

Subject Weld Quality Standards	Effective Date: 07/28/2025	Number: QAP018
	Pages: 5	Revision: B

- 1.0 PURPOSE:** To clearly define the Quality Standard allowances for welds on each Production line.
- 2.0 SCOPE:** Standard applies to all welds on window or door sashes and frames after corner cleaning excluding beveled edges.
- 3.0 PROCEDURE:** Suspect sash and frame welds should be compared to the standards outlined below. Welds which do not meet the allowances listed in the chart shall be rejected. Rejected window welds can be reworked by Production if determined acceptable by Quality Manger, Engineer or Supervisor and Production Manager or Supervisor.
- 4.0 INSPECTION:** Completed based on the criteria outlined in the Table 2: Characteristics A, B and C below. 3 weld classifications have been identified (A, B and C surfaces) with examples for each Production line identified in Table 2 below.
- 4.1** Window weld inspections **MUST** be completed before the window(s) are wrapped or boxed for shipment.
- 4.1.1** Check all 4 corners on interior outmost facing welds of both the frame and sash(s)
- 4.1.2** Verify inner weld channels of frame and functionality of sash and screen
- 4.1.3** Turn window around, check all 4 corners on exterior outmost facing welds of both the frame and sash(s)
- 5.0 WELD CONSISTENCY:**
- 5.1** If one weld on an A surface is flush, all other welds **MUST** be flush.
- 5.2** Full length of the weld must be cleaned and meeting the criteria outlined in Table 2: Characteristics A, B and C.
- 5.3** Due to the highly variable nature of the vinyl welding process some Acceptable Cosmetic Variations within a weld joint are expected. Variations can include changes in height, width, or steps. Variations are outlined in Table 1: Acceptable Cosmetic Variations below. While variations are acceptable, they will still fall within the specifications outlined in Table 2: Characteristics A, B and C

Table 1: Acceptable Cosmetic Variations

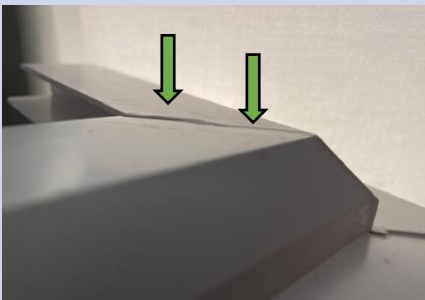
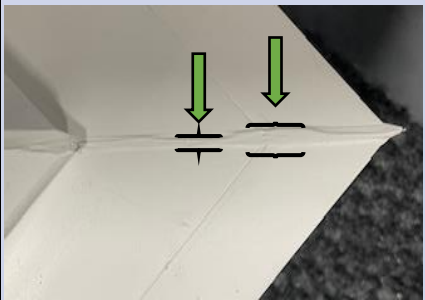
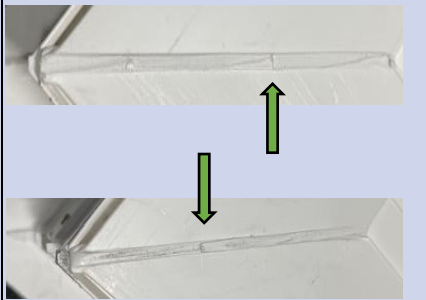
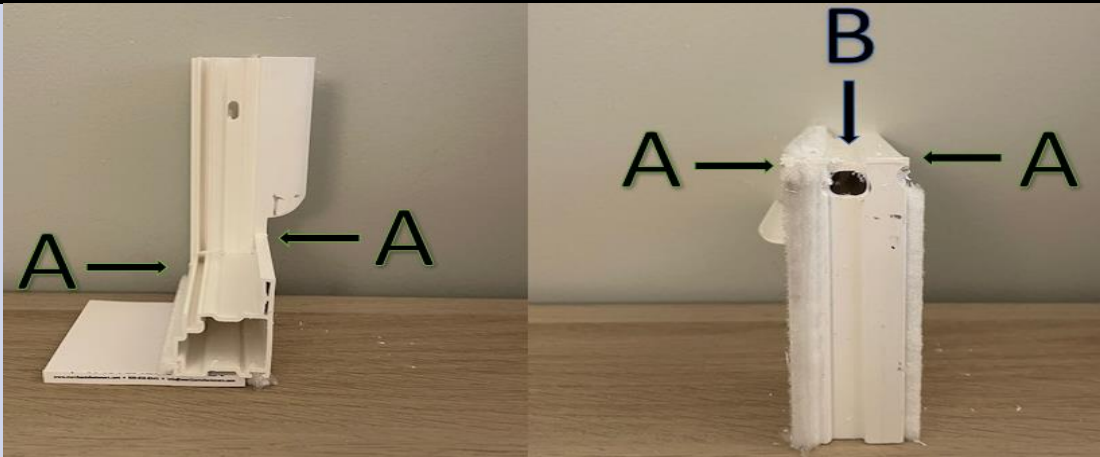
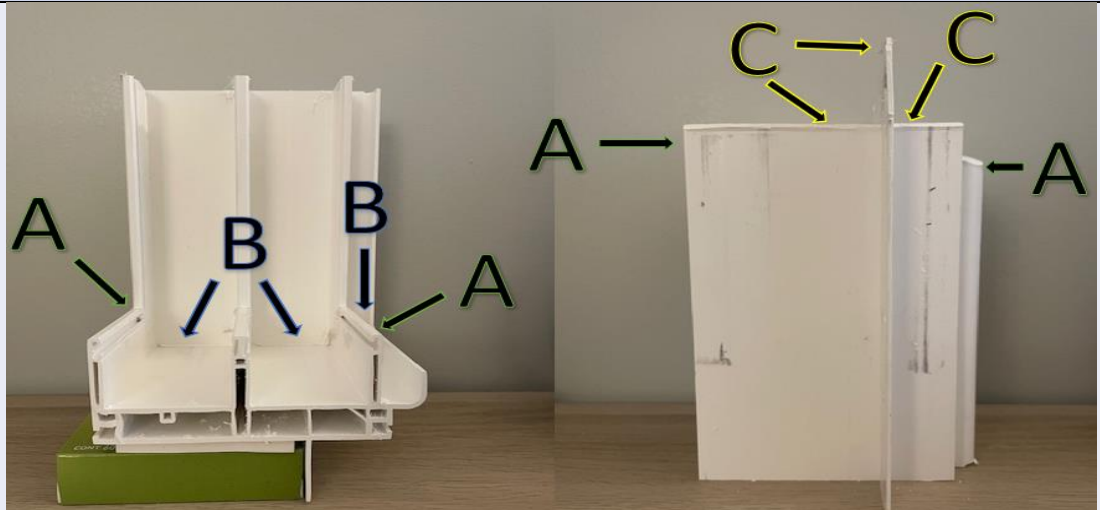
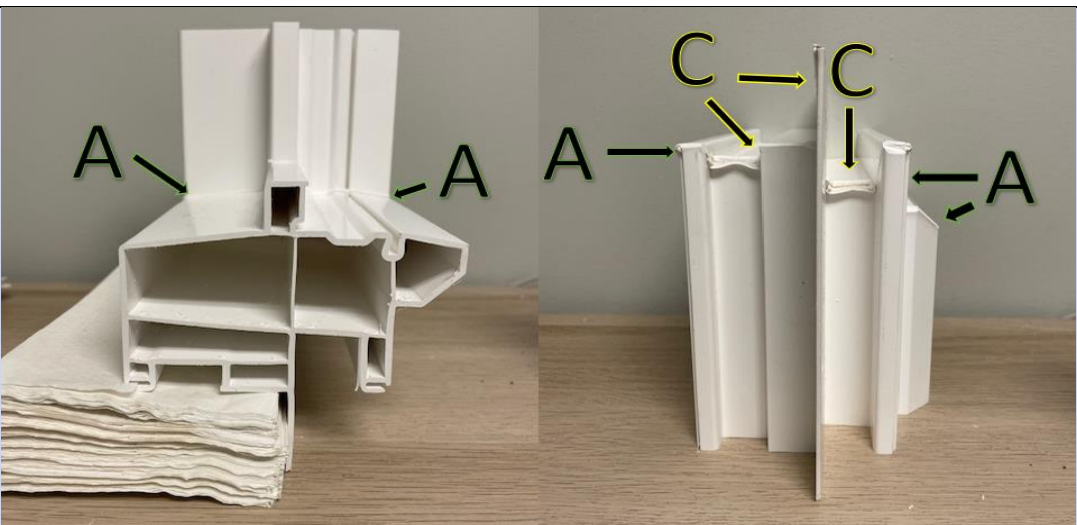
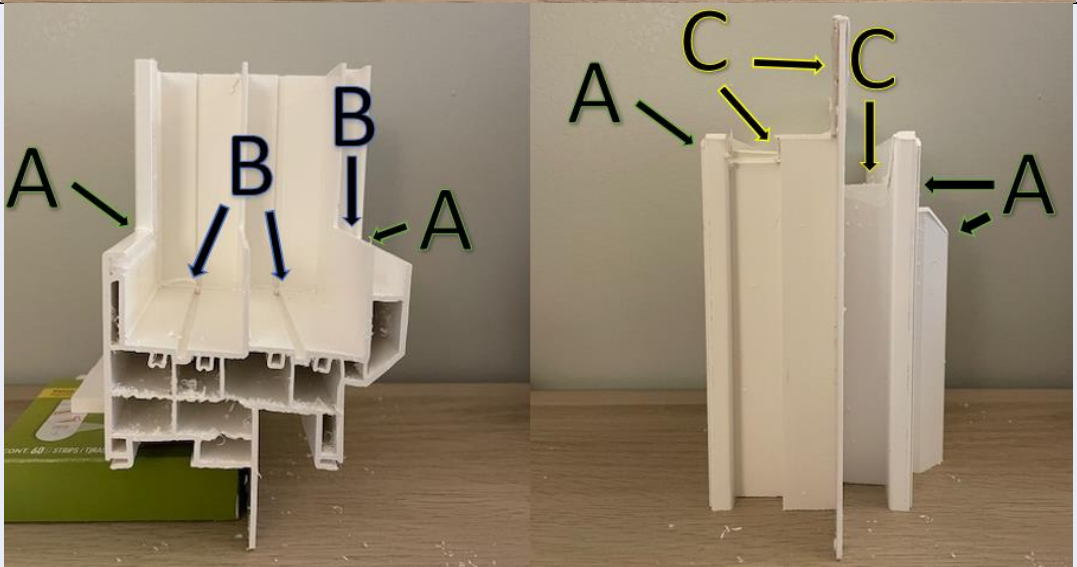
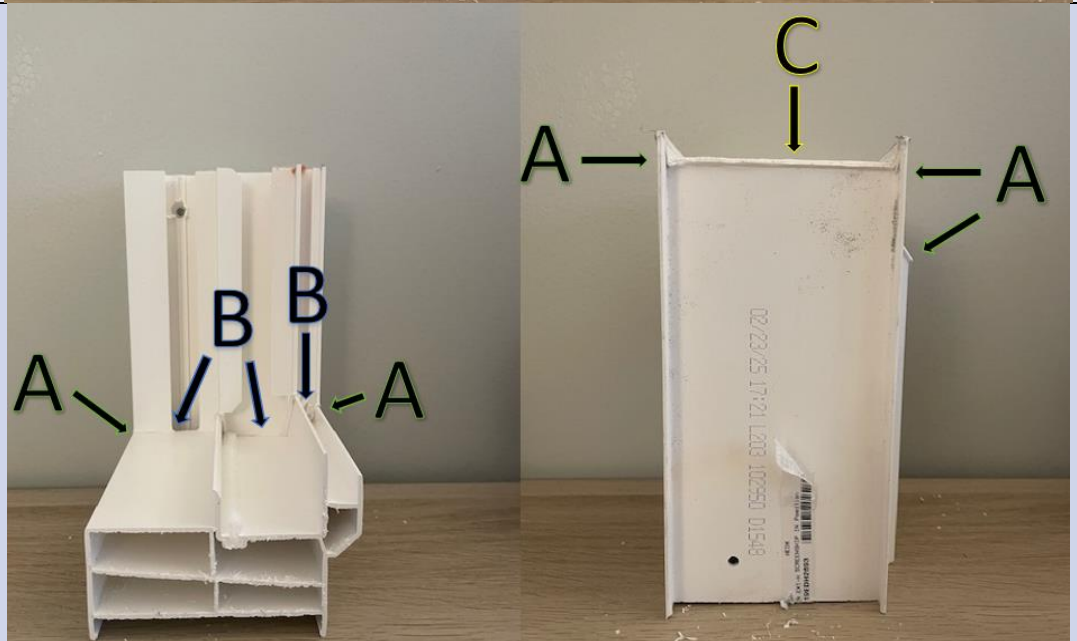
	Height	Width	Steps
SAMPLE PHOTO			

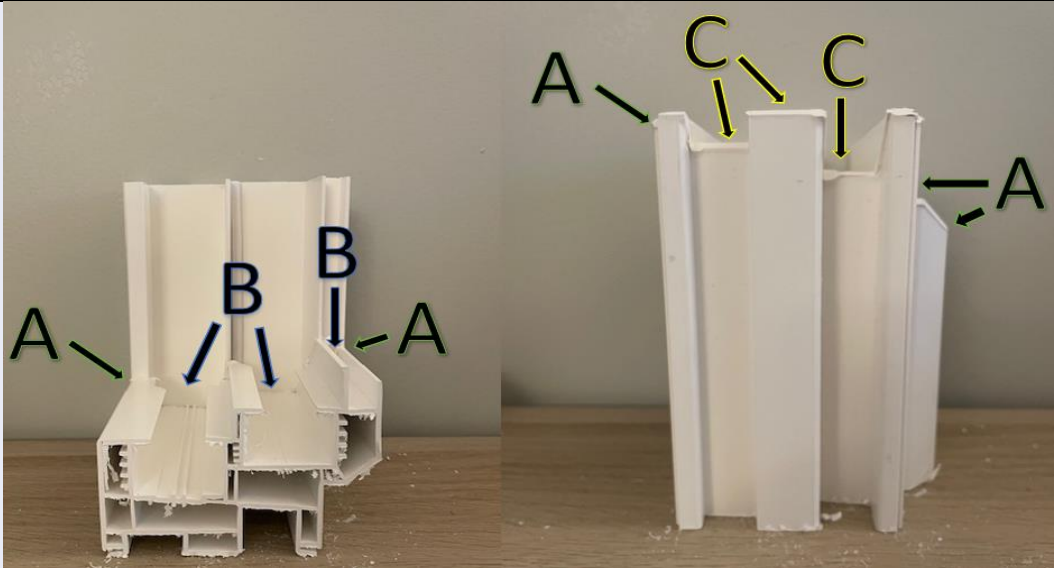
Table 2: Characteristics A, B and C

	A	B	C
Characteristic	Outward facing welds require aesthetic consistency	Inner weld channels. Functional ONLY , do NOT require aesthetic consistency	Non-visible welds, may or may not be cleaned. No aesthetic or functional standards.
Gaps/Cracks	Zero Tolerance		
Weld Offset (step)	+/- 1/32"	N/A	N/A
Weld Flashing (hanging)	Zero Tolerance		N/A

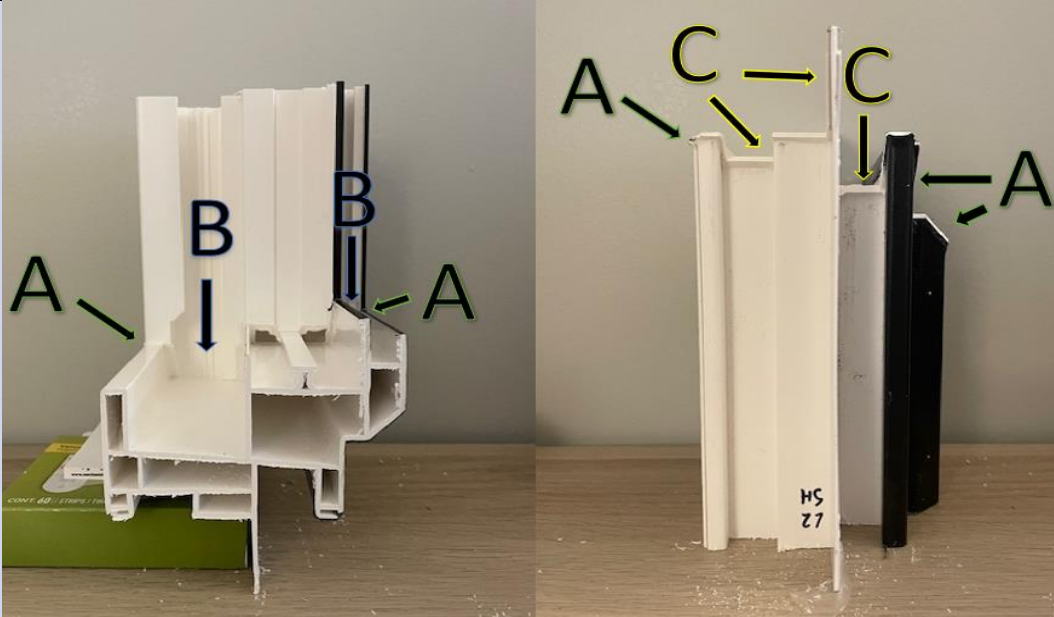
Max Weld Height	1/32"	Cannot impede function of the sash/screen	N/A
Max Weld Width	1/8"	Cannot impede function of the sash/screen	N/A
SAMPLE PHOTO			
All Sash			
Patio Door			

Picture	
Slider	
Edgemont Double Hung	

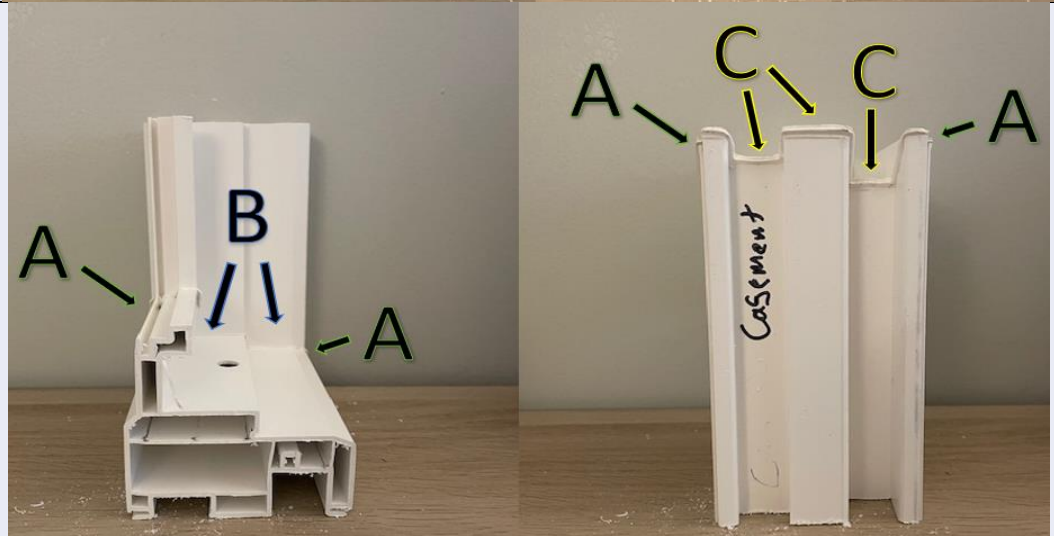
**S-series
Oceanview
Cambridge
Double Hung**



Single Hung



Casement



**Florida
Flange**

