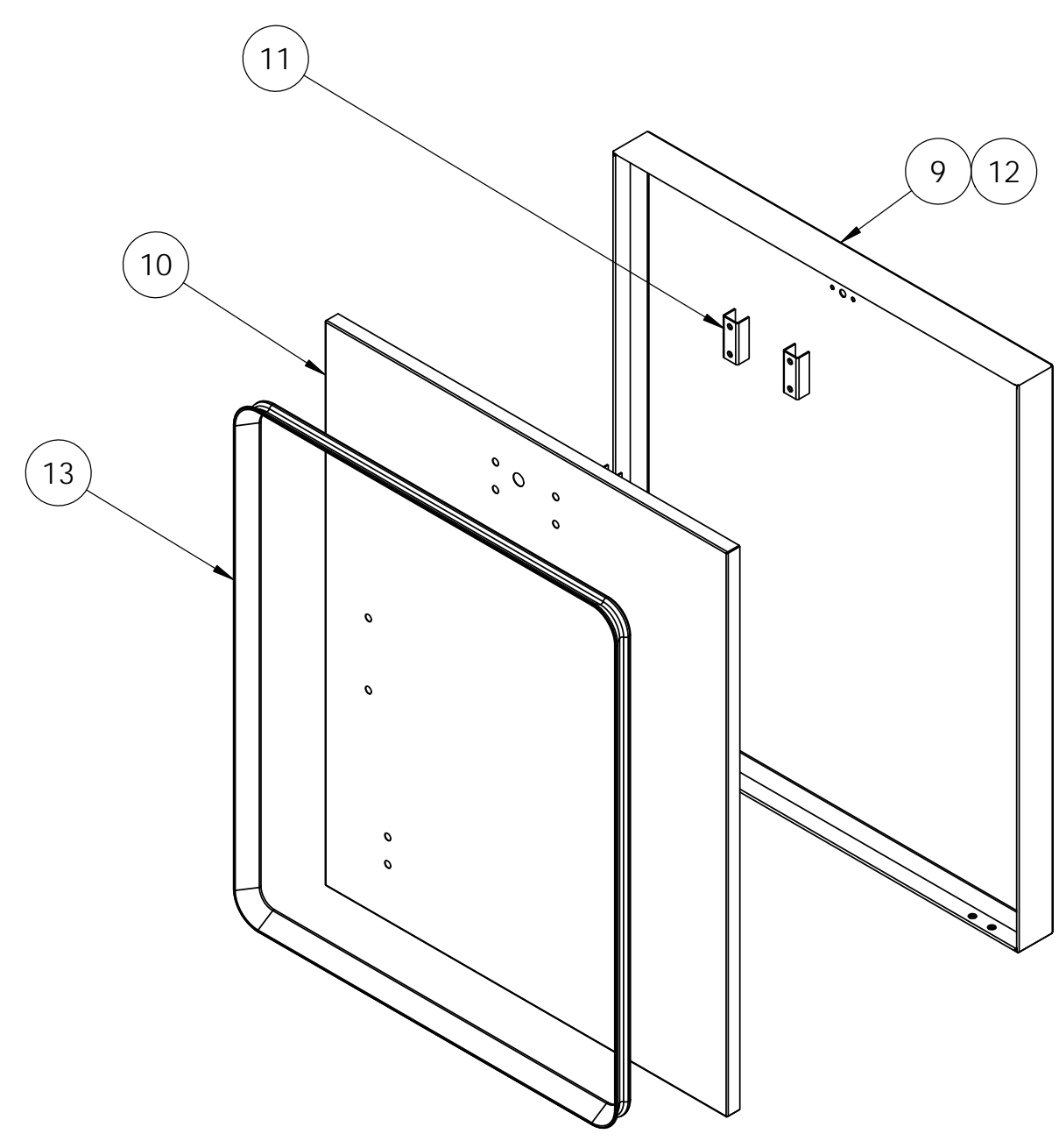
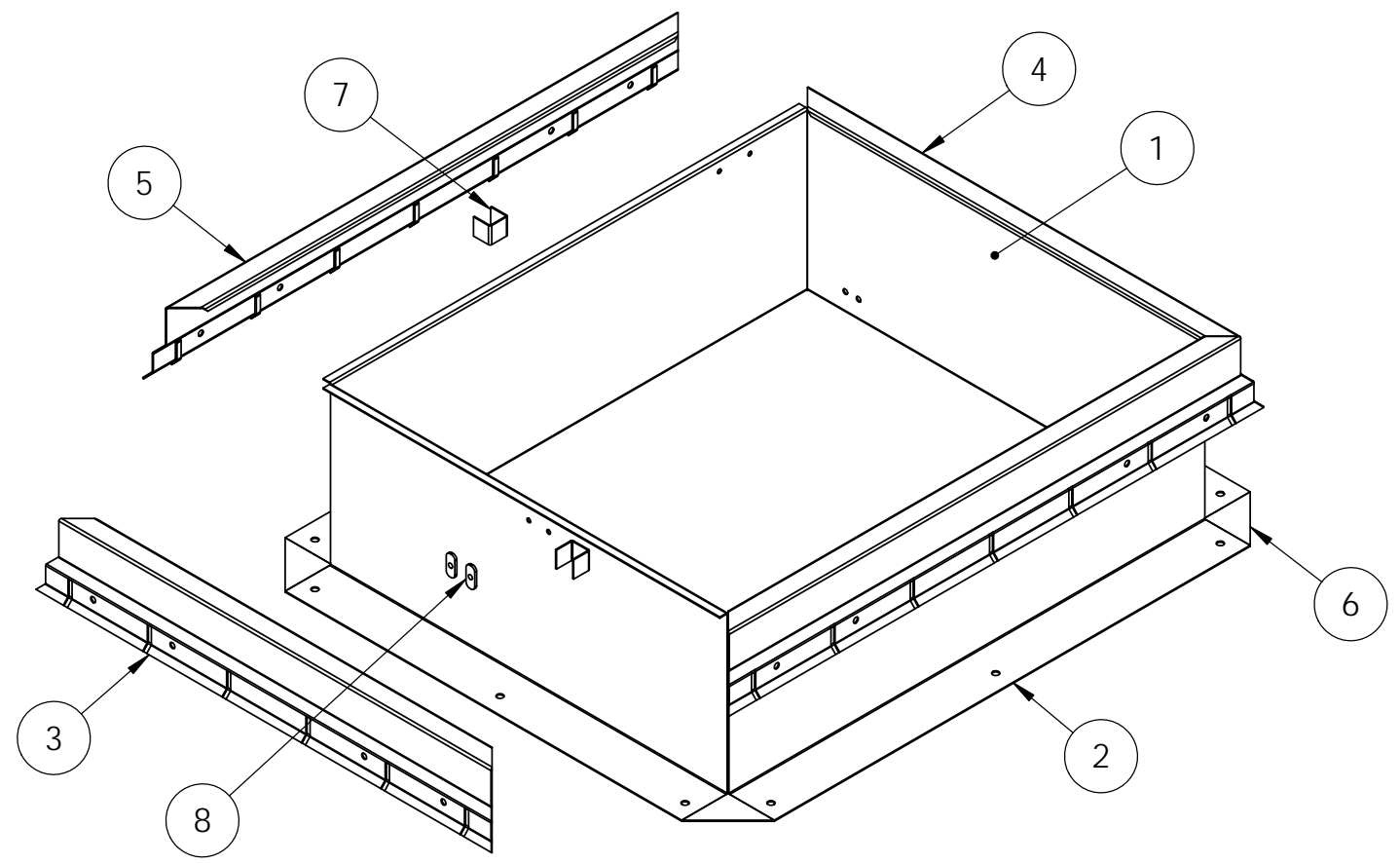


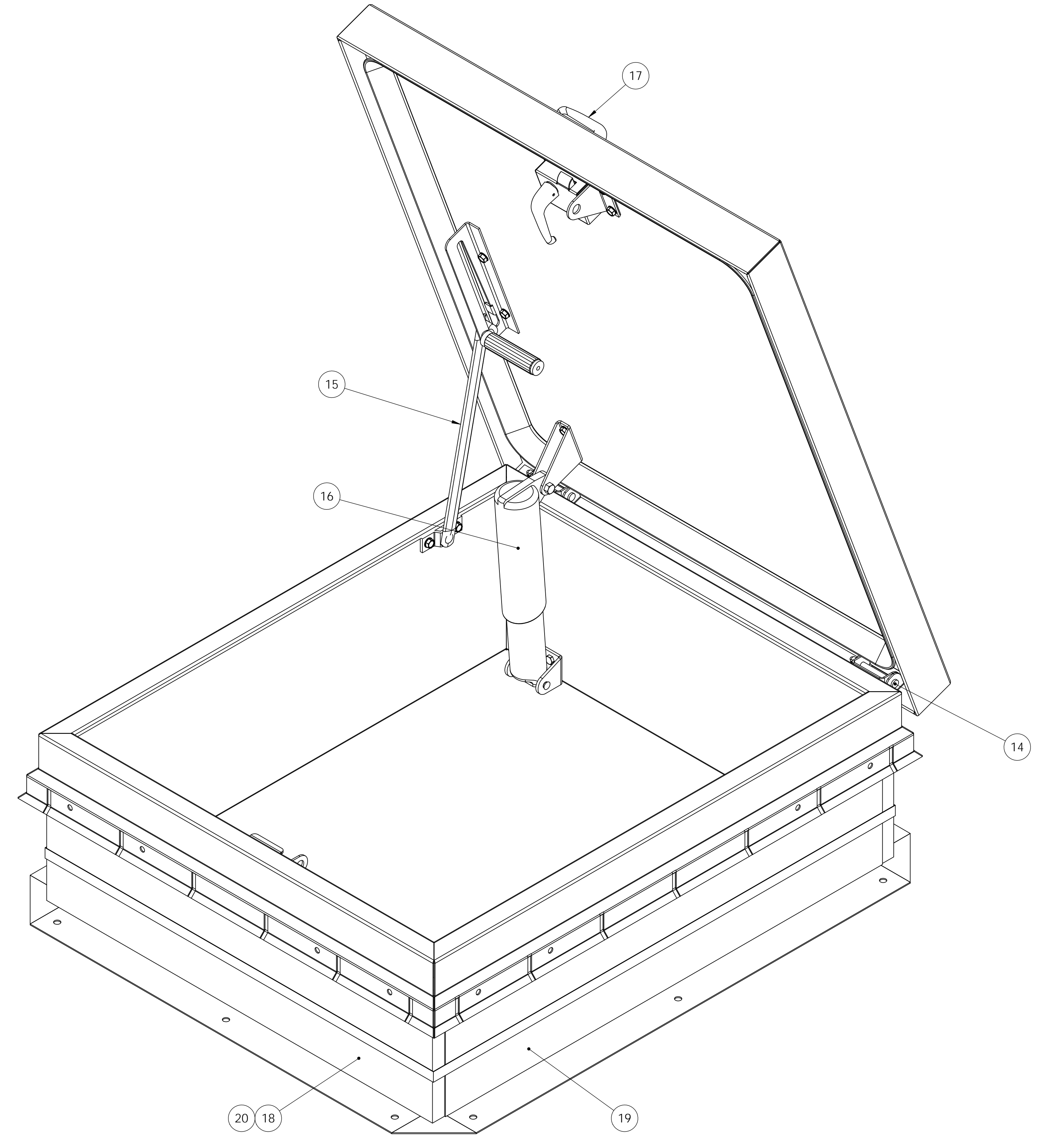
ITEM NO.	PART NO.	DESCRIPTION	QTY.
<b>FRAME</b>			
1	SD504A	FRAME-RS, 30" STEEL (15 13/16" x 30")	2
2	SD505A	FRAME-RS, 36" STEEL (15 13/16" x 36")	2
3	SD506	FLASHING-RS, 30" STEEL, (6 5/8" x 36")	1
4	SD506P	FLASHING-RS, 30" STEEL, PUNCH (6 5/8" x 36")	1
5	SD507	FLASHING-RS, 36" STEEL, (6 5/8" x 42")	2
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER-FRAME & FLASHING STEEL	5
8	SD165	NUT-WELD, 5/16"-18 STEEL	2
<b>COVER</b>			
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
<b>HARDWARE &amp; ACCESSORIES</b>			
14	KT13-P	KIT-HINGE RS, PLATED	2
15	KT562L-P	KIT-HOA, RS LH 14 1/4", STEEL FRAME, 70°	1
16	KT360N	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
<b>ITEMS NOT SHOWN</b>			
21	KTLBL-RS	KIT-LABELS, RS	1
22	SD1030	PRIMER-RED OXIDE	A/R



**COVER PARTS**



**FRAME PARTS**



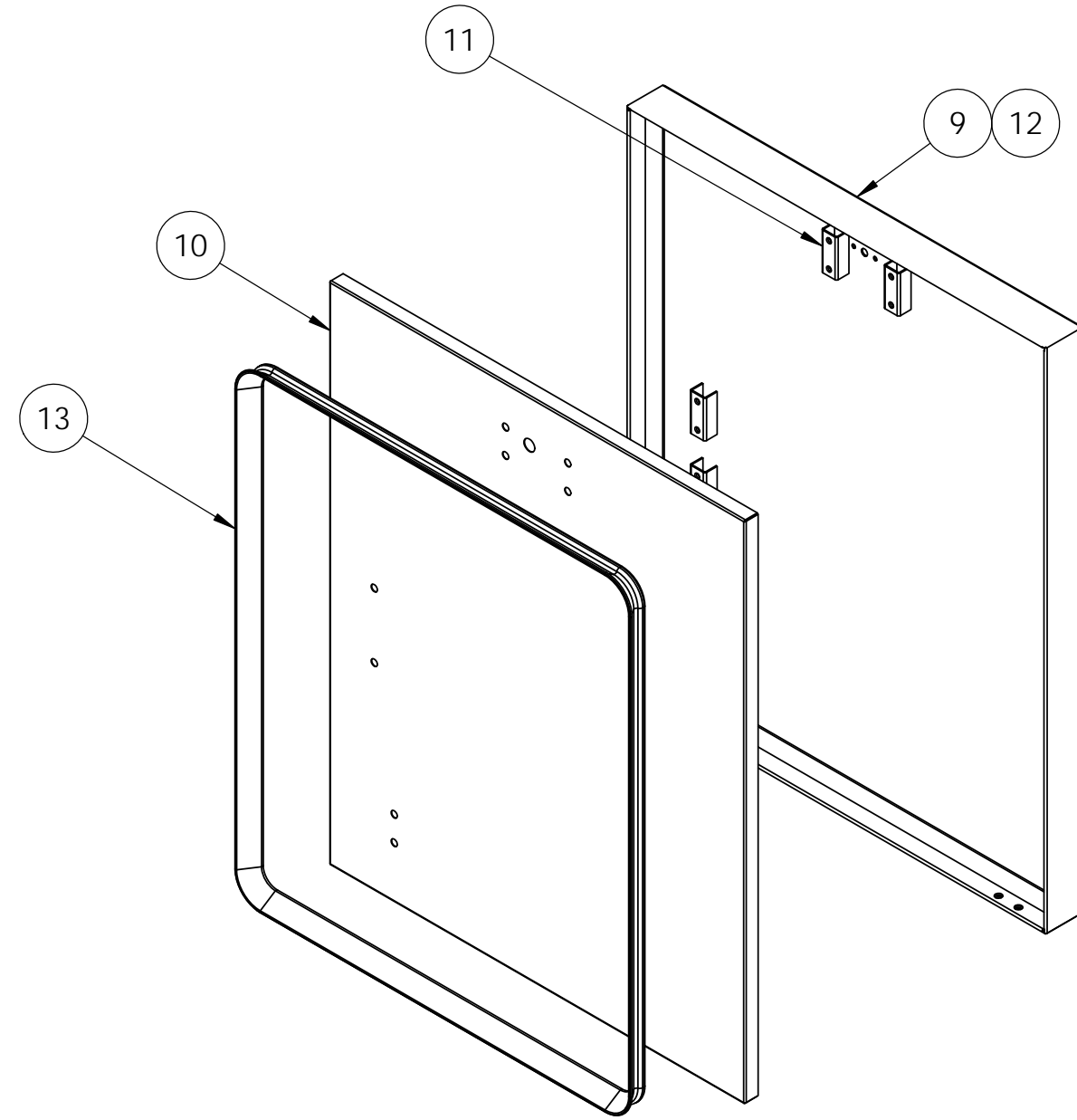
**S-20**

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. HOA. FRAME CORNER. SPRING HOUSING BRACKET. TURN HANDLE ASSY. COVER DESIGN & HINGE WELD NUTS	29676	ATR 06/01/12
J	CHANGED SD2125 LABEL TO SD2125-MD	28125	ATR 05/26/10
K	RECREATED IN SOLIDWORKS & ADDED WELD CALLOUTS	21665	DMP 06/05/07
		ECR	

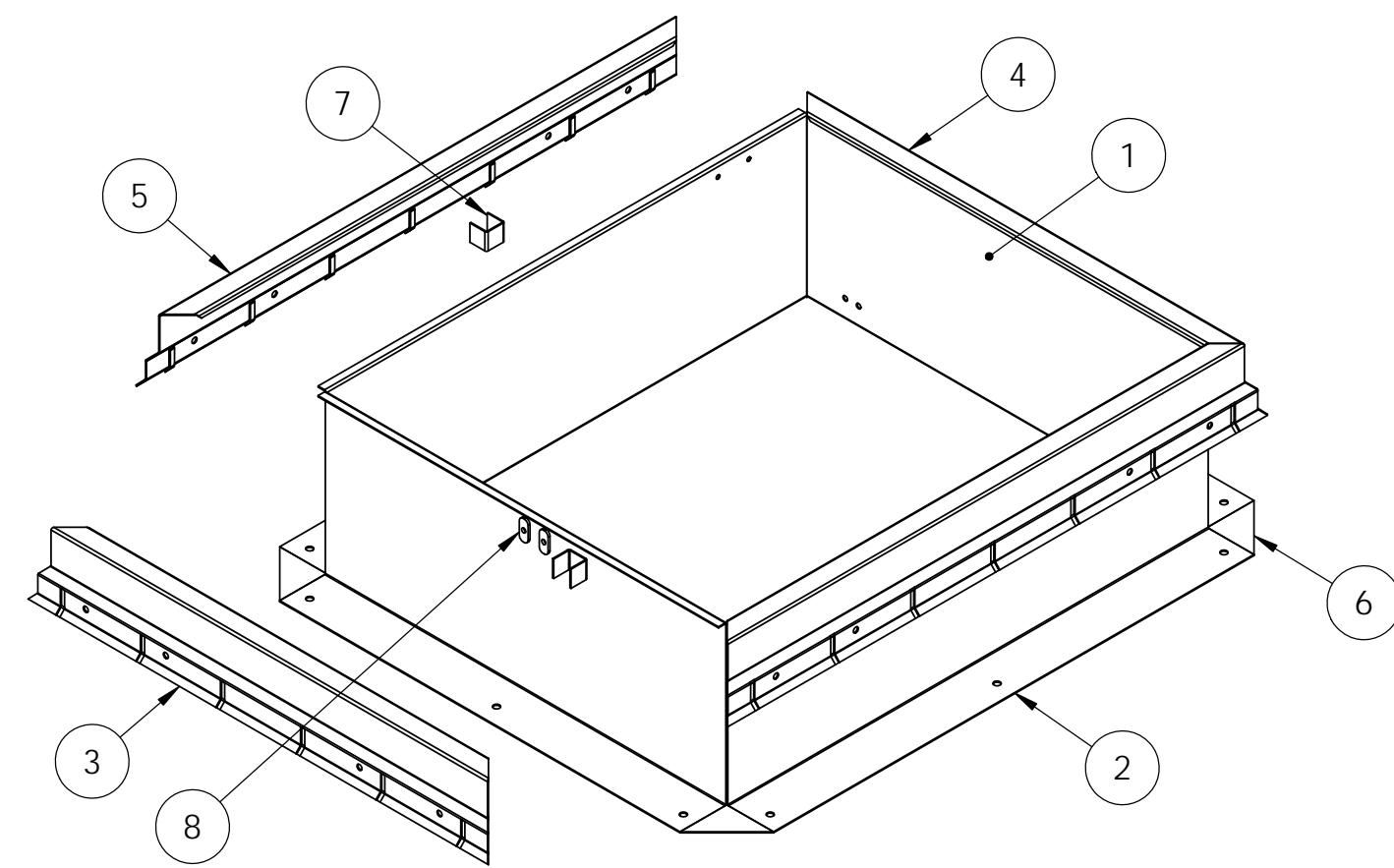
UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSIONS TOLERANCES: XXX .000 XXX .005 XXX .010 XXX .015 XXX .020	NAME/REV DATE	DATE	 <b>THE BILCO COMPANY</b> <small>New Haven, Connecticut 06955</small>
DRAWN	ATR	05/20/10	
ORG. AUTHOR	TJ		
ORG. ECR	5921	02/14/00	
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL	D.A.		TITLE: <b>S DOOR ASSY</b>
3RD-ANGLE PROJECTION			SIZE DWG. NO. <b>D S-DOOR</b>
DO NOT SCALE DRAWING			REV <b>P</b>
			SCALE: 1:4 WEIGHT: SHEET 1 OF 7

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

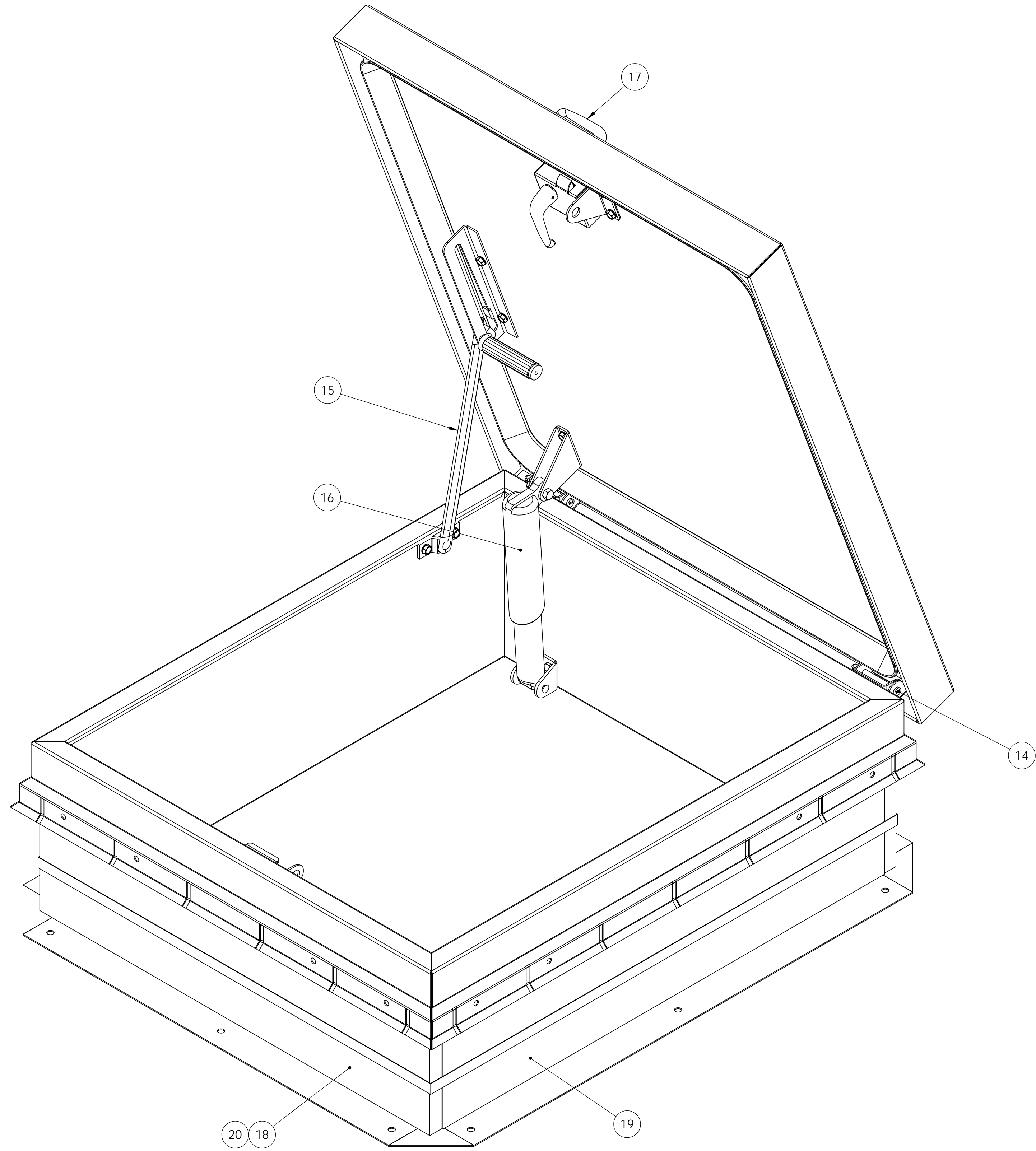
ITEM NO.	PART NO.	DESCRIPTION	QTY.
<b>FRAME</b>			
1	SD504A	FRAME-RS, 30" STEEL (15 13/16" x 30")	2
2	SD505A	FRAME-RS, 36" STEEL (15 13/16" x 36")	2
3	SD506	FLASHING-RS, 30" STEEL, (6 5/8" x 36")	1
4	SD506P	FLASHING-RS, 30" STEEL, PUNCH (6 5/8" x 36")	1
5	SD507	FLASHING-RS, 36" STEEL, (6 5/8" x 42")	2
6	SD1649	FRAME-CORNER, STEEL	4
7	SD15	SPACER-FRAME & FLASHING STEEL	5
8	SD165	NUT-WELD, 5/16"-18 STEEL	2
<b>COVER</b>			
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
<b>HARDWARE &amp; ACCESSORIES</b>			
14	KT13SS	KIT-HINGE RS, SS	2
15	KT562L-P	KIT-HOA, RS LH 14 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
<b>ITEMS NOT SHOWN</b>			
21	KTLBL-RS	KIT-LABELS, RS	1
22	SD1030	PRIMER-RED OXIDE (FRAME ONLY)	A/R



**COVER PARTS**



**FRAME PARTS**

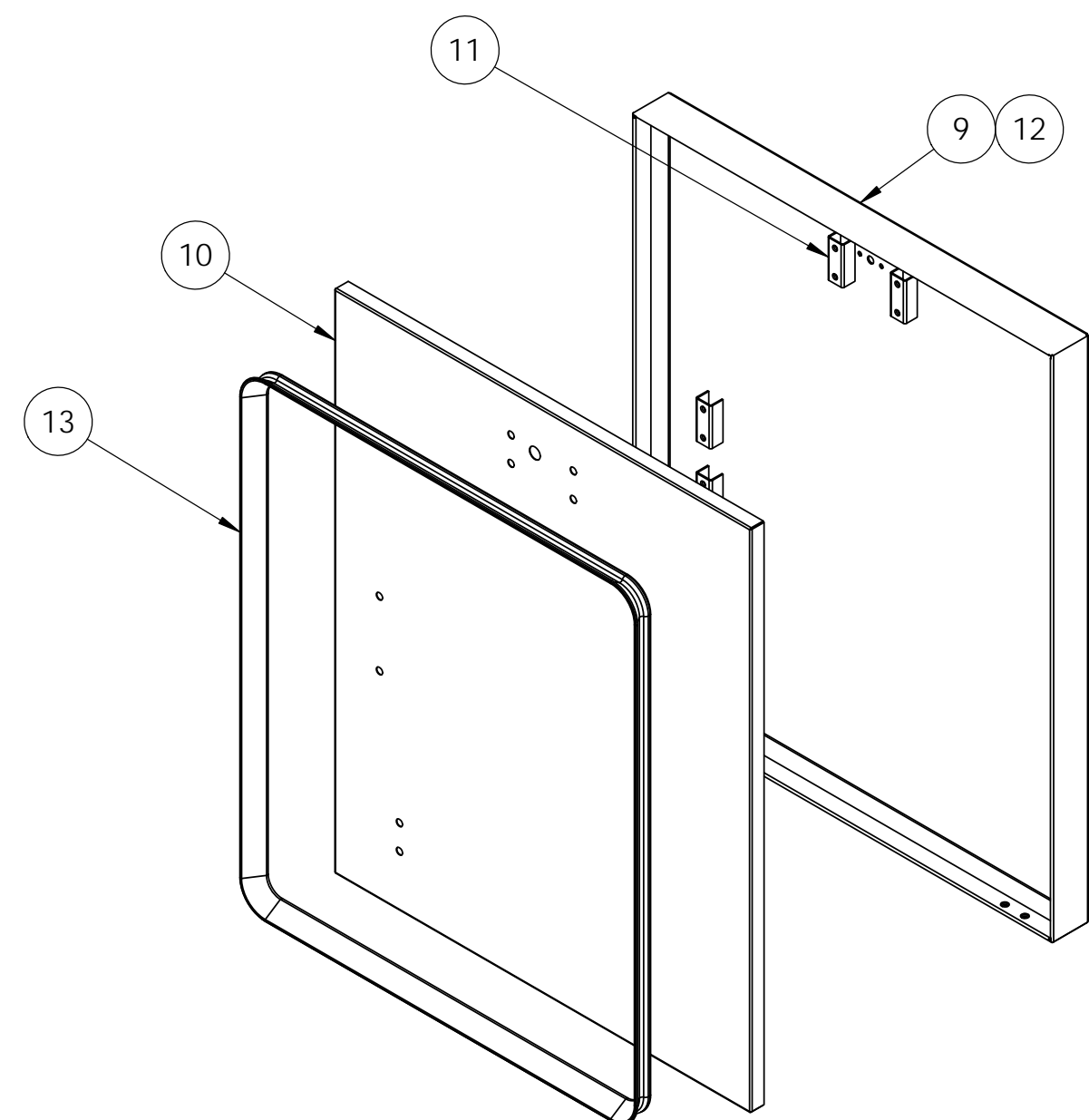


**S-40**

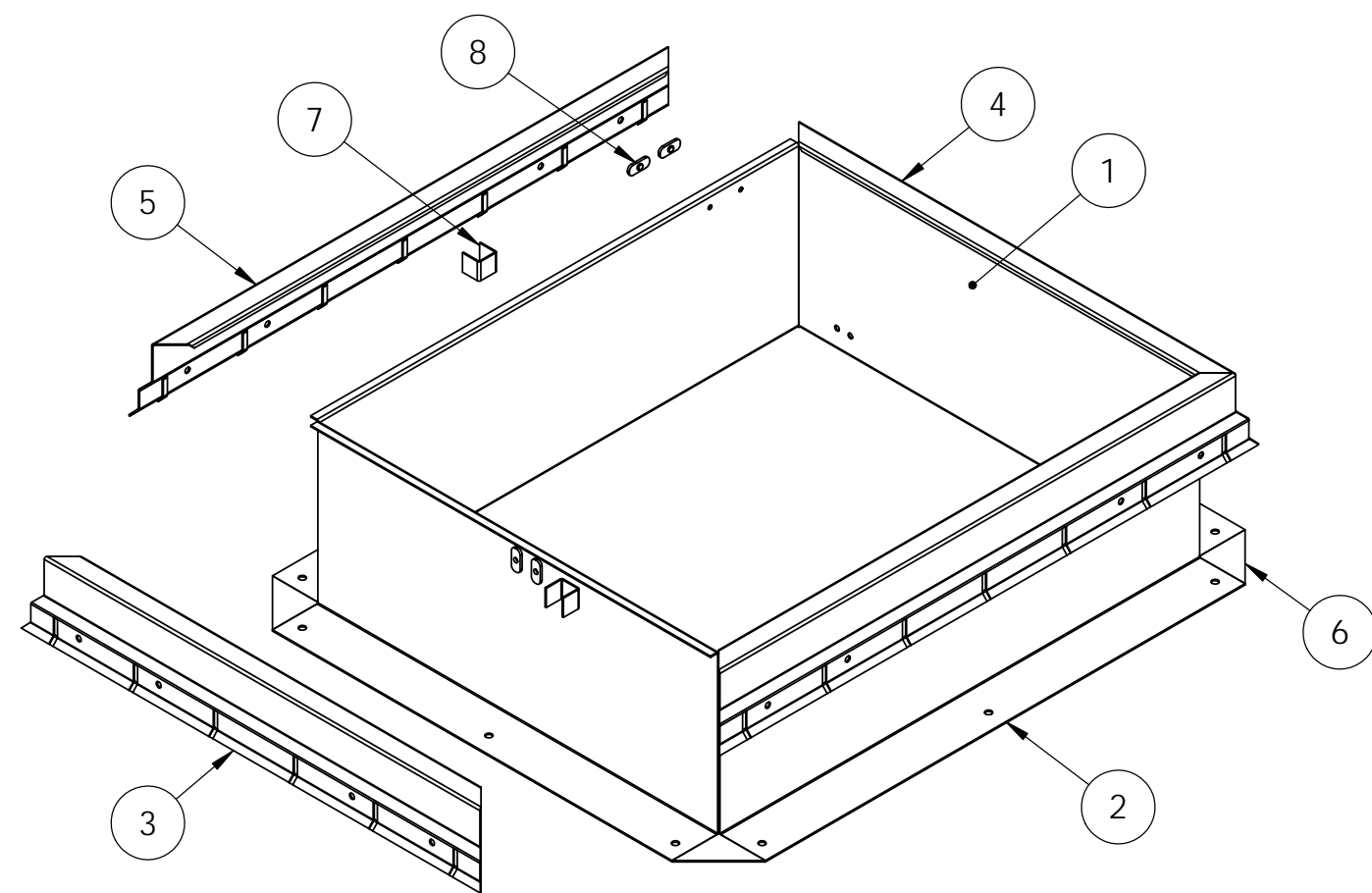
**RELEASED TO MANUFACTURING**  
 DATE: 11/14/13  
 APPROVED BY: D.J.C.

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BARRS & SHARP CORNERS DIMENSION TOLERANCES: XXX .XX XXX .XX XXX .XX XXX .XX XXX .XX		NAME/REV DATE	 <b>THE BILCO COMPANY</b> <small>New Haven, Connecticut 06905</small>
<small>THIS DRAWING IS THE PROPERTY OF THE BILCO COMPANY AND INFORMATION CONTAINED HEREIN IS UNCLASSIFIED UNLESS INDICATED OTHERWISE. NO PART IS EXPRESSLY PROHIBITED FROM BEING REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF THE BILCO COMPANY. THE BILCO COMPANY MAKES NO WARRANTY, REPRESENTATION OR GUARANTEE, EXPRESS OR IMPLIED, REGARDING THE INFORMATION CONTAINED HEREIN. THE BILCO COMPANY ASSUMES NO LIABILITY FOR DAMAGES OF ANY KIND, INCLUDING CONSEQUENTIAL DAMAGES, ARISING FROM THE USE OF THIS DRAWING.</small>	DRAWN: ATR DATE: 05/20/10 ORG. AUTHOR: TJ ORG. ECR: 5921 DATE: 02/14/00 Q.A. 3RD-ANGLE PROJECTION	TITLE: <b>S DOOR ASSY</b> SIZE: DWG. NO. <b>D S-DOOR</b> REV <b>P</b> SCALE: 1:4 WEIGHT: SHEET 2 OF 7	

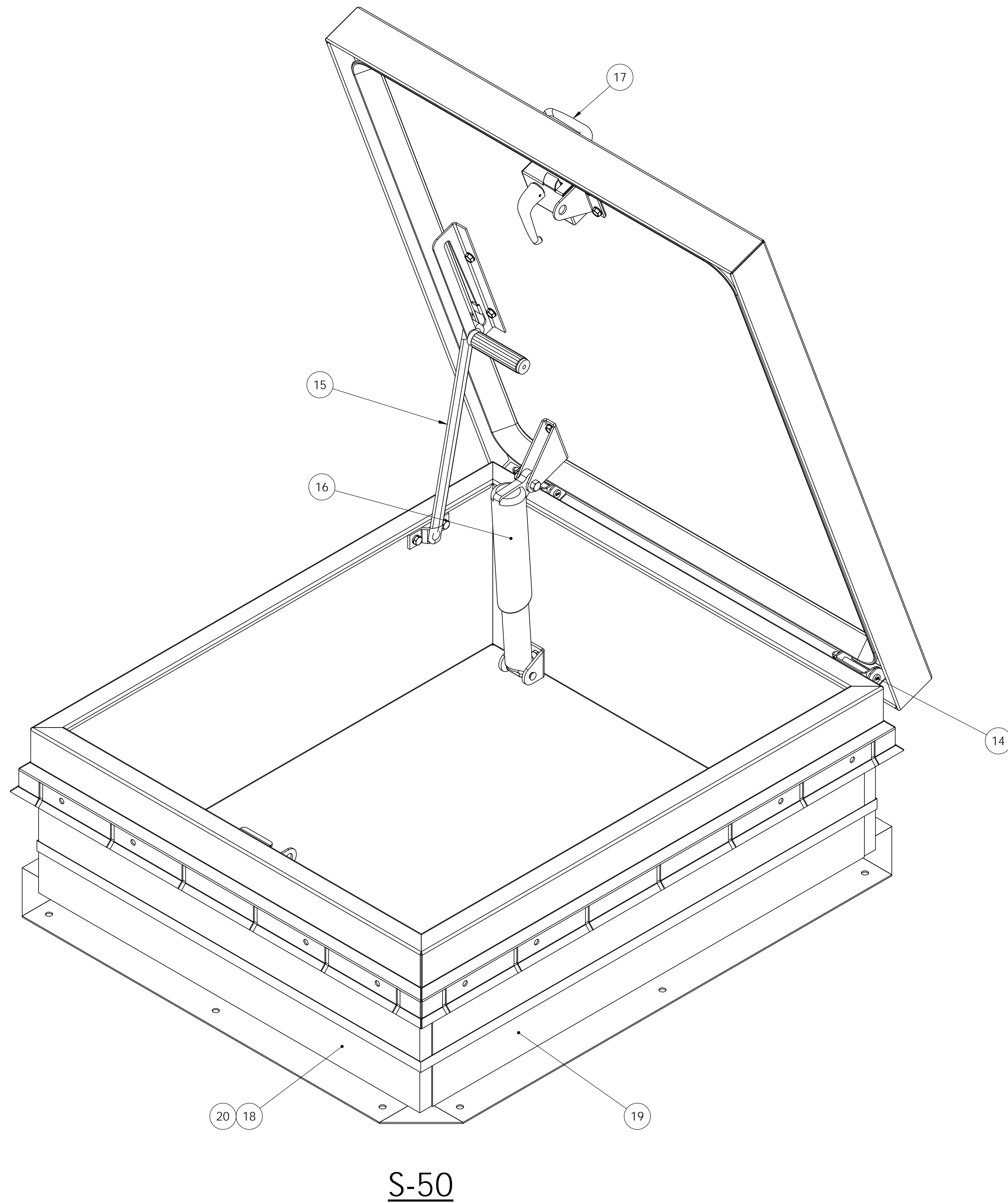
ITEM NO.	PART NO.	DESCRIPTION	QTY.
<b>FRAME</b>			
1	SD504A-AL	FRAME-RS, 30" ALUM (15 13/16" x 30")	2
2	SD505A-AL	FRAME-RS, 36" ALUM (15 13/16" x 36")	2
3	SD506AL-1	FLASHING-RS, 30" ALUM, (6 5/8" x 36")	1
4	SD506ALP1	FLASHING-RS, 30" ALUM, PUNCH (6 5/8" x 36")	1
5	SD507AL	FLASHING-RS, 36" ALUM, (6 5/8" 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
<b>COVER</b>			
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
<b>HARDWARE &amp; ACCESSORIES</b>			
14	KT13SS	KIT-HINGE RS, SS	2
15	KT562AL-P	KIT-HOA, RS LH 14 1/4" ALUMINUM 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
<b>ITEMS NOT SHOWN</b>			
21	KTLBL-RS	KIT-LABELS, RS	1



**COVER PARTS**



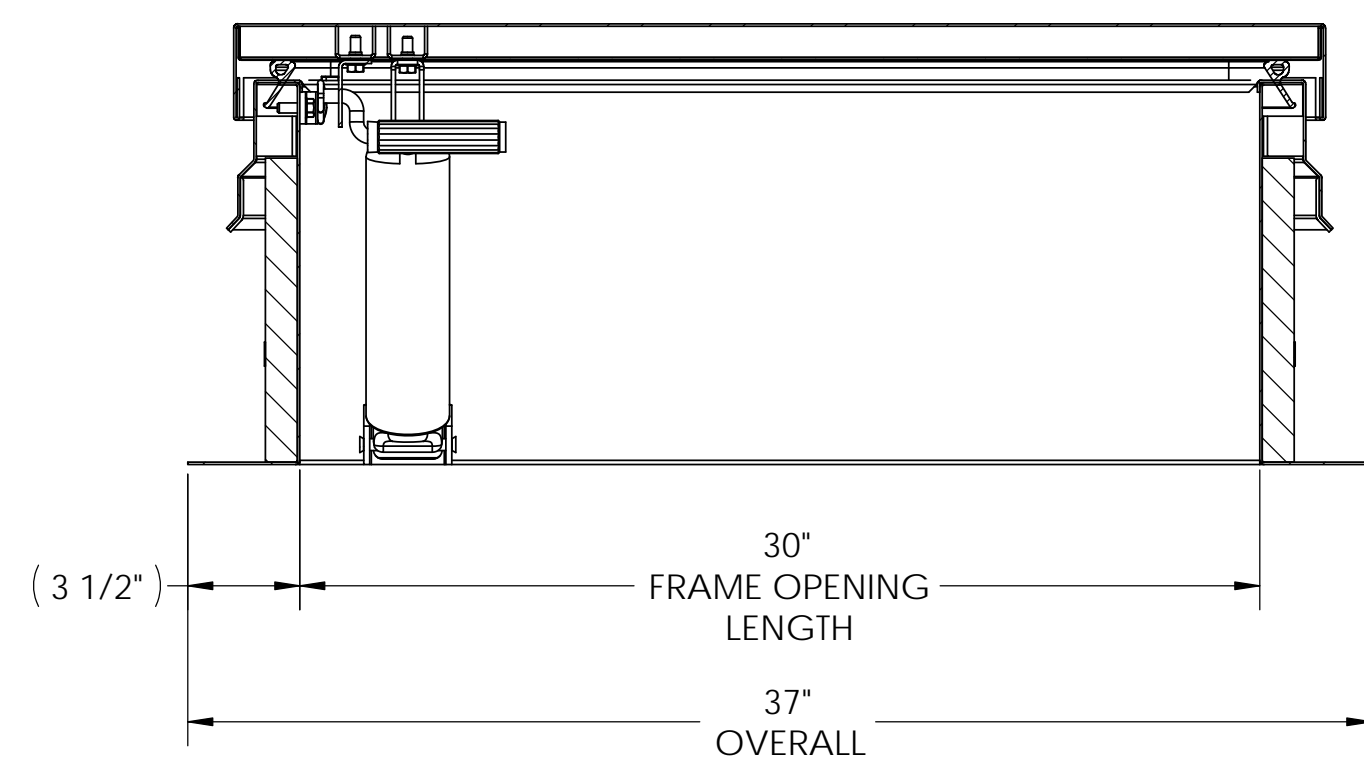
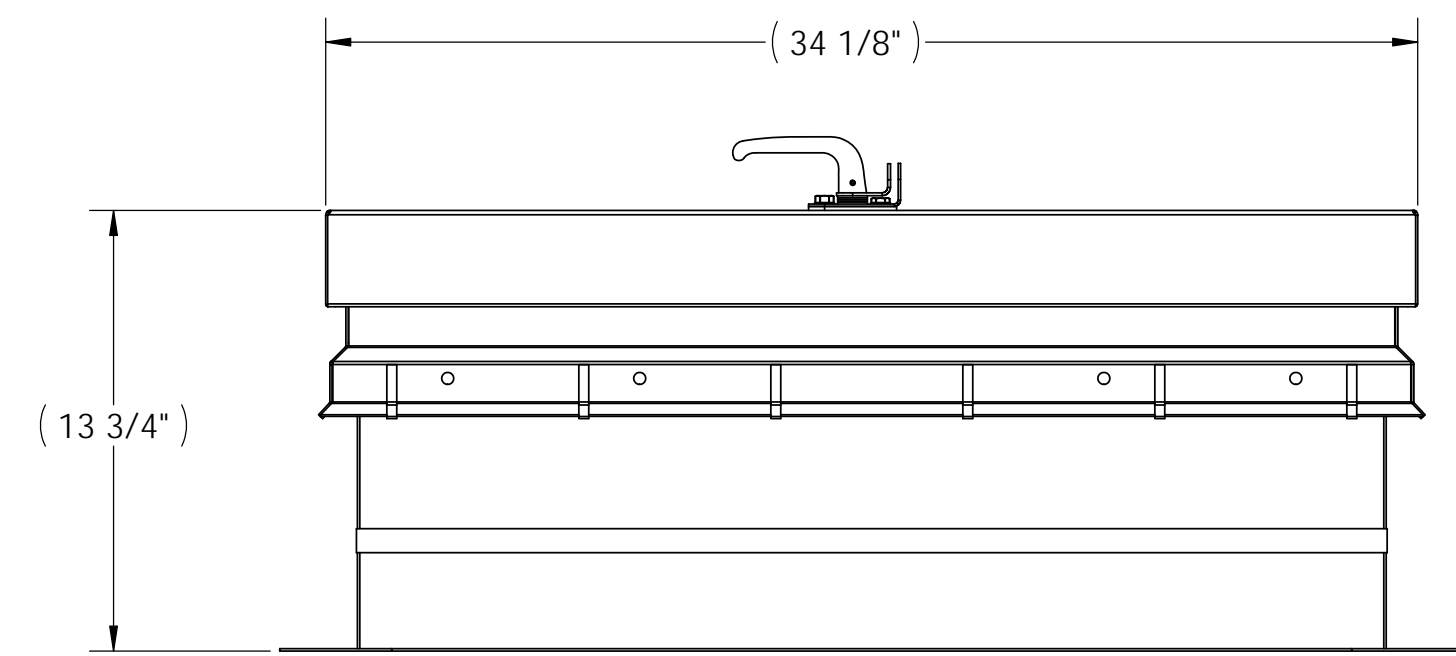
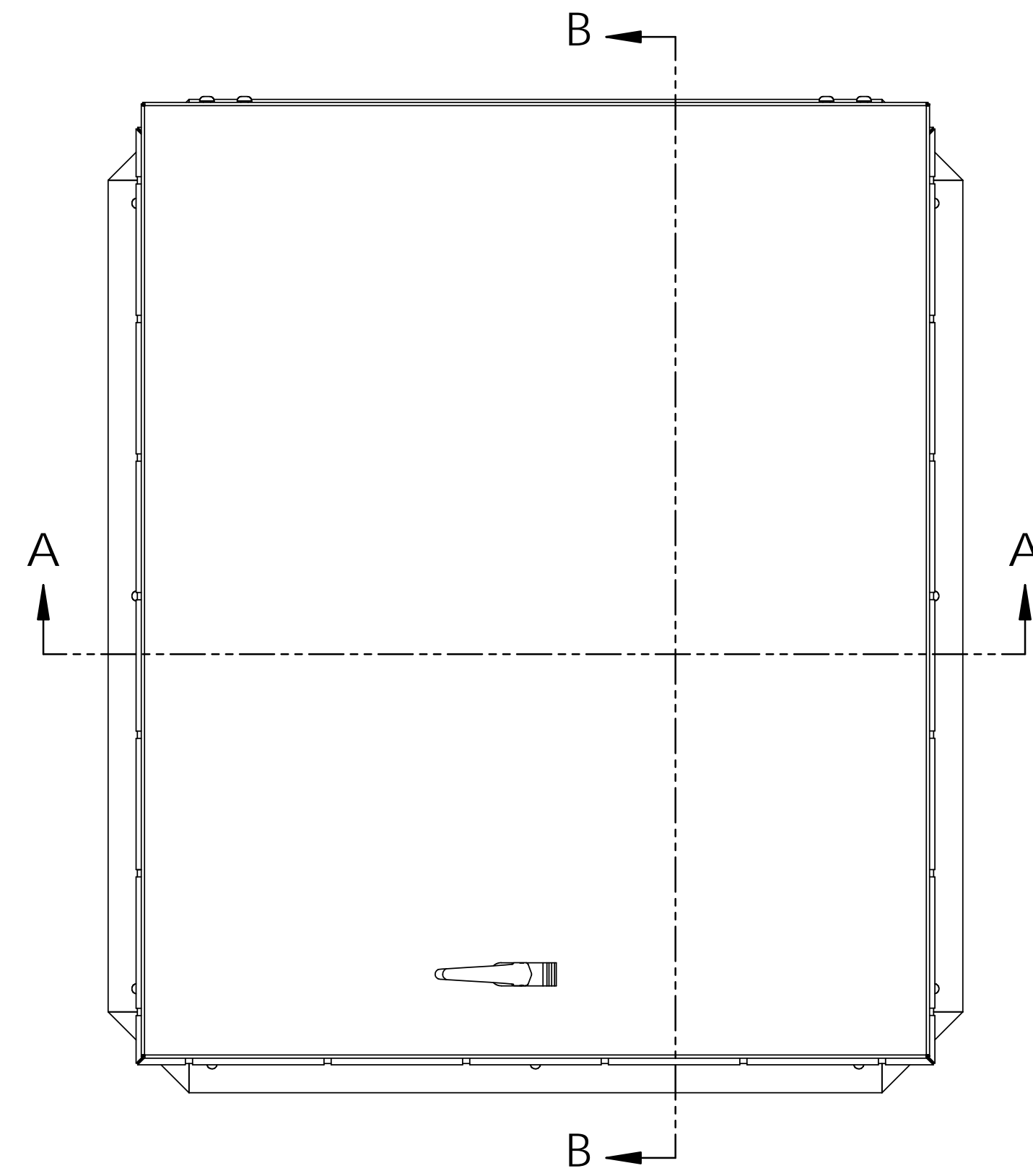
**FRAME PARTS**



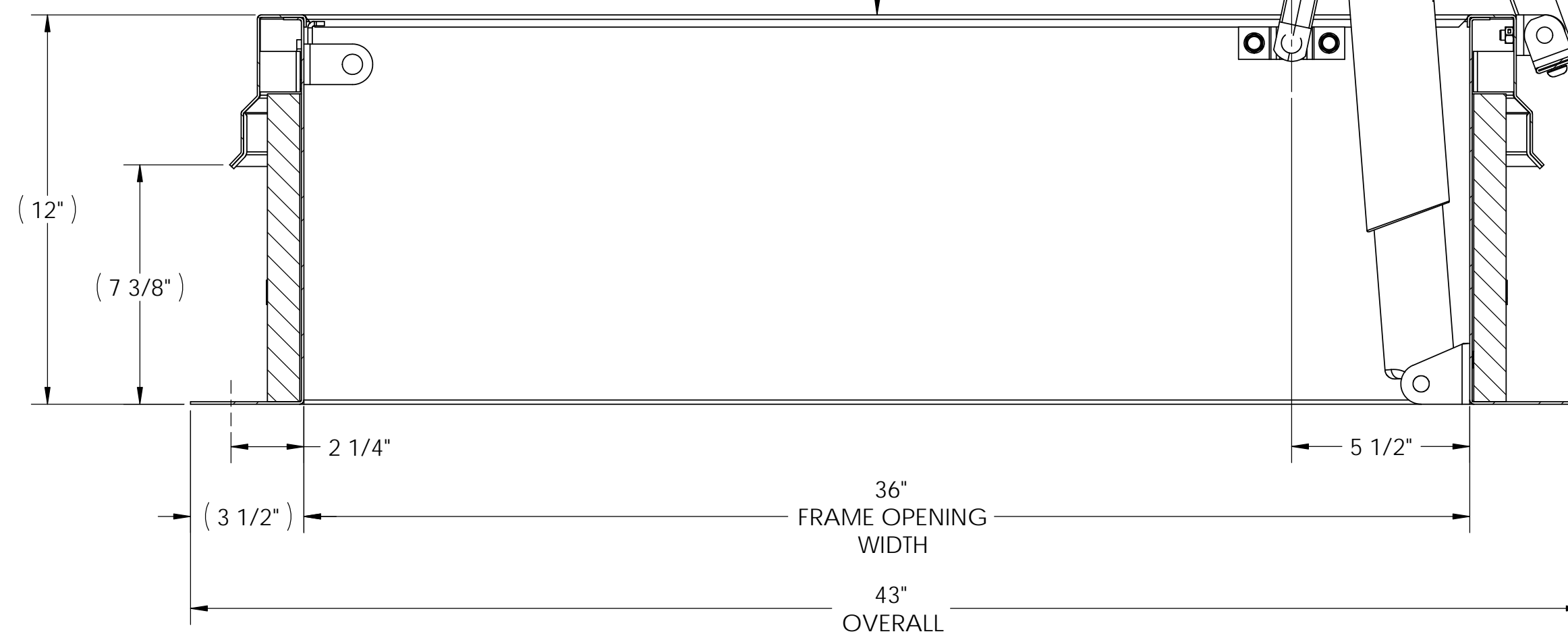
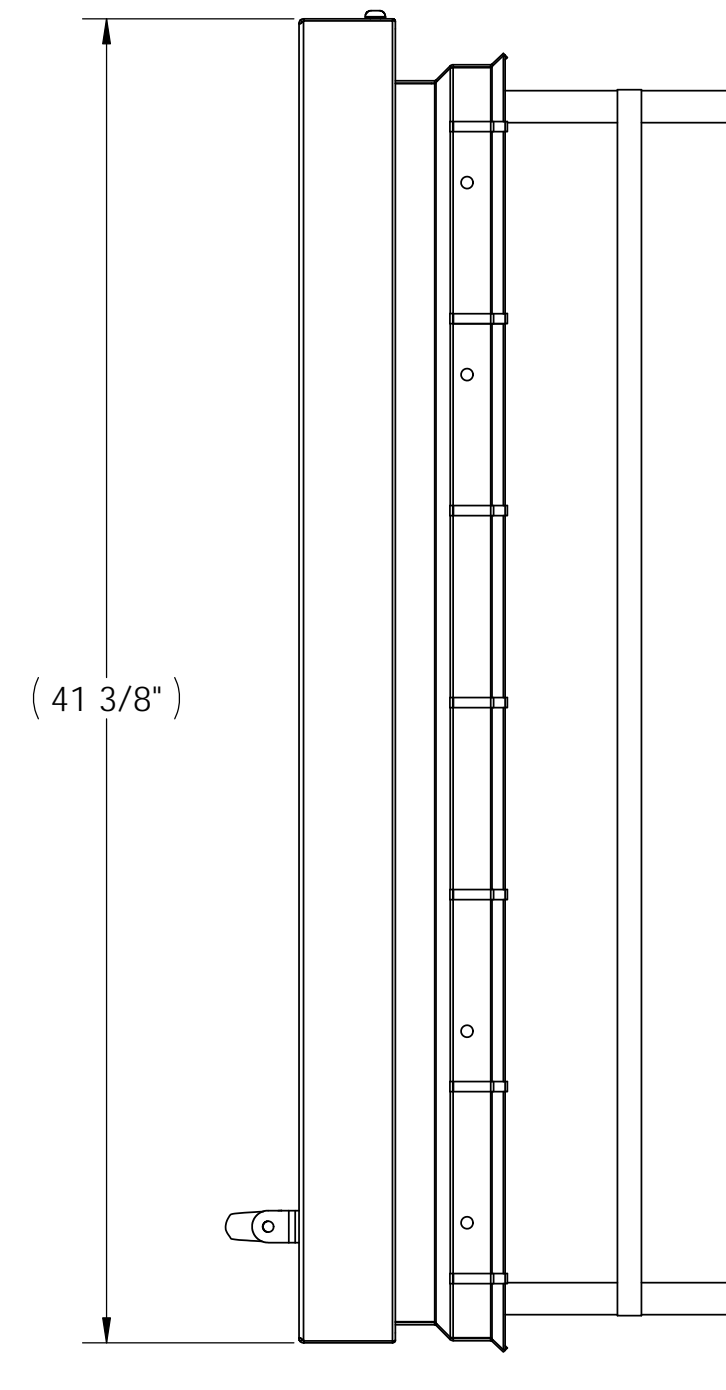
**S-50**

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

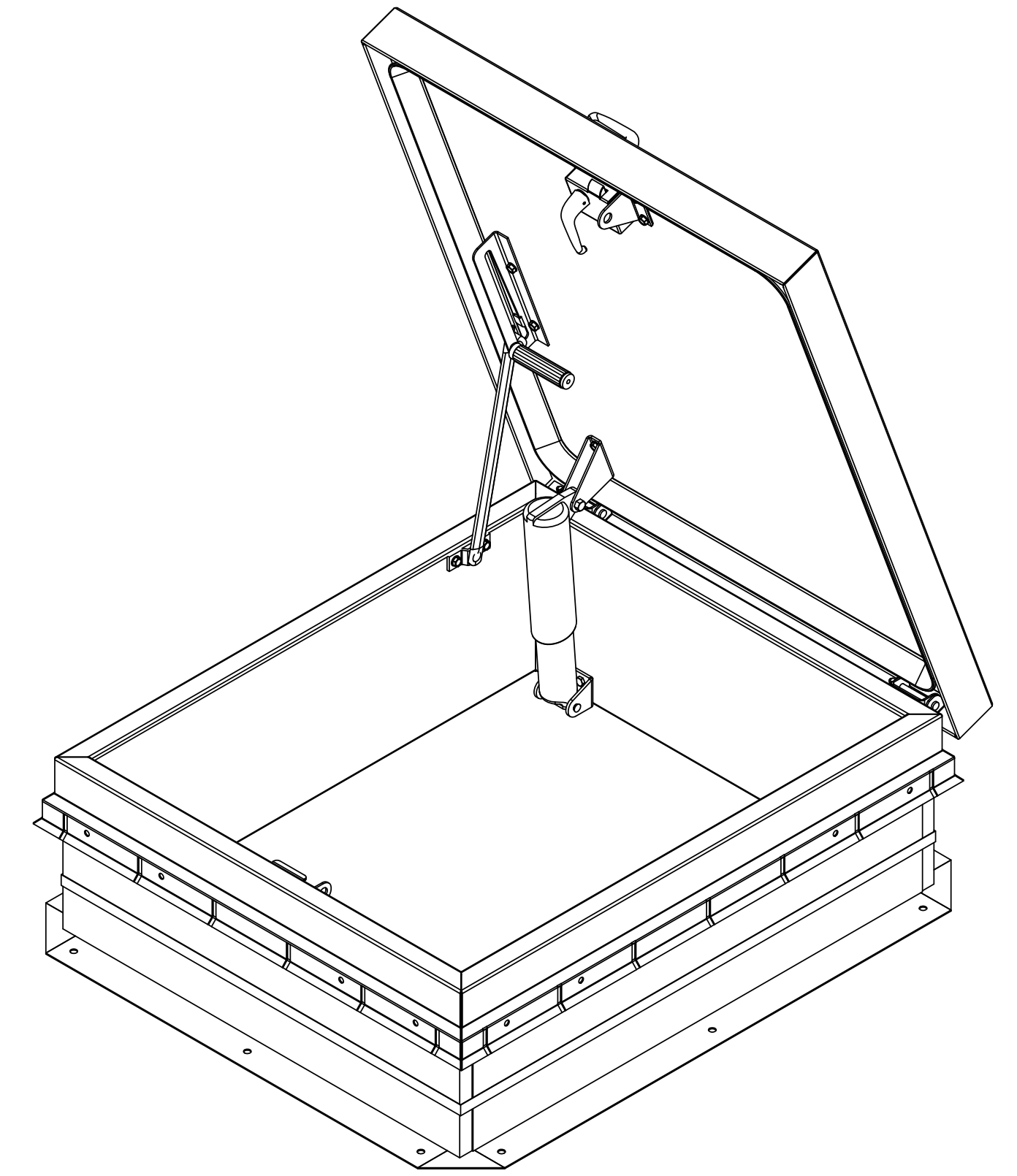
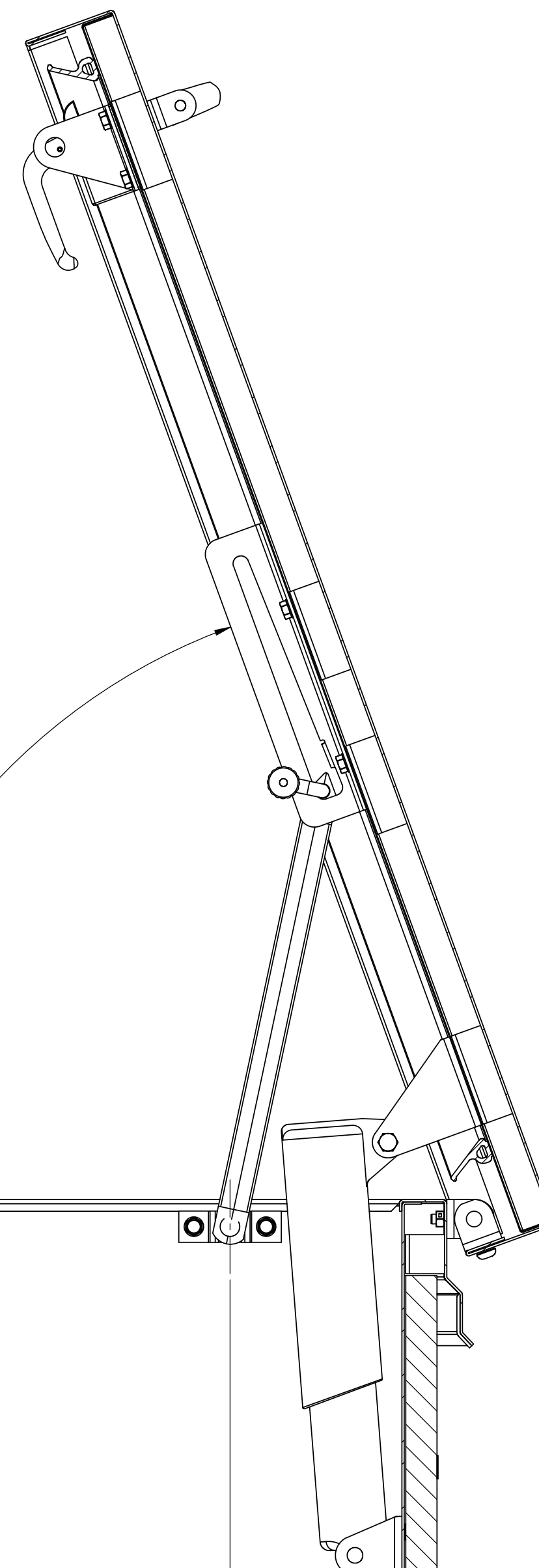
<small>UNLESS OTHERWISE SPECIFIED: REMOVE ALL BARRS &amp; SHARP CORNERS DIMENSION TOLERANCES XXX ±.010 XXX ±.015 XXX ±.020 FINISHES: .015 FRACTURING: 1:1/2</small>	NAME/ #	DATE		<small>THE BILCO COMPANY New Haven, Connecticut 06905</small>	
	DRAWN	ATR			05/20/10
	ORG. AUTHOR	TJ			
	ORG. ECR	5921			02/14/00
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<small>DO NOT SCALE DRAWING</small>			<small>SIZE</small> D	<small>DWG. NO.</small> S-DOOR	<small>REV</small> P
	SCALE: 1:4	WEIGHT:		SHEET 3 OF 7	



SECTION A-A

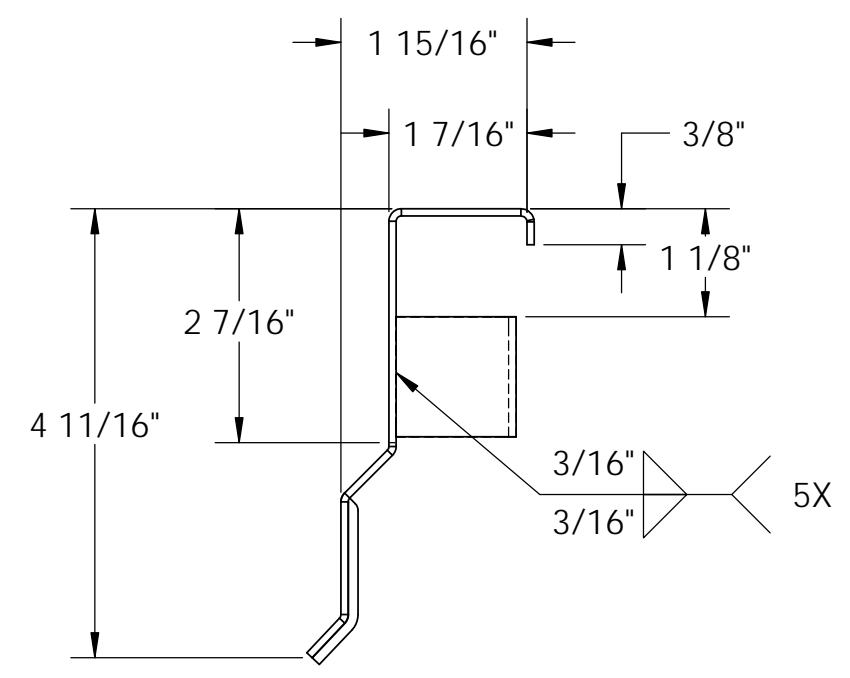
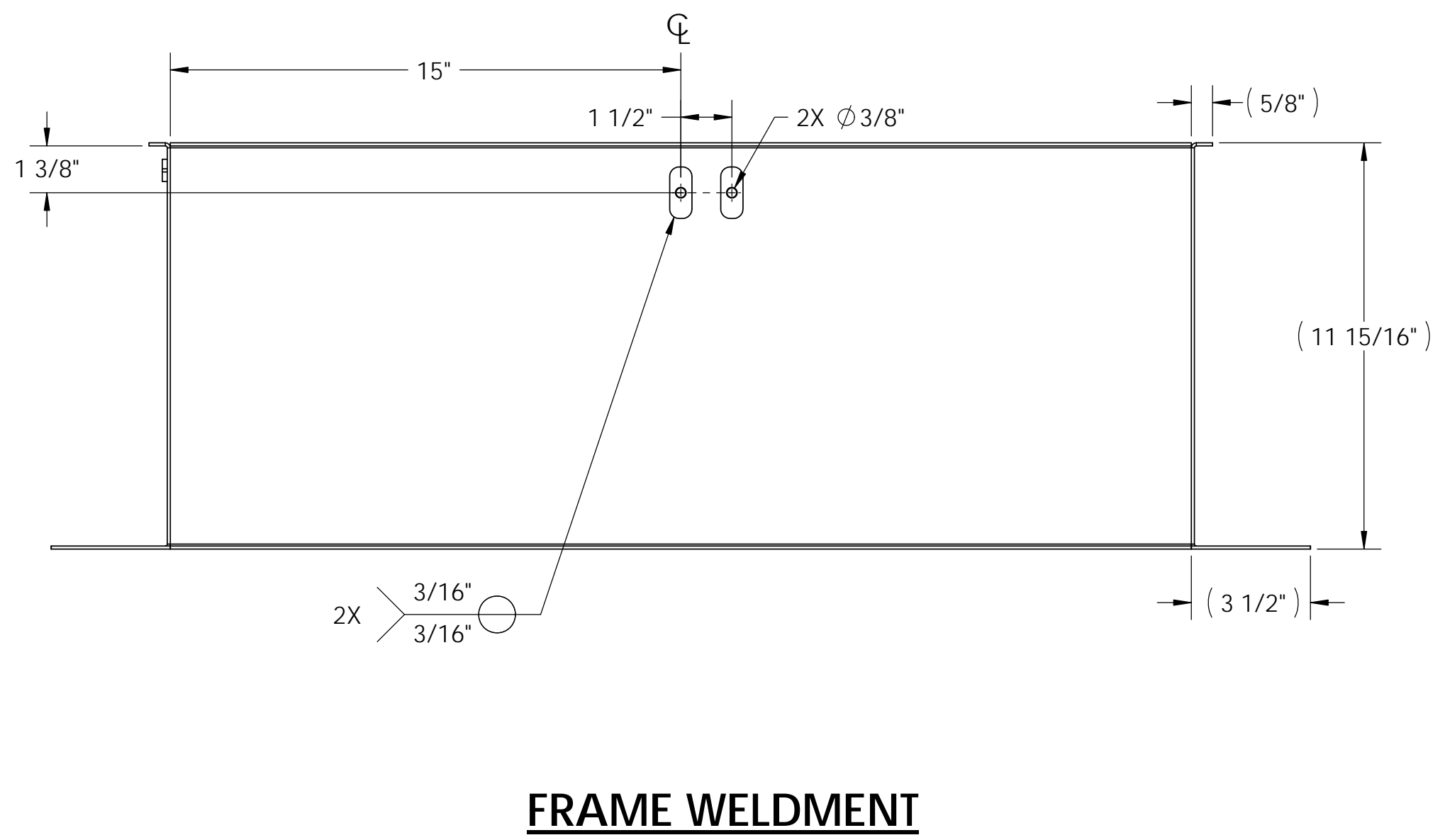
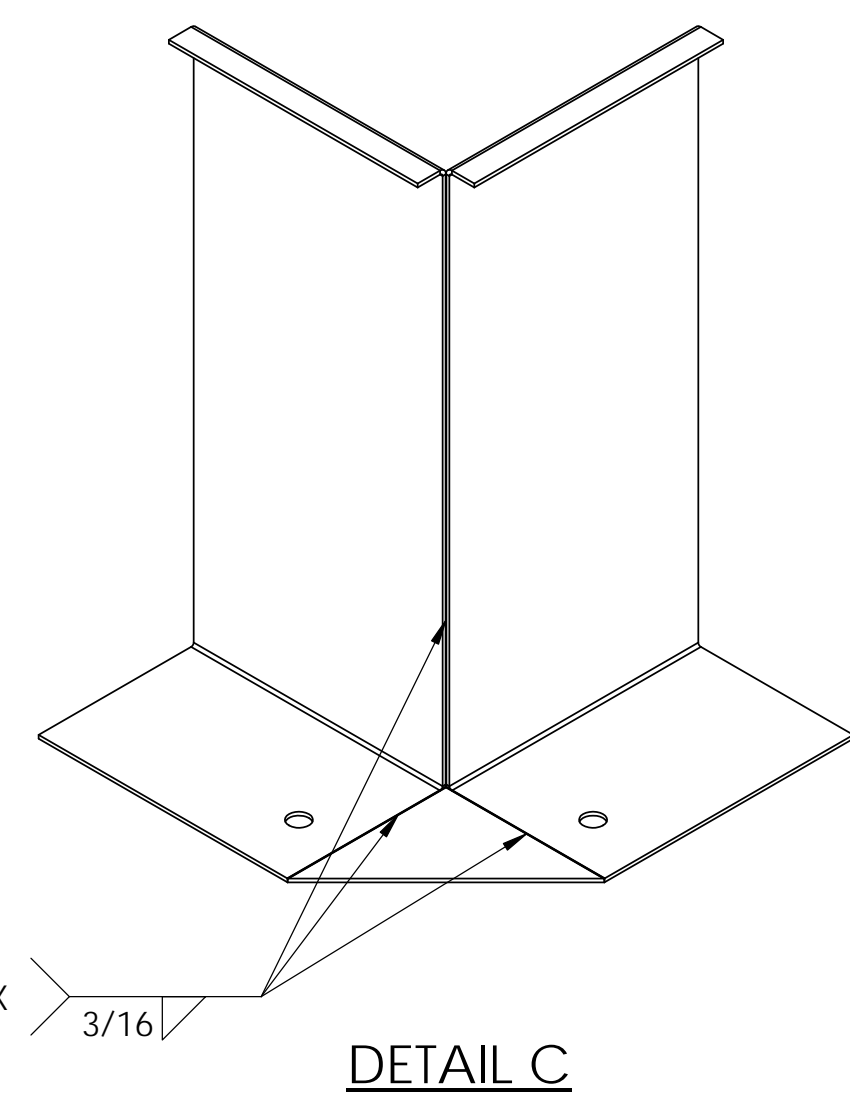
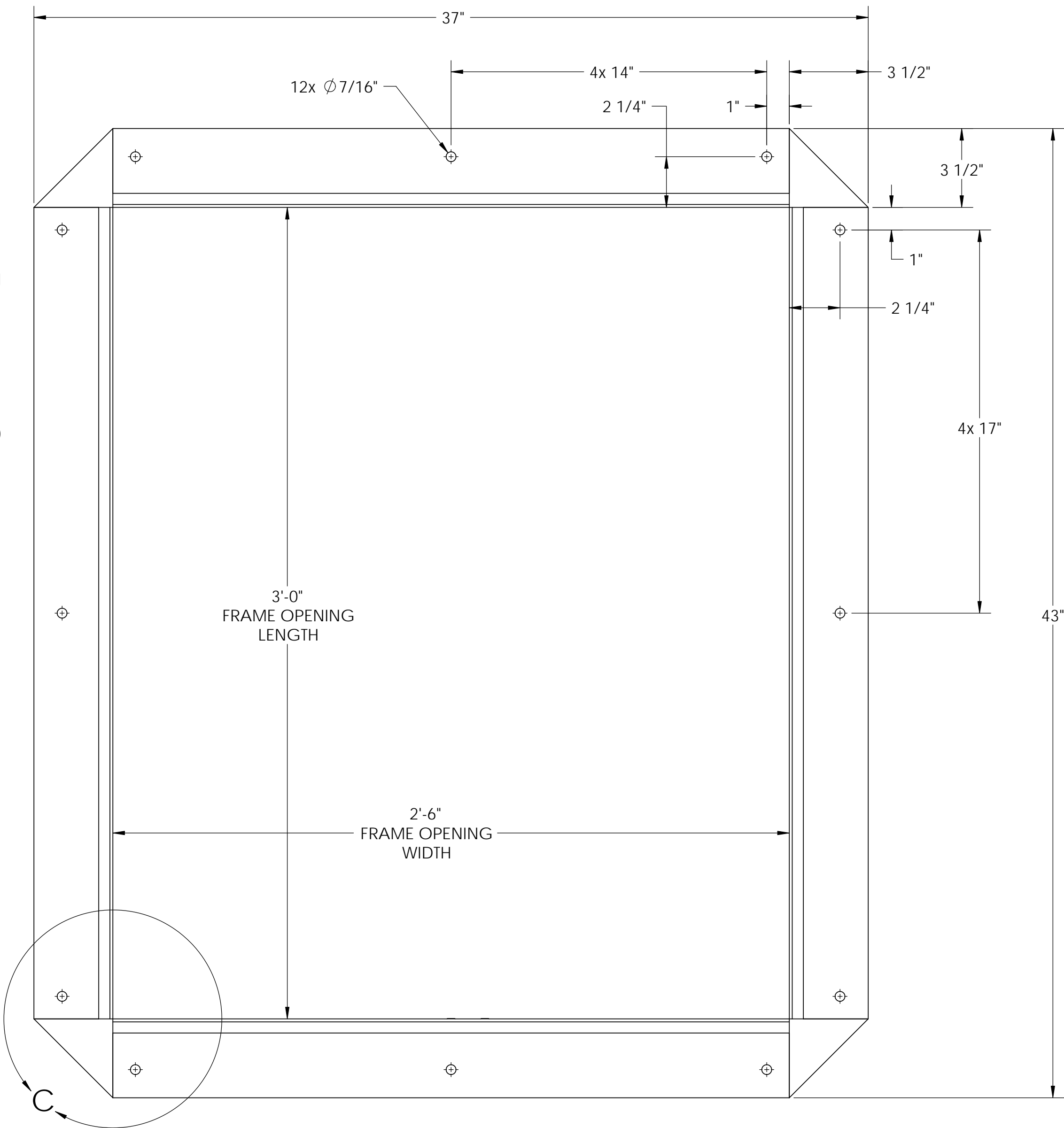
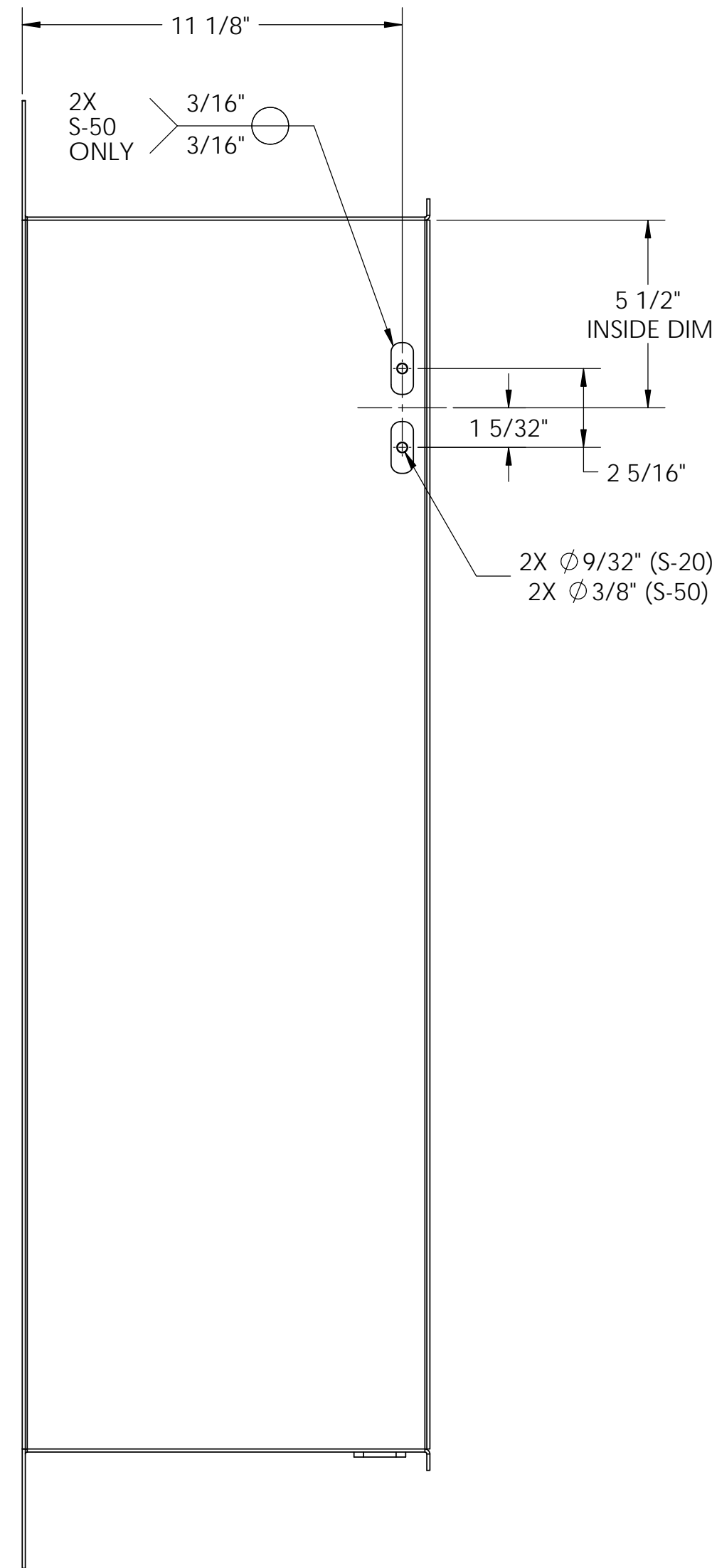


SECTION B-B

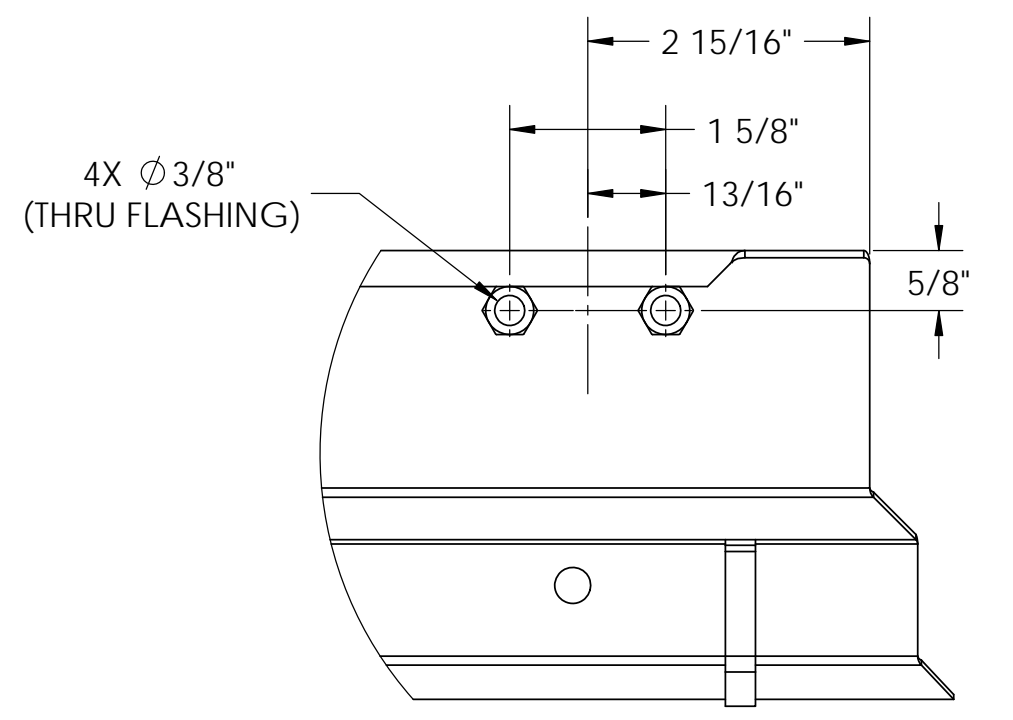


RELEASED TO  
MANUFACTURING  
DATE: 11/14/13  
APPROVED BY: D.J.C.

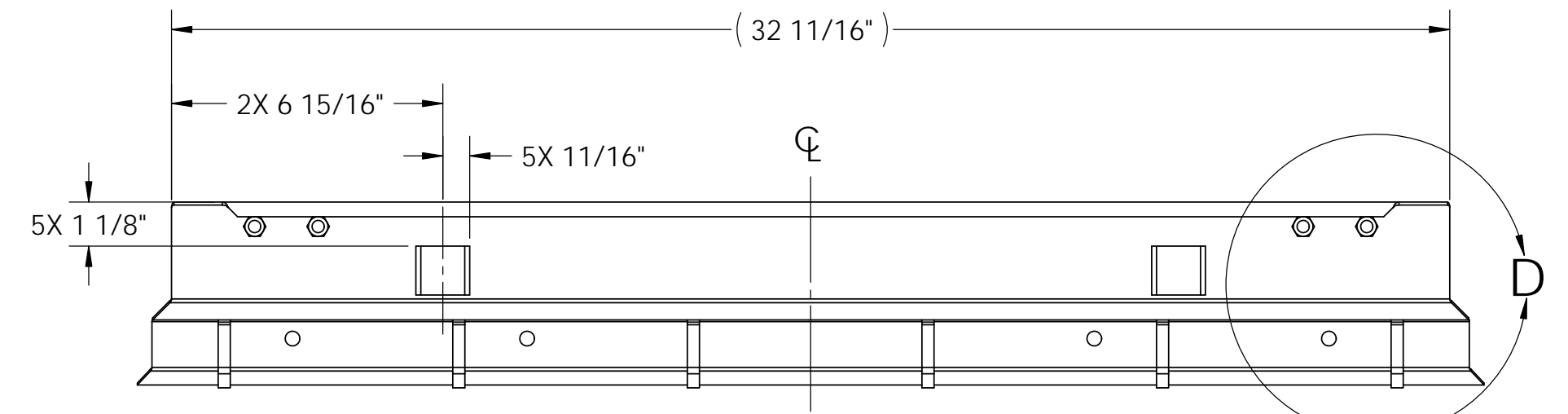
UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURS & SHARP CORNERS		NAME/ID	DATE	 THE BILCO COMPANY New Haven, Connecticut 06505
DIMENSION TOLERANCES FRACTIONS .005 DECIMALS .015 ANGLES .015 HOLE POSITION .015	DRAWN ATR 05/20/10	ORG. AUTHOR TJ	DATE 02/14/00	
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL	ORG. ECR 5921	Q.A.	3RD-ANGLE PROJECTION	TITLE: S DOOR ASSY
FINISH DO NOT SCALE DRAWING	SIZE D	DWG. NO. S-DOOR	REV P	SCALE: 1:6 WEIGHT: SHEET 4 OF 7



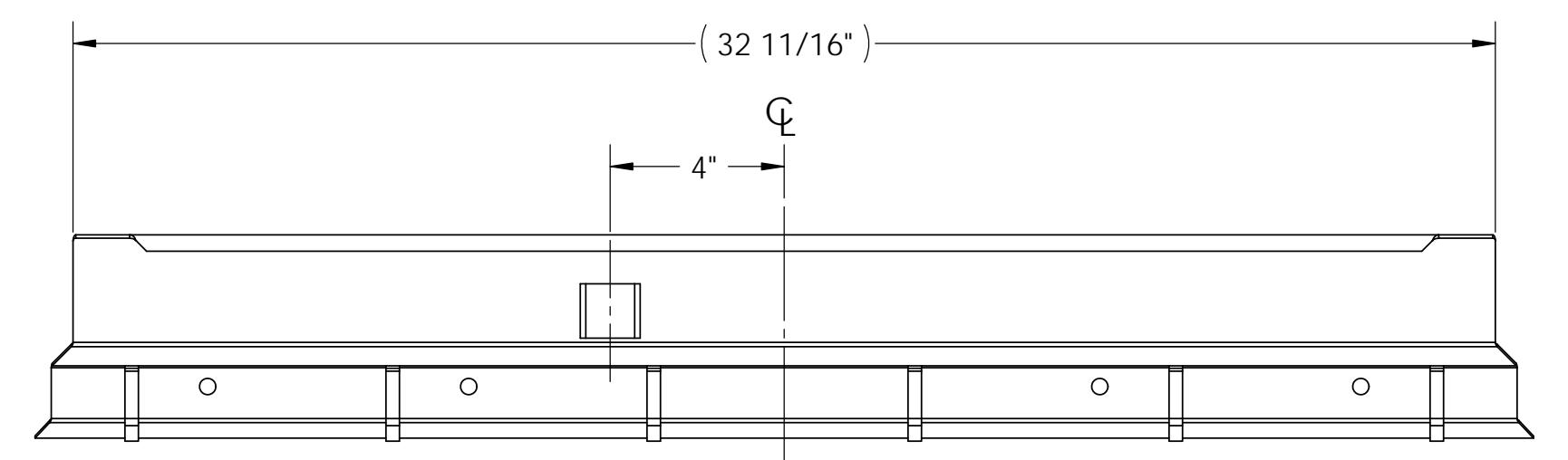
FLASHING SECTION (TYP)



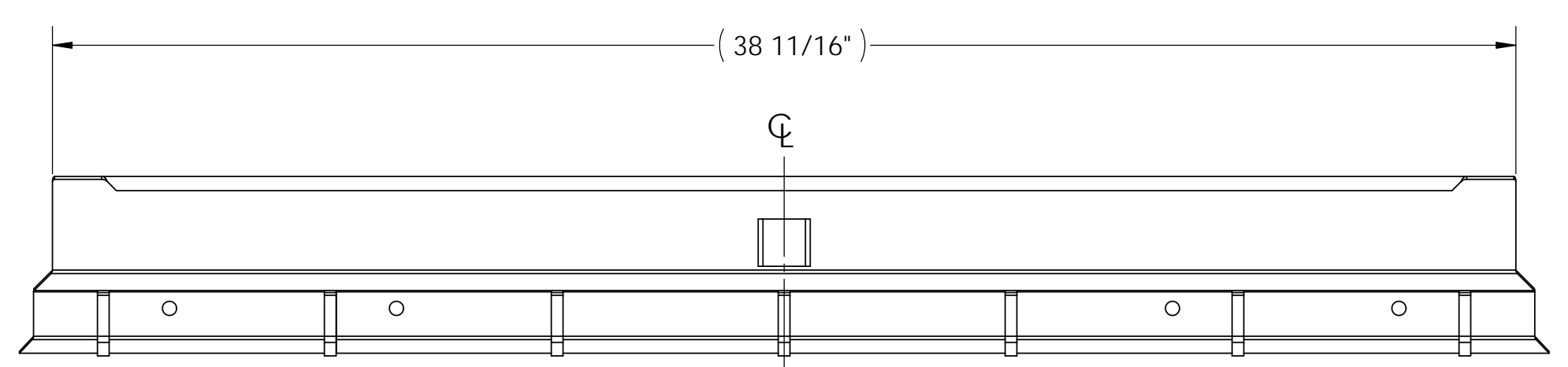
DETAIL D



HINGE SIDE



LATCH SIDE

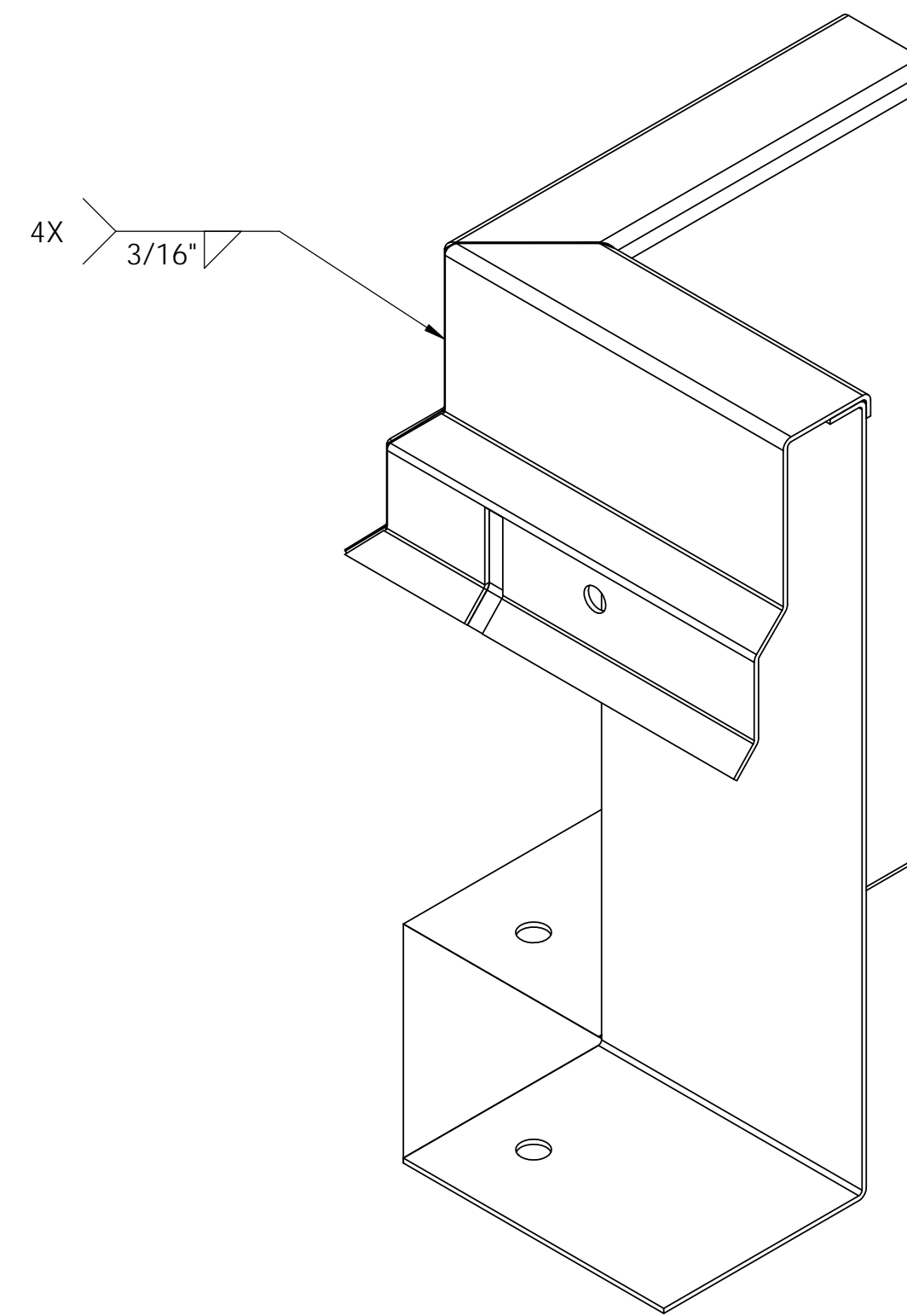
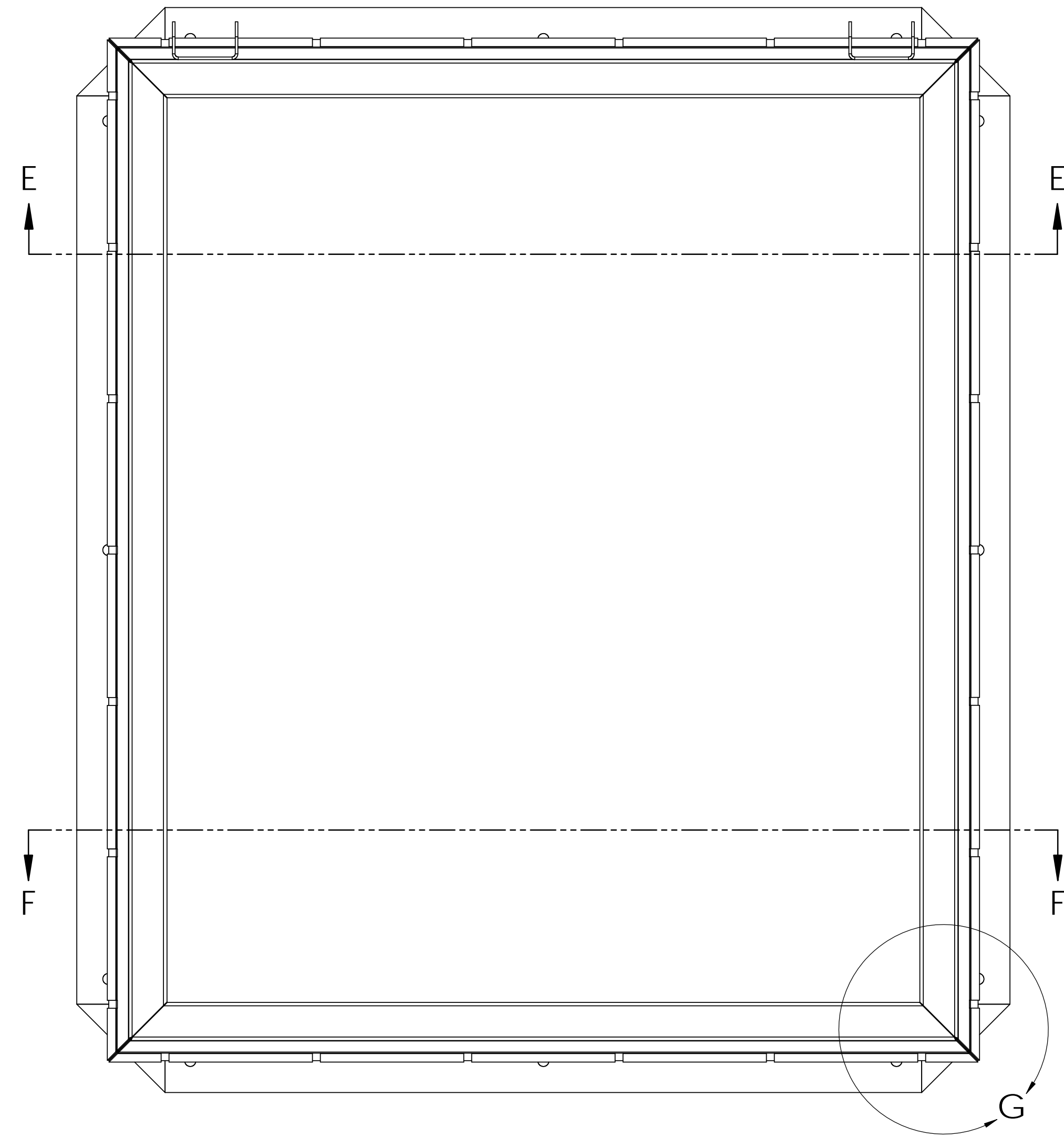


NON-HINGE SIDES

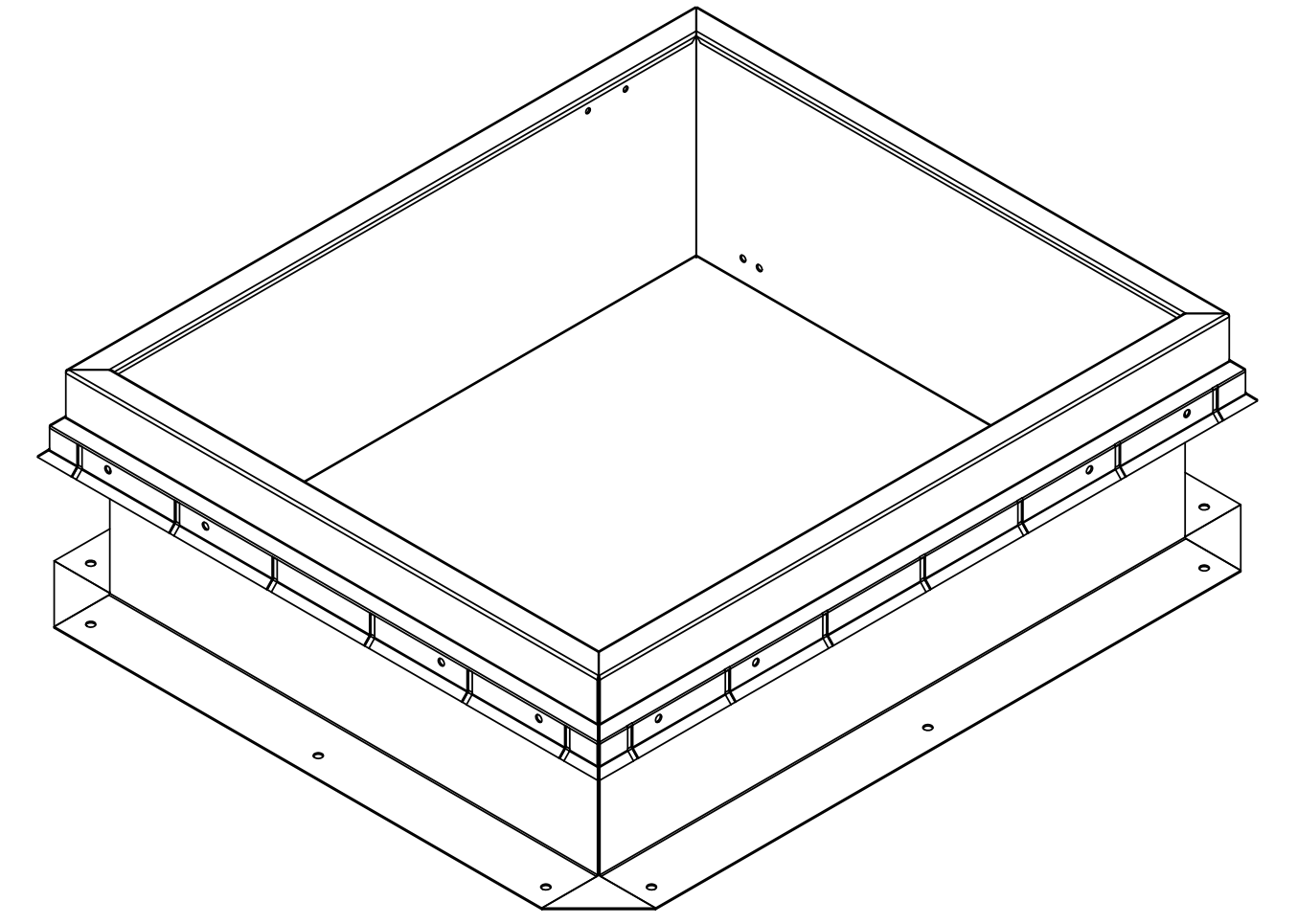
FLASHING WELDMENT

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

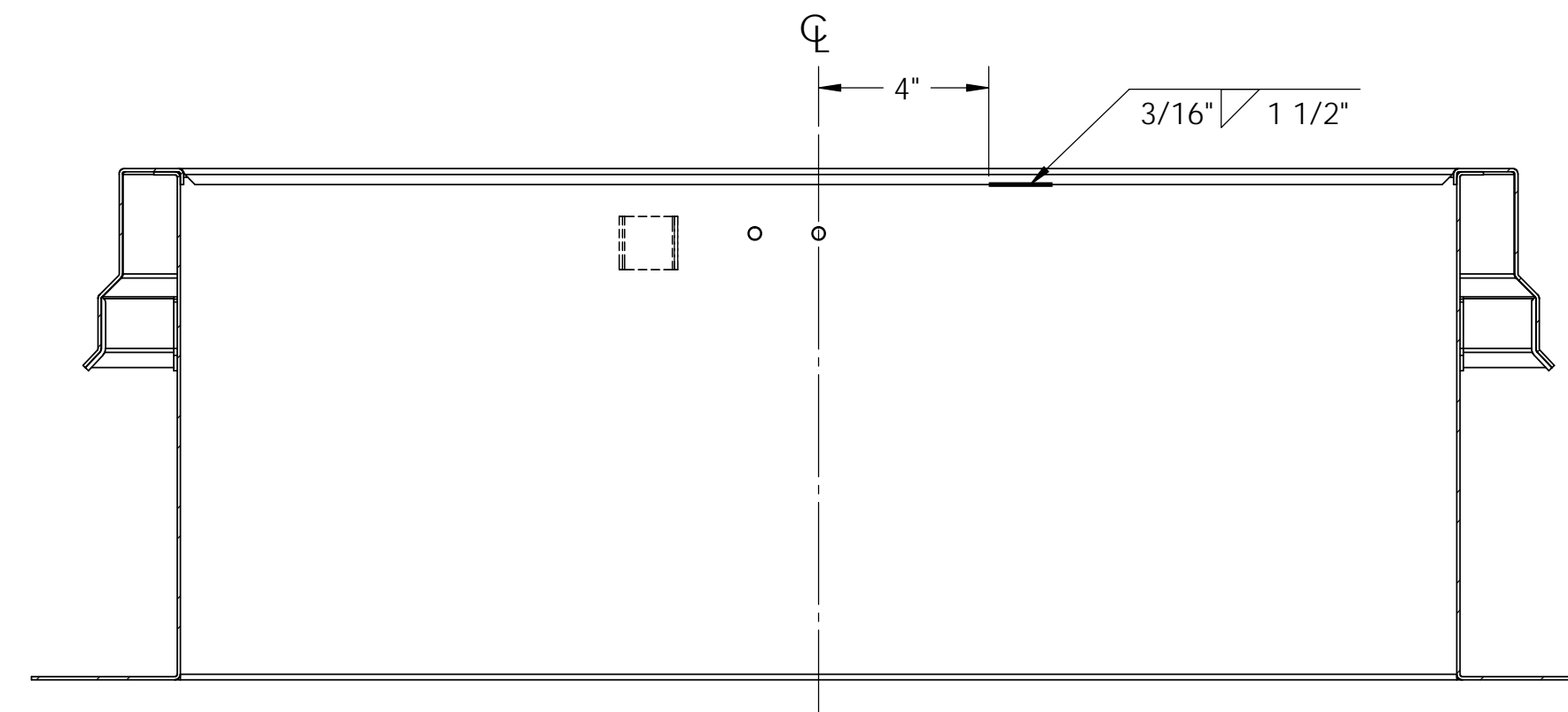
UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES XXX .XX .010 XXX .XX .005 XXX .XX .002 XXX .XX .001 XXX .XX .0005 XXX .XX .0002		NAME/ID ATR	DATE 05/20/10	THE BILCO COMPANY New Haven, Connecticut 06905 TITLE: S DOOR ASSY
THIS DRAWING IS THE PROPERTY OF THE BILCO COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN CONSENT OF THE BILCO COMPANY. THE INFORMATION CONTAINED HEREIN REMAINS THE PROPERTY OF THE BILCO COMPANY. ALL RIGHTS RESERVED.		ORG. AUTHOR TJ	DATE 02/14/00	
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL		3RD-ANGLE PROJECTION		SIZE DWG. NO. D S-DOOR
DO NOT SCALE DRAWING				REV P
		SCALE: 1:4		WEIGHT: SHEET 5 OF 7



**DETAIL G**



**SECTION E-E  
HINGE SIDE**

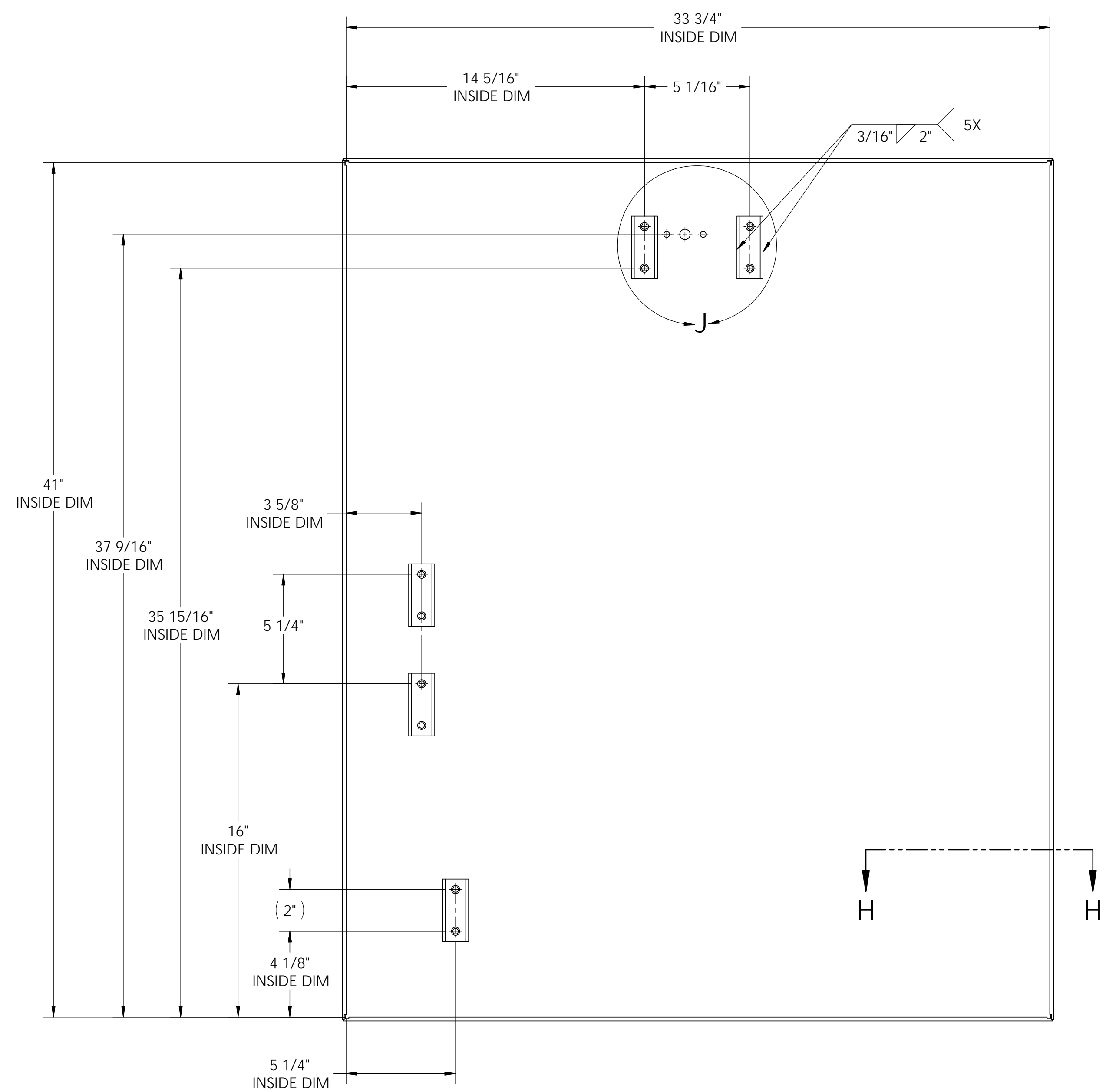


**SECTION F-F  
LATCH SIDE**

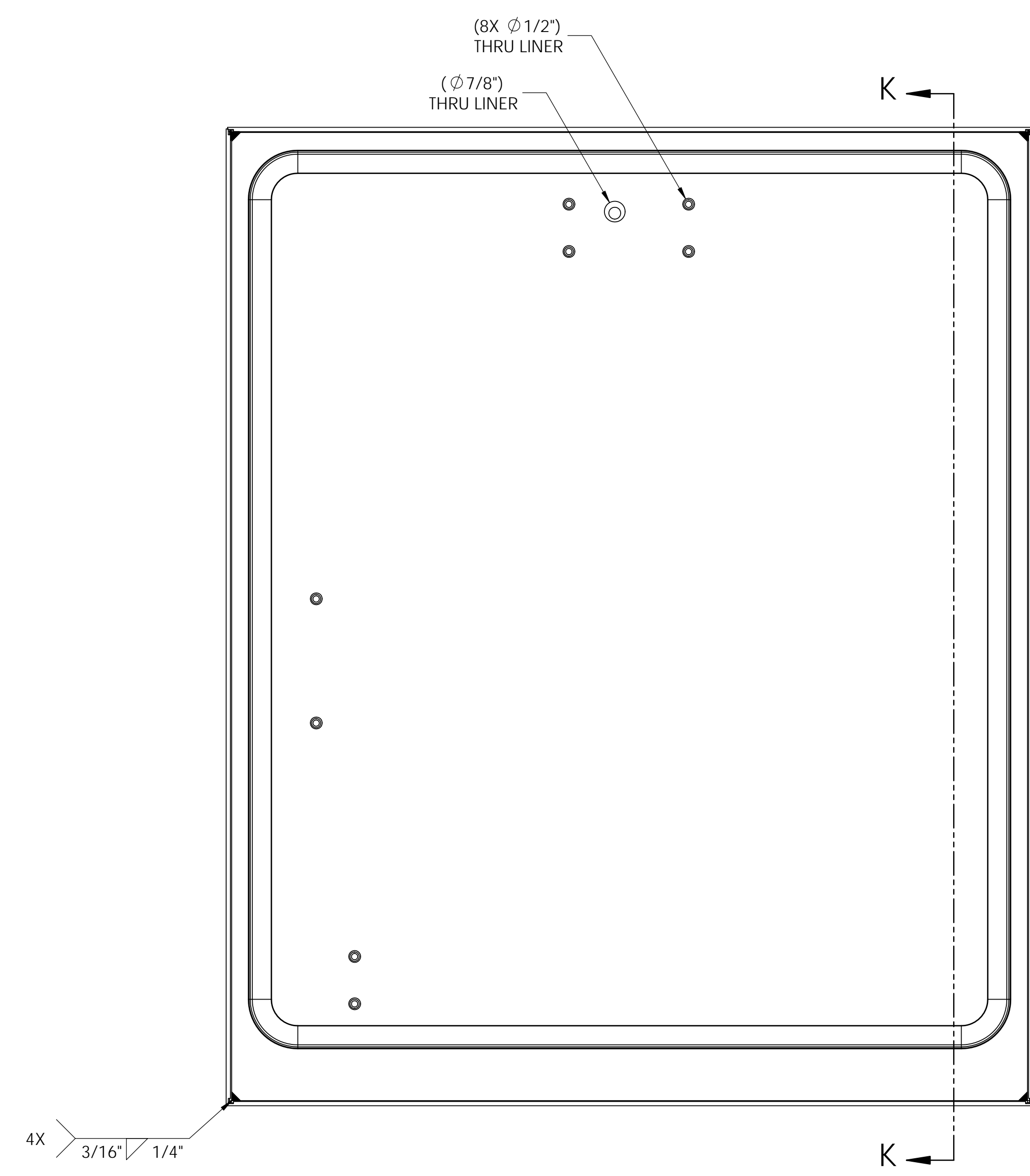
**FRAME/FLASHING WELDMENT**

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

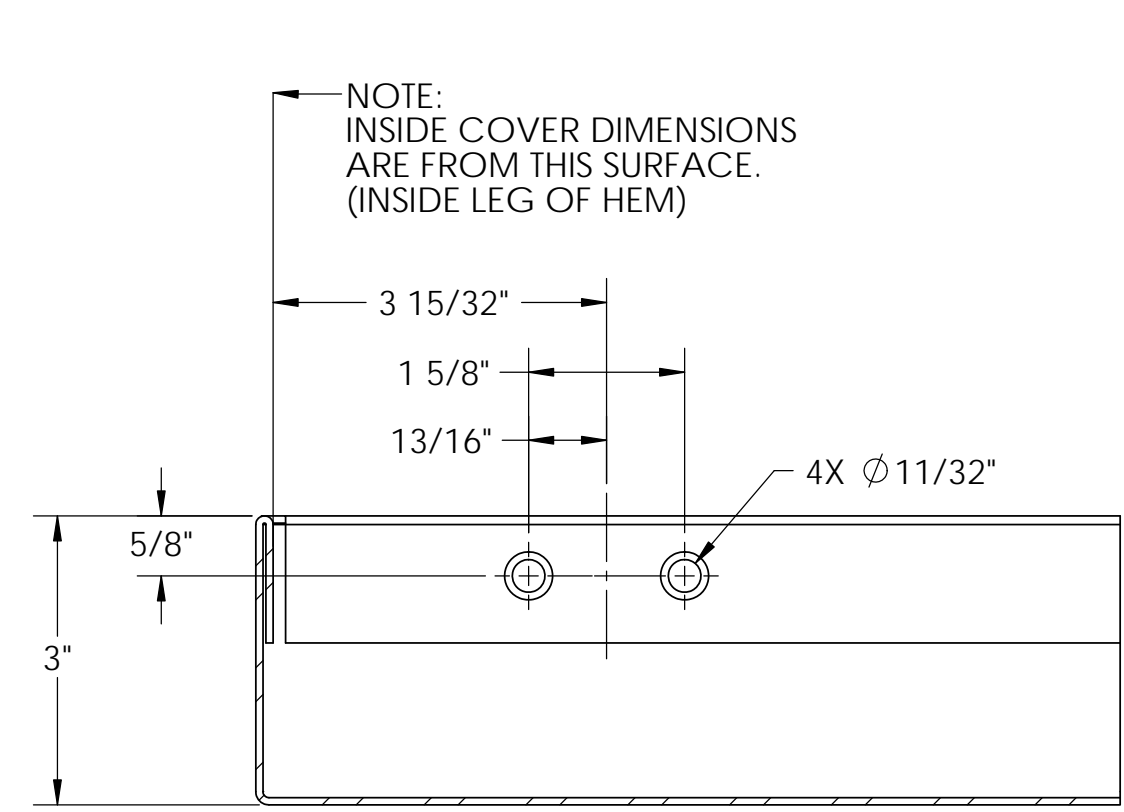
UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURS & SHARP CORNERS		NAME/ID	DATE		THE BILCO COMPANY <small>New Haven, Connecticut 06905</small>
DRAWN	ATR	05/20/10			
DIMENSION TOLERANCES XXX OF .010 XXX OF .010 XXX OF .010 XXX OF .010 XXX OF .010		ORG. AUTHOR	TJ	TITLE:	
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL		ORG. ECR	5921	02/14/00	S DOOR ASSY
FINISH		3RD-ANGLE PROJECTION		SIZE DWG. NO.	
DO NOT SCALE DRAWING				<b>D</b> S-DOOR	
				SCALE: 1:4	WEIGHT: SHEET 6 OF 7
				REV	P



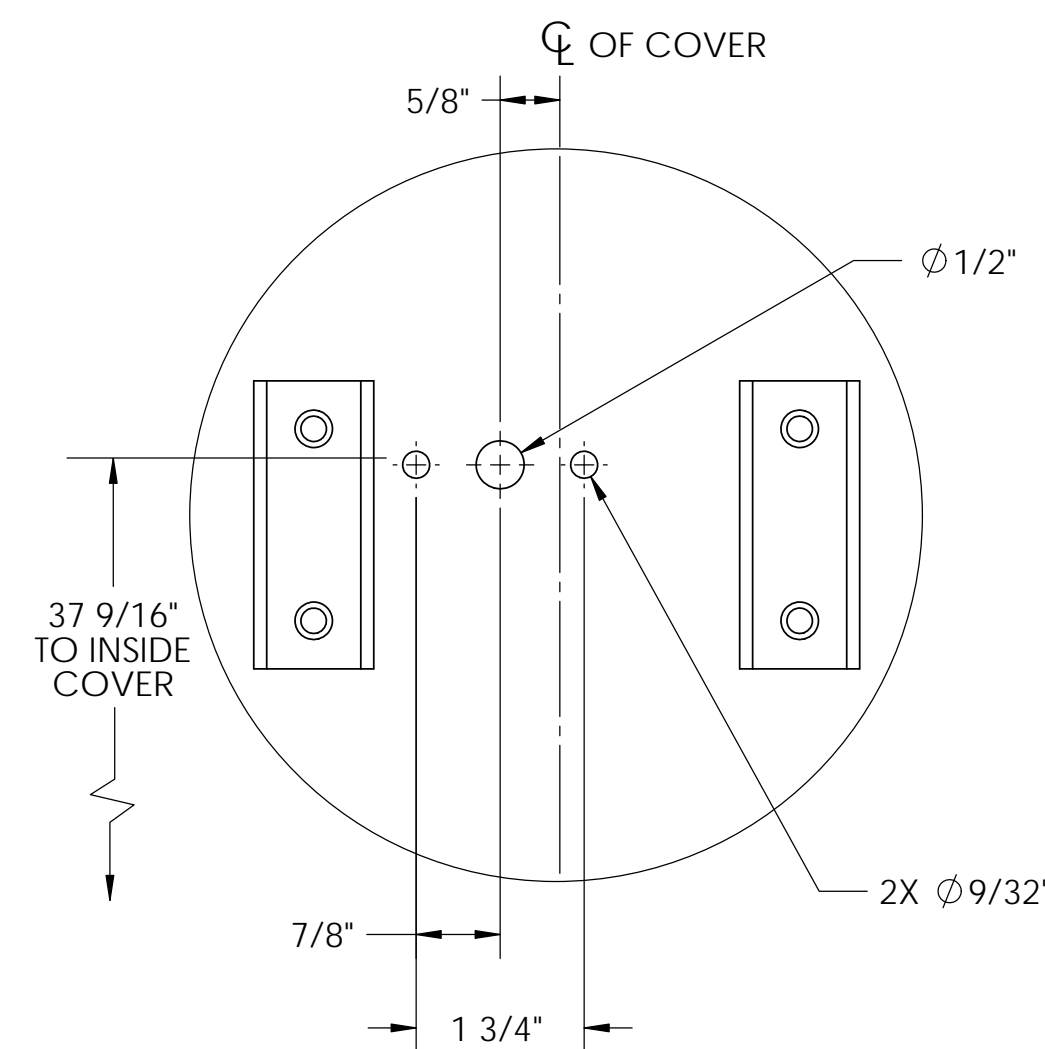
**COVER SPACER LAYOUT**



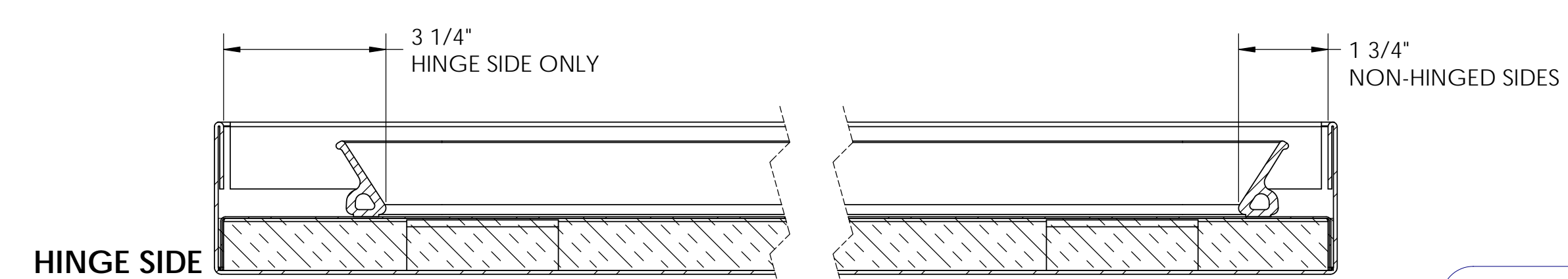
**COVER LINER WELDMENT & GASKET LOCATION**



**SECTION H-H**



**DETAIL J**



**SECTION K-K**

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

UNLESS OTHERWISE SPECIFIED: REMOVE ALL BURRS & SHARP CORNERS DIMENSION TOLERANCES XXX .125 XXX .075 XXX .050 FINISH: .015 PRACTICES: 11.152		NAME/ID ATR	DATE 05/20/10	 THE BILCO COMPANY New Haven, Connecticut 06505
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INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL		3RD-ANGLE PROJECTION		TITLE: S DOOR ASSY
DO NOT SCALE DRAWING		SIZE D	DWG. NO. S-DOOR	REV P
		SCALE: 1:4	WEIGHT:	SHEET 7 OF 7