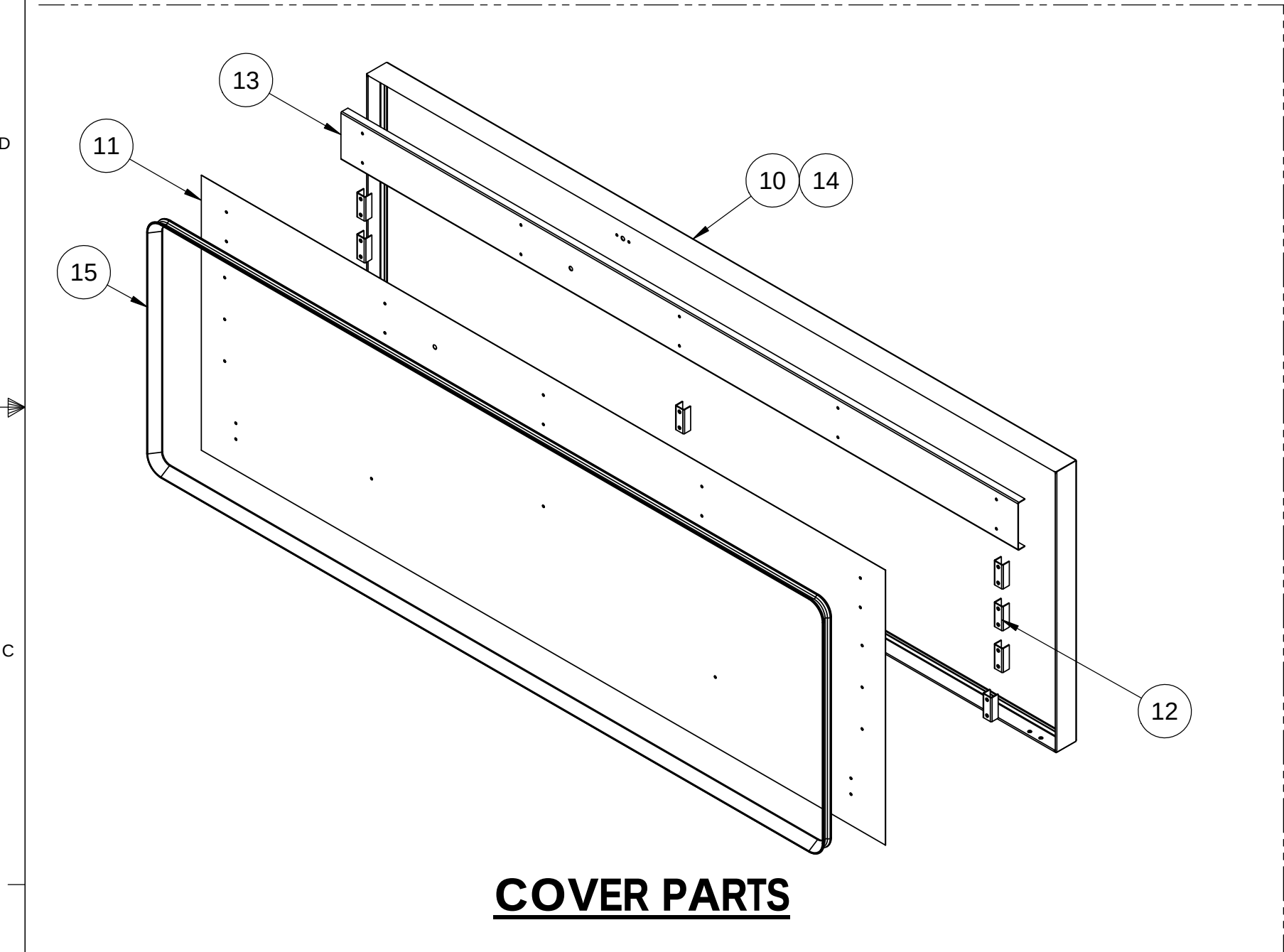


ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A	FRAME-RS, 30" STEEL (15 13/16" X 30")	2
2	SD523	FRAME-RS, 96" STEEL (15 13/16" x 96")	2
3	SD506	FLASHING-RS, 30" STEEL, (6 5/8" x 36")	2
4	SD525	FLASHING-RS, 96" STEEL, (6 5/8" x 102")	1
5	SD525P	FLASHING-RS, 96" STEEL, PUNCH (6 5/8" x 102")	1
6	SD1649	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	BUP-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	KTLBXL20	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	SD16-1	FIBERBOARD 1" X 9 1/2" X 32"	2
24	SD125	TAPE-FIBERGLASS 3/4" X 12'	A/R
ITEMS NOT SHOWN			
25	KTLBL-RS	KIT-LABELS, RS	1
26	SD1030	PRIMER-RED OXIDE	A/R



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	32622	ATR	11/21/13
L	ADDED KT100N (100# SPRING) TO L-40 & L-50	31597	ATR	01/08/13
K	ADDED KITS TO BOM, CHANGED SPRING LOAD, HOA, FRAME CORNER, SPRING HOUSING BRACKET, TURN HANDLE ASSY & HINGE WELD NUT	29540	ATR	06/01/12
REV.	DESCRIPTION	ECR	BY	DATE

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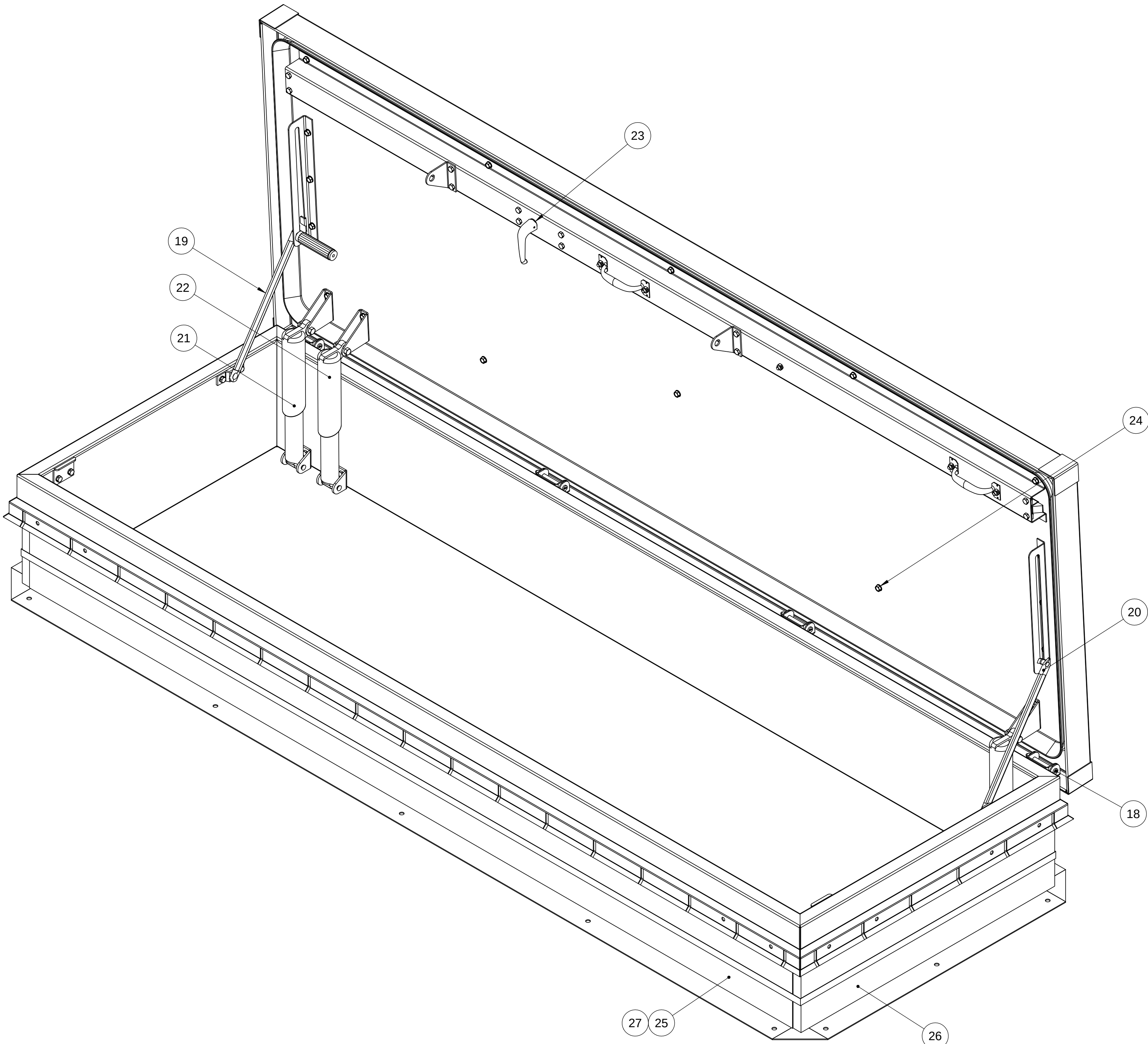
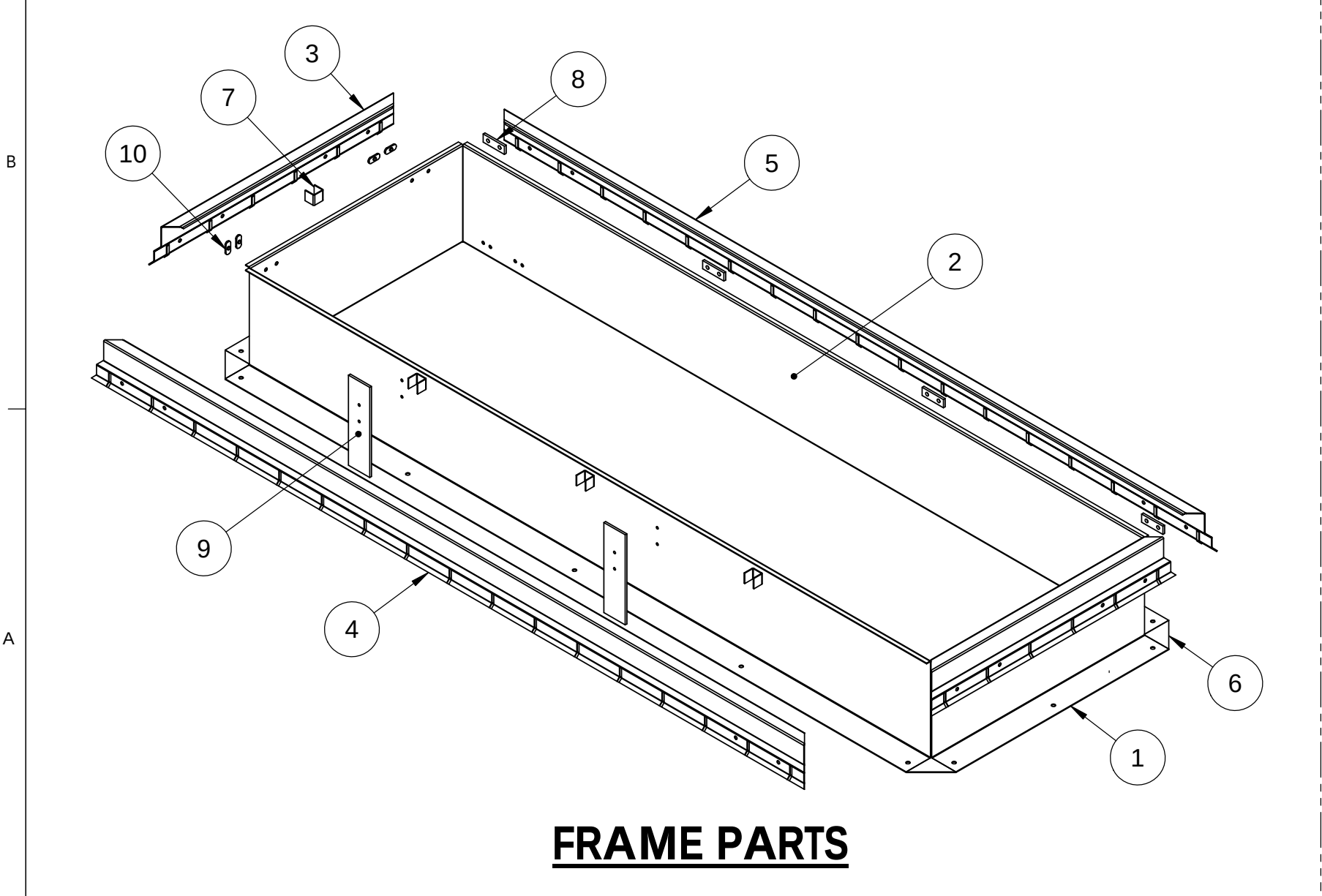
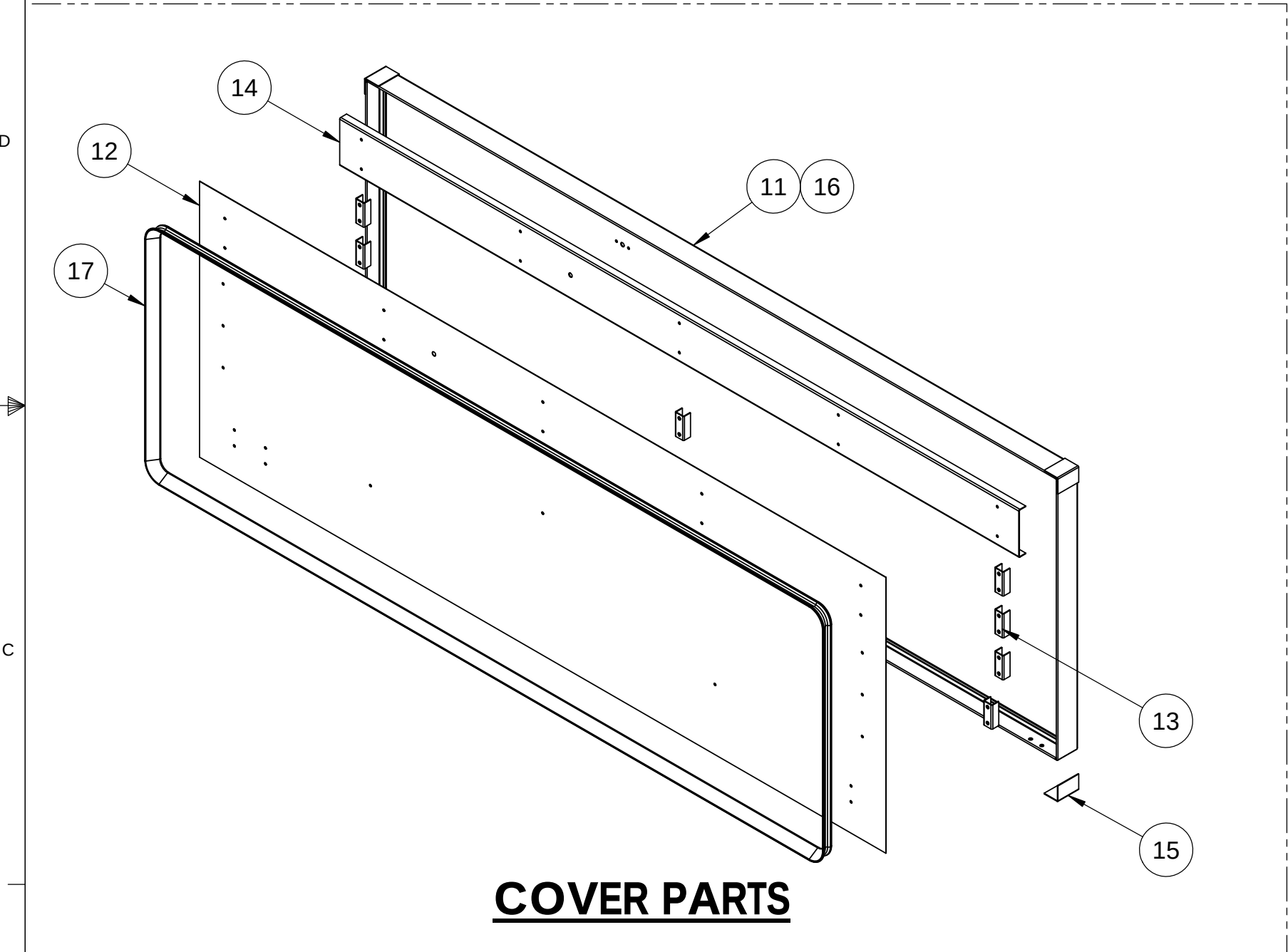
UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES XMM +/- .250 INCH +/- .005 FRACTIONS +/- .005		DRAWN	ATR	01/20/11
INTERPRET GEOMETRIC TOLERANCING PER:		ORG. AUTHOR	TJ	
MATERIAL		ORG. ECR	5921	02/28/00
FINISH		Q.A.		
DO NOT SCALE DRAWING		3RD-ANGLE PROJECTION		

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

THE BILCO COMPANY New Haven, Connecticut 06605		TITLE: L DOOR ASSY	
SIZE	DWG. NO.	REV	
D	L-DOOR	N	
SCALE: 1:6	WEIGHT:	SHEET 1 OF 9	

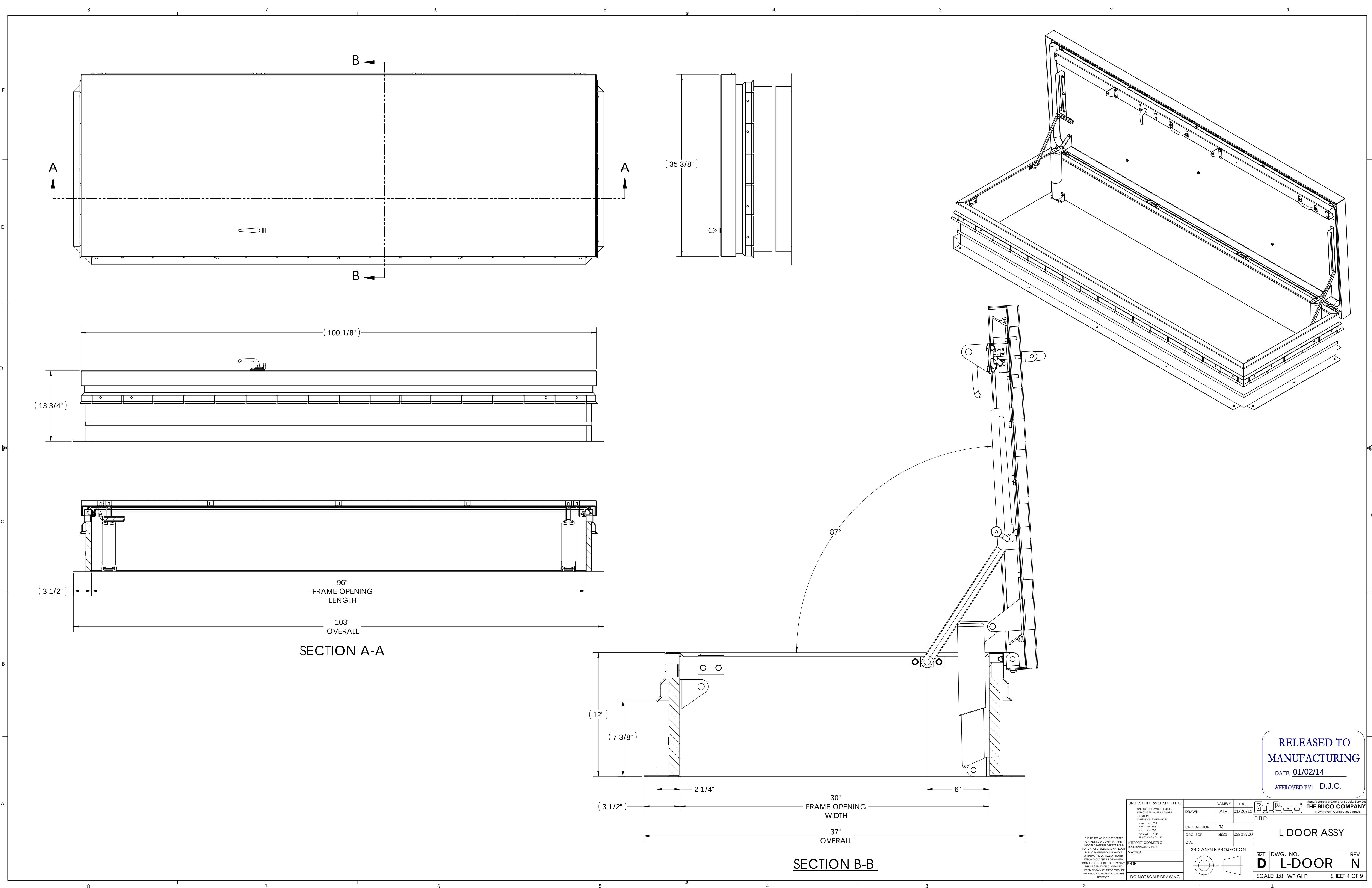
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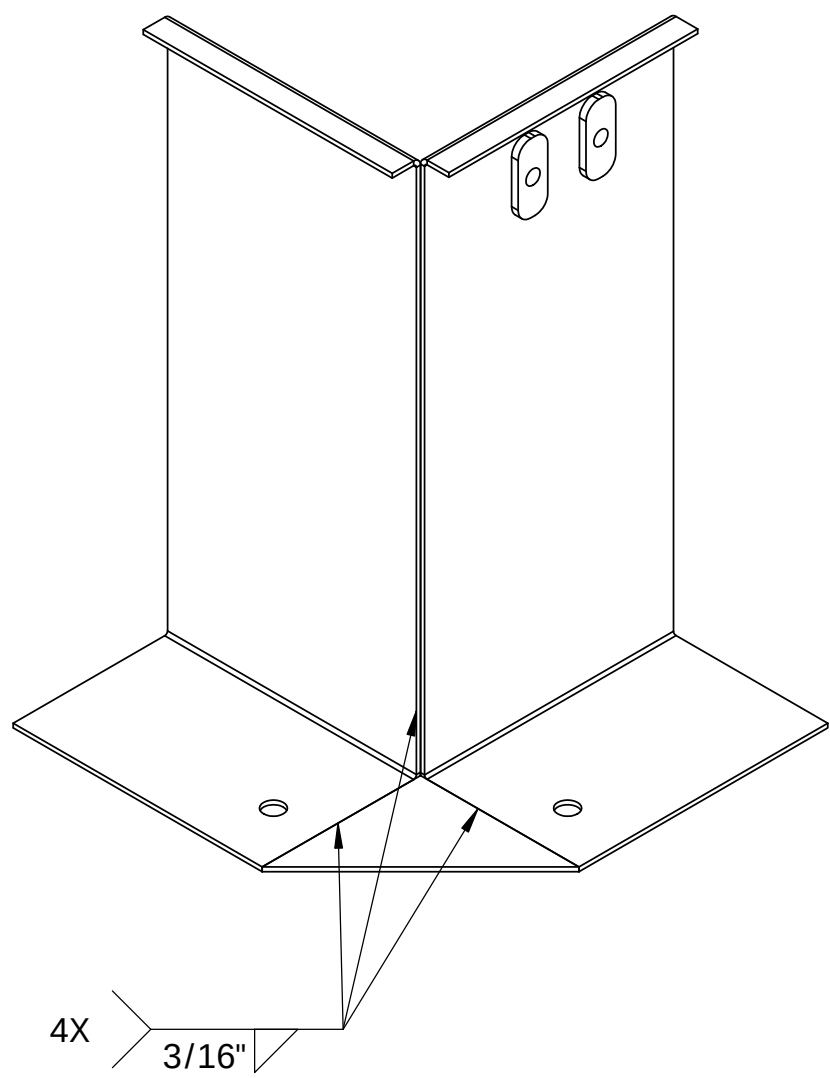
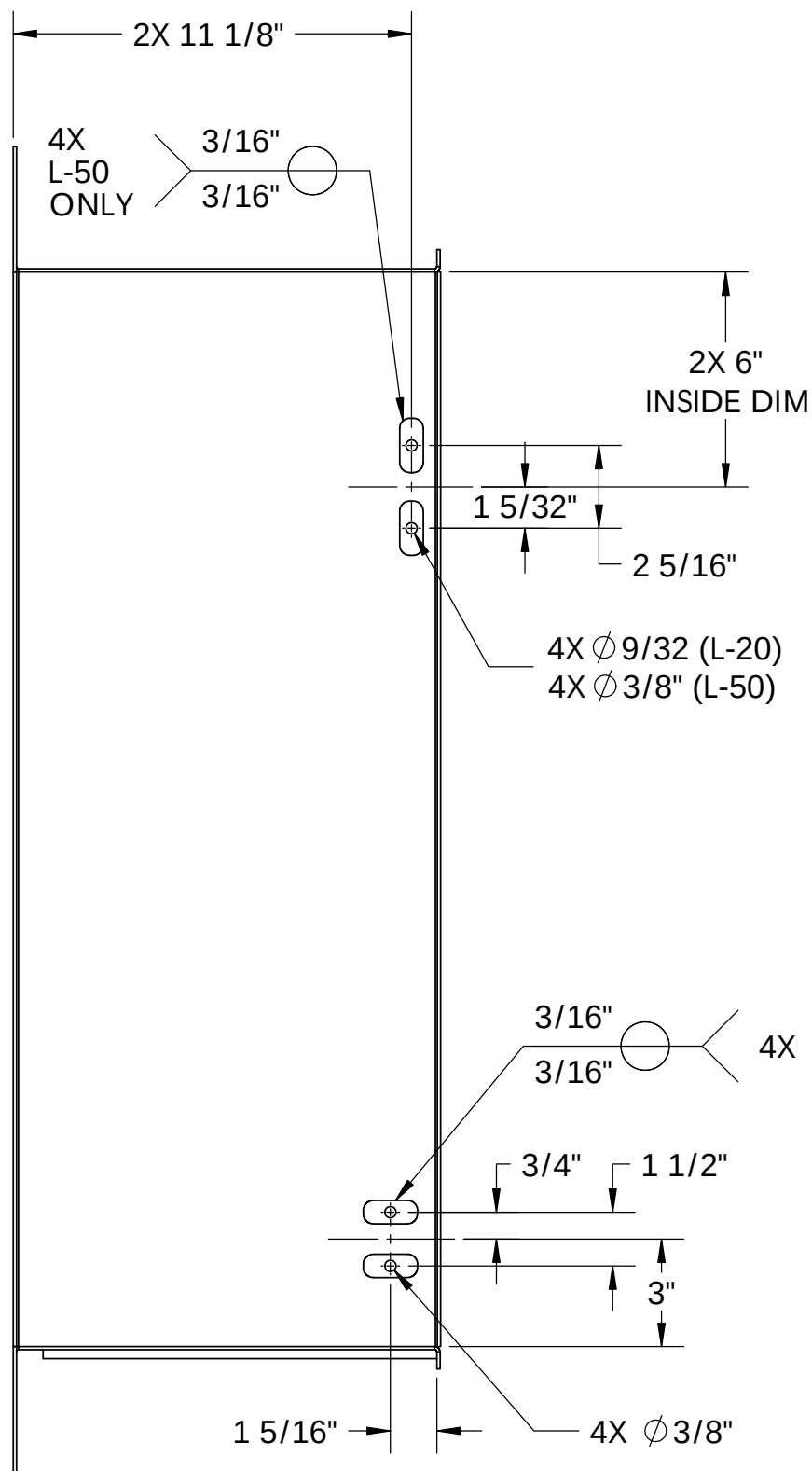
ITEM NO.	PART NO.	DESCRIPTION	QTY.
FRAME			
1	SD504A-AL	FRAME-RS, 30" ALUM (15 13/16" x 30")	2
2	SD523AL	FRAME-RS, 96" ALUM (15 13/16" x 96")	2
3	SD506AL-1	FLASHING-RS, 30" ALUM, (6 5/8" x 36")	2
4	SD525AL	FLASHING-RS, 96" ALUM, (6 5/8" x 102")	1
5	SD525ALP	FLASHING-RS, 96" ALUM, PUNCH (6 5/8" x 102")	1
6	SD1649AL	FRAME-CORNER, ALUM	4
7	SD15AL	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	KT13SSBF	KIT-HINGE RS SS, BUP FRAME	4
19	KT3445A-P	KIT-HOA, RS LH 14 1/4", ALUMINUM FRAME	1
20	KT4820A-P	KIT-GUIDE ARM, RS 14 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	KTLBXL50	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	KTLBL-RS	KIT-LABELS, RS	1



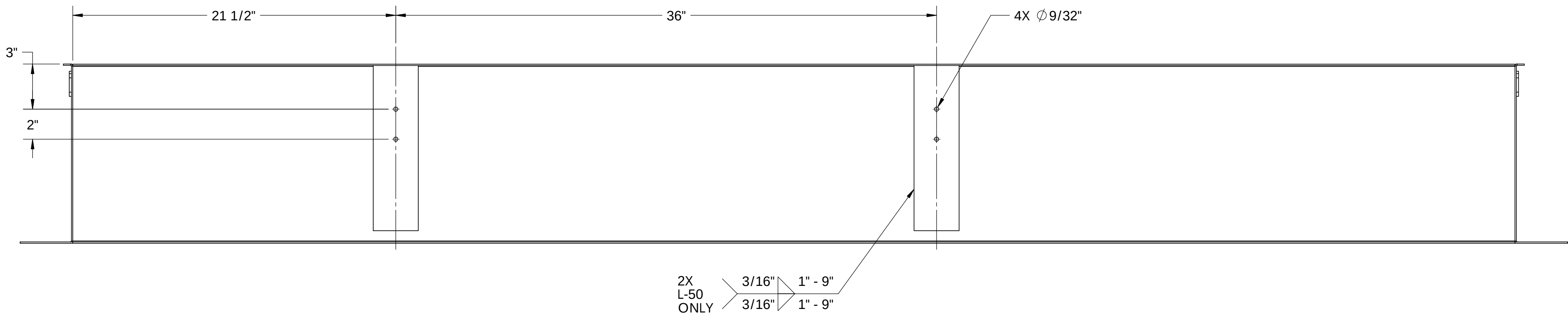
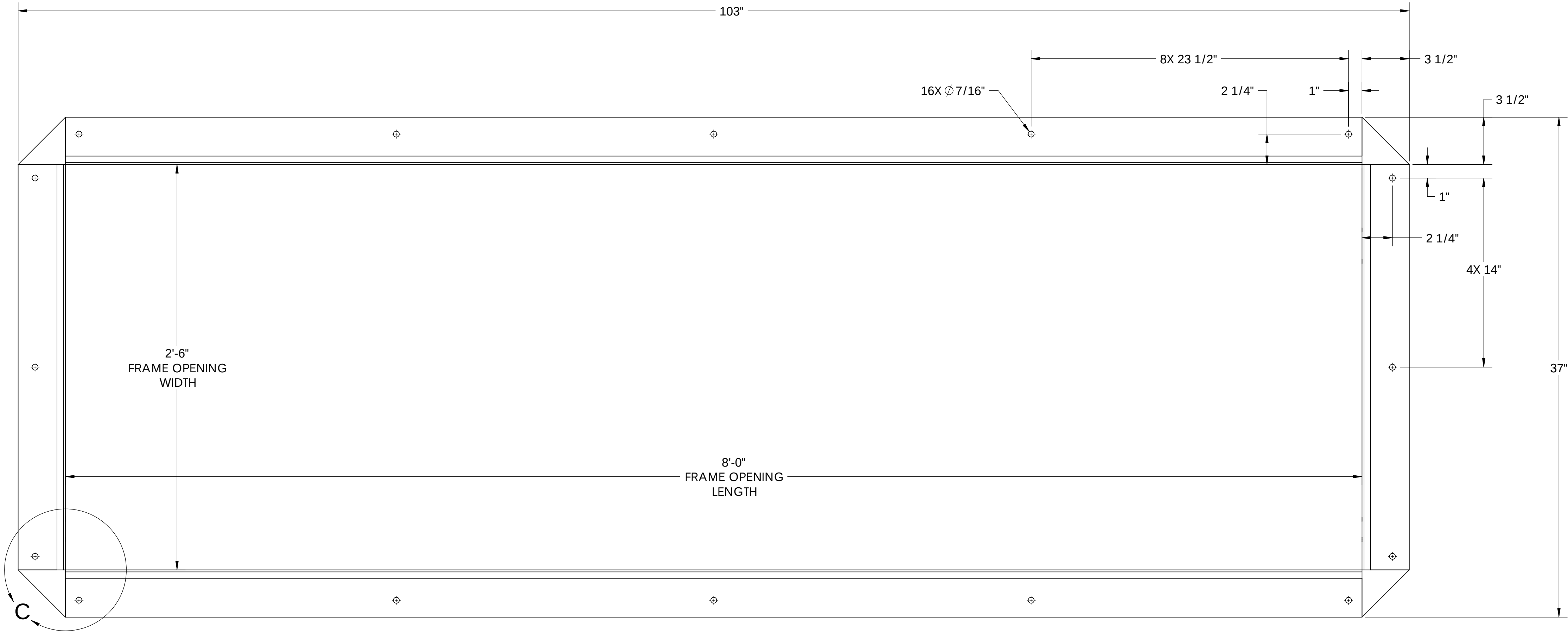
L-50

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURS & SHARP CORNERS DIMENSION TOLERANCES X.XX -1/2, 0.00 X.X -1/2, 0.00 X.X -1/2, 0.00 FRACTIONS -1/2, 0.00		NAME/ID DRAWN ATR 01/20/11	DATE 01/20/11
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MATERIAL FINISH DO NOT SCALE DRAWING		Q.A. 3RD-ANGLE PROJECTION	INTERPRET GEOMETRIC TOLERANCING PER:
RELEASED TO MANUFACTURING DATE: 01/02/14 APPROVED BY: D.J.C.		THE BILCO COMPANY New Haven, Connecticut 06605	
SIZE D		DWG. NO. L-DOOR	
SCALE: 1:6		WEIGHT: SHEET 3 OF 9	
REV N		REV N	





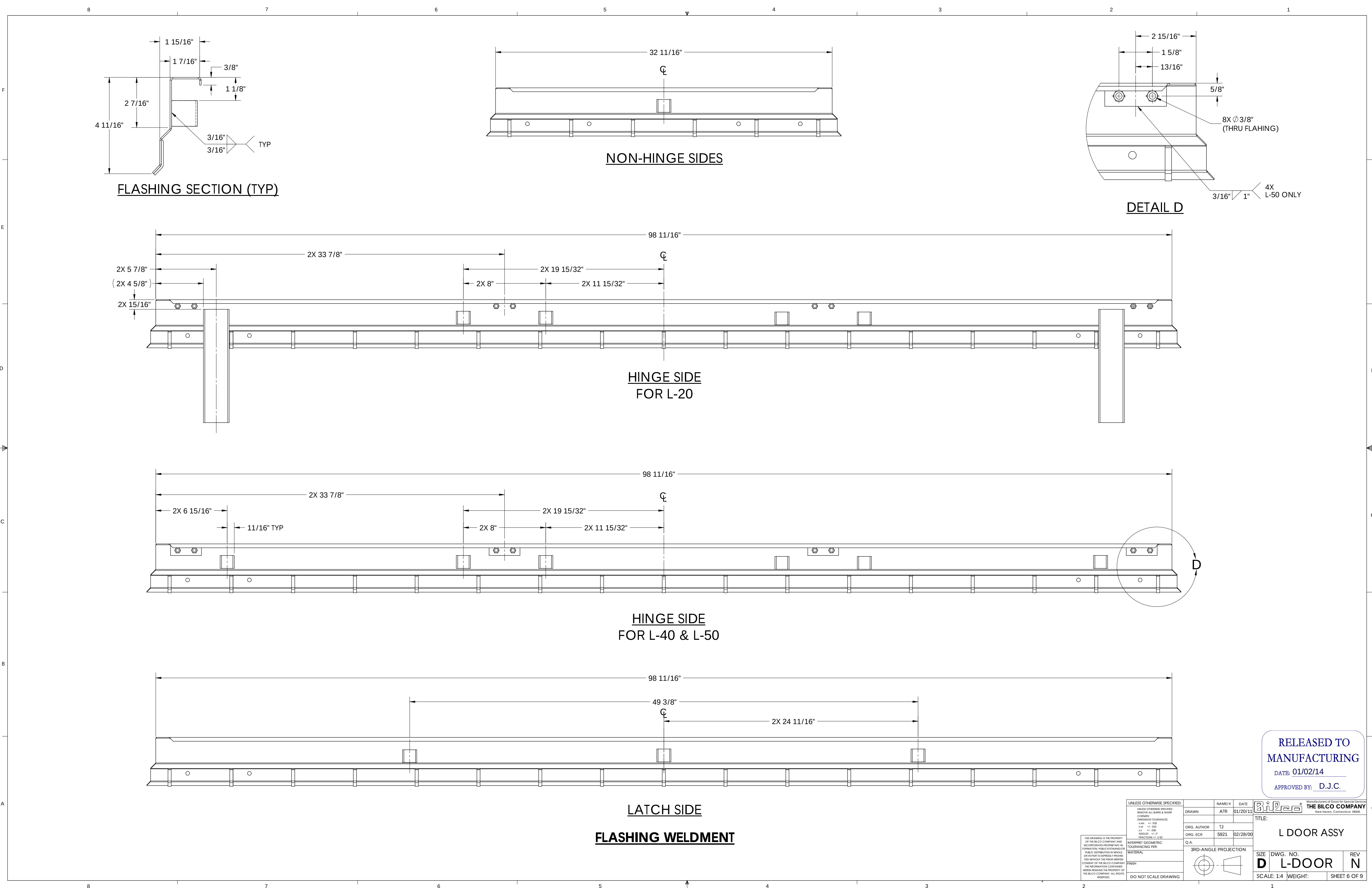
DETAIL C



FRAME WELDMENT

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

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES X.XX .01 .005 X.X .01 .005 X.XX .01 .005 FRACTIONS .01 .005		NAME/DATE	DATE	THE BILCO COMPANY Manufacturers of Doors for Special Services New Haven, Connecticut 06605	
DRAWN	ATR	01/20/11		TITLE: L DOOR ASSY	
ORG. AUTHOR	TJ			SIZE DWG. NO. D L-DOOR	
ORG. ECR	5921	02/28/00		REV N	
Q.A.		3RD-ANGLE PROJECTION		SCALE: 1:5 WEIGHT: SHEET 5 OF 9	
DO NOT SCALE DRAWING		MATERIAL		FINISH	
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MANUFACTURING

DATE: 01/02/14

APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES X.XX -1/2 .005 X.X -1/2 .005 X.XX -1/2 .005 FRACTIONS -1/2 .005		NAME/DATE DRAWN ATR 01/20/11	3RD-ANGLE PROJECTION 	
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MATERIAL		ORG. ECR 5921		Q.A.
FINISH		DO NOT SCALE DRAWING		

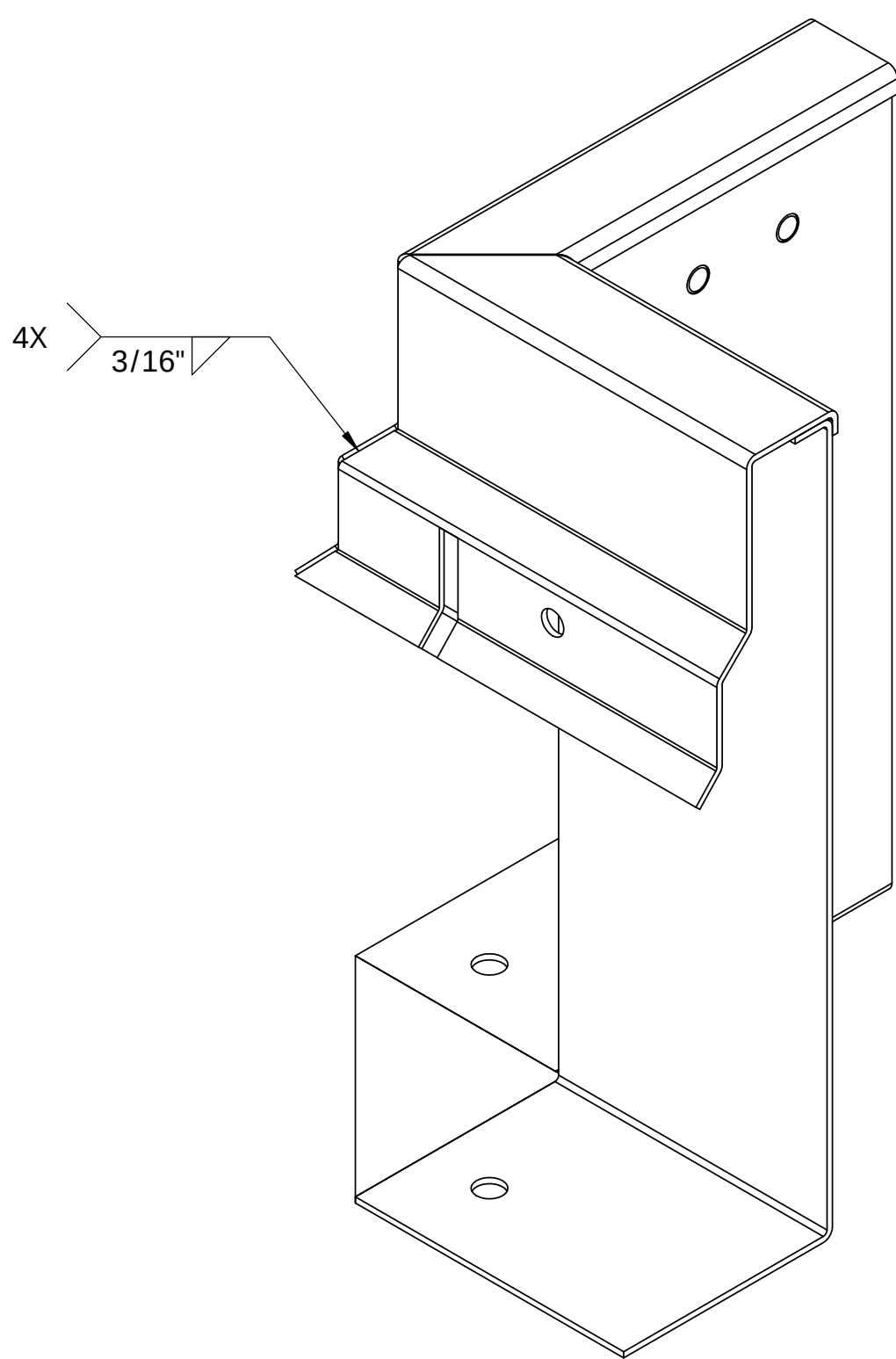
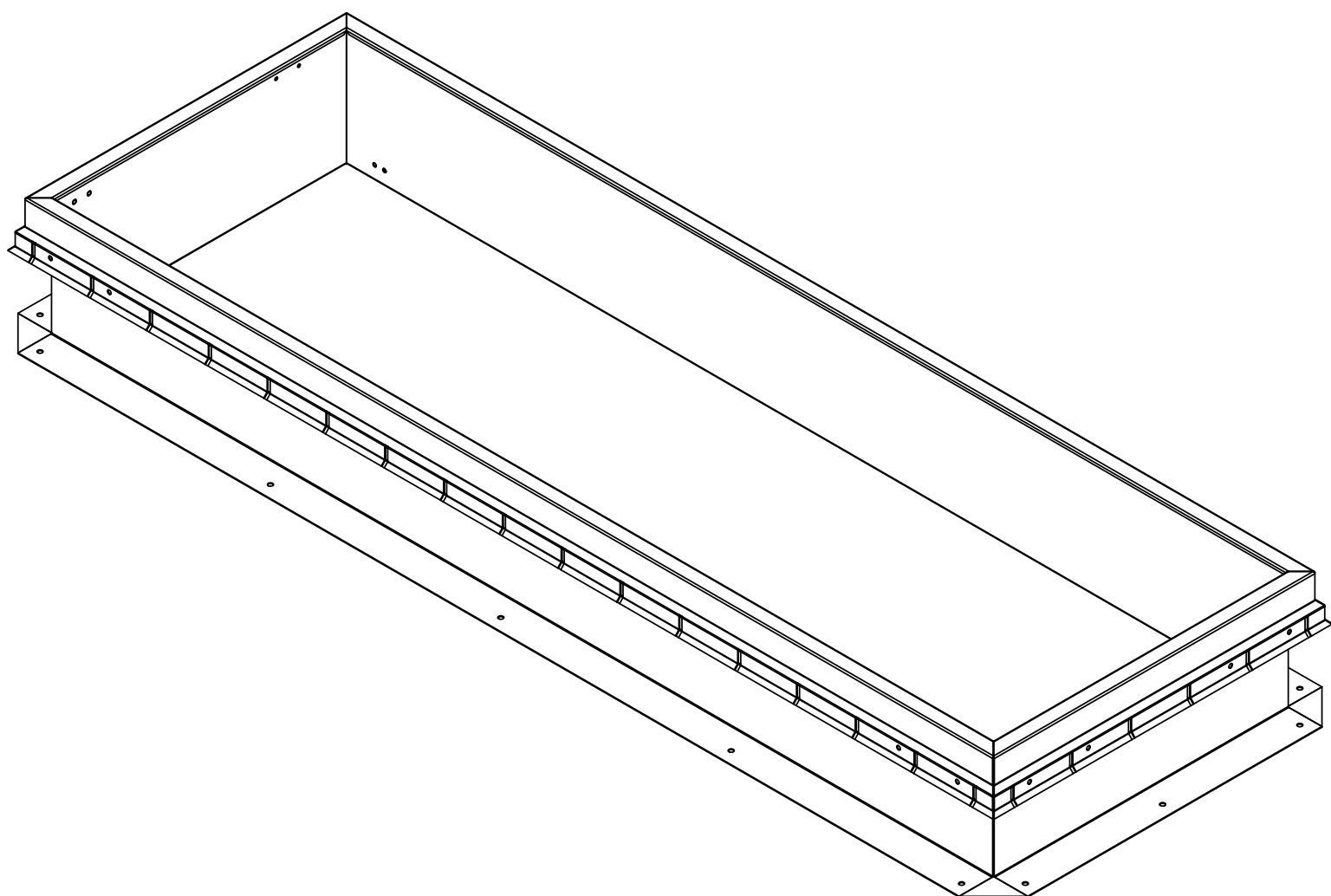
THE BILCO COMPANY
Manufacturers of Doors for Special Services
New Haven, Connecticut 06605

TITLE:
L DOOR ASSY

SIZE DWG. NO.
D L-DOOR

REV
N

SCALE: 1:4 WEIGHT: SHEET 6 OF 9



DETAIL G

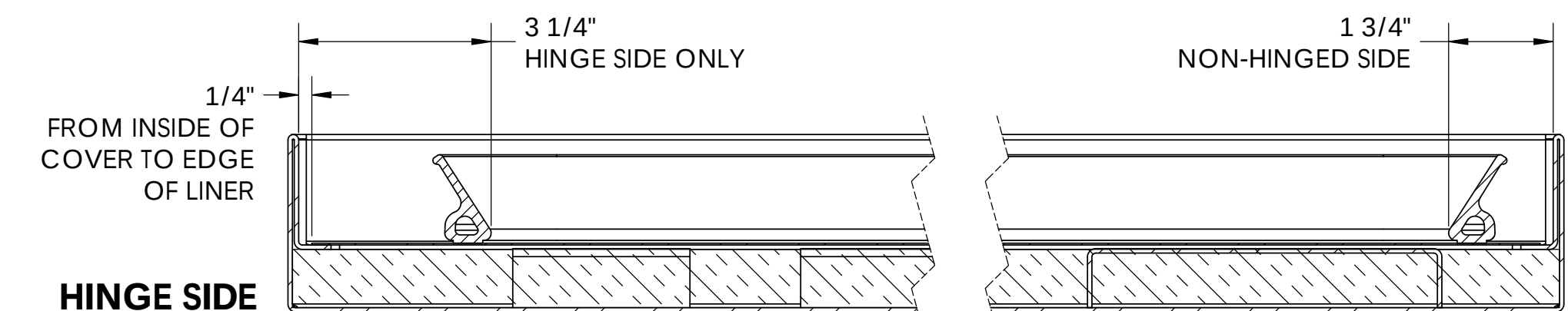
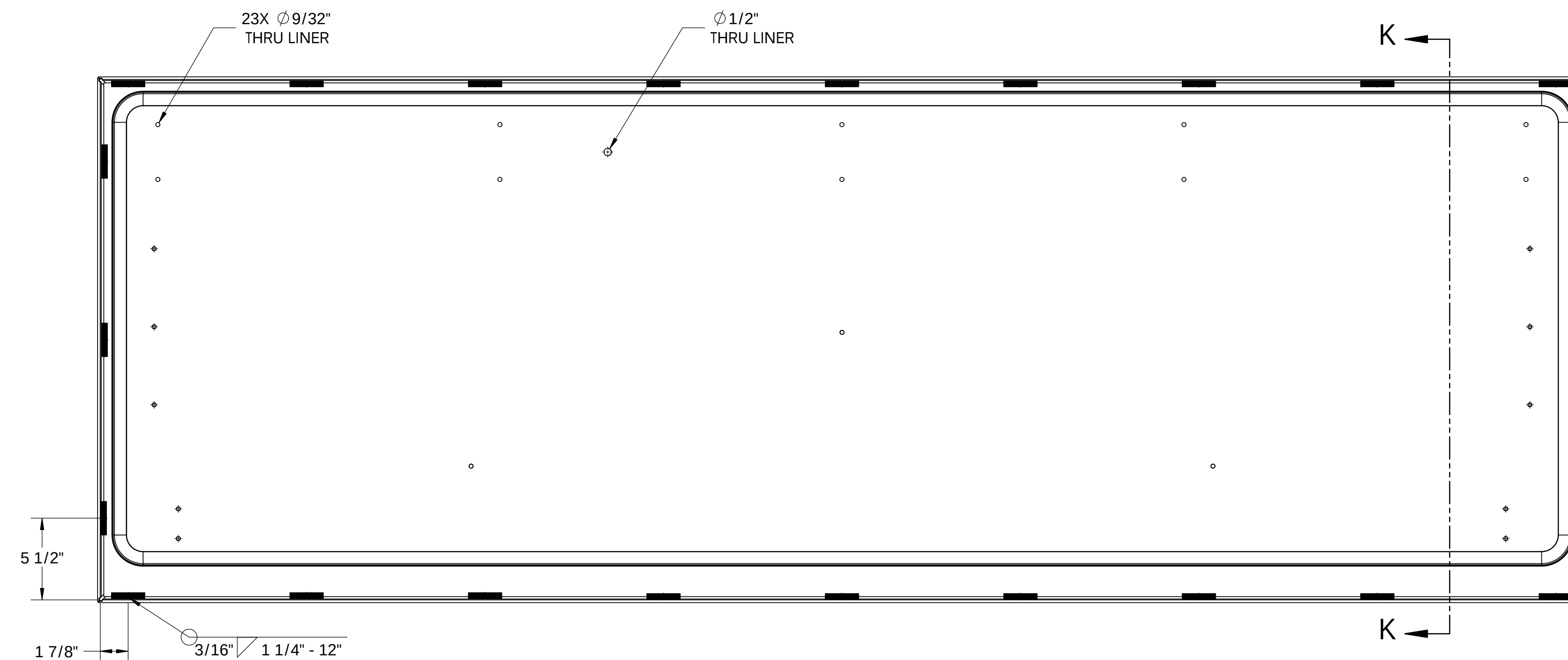
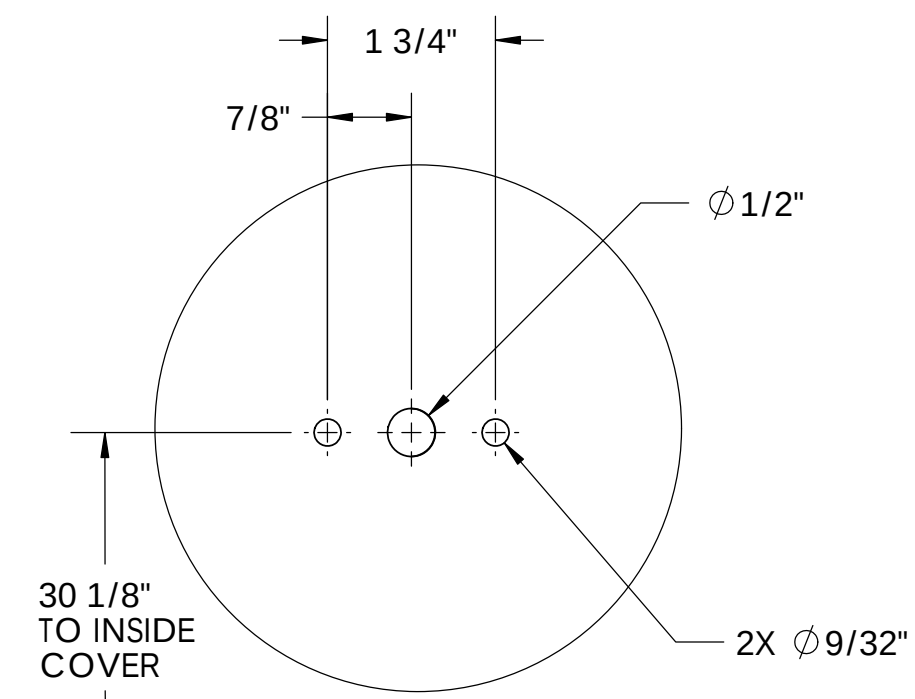
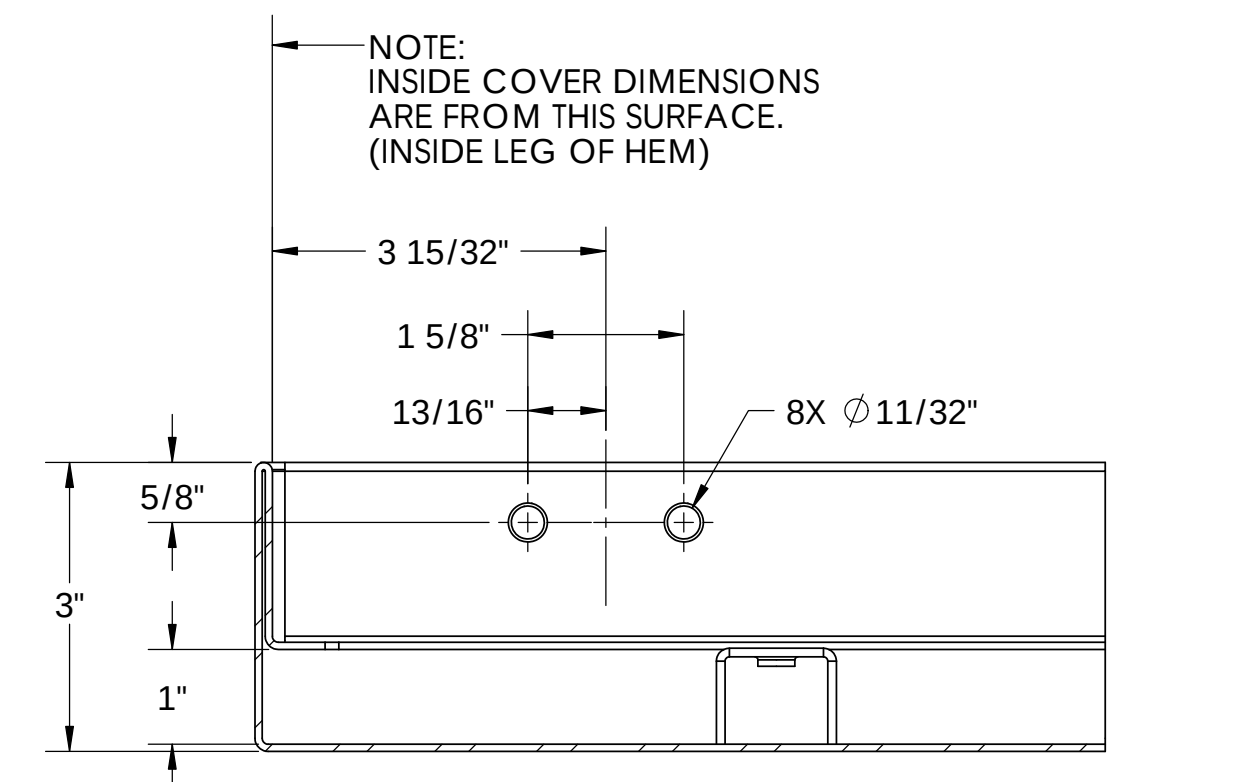
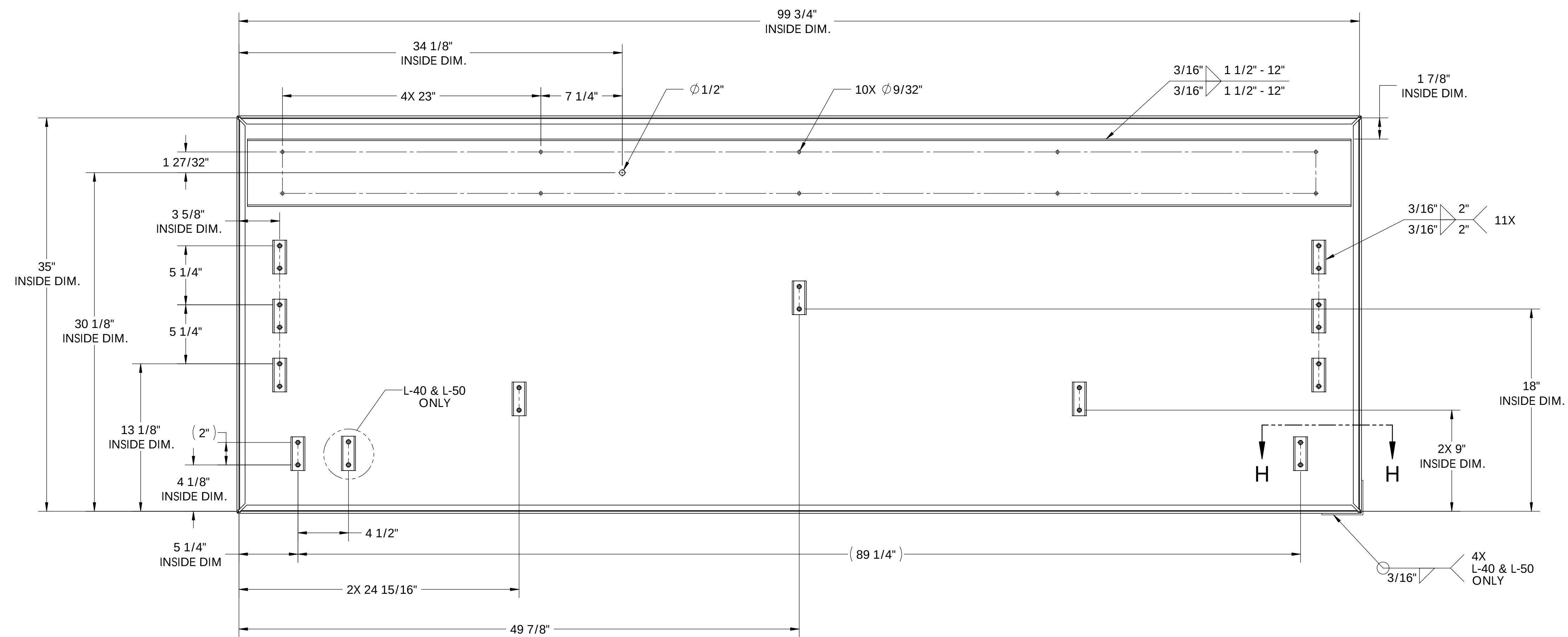


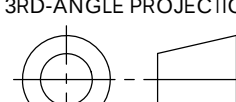
L DOOR ASSY

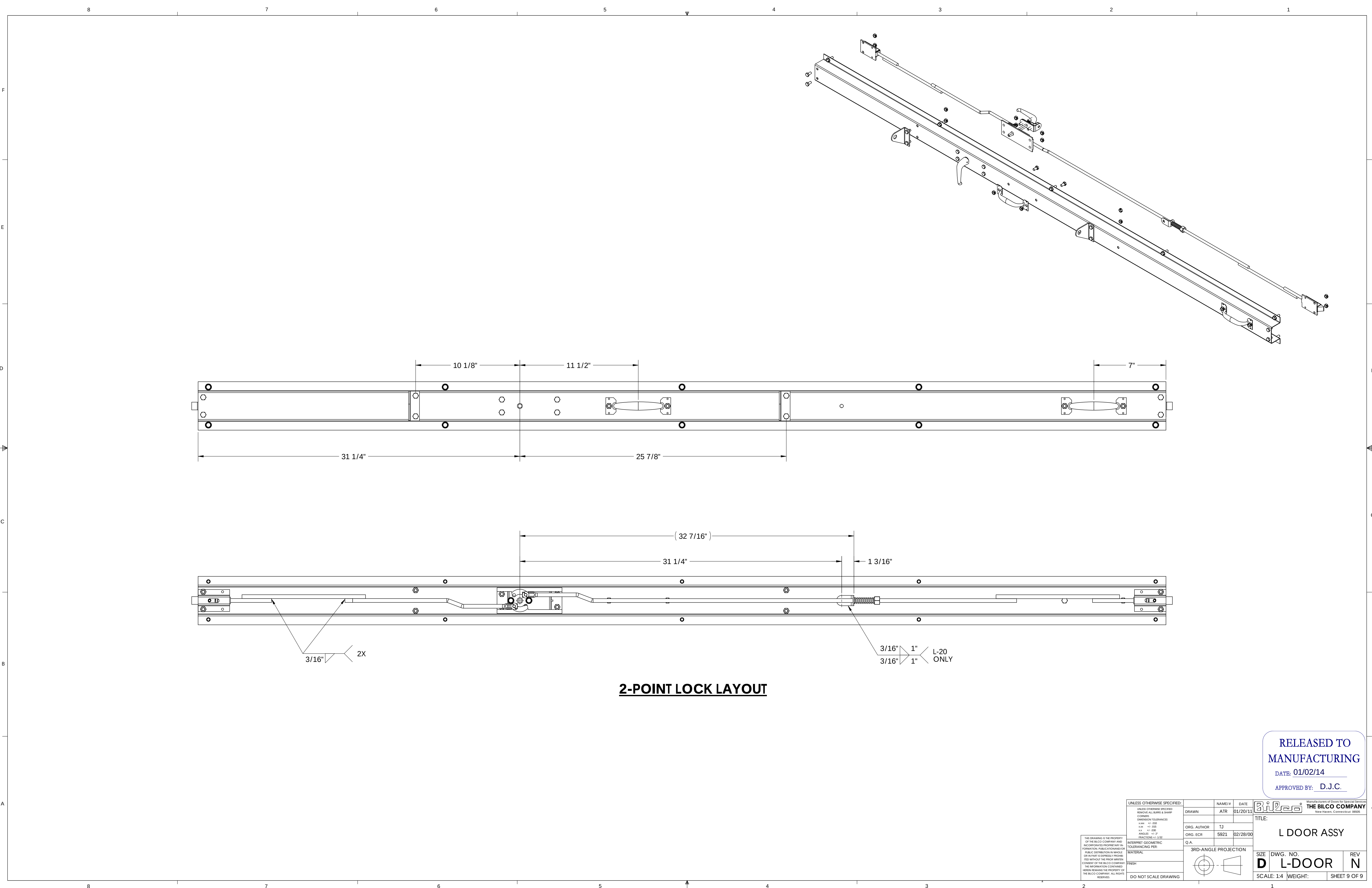
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Bilco[®] Manufacturers of Doors for Special Services
THE BILCO COMPANY
New Haven, Connecticut 06505

SIZE D	DWG. NO. L-DOOR	REV N
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UNLESS OTHERWISE SPECIFIED: UNLESS OTHERWISE SPECIFIED REMOVAL ALL BURR & SHARP CORNERS DIMENSION TOLERANCES X.MM +/- .000 Y.MM +/- .000 Z.MM +/- .000 ANGLES +/- 1' 00" RADIATIONS +/- 1/32 INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL: FINISH THE DRAWING IS THE PROPERTY OF THE BILCO COMPANY AND IS NOT TO BE REPRODUCED OR PUBLIC DISTRIBUTION WITHOUT WRITTEN PERMISSION. ANY REPRODUCTION OR DISTRIBUTION WITHOUT THE WRITTEN PERMISSION OF THE BILCO COMPANY IS PROHIBITED. THE BILCO COMPANY ASSUMES NO LIABILITY FOR DAMAGES OF ANY KIND ARISING OUT OF THE USE OF THIS DRAWING. REVISIONS:		NAME/# DRAWN ATR ORIG. AUTHOR TJ ORIG. ECR 5921 Q.A.	DATE 01/20/11 02/28/00		RELEASED TO MANUFACTURING DATE: <u>01/02/14</u> APPROVED BY: <u>D.J.C.</u> TITLE: L DOOR ASSY	Manufacturers of Doors for Special Service THE BILCO COMPANY New Haven, Connecticut 06605
DO NOT SCALE DRAWING		3RD-ANGLE PROJECTION 		SIZE D SCALE: 1:6	DWG. NO. L-DOOR WEIGHT:	REV N SHEET 8 OF 9



2-POINT LOCK LAYOUT

RELEASED TO
MANUFACTURING

DATE: 01/02/14

APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES XXX -1/-250 XXX -1/-250 XXX -1/-250 FINISHES -1/-2 REWORKS -1/-250		NAME/DATE		 Manufacturers of Doors for Special Services THE BILCO COMPANY New Haven, Connecticut 06605
		DRAWN ATR 01/20/11		
		ORG. AUTHOR TJ		
		ORG. ECR 5921 02/28/00		
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		MATERIAL		
		FINISH		
		DO NOT SCALE DRAWING		
		3RD-ANGLE PROJECTION		
		SIZE DWG. NO. REV		
		SCALE: 1:4 WEIGHT: SHEET 9 OF 9		