



Customer: The Bilco Company  
Location: 536 Hwy. 463 S., Trumann, AR 72472  
Equipment: SW FT30 4'-6" x 5' 10"  
Sales Order: 943132  
Customer PO: 207640  
Contact: Darrell Holton, Zach Steeves  
Phone: 870-483-5118

**Tier One Services, LLC**  
Inspected By: Chuck Gordon, AWS CWI #14080621  
Report By: Chuck Gordon  
Job No.: 20876  
Insp. Date: Sept. 29, 2025



### Inspection Summary:

Tier One was contracted by The Bilco Company for inspection services on a Model Type FT30 (H20) Aluminum Single Leaf Access Sidewalk Door. Size 4' 6" x 5' 10".

### Inspections Included:

1. Verify chalk test on sealing surfaces.
2. Witness hydrostatic testing of unit.
3. Photos and reference document reviews.

Reference documents included Drawing No. FT3-10069 Rev. A and Sales Order 943132 packet. Per Client, unit was modified/reinforced to replicate unit being installed in concrete.



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1. Chalk Test: A chalk test was performed to assure that the door unit could make a 100% watertight seal. A green chalk paste was applied to the doors sealing surfaces and unit was closed and sealed per manufacturer specifications. Unit was then re-opened and sealing surfaces inspected to verify inner seals made full contact around all sealing surfaces. The chalk test was successful.
2. Hydrostatic Test: A hydrostatic test chamber was installed on top of the door unit and sealed by means of adhesive stripping and bolts. The test chamber was then filled completely with water and capped off. A new calibrated pressure gauge was used for the test. The unit was pressurized to 13 PSI and held for two (2) hours. During the test, water leakage was captured and measured every 30 minutes. The pressure gauge was monitored to ensure there was no loss of pressure during testing. One (1) leak point was noted in the right corner on the hinge side of the unit.

Pressure Gauge: Serial No. – MC051521, Calibration Date – 5/23/25, Range – 0-15 PSI.

Start Time – 9:44 a.m. End Time – 11:44 a.m.

Leakage rates per 30 min. interval.

10:14 a.m. – 9.5 oz.

10:44 a.m. – 10.5 oz.

11:14 a.m. – 10.5 oz.

11:44 a.m. – 10.5 oz.

Total leakage – 41 oz.

Hydrostatic Test was successful.

3. Photos and reference documents: See report pages hereafter.

Inspections verified / witnessed by:

Chuck Gordon *Chuck Gordon* Date 9/29/2025

Inspection report written by:

Chuck Gordon *Chuck Gordon* Date 9/29/2025

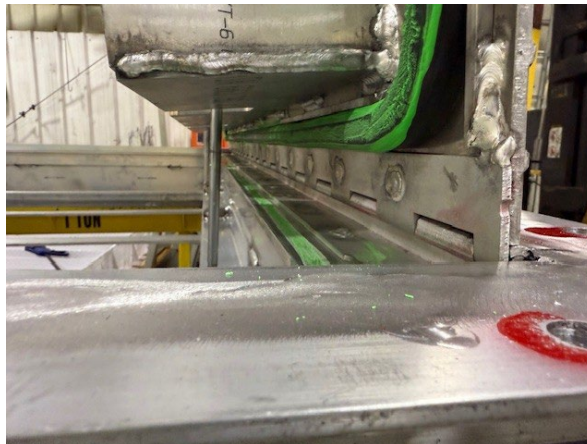
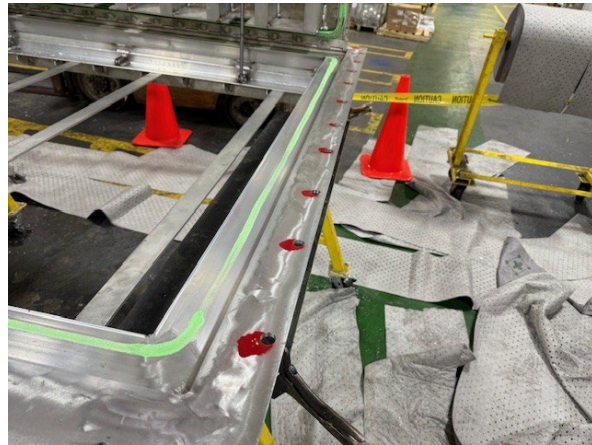
AWS CWI #14080621

Tier One Services, LLC  
 2990 Sandbrook St.  
 Memphis, TN 38116  
 (901) 213-9020



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SPAN  
 1209 Pearl Street  
 Birmingham, AL 35202  
 Phone: (205) 941-1789  
 Fax: (205) 941-6493

**PRESSURE GAUGE  
 CERTIFIED CALIBRATION RECORD**

TRACEABLE TO NIST

Customer/Distributor: [ ]  
 Installation Date: [ ]  
 Project: [ ]  
 Purchase Order Number: **FD-88445170**  
 Invoice Number: [ ]  
 Calibration Date: **5/23/2025**  
 Calibration Due Date: [ ]  
 Serial Number: **MC051521**

Gauge Part Number: **1501002**  
 Serial Number: **MC051521**      ANSI Grade: **1.5**

Calibration Standard: **Dead Weight Tester**  
 Certification Number: **SN**

Note: The above-mentioned customer should be at least four times as accurate as the instrument being tested.

INCREASING PRESSURE			DECREASING PRESSURE		
CALIBRATION STANDARD	PRESSURE GAUGE	DEVIATION	CALIBRATION STANDARD	PRESSURE GAUGE	DEVIATION
0	5.9	-5.9	12	9	-3
7.0	7.4	-0.4	7.5	7.3	0.2
12	11.9	-0.1	8	8	0
15	14.9	-0.1	9	9	0

Calibrated by: [ ]



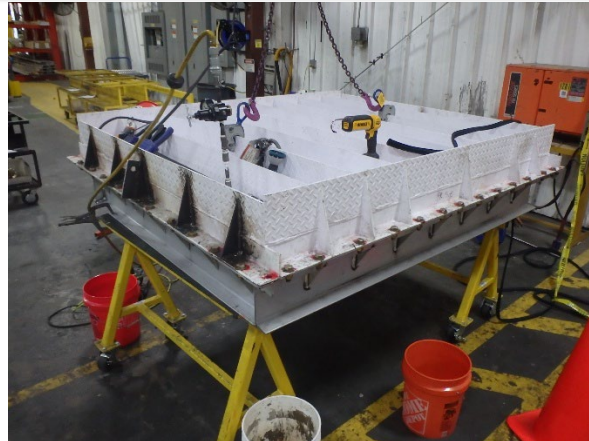


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Unit pressurized up to 13 PSI



9:44 am - 10:14 am = 9.5 oz.



10:14 am - 10:44 am = 10.5 oz.



10:44 am - 11:14 am = 10.5 oz.

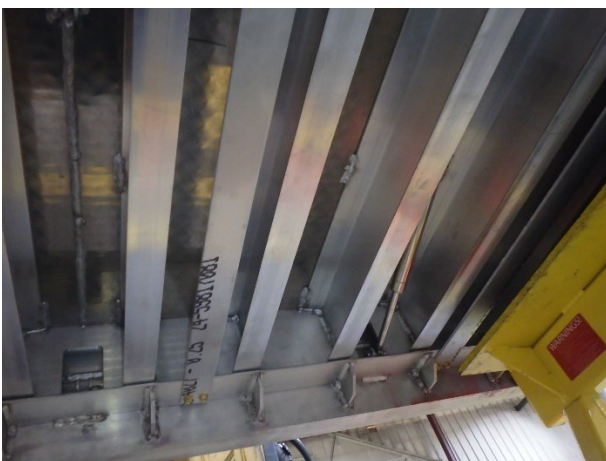
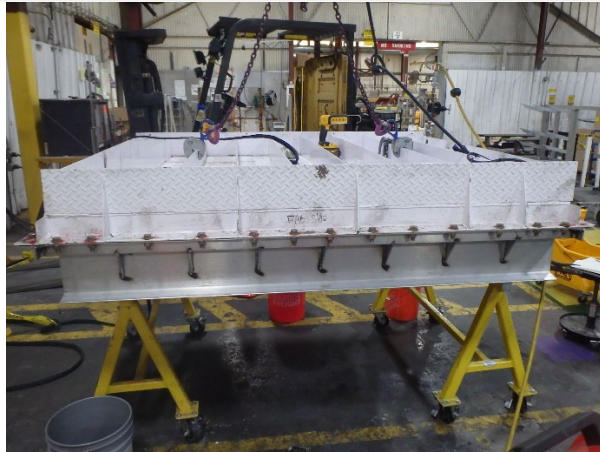


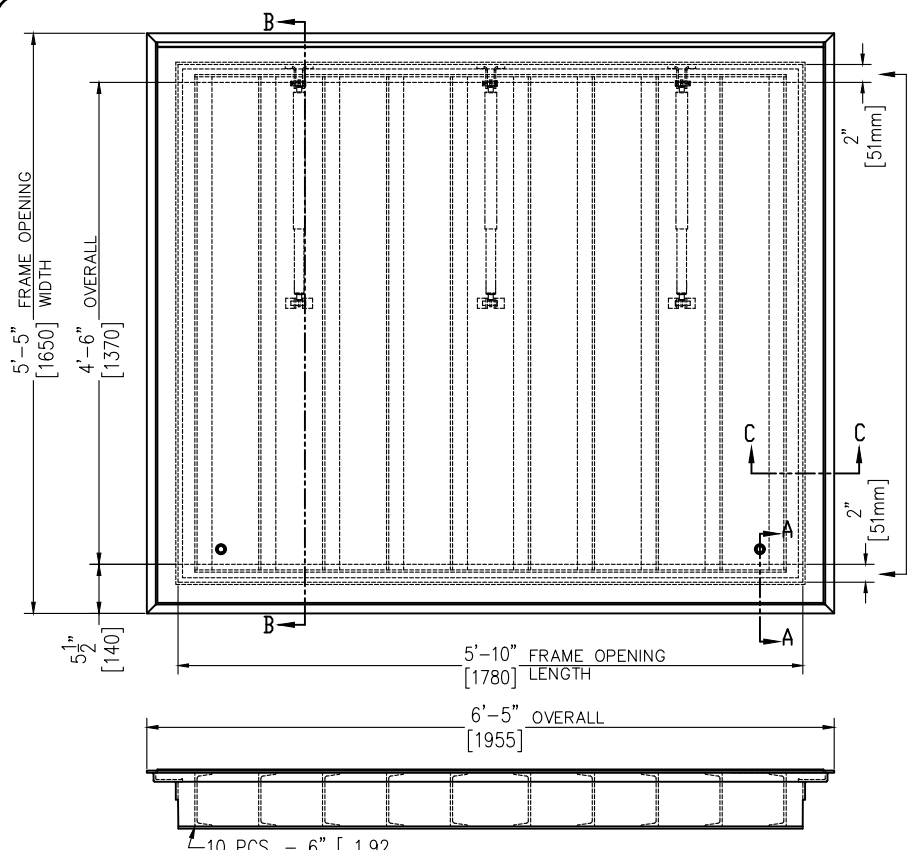
11:14 am - 11:44 am = 10.5 oz.



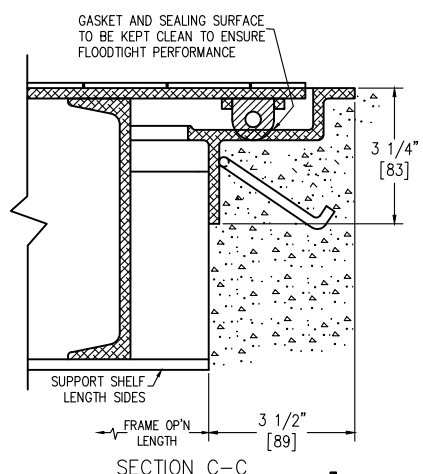
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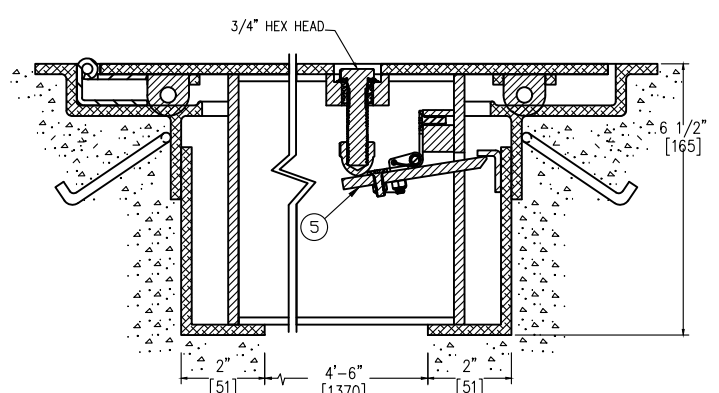


CHANNEL SUPPORT SHELF

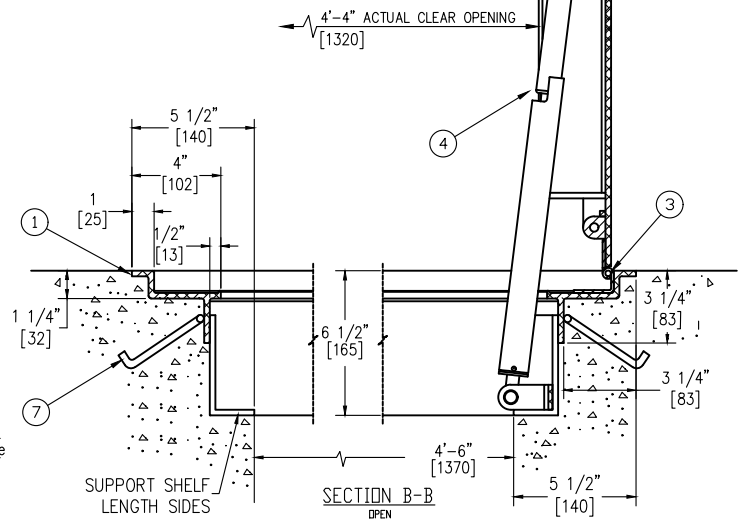


SECTION C-C

NOTE:  
 1. DESIGNED TO WITHSTAND H-20 WHEEL LOADINGS SUITABLE FOR USE IN OFF-STREET LOCATIONS, INFREQUENT & INCIDENTAL WHEEL LOADINGS ONLY. NOT SUBJECTED TO HIGH DENSITY TRAFFIC  
 2. DESIGN FACTORY TESTED TO WITHSTAND 30' HEAD OF WATER



SECTION A-A



SECTION B-B  
OPEN

THIS DRAWING IS THE PROPERTY OF THE BILCO COMPANY AND INCORPORATES INFORMATION WHICH IS PROPRIETARY. PUBLICATION AND/OR PUBLIC DISTRIBUTION IN WHOLE OR IN PART IS EXPRESSLY PROHIBITED WITHOUT THE PRIOR WRITTEN CONSENT OF THE BILCO COMPANY. THE INFORMATION CONTAINED HEREIN REMAINS THE PROPERTY OF THE BILCO COMPANY. ALL RIGHTS RESERVED.

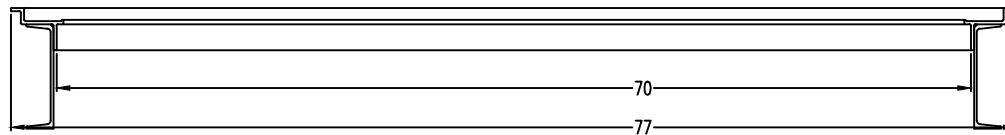
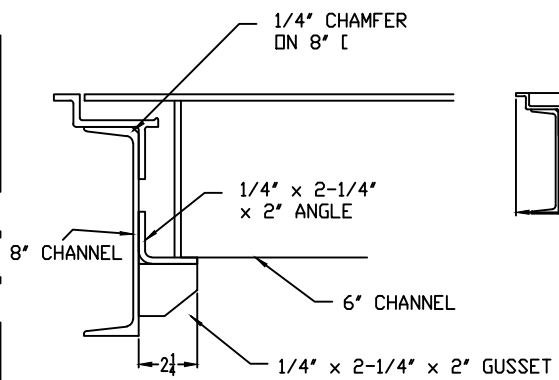
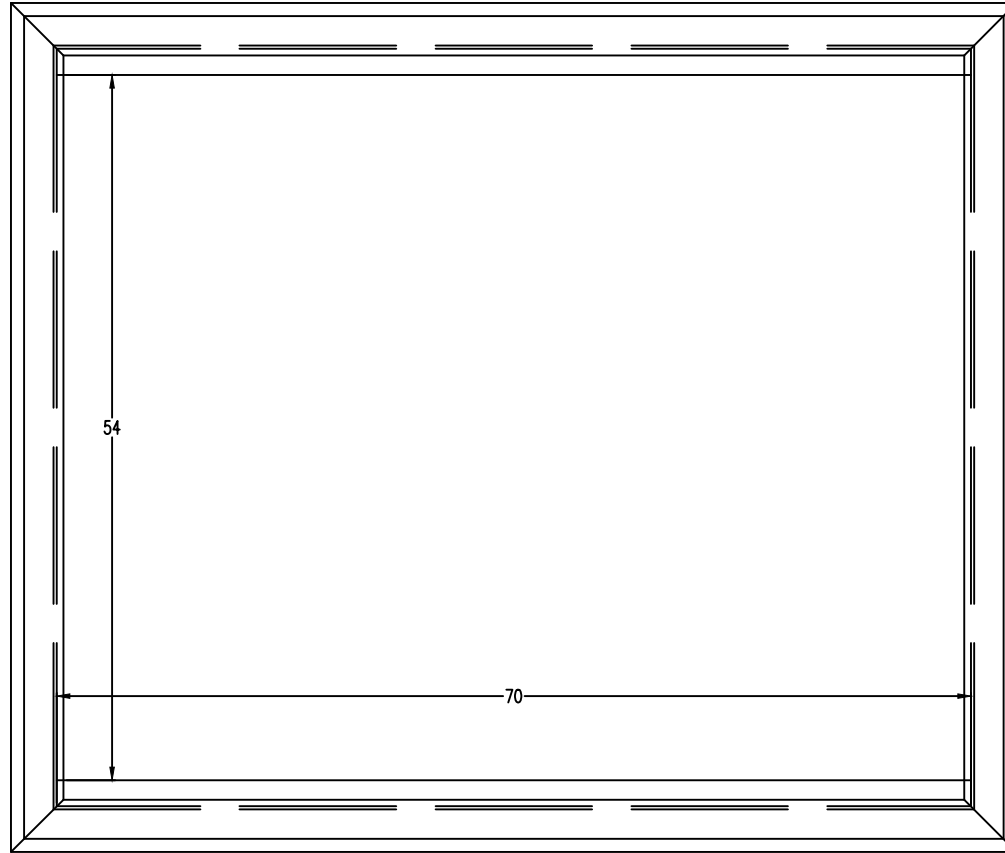
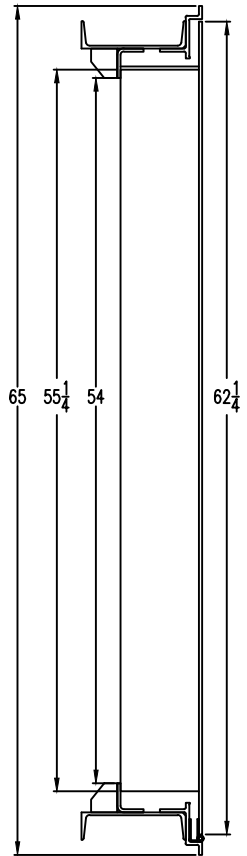
CHANNEL SUPPORT SHELF MUST BE SUPPORTED BY CONCRETE OR STEEL TO CARRY H-20 LOADING

Frame areas that come in contact with concrete shall be coated with bituminous paint

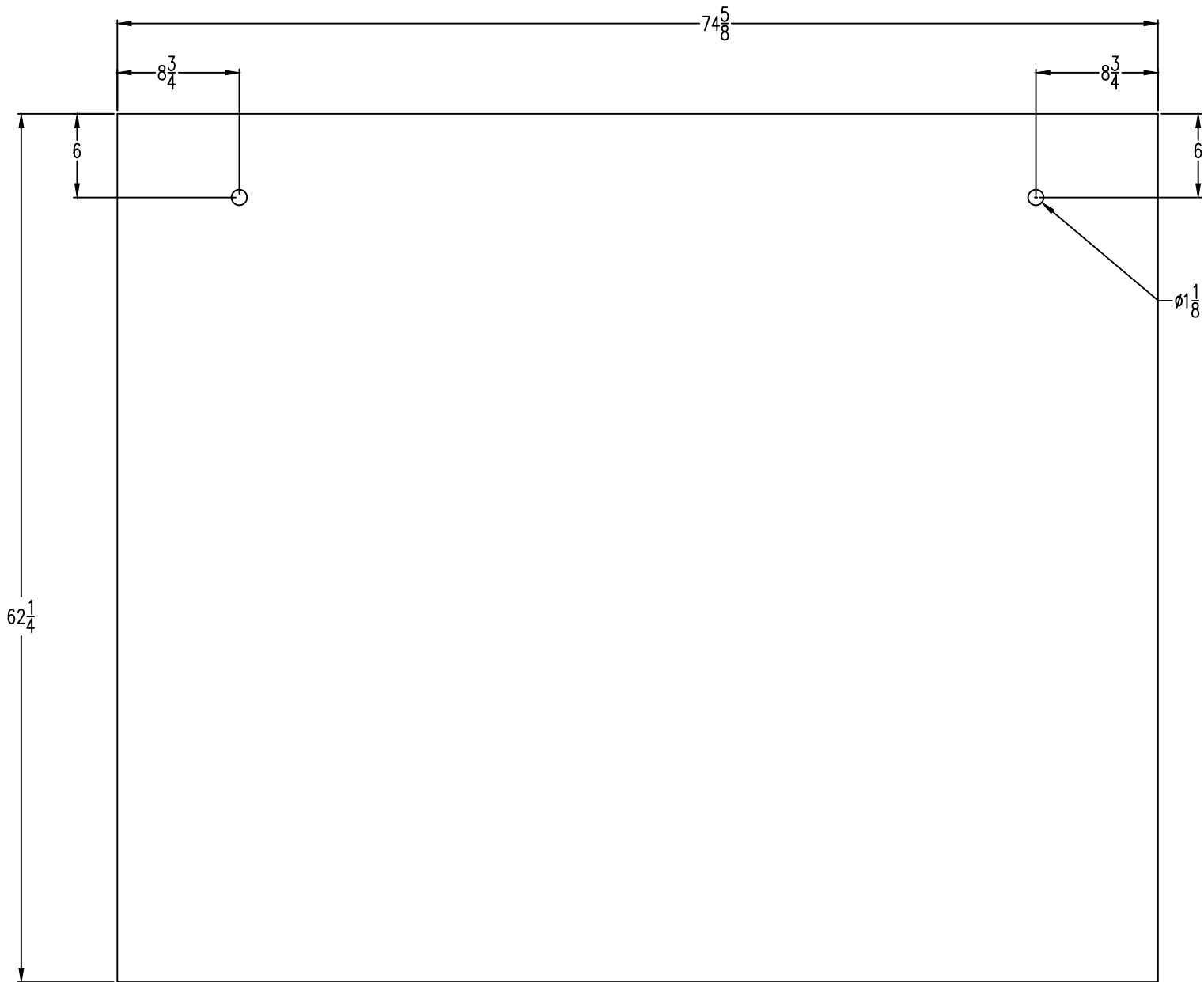
Sym.	Revision	Date	By
A	NEW RELEASE		
<b>SPECIFICATIONS:</b>			
1. BILCO 1/4" ALUMINUM FRAME			
2. 1/4" ALUMINUM DIAMOND PATTERN PLATE COVER			
3. PIANO HINGE, 3" WITH STAINLESS STEEL PIN			
4. GAS SPRINGS WITH DAMPER & HOLD OPEN FEATURE			
5. LEVER LOCK			
6. EPDM GASKET (ALL AROUND COVER)			
7. 3/8" DIA. ALUMINUM ANCHOR ROD (SPACED 18" O.C.)			
<b>INSTALLER NOTES:</b>			
A. USE CAUTION. COVER IS SPRING LOADED. DO NOT REMOVE SAFETY SHIPPING BOLT UNTIL UNIT IS TO BE INSTALLED AND IN NORMAL HORIZONTAL OPERATING POSITION.			
B. BEFORE ANCHORING IN PLACE OPEN AND CLOSE DOOR. CHECK TO SEE THAT THE DOOR IN THE CLOSED POSITION RESTS ON THE FRAME ALL AROUND. IF NOT, SHIM UNDER THE FRAME AT THE PROPER CORNER.			
1	UNIT(S) REQUIRED AS SHOWN (Aluminum Weldment) COVER REINF. FOR H-20 LOADING		
SHOP FINISH:			
COVER:		MILL FINISH	
FRAME:		MILL FINISH	
HARDWARE:		TYPE 316 STAINLESS STEEL (UNLESS OTHERWISE SPECIFIED)	
Customer:		THE BILCO COMPANY P O BOX 1203 NEW HAVEN CT 06505	
P.O. No:			
Job:			
Tag:			
Sales Rep:		THE BILCO COMPANY P O BOX 1203 NEW HAVEN CT 06505	
Approved By:			
Date:			
Manufacturers of Doors for Special Services THE BILCO COMPANY New Haven, Connecticut 06505			
TYPE "FT30"- (H20) ALUMINUM SINGLE LEAF ACCESS DOOR - SIZE [ 1370 mm x 1780 mm ]			
Drawn By:	Date:	Drawing No.	Rev.
RAV	09-30-25	FT3-10069	A
943132	Scale: DO NOT SCALE		



Shear List and Work Sheet For Single Leaf (FT30) Alum Door (Reinforced For H20 Loading)				Shop Order No. <b>943132</b>
Customer: <b>THE BILCO COMPANY</b>				No. of Units Required <b>1</b>
Type: <b>FT30</b>	Size: <b>54 X 70 ( 4' - 6 X 5' - 10 )</b>			<b>1</b>
Part Name	Quantity	Cutting Size	Notes	Rev. 12/16/24
<b>FRAME</b>				
Frame (W)	2	Extruded Alum x 65 (Overall)	<b>SD1401</b>	
Frame (L)	2	Extruded Alum x 77 (Overall)	<b>SD1401</b>	
Frame Reinf	2	8" X 4.25# Channel X 63" long	<b>SD1656AL</b>	
Frame Reinf	2	8" X 4.25# Channel x 75" long	<b>SD1656AL</b>	
Support Shelf	2	1/4 Alum x 2 x 2 1/4 Angle x 69 7/16 - 3 13/16 Blank	<b>SH92</b>	
Frame Extn Angle (W)	2	2 x 2 X 1/4" Angle X 69" long	<b>AI-9</b>	
Frame Extn Angle (L)	2	2 x 2 X 1/4" Angle X 81" long	<b>AI-9</b>	
Gussets	20	1/4 x 2 x 2 3/4	<b>SH92</b>	
<b>COVER</b>				
Cover Plate	2	1/4 <-> Plate x 62 1/4 x 37 5/16	<b>SH98</b>	<b>Butt Weld</b>
A Reinf	1	1/4 Alum x 6 x 66 1/4	<b>SH92</b>	
C Reinf	10	6 x 1.92 Alum Channel x 55 1/4 (Space 7 5/32)	<b>SD1523</b>	
D Reinf	1	1/4 Alum x 6 x 66 1/4	<b>SH92</b>	
Gasket Ret (W) Inner	2	1/4 Square Alum Bar x 54 1/4	<b>SD918AL</b>	
Gasket Ret (W) Outer	2	1/4 Square Alum Bar x 59 1/4	<b>SD918AL</b>	
Gasket Ret (L) Inner	2	1/4 Square Alum Bar x 68 1/8	<b>SD918AL</b>	
Gasket Ret (L) Outer	1	1/4 Square Alum Bar x 73 5/8	<b>SD918AL</b>	
<b>OTHER</b>				
Hinge	1	1/4" Barrel Alum Piano Hinge x 74 5/8	<b>SD1608</b>	
Lock	2	Standard Lock	<b>KTLOCKFT3</b>	
Gas Springs	3	(1) @ 220#, (1)@320#, (1)@410#	<b>SD3146-0_</b>	
Gasket	1	Linear Gasket Length x 22' 0"	<b>SD4028</b>	
<b>DIMENSIONS</b>				
Lock Hole (W)	6	From Leading Edge of Cover to Center of Lock Hole		
Lock Hole (L) Ends	8 3/4	From Outside Edge of Cover to Center of End Lock Hole (First Stiffener Gap)		
<b>Prepared By: DJC Sheet 1 of 1 Date: 08/12/25</b>				

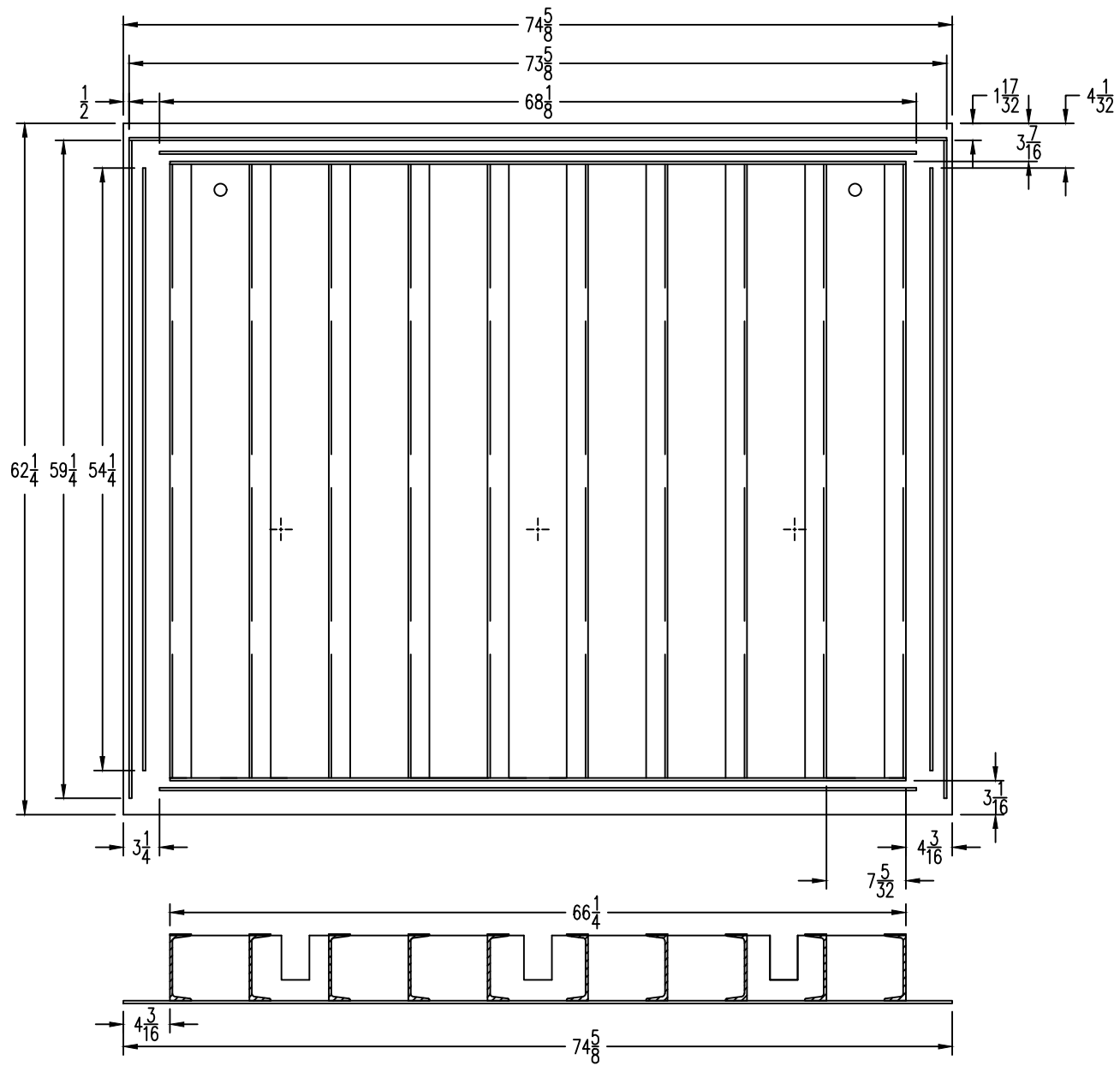


FRAME WELDMENT  
FT30 4'-6" X 5'-10"  
RAV 08/13/25



COVER LOCK HOLES  
DIAMOND SIDE DOWN  
FT30 4'-6" X 5'-10"  
RAV 08/13/25





COVER WELDMENT  
 FT30 4'-6" X 5'-10"  
 RAV 08/13/25



S/O#: 943132 QTY FINISH  
PART: 2PARTS SW FT30 4'6"X 5'10" 1 scottm 08/25/25

SINGLE LEAF SIDEWALK DOOR. CERTIFIED HYDROSTAYIC TEST TO BE DONE IN TRUMANN BY ELEMENTS TECHNOLOGIES. REINFORCE FRAME FOR TEST FIXTURE-ADD ANGLE, GUSSETS AND PLATE STIFFENERS. DO NOT OVERHEAT THE COVER OR FRAMEWHEN WELDING TO LIMIT WARPING AND DISTORTION. FRAME AND COVER FLATNESS IS CRITICAL.

OPER	DESCRIPTION	SETUP	RUN	TOTAL HR
PART NO	P I C K I N G L I S T	REQUIRED	ISSUED DATE	ON HAND ON ORDER COMMITTED AVAILABLE LOCATION
2LOCK545	- LOCK-SPACER 3/4"X1"X 2 1/2"	2.00	.00 08/11/25	5 40 29 24-
2SD1401	- EXTRU-6005A T61 FT-ECO 14'FT 28.69# PER STICK	52.62	.00 08/11/25	2378 1187 547 1831
2SD1608	- HNG-PIANO, 1/4 S/S PIN ALUM, FORMED	.78	.00 08/11/25	15 35 8 7
2SD2266SS	- HHCS,1/2-13 X 3" LG SS MASTER CARR 93395A322	2.00	.00 08/11/25	12 0 29 17-
2SD2267	- WASHER-SEALING, 1/2" MASTER CARR 91195A128	2.00	.00 08/11/25	50 0 29 21
2SD248SS	- PIN-CLEVIS, 1/2" DIA x 1 1/2" LONG 92390A383	6.00	.00 08/11/25	97 0 68 29
2SD249SS	- FLMS-M5X0.80MM THD, x 16mm LG, 316SS	6.00	.00 08/11/25	100 0 87 13
2SD250SS	- NUT-LOCK,M5 X 0.080MM THD, NYLON INSERT, 316	12.00	.00 08/11/25	100 0 174 74-
2SD2943SS	- NUT-ACORN,1/2"-13,18-8 MCMaster CARR91855A480	2.00	.00 08/11/25	144 0 29 115
2SD3146S02	- SPRNG-GAS,SS 220#FORCE 316 SS	1.00	.00 08/11/25	0 64 8 8-
2SD3146S04	- SPRNG-GAS,SS 320#FORCE 316 SS	1.00	.00 08/11/25	0 20 5 5-
2SD3146S06	- SPRNG-GAS,SS 410#FORCE 316 SS	1.00	.00 08/11/25	0 13 4 4-
2SD414AL	- ANCHOR-ROD, DIA 3/8 BENT	12.00	.00 08/11/25	0 0 126 126-
2SD1523	A 6" ALUMINUM CHANNEL 2.83#	130.30	.00 08/11/25	1274 7206 1762 488-
2SD1656AL	A 8"[4.25 CHANNEL ALUM.	97.76	.00 08/11/25	215 2975 998 783-SAW
2SH92	A 1/4" X 48" X 120" SM PLATE, 5086 H-34	19.48	.00 08/11/25	5920 13869 4705 1214
2SH98	A 1/4X52X168 AL DIA PLT 5086 H34	116.14	.00 08/11/25	1297 0 14473 13176-
2AI-9	C 1/4 X 2 X 2 6061 T-6 ALUM ANGLE X 25'	28.13	.00 08/11/25	864 554 292 572

PART NO	P I C K I N G L I S T	REQUIRED	ISSUED	DATE	ON HAND	ON ORDER	COMMITTED	AVAILABLE LOCATION
2LOCK302	C LOCK-HGE MOUNT,GRIPWEL RELAINIT	2.00	.00	08/11/25	101	0	29	72
2LOCK303	C LOCK-LVR,1/4"X1 3/4"X 3 1/2"	2.00	.00	08/11/25	85	0	29	56
2LOCK304	C LOCK-BUNG,1 1/2"DIA X 3/4" LG, ALUM	2.00	.00	08/11/25	50	0	29	21
2SD1614/16	C SCREW-FHMS,5/16"-18 X 1", 316SS, SLOTTED	2.00	.00	08/11/25	0	0	209	209-A034
2SD225AS6	C STRIKE - LOCK, BENT, FOR T,K,Q, 316SS	2.00	.00	08/11/25	0	0	257	257- SE5
2SD2265SS	C LOCK-THRD INST,1/2-13 MASTER CARR 90266A336	2.00	.00	08/11/25	84	0	29	55
2SD2268AL1	C BRKT,FT30,GS 1/4" ALUM CVR BRKT	6.00	.00	08/11/25	150	0	68	82
2SD2268AL2	C BRKT,FT30,GS 1/4" ALUM FRM BRKT	3.00	.00	08/11/25	150	0	34	116
2SD273/316	C 5/16-18 HEX NYL INSERT LOCK NUT TYPE 316 SS	4.00	.00	08/11/25	0	0	4778	4778- SH1
2SD3/316	C SCREW-5/16-18X7/8", 316SS, TAPTITE	4.00	.00	08/11/25	0	0	98	98- SK2
2SD4028	C GASKET,FT30,TRIM LOCK 1678 X1678BT TRIM LOCK	22.00	.00	08/11/25	500	1250	219	281
2SD918AL	C 1/4"ALUM RABBIT BAR 9447T33 6FT	36.41	.00	08/11/25	0	4080	356	356-