

# Technical Data

Lexington uses the latest lamination equipment, glue technology, and adhesive bonding processes to meet or exceed window and door industry standards for adhesive bond performance. In addition, we have developed working relationships with adhesive, laminate, equipment, and other suppliers to the industry so that we stay current with the latest innovations and product development efforts in the industry. Lexington Manufacturing is 99.26% on time/ in full YTD 2019.

## Profile Wrapping Testing

TEST NAME	STANDARD	REF CODES	APPLICATION
Green Peel	Lexington QC Measure	WI 5011	Porous & Non-Porous Substrates
30 Minute Green Peel	Lexington QC Measure	WI 5011	Porous & Non-Porous Substrates
Peel Test	AAMA (FGIA)	AAMA 303 (FGIA)	Porous & Non-Porous Substrates
Boil Test	ASTM	ASTM D5751, D5572	Non-Porous Substrates
Vacuum Pressure	ASTM	ASTM D5751, D5572	Porous Substrates
Hydrolysis & Thermolysis Chamber	ASTM	ASTM G154, D4329, D4587	Weather Cycle for Porous & Non-Porous Substrates
Hydrolysis & Thermolysis Chamber	European Standard (National Board for Delivery Conditions)	European RAL-GZ-716	Weather Cycle for PVC Window Systems (Exterior Adhesive)

## Profile Wrapping Quality Systems

ELEMENTS OF QA SYSTEM	DESCRIPTION
Lot Traceability	Ability to trace production runs to the date, the shift, the operator
Process Capability	Capable process design to meet our customer's specific requirements
Quality Auditing	Scheduled & non-scheduled audits to ensure quality control procedures are followed. Audit strategy is driven by the incident volume and incident frequency of each manufacturing cell
Material Compliance	Process for ensuring material meets specifications. Process for securing, labeling, & isolating non-conforming material
Corrective Action - 8-D Format	Problem description, containment, define root cause, long term corrective action, verification, prevent recurrence
Continuous Improvement	Six Sigma discipline. Operational Excellence initiative to increase the number of green belts. Initiative for all existing employees to receive yellow belt training. New hire on-boarding process will include yellow belt training
Engineering Changes	Utilize a disciplined process for documenting, communicating and expediting changes to manufacturing processes and procedures
PPAP Process	Production Part Approval Process
Key QA Metrics	Cost of Quality, On-Time Delivery, Customer Complaints, Work Order Efficiency Fulfillment Rate, External Incident Rate