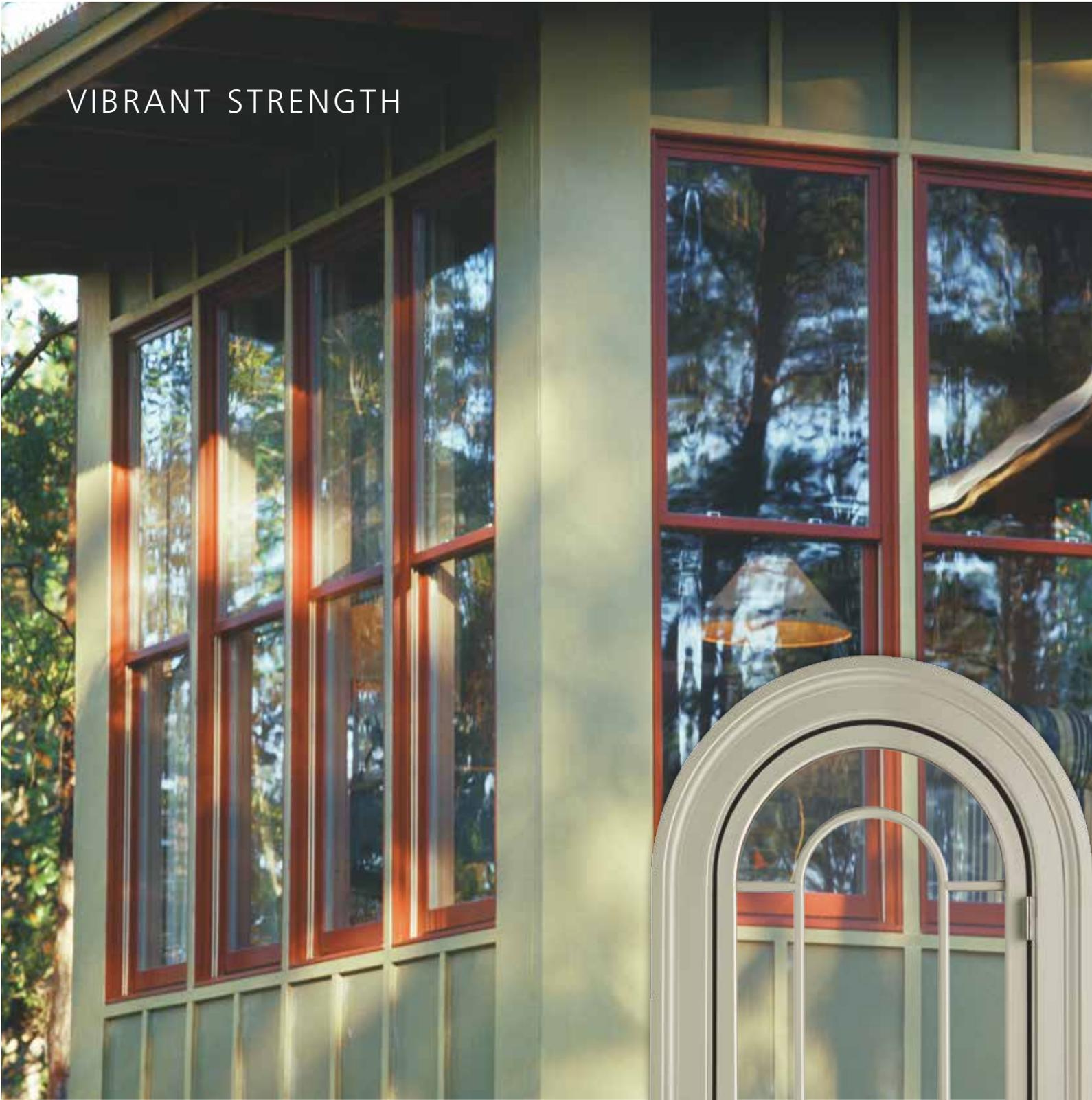


**Custom**  
Wood Windows & Patio Doors

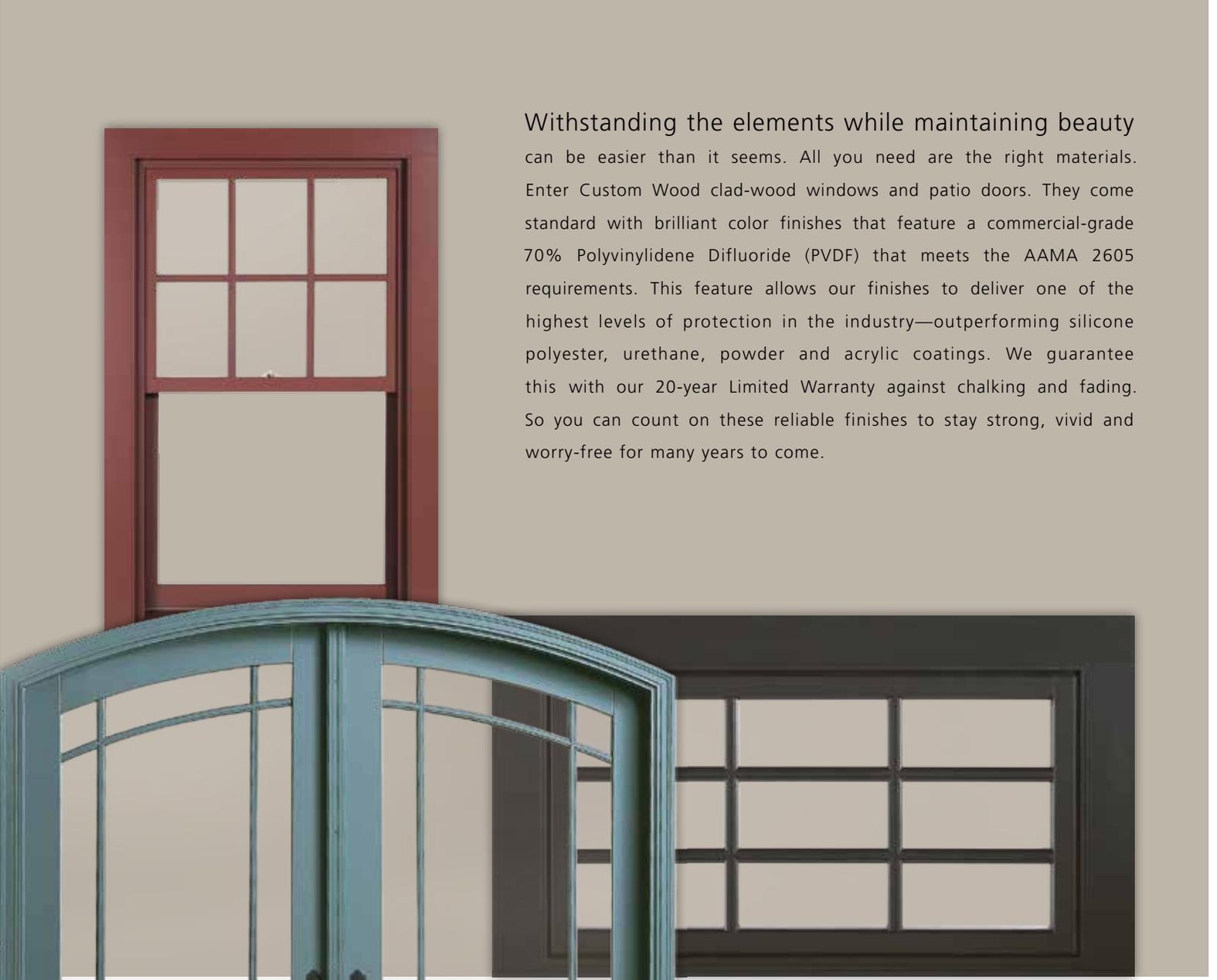
Exterior Clad Colors and Finishes



# VIBRANT STRENGTH



Our wood and clad-wood windows and patio doors are crafted from solid pine AuraLast® wood. It protects against wood decay, water saturation and termites and is supported by a Lifetime Limited Warranty. Learn more at [www.jeld-wen.com/auralast](http://www.jeld-wen.com/auralast).



Withstanding the elements while maintaining beauty can be easier than it seems. All you need are the right materials. Enter Custom Wood clad-wood windows and patio doors. They come standard with brilliant color finishes that feature a commercial-grade 70% Polyvinylidene Difluoride (PVDF) that meets the AAMA 2605 requirements. This feature allows our finishes to deliver one of the highest levels of protection in the industry—outperforming silicone polyester, urethane, powder and acrylic coatings. We guarantee this with our 20-year Limited Warranty against chalking and fading. So you can count on these reliable finishes to stay strong, vivid and worry-free for many years to come.

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# ENCHANTING FINISHES

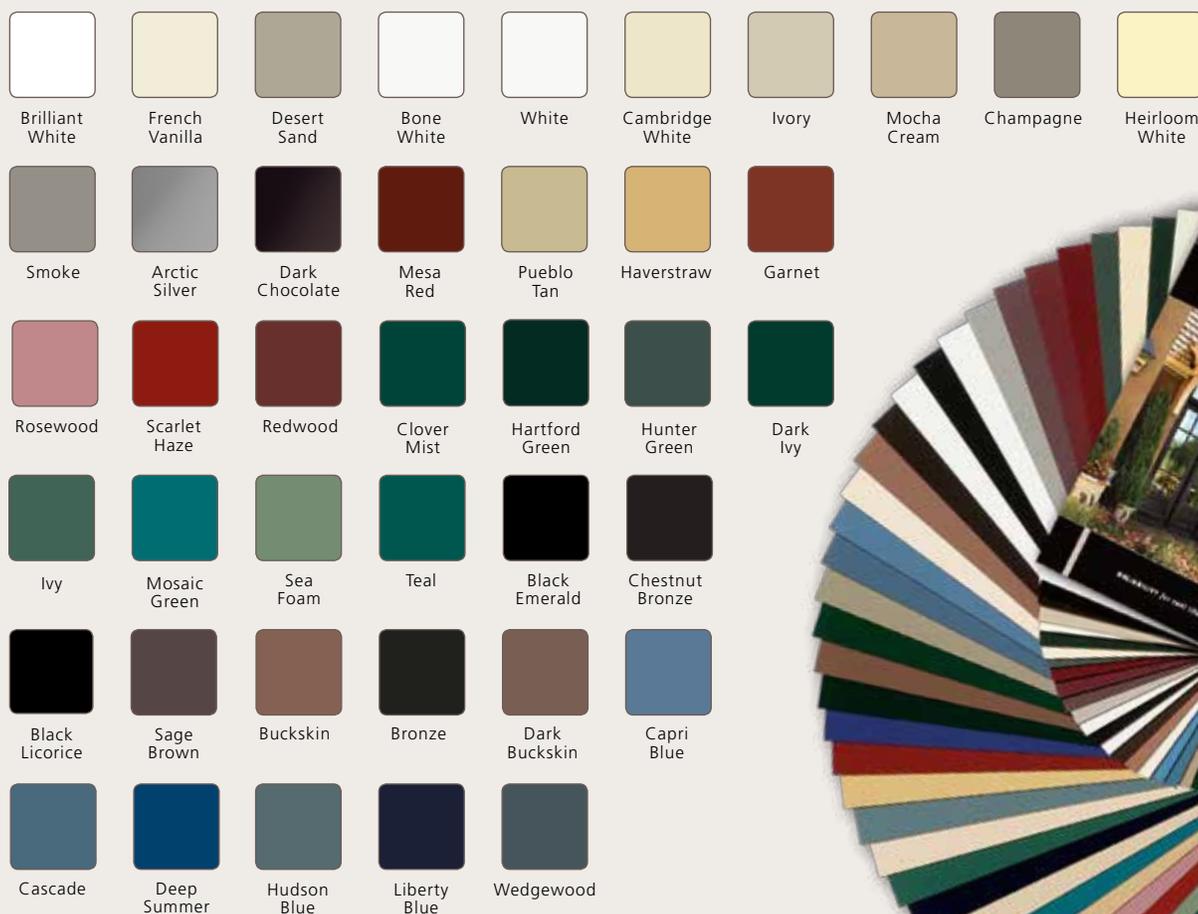


## Metal Clad Colors

Our Custom Wood windows and patio doors with clad-wood exteriors are available in a large array of color finishes. We offer 41 standard colors\*, as well as custom color matching for a truly personalized look. For added visual interest, select two different colors for your window (one for the frame, one for the sash).

Standard colors are shown in the swatches below. To obtain a custom color, send us a sample of the color you desire painted on a piece of aluminum, and our lab experts will create a customized match. No minimum order is required.

### 41 exterior metal clad colors with a 70% PVDF finish



*Color swatches are for representation only and may not match our clad colors exactly.*

*\*Some colors may require additional lead time.*



## Copper Cladding

With our copper cladding options, you can enjoy a look that constantly changes, yet remains beautiful. This architectural element features an appearance that fluctuates based upon region, exposure to moisture and interaction with various elements in the atmosphere. These stages of oxidation create a variety of different natural looks which will appear over time.

Copper cladding is available on the window sash component or patio door panel only, so you can select a contrasting or complementary metal clad color for the frame. Along with Bright Copper cladding, we offer Speckled Patina Copper and Hand-Rubbed Patina Copper for the look of aged copper without the wait.

### Copper Cladding

1. Speckled Patina Copper
2. Hand-Rubbed Patina Copper
3. Bright Copper



# OUR TRUE COLORS

## Chalking and Fading Resistance

The color finishes we use on our clad-wood windows and patio doors are designed to stay truer and brighter than other finish options. The commercial-grade 70% PVDF resin system ensures our products will steadfastly resist chalking and fading for years.

Chalking is caused when the resin systems at the surface of a finish begin to degrade, primarily due to ultraviolet (UV) exposure. The resin loses its ability to properly adhere to the surface. When this occurs, the particles become white in appearance, which creates a chalky look. Fading happens when substances in the environment attack the pigment in the finish, causing the cladding color to change.

In contrast, our 70% PVDF resin system features the carbon-fluorine bond, which is one of the strongest molecular bonds in existence. Therefore, it resists chalking and fading better than either polyester or siliconized polyester finishes, and our warranty guarantees it won't chalk or fade for 20 years.

### New finish



Acrylic



Silicone Polyester

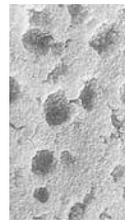


JELD-WEN Custom with 70% PVDF

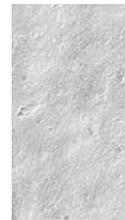
### Exposed for 160 months



Acrylic



Silicone Polyester



JELD-WEN Custom with 70% PVDF

## A COMPLETE SHIELD

### Types of Cladding

Custom Wood windows with clad-wood exteriors have both extruded aluminum cladding and roll-formed cladding. Window and patio door frames and door panels have extruded aluminum cladding for increased structural integrity. Window sashes have roll-formed cladding. This cladding method allows us to add a protective layer to the sash, while sustaining the wood content of the window. In short, our windows and patio doors are designed to feature more wood than other clad products in the industry.



# THE COLORS OF SUCCESS

The commercial-grade 70% PVDF finish we use meets or exceeds the stringent AAMA (American Architectural Manufacturers Association) 2605 paint standard\*. AAMA 2605 is a specification that sets standards for a variety of performance areas, as well as overall hardness, durability and color retention. To earn an AAMA 2605 grade, Custom Wood components, including our roll-formed sash cladding, must meet or exceed this performance criteria. The following information includes some of the most vital AAMA tests and the criteria products must meet to achieve the AAMA 2605 paint standard.

## Impact Resistance

Film must continue to adhere when a load is applied directly to the surface with an impact tester.

## Abrasion Resistance

The abrasion coefficient value of the coating must be a minimum of 40. This value is derived by the equation abrasion coefficient minus liters per mil equals V/T (where V is the volume of sand used in the testing procedure and T is the thickness of the coating).

## Muriatic Acid Resistance

After undergoing this 15-minute spot test, there must be no blistering or visual changes when examined by the unaided eye.

## Mortar Resistance

Mortar must dislodge easily from the painted surface after it is applied as part of a 24-hour pat test.

## Nitric Acid Resistance

The tested surface should display no more than 5  $\Delta E$  units (Hunter) of color change when it is compared with a surface that has not been exposed to the acid.

## Detergent Resistance

There should be no loss of adhesion, no blistering and no significant visual change in appearance (when examined by the unaided eye) after a 3 percent solution of detergent and distilled water is applied to the surface for 72 hours.

## Window Cleaner Resistance

After testing the surface with a glass cleaner solution, there must be no blistering or noticeable change in appearance when viewed with the unaided eye. Also, no film should be removed.

## Humidity Resistance

There must be only minimal blistering after the surface has been placed in a heat and humidity cabinet for 4,000 hours.

## Salt Spray Resistance

There must be only 1/32" to 1/16" of creepage and minimum blistering after the surface is exposed to a 5 percent salt solution for 4000 hours.

## South Florida Weathering

There is a series of tests for finishes that will be exposed to South Florida weathering conditions. These tests measure color retention, chalk resistance, gloss retention and erosion resistance. After testing, the film should display no more than 5  $\Delta E$  units (Hunter) of color change, minimal chalking, greater than 50 percent gloss retention (after 10 years), and less than 10 percent film loss due to erosion.

*\*With the exception of the extruded criteria*



### AAMA Paint Specifications

|                                 | AAMA 2603               | AAMA 2604               | AAMA 2605                |
|---------------------------------|-------------------------|-------------------------|--------------------------|
| <b>South Florida Weathering</b> |                         |                         |                          |
| Color Retention                 | 1 year - "slight" fade  | 5 years - fade = 5 Δ E  | 10 years - fade = 5 Δ E  |
| Chalk Resistance                | 1 year - "slight" chalk | 5 years - chalk = 8     | 10 years - chalk = 8     |
| Gloss Retention                 | No specification        | 5 years - 30% retention | 10 years - 50% retention |
| Erosion Resistance              | No specification        | 5 years - 10% loss      | 10 years - 10% loss      |
| <b>Pretreatment System</b>      | Chrome or Chrome-free   | Chrome or Chrome-free   | Chrome or Chrome-free    |
| <b>Accelerated Testing</b>      |                         |                         |                          |
| Salt Spray                      | 1,500 hours             | 3,000 hours             | 4,000 hours              |
| Humidity                        | 1,500 hours             | 3,000 hours             | 4,000 hours              |

(Effective June 2013)

# CARE AND MAINTENANCE HIGHLIGHTS

**Note:** The following information provides limited "highlights" for care and maintenance of your clad finish. For complete care and maintenance information, please visit the resource section of our website at [www.jeld-wen.com](http://www.jeld-wen.com).

Metal cladding provides both beauty and durability. It features a paint film surface which resists cracking, flaking, peeling and blistering under normal conditions and use\*. In addition, the adhesion and flexibility of clad coatings resist chipping and scratching.

We've provided several tips for cleaning aluminum-clad surfaces. First, we recommend that you do not clean these surfaces in direct sunlight or in temperatures that are either very hot or very cold. Avoid scouring, excessive rubbing and overcleaning. And do not use abrasive cleaners or tools that may scratch the cladding or glass. Surfaces should be cleaned twice a year (or monthly in coastal, industrial and very dry areas).

## For Light Cleaning:

1. Rinse surface with clean water from top to bottom.
2. Clean with mild soap and water using a sponge or soft brush.
3. Immediately rinse thoroughly with clean water. Sponging while rinsing may be helpful. It is important that the cleaning solution does not dry on the surface.
4. Air dry or wipe dry with a soft, dry cloth.

## Touch-up Paints

Metal-clad surfaces on windows and patio doors do not require painting or finishing. However, paints that match our clad colors are available for touching up scratches or other minor blemishes.

## For Moderate to Heavy-duty (non-water soluble) Cleaning:

Use our recommended cleaning agents (For a full list refer to [jeld-wen.com](http://jeld-wen.com)) to remove heavy soils such as oil, grease, sealants, dried concrete stains, tar, rust and graffiti. After using cleaning agents, clean the area with soap and water to remove any traces of the remaining agent.

*\*Clad products installed within one mile of a saltwater source (or other corrosive environment) require additional and specific maintenance requirements. Please refer to our full care and maintenance instructions at [www.jeld-wen.com](http://www.jeld-wen.com).*

**Caution:** For your safety, never mix cleaners or agents, and always follow manufacturer warnings and instructions. Test any cleaner in a small, inconspicuous area before using. Use only in small amounts, wear protective clothing and goggles, and provide proper ventilation. Do not use near open flames, sparks or electrical motors.

## OUR RELIABILITY PROMISE

JELD-WEN® products create lasting value for your home. We are so confident that you will be pleased with our clad-wood windows and patio doors, that each one carries our industry-leading warranty. This limited warranty includes:

- Lifetime Limited coverage against defects in material and workmanship for most product components (such as insulating glass, metal and wood components, and hardware)
- Lifetime Limited coverage for AAMA 2605 finishes
- Lifetime Limited coverage on AuraLast® pine against wood decay and termite damage
- Skilled labor coverage for warranty repairs for 2 years
- Coverage is transferable for 10 years

NOTE: The above information is a summary of key provisions of the JELD-WEN® Wood and Metal-Clad Wood Window & Patio Door Limited Warranty. For a complete copy of the warranty, see your dealer/distributor or refer to [www.jeld-wen.com](http://www.jeld-wen.com).

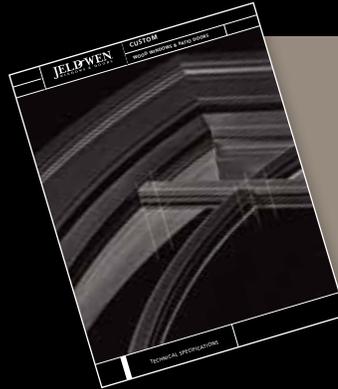
## ABOUT JELD-WEN

Since 1960, when JELD-WEN began with one Oregon millwork plant, we've been dedicated to crafting windows and doors that enhance the beauty and functionality of your home. Today we continue that tradition with products that are durable and worry-free. Our extensive product offering is available globally through multiple distribution channels, including retail home centers, wholesale distributors and building products dealers.

We strive to conduct our business with the highest ethical standards. That includes providing our customers with superior products, establishing solid relationships in the communities where we live and work, and conserving valuable resources.

JELD-WEN's goal is to be the industry leader in environmentally responsible practices and to conduct our business in a manner that demonstrates environmental stewardship. At JELD-WEN, we believe that a healthy environment and healthy business practices go hand in hand.

The JELD-WEN website is your ultimate resource for learning about our reliable windows and doors. It has all the product information and design advice you need. Visit us at [jeld-wen.com](http://jeld-wen.com) today.



To see the complete Custom Wood Window & Patio Door Technical Specifications visit [www.JELD-WEN.com](http://www.JELD-WEN.com) to download a PDF.



Official window and door provider of Major League Soccer



JELD-WEN is proud to support a better way to build